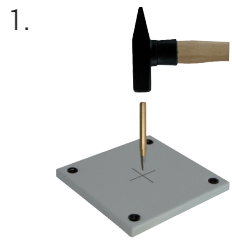
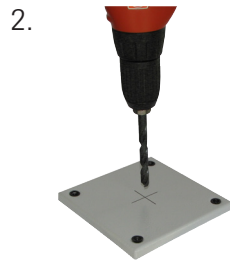


Note tool - Working with punching pumps

General instructions when working with hydraulic punching pumps



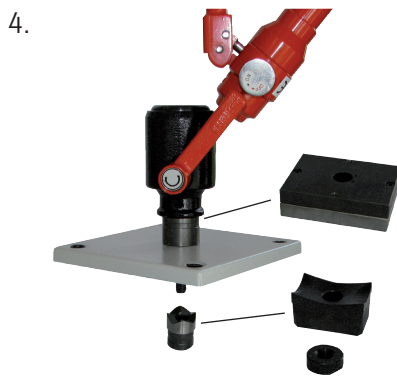
Make punch mark on cross mark.



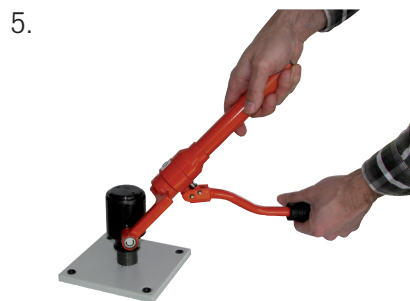
Pre-drill:
 - with screw \varnothing 9.5 mm, with \varnothing 10.5 mm
 - with screw \varnothing 11.1, mm with \varnothing 12 mm
 - with screw \varnothing 19 mm, with \varnothing 20 mm
 with screw \varnothing 19 mm, may also be pre-scored with \varnothing 20.4 mm.



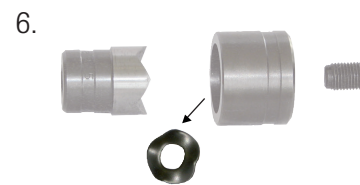
Fix the screw into the hydraulic cylinder and attach the die. Insert the screw through the Pre-drilled hole.



For round punch: screw on the stamp.
 For square and special punches: attach the stamp and screw and fasten with bolt.
 Align with cross mark.



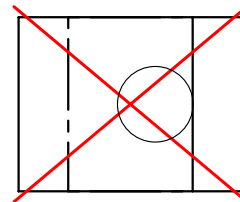
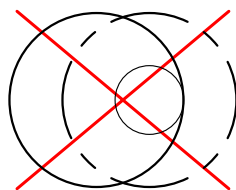
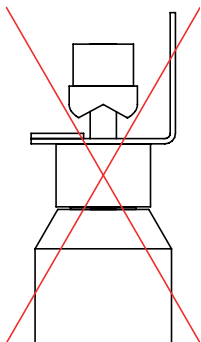
Attach return screw on the device. Press the pump until the stamp is pressed through the metal (audible click sound). Pump slowly as the stamp must set. After the clicking sound, perform 2-3 pumps more until the cutting waste falls freely from the die.



By opening the pump the return screw is released. Stamp returns with spring. Remove stamp and die, and then remove the punch waste.

Important:

- Only use matching punch tools
- Always use cutting oil to extend the service life (2684-0700-25-00)
- With key-operation always grease actuation screws
- Sharpen punching tools regularly
- Never apply force!





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