



Instructions for changing inserts PASS Beta-V2[®] System

1. Station A and B

1. Bring markings together



2. Pull the guide from the head



3. The punch has to be screwed off



4. Remove the stripper





5. New or regrinded punch has to be screwed up to approx. 5 to 15 mm



6. Snap the stripper





7. Clip the guide and align stripper to the punch



8. Snap the guide (in correlation to the markings)



9. Press the snap valve and adjust punch length by turning the head





2. Station C, D and E

1. Press the stripper clamping
(stripper jumps out)



2. Remove the stripper



3. Tighten the PASS assembly adapter into the bench vice and put the guide unit into the relevant adapter. Open the screw (hexagon key SW 10 mm)





4. Remove the punch



5. Insert a new or a regrinded punch



6. Tighten the screw
Recommended turning moment:
120 Nm



It is not allowed to dismantling the head screws!!



7. Insert the stripper



8. Length can be adjusted by pressing the snap valve and turning the head, if necessary. Punch approx. 0,5 - 1 mm behind the stripper



If there might be any problems (e.g. break of springs) we ask you for returning the tool to us for repair.

Yours PASS Stanztechnik AG