



OPERATION MANUAL 09/2019-WW  
**ps:®MTP8Ri3-16**

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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. Assembling of the stripper

The stripper must be inserted from the side. The axis orientation will be fixed with click of the borehole into the spring ball.



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## 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 towards the „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 .



**SALVAGNINI** | **THICK TURRET** | **TRUMPF**



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