

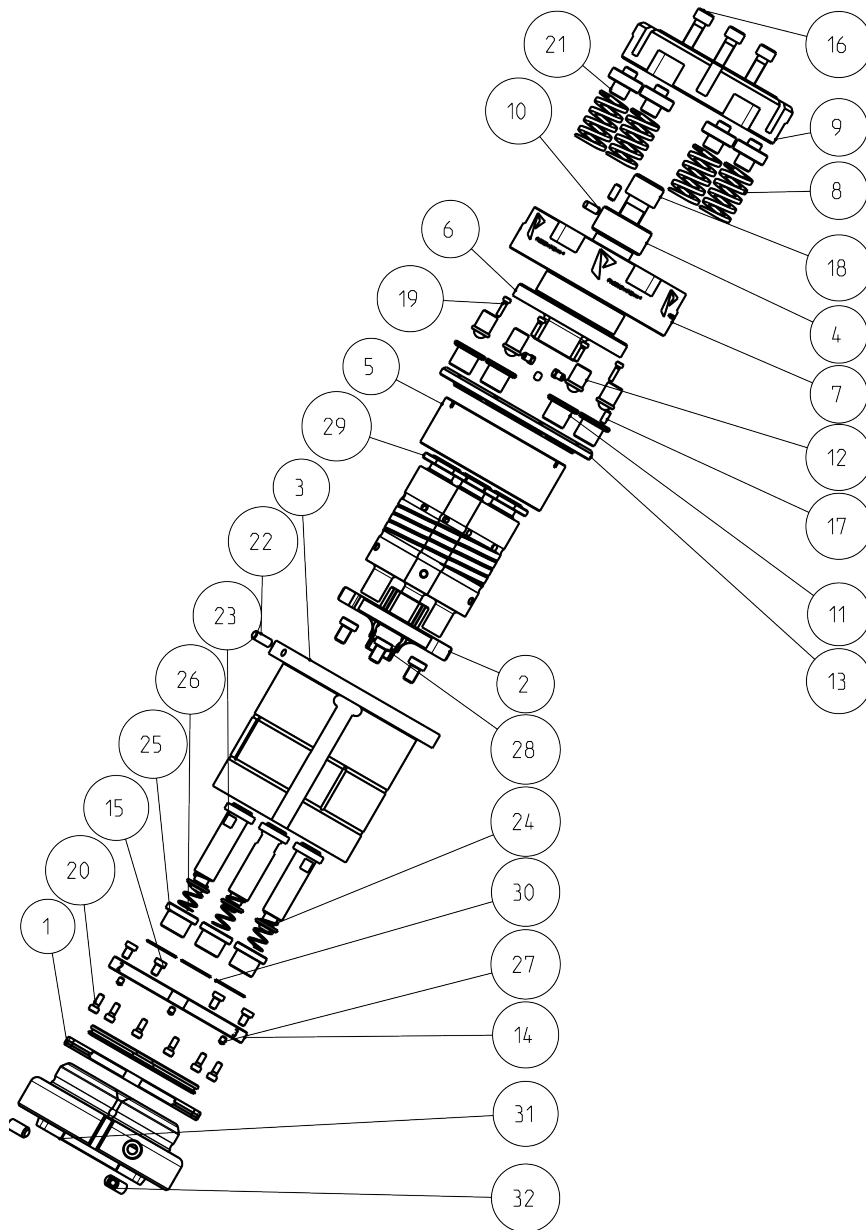


OPERATION MANUAL 02/2020-WW

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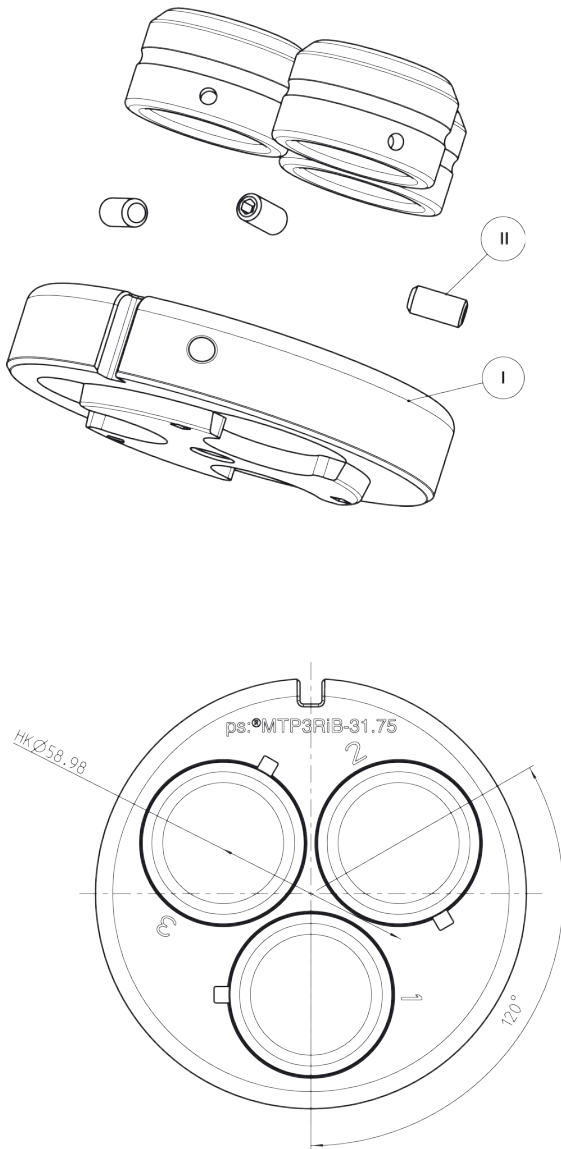
OVERVIEW DRAWINGS



- ① stripper holder plate
- ② punch support plate
- ③ punch guide
- ④ connection bushing
- ⑤ ring
- ⑥ ram
- ⑦ locking ring
- ⑧ spring
- ⑨ head plate
- ⑩ cylinder pin
- ⑪ spring plungers bushing
- ⑫ spring plungers Ø12
- ⑬ location pin
- ⑭ distance plate
- ⑮ cylinder screw
- ⑯ cylinder screw
- ⑰ cylinder pin
- ⑱ cylinder screw
- ⑲ cylinder screw
- ⑳ cylinder screw
- ㉑ spring guide
- ㉒ screw with spring-loaded ball
- ㉓ guide bolt
- ㉔ center screw
- ㉕ cap
- ㉖ pressure spring
- ㉗ spring plungers Ø4
- ㉘ cylinder screw
- ㉙ punch head
- ㉚ snap ring DIN 472
- ㉛ die adapter
- ㉜ screw

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OVERVIEW DRAWINGS



- I die adapter
- II screw

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FOR MACHINE TYPE PRIMA POWER - SHEET THICKNESS UP TO S = 6 MM

1. Disassembly of the guide assembly

Loosen central cylinder screw M16. Afterwards please put the head to the side.



2. Removing the punch inserts

The punch can be removed from the position which is deblocked by the port in the driving collar.

The remainder of the punches can be removed by rotating the driving collar.



3. Removing the stripper

Then the strippers can be removed to the side.

4. Assembly of the stripper

The stripper must be inserted from the side.



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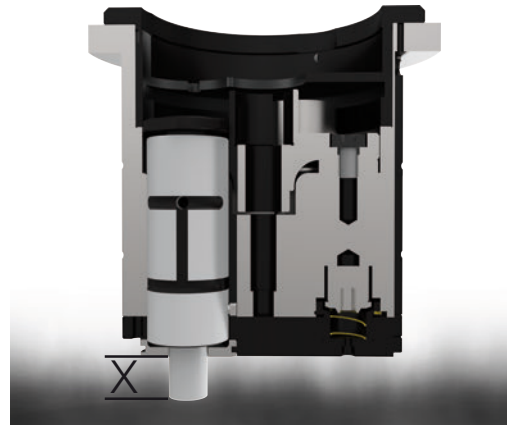
FOR MACHINE TYPE PRIMA POWER - SHEET THICKNESS UP TO S = 6 MM


5. Replacement of the punch

The punches can be assembled from above (x or y direction selectively). Collectively each punch can be checked towards the sufficient length of the cutting part "x".

6. Reassembly of the head unit

The screw should be torqued to 120 Nm when assembled.
Please use a torque wrench.

**7. Assembly of the turret**

Before assembly of the turret, please turn the head with the marking "home position" to position .

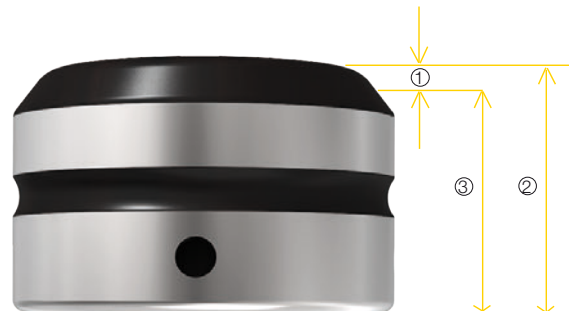
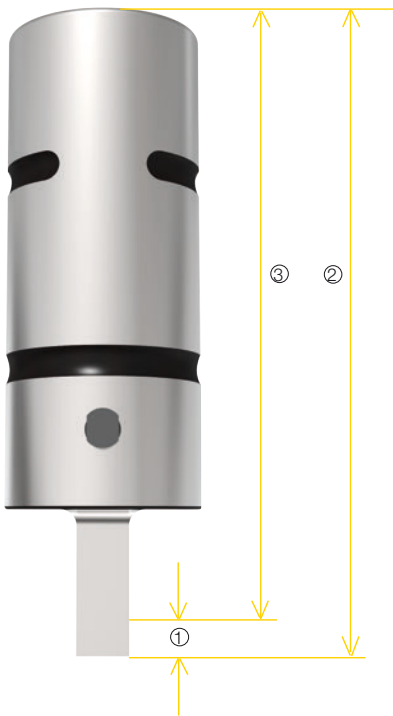


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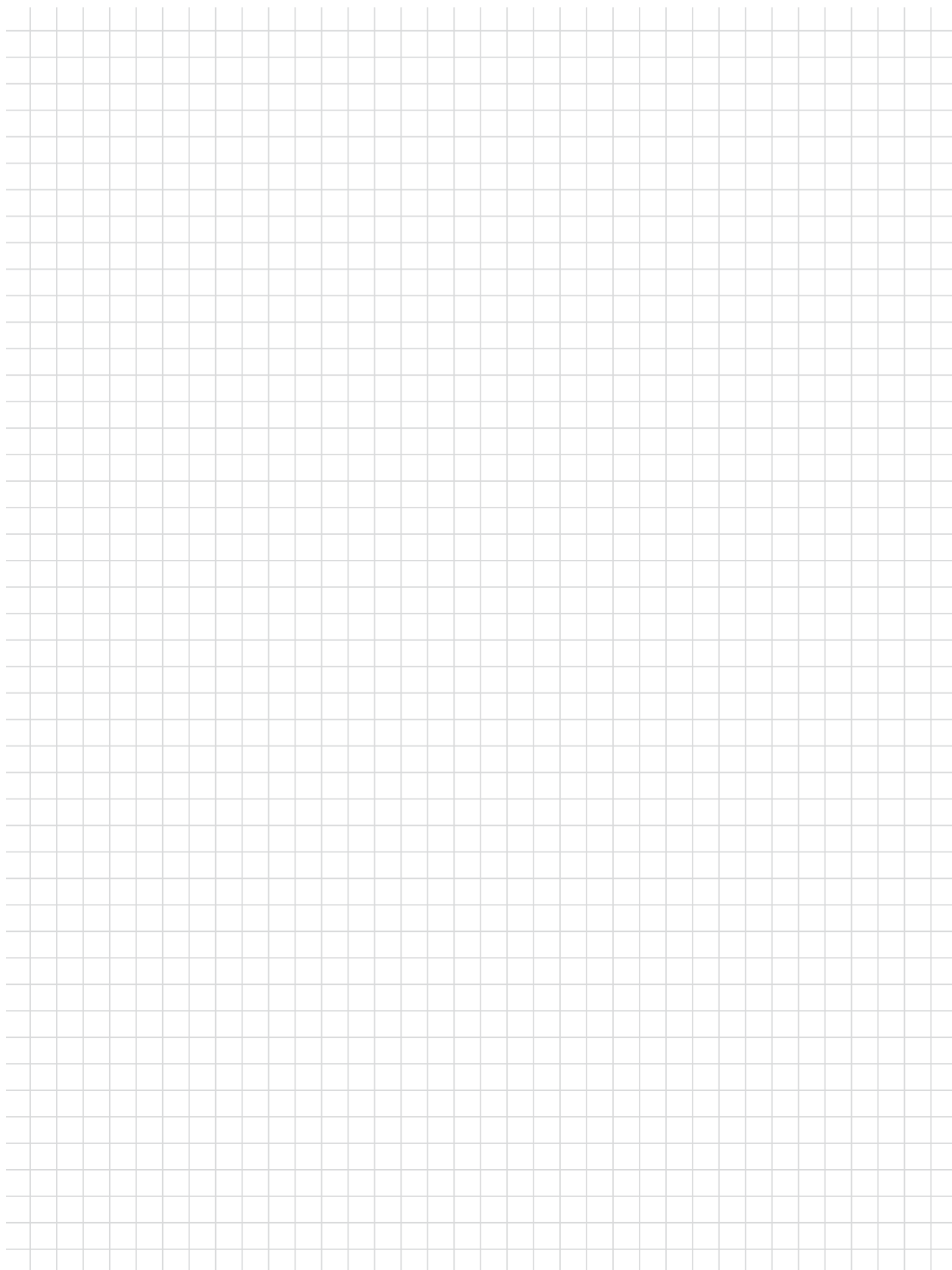
REGRINDING LENGTH

PUNCH		STAT. B
①	Regrinding length	10 mm
②	Complete length	100,5 mm
③	Minimal length	90,5 mm

DIE		STAT. B
①	Regrinding length	2,5 mm
②	Complete height	30,15 mm
③	Minimal height	27,65 mm



NOTES



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