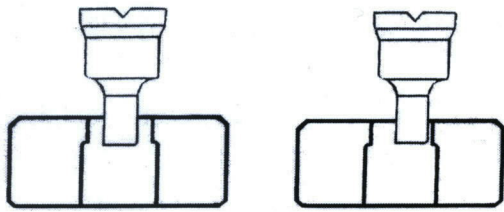


Information: Punch and Die Alignment Stripper Height Adjustment Punch and Die Clearances

Alignment of Punch and Die:

Punch and Die alignment is very important for good punching results and safe operation. Correct alignment is when the punch is inside the die and the clearance around the punch is equal.

See illustration below:



Correct

Incorrect

IMPORTANT: Shaped Tool Alignment

When using any shaped punch and die you must always use an aligning pin on punches with "V" Grooves or Square Keys on punches with Keyways. Also, ensure that the shaped dies are aligned with the shaped punches.

Stripper Adjustment:

The stripper must be adjusted evenly and close to the material being punched. (Approx. 1/8" above material) Strippers with excess clearance will cause premature punch failure, side loading on the cylinder, and poor quality holes.

WARNING:

It is the end users responsibility to make sure the machinery and punches and dies are being used in accordance with local and national OSHA rules and ANSI B11.5 safety standards. Set up and correct machine operation should be performed by properly trained personnel only.

Punching or shearing of metal will generate extreme forces. Use extreme caution when operating machinery and always use OSHA approved guards and safety glasses. Follow safe operation practices shown in operators manual.

