



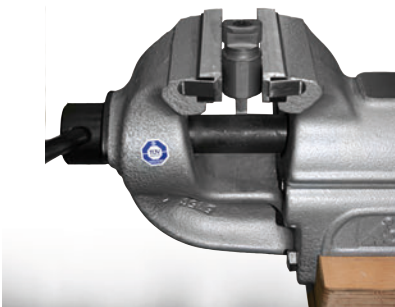
OPERATION MANUAL 10/2019-WW  
SYSTEM SALVAGNINI P2, P4, P5, P6, P7, P9, P10

## P2 SYSTEM

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1.

Clamp the punch assembly containing the punch insert, including washers if required, into the bench vice (use soft jaws).



2.

Tighten the countersink screw M8 with approx. 20 Nm.



# P4 SYSTEM

1.  
Place the punch insert from the top into the punch head.



2.  
Tighten the countersink screw M14 x 1,5 x 12 with approx. 50 Nm.



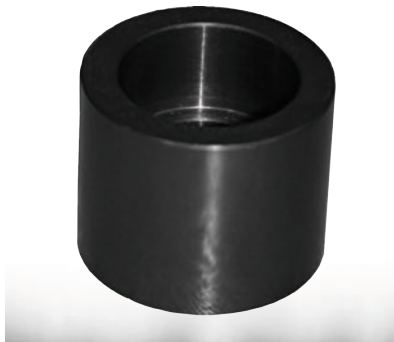
3.  
Lightly grease the inside of the guide. Place the yellow compression spring  $\varnothing 25 \times 38$  into the guide together with the assembled punch insert.



4.  
Place the snap-ring over the head.



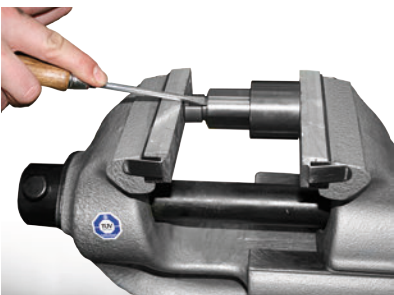
5.  
Clamp with help of the assembly adapter



6.  
the tool axially into the bench vice and compress to a total length of approx. 95 mm.



7.  
Push the snap-ring with a screw driver into the designated slot of the punch guide.



# P5 AND P6 SYSTEM

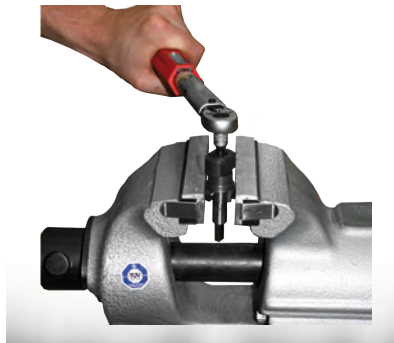
1.

Place the punch insert into the head from the bottom while respecting the assembly position 0° or 90°.



2.

Tighten the barrel head screw M6 with approx. 15 Nm.



3.

Lightly grease the inside of the guide. Place the yellow compression spring  $\varnothing 25 \times 38$  into the guide together with the assembled punch insert.



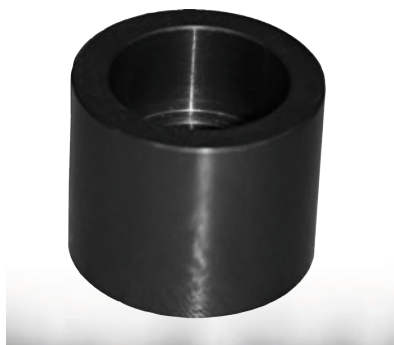
4.

Place the snap-ring over the head.



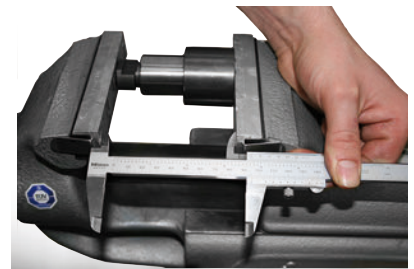
5.

Clamp with help of the assembly adapter



6.

the tool axially into the bench vice and compress to a total length of approx. 95 mm.



7.

Push the snap-ring with a screw driver into the designated slot of the punch guide.



# P7 SYSTEM

1.

Lightly grease the inside of the guide and place the punch insert from the top into the punch guide.



2.

Insure punch insert seats solidly on the base.



3.

Attach the snap-ring



4.

with the help of circlip pliers



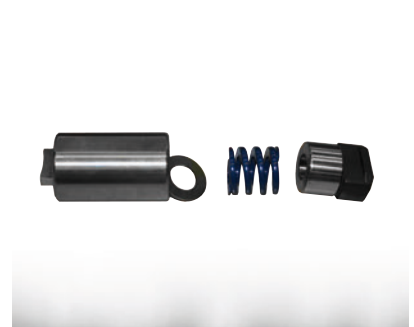
5.

into the deep lying slot.



6.

Place pressure disc followed by blue pressure spring  $\varnothing 25 \times 25$  and finally the head into the guide.



7.

Insure the punch head is at position  $0^\circ$  or  $90^\circ$ .



8.

Insert the assembly pin laterally through the guide into the punch shoulder. This is important to avoid damaging the cutting part edge of the punch when tightening the screw.



9.

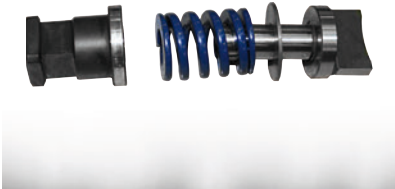
Lock the screw M8 with approx. 30 Nm with the aid of a bench vice. Remove the assembly pin.



# P9 SYSTEM

1.

Place the pressure disc, then the blue pressure spring  $\varnothing 25 \times 25$  and finally the punch head from the top over the punch shank.



2.

Tighten the barrel head screw M6 with approx. 15 Nm with the aid of a bench vice.



3.

Place this assembly into the lightly greased punch guide.



4.

Place the special snap-ring



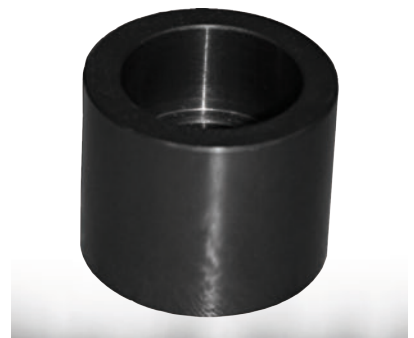
5.

over the head.



6.

Clamp with help of the assembling adapter



7.

the tool axially into the bench vice and compress to a total length of approx. 100 mm.



8.

Push the snap-ring with a screw driver into the designated slot of the punch guide.

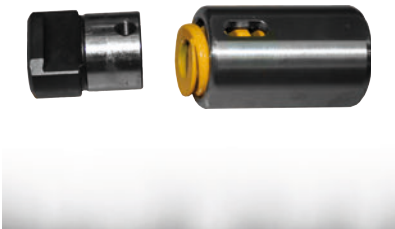




# P10 SYSTEM

1.

Lightly grease the inside of the punch guide. Place the yellow compression spring  $\varnothing 25 \times 38$  into the guide.



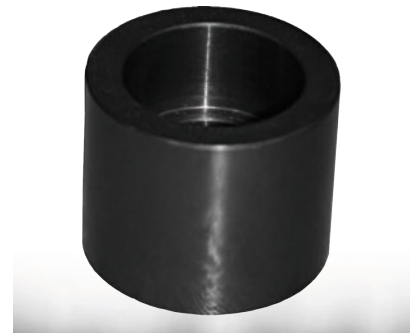
2.

Insure the punch head is at position  $0^\circ$  or  $90^\circ$ .



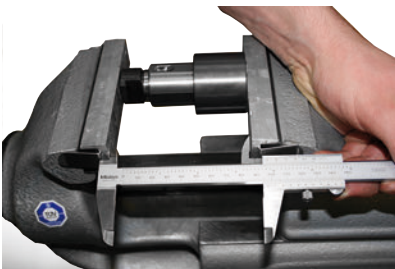
3.

Clamp with help of the assembling adapter



4.

the tool axially into the bench vice and compress to a total length of approx. 98 mm.



5.

Tighten the special srew on the side and release the clamped system again.



6.

Place the punch insert from the top through the punch head (align flat punch surface by hand in direction to the screw).



7.

Insure that the clamp screw is only hand tight and has to be lightly released again.



8.

Tighten the screw on the side with approx. 3 Nm – this will position the punch insert correctly.



9.

Finally tighten the head screw with approx. 50 Nm.



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