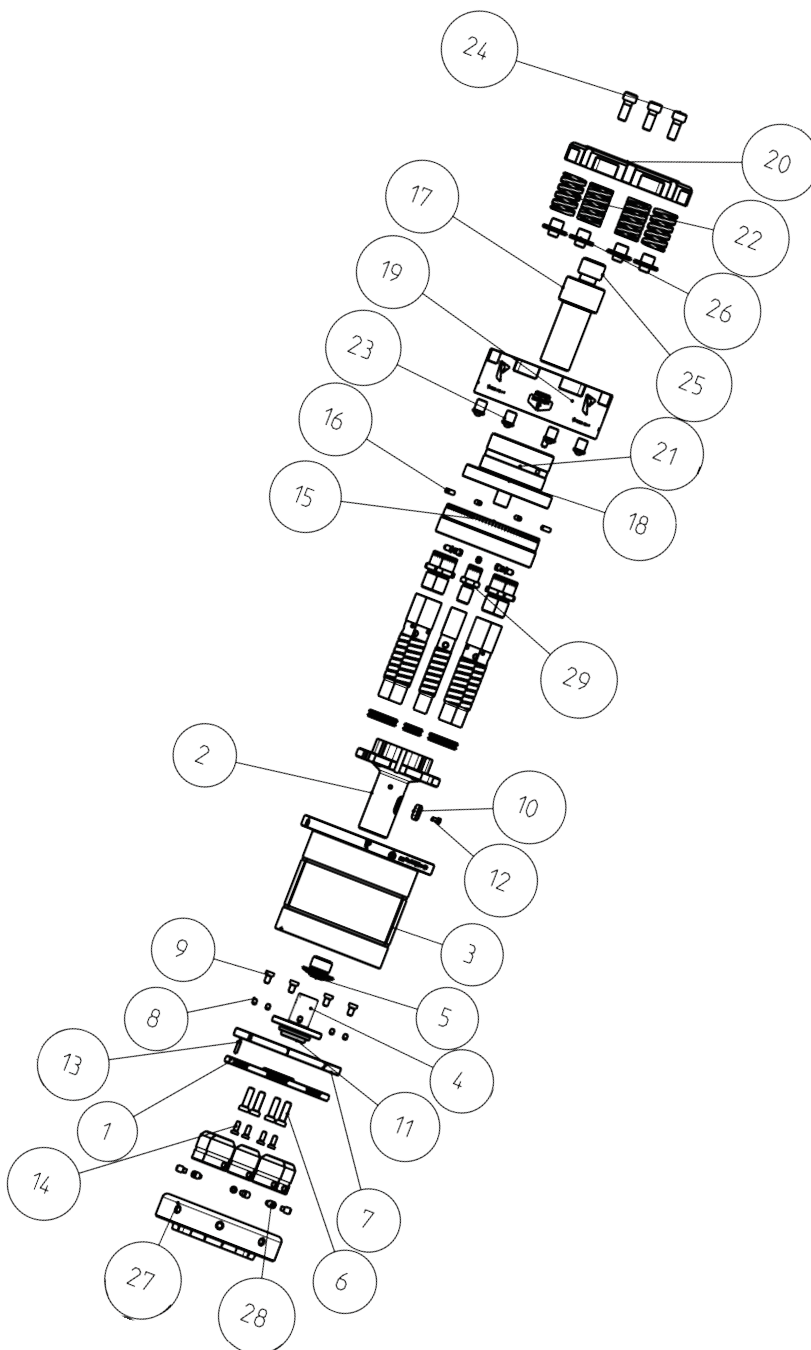




OPERATION MANUAL 10/2019-WW
ps:®MTP8RiA-12,7

ps:®MTP8RiA-12,7

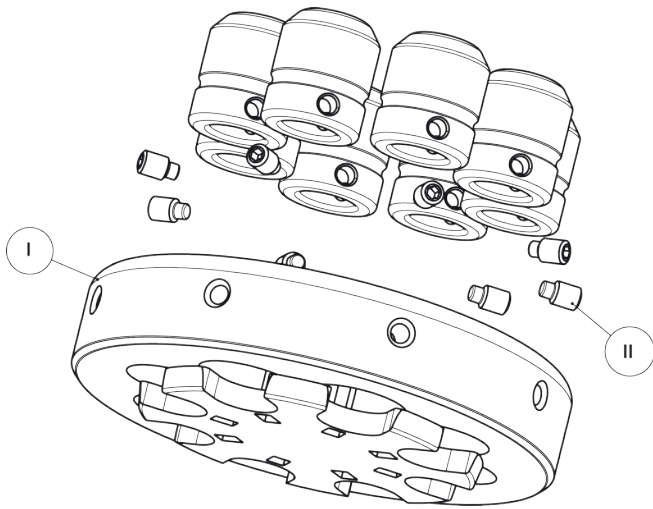
OVERVIEW DRAWINGS



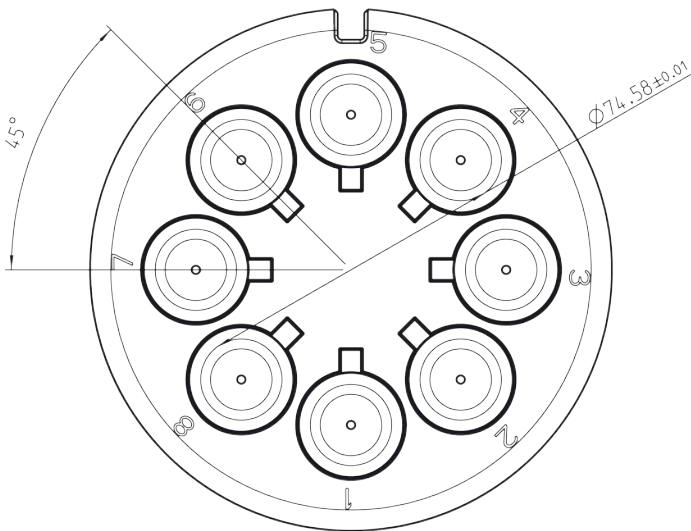
- ① stripper holder plate
- ② punch support plate
- ③ punch guide
- ④ pressure spring
- ⑤ center screw
- ⑥ cylinder screw
- ⑦ distance plate
- ⑧ spring plungers Ø4
- ⑨ cylinder screw
- ⑩ parallel key
- ⑪ cap
- ⑫ cylinder screw
- ⑬ cylinder pin
- ⑭ cylinder screw
- ⑮ ring
- ⑯ threadscrew
- ⑰ connection bushing
- ⑱ ram
- ⑲ locking ring
- ⑳ head plate
- ㉑ cylinder pin
- ㉒ spring
- ㉓ spring plungers Ø10
- ㉔ cylinder screw
- ㉕ cylinder screw
- ㉖ spring guide
- ㉗ die adapter
- ㉘ screw
- ㉙ punch head

ps:®MTP8RiA-12,7

OVERVIEW DRAWINGS



- (I) die adapter
- (II) screw



ps:®MTP8RiA-12,7

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

1. Disassembly of the guide assembly

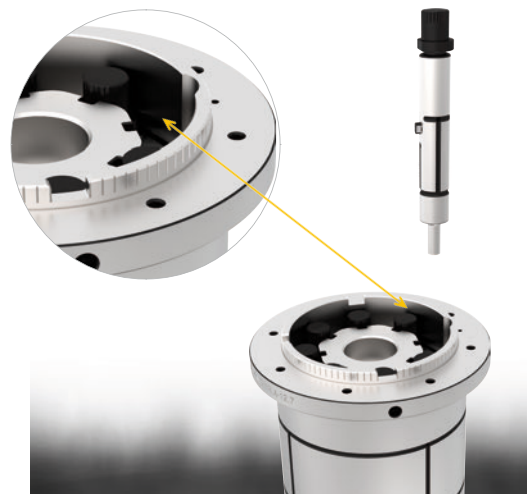
Loosen central cylinder screw M16. Afterwards please put the head to the side.



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.



ps:®MTP8RiA-12,7

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 .

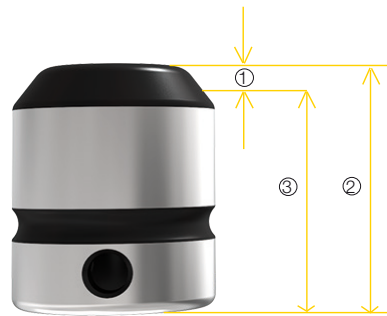
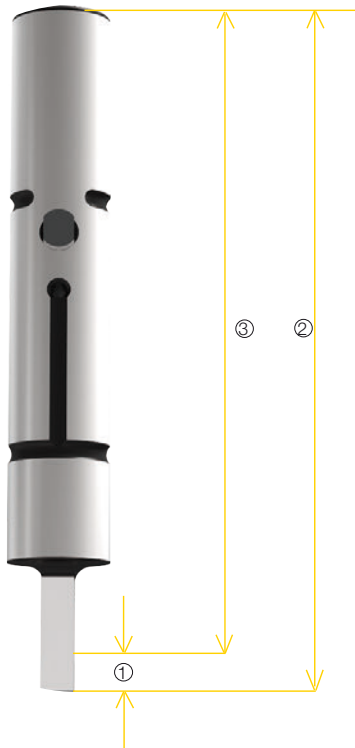


ps:®MTP8RiA-12,7

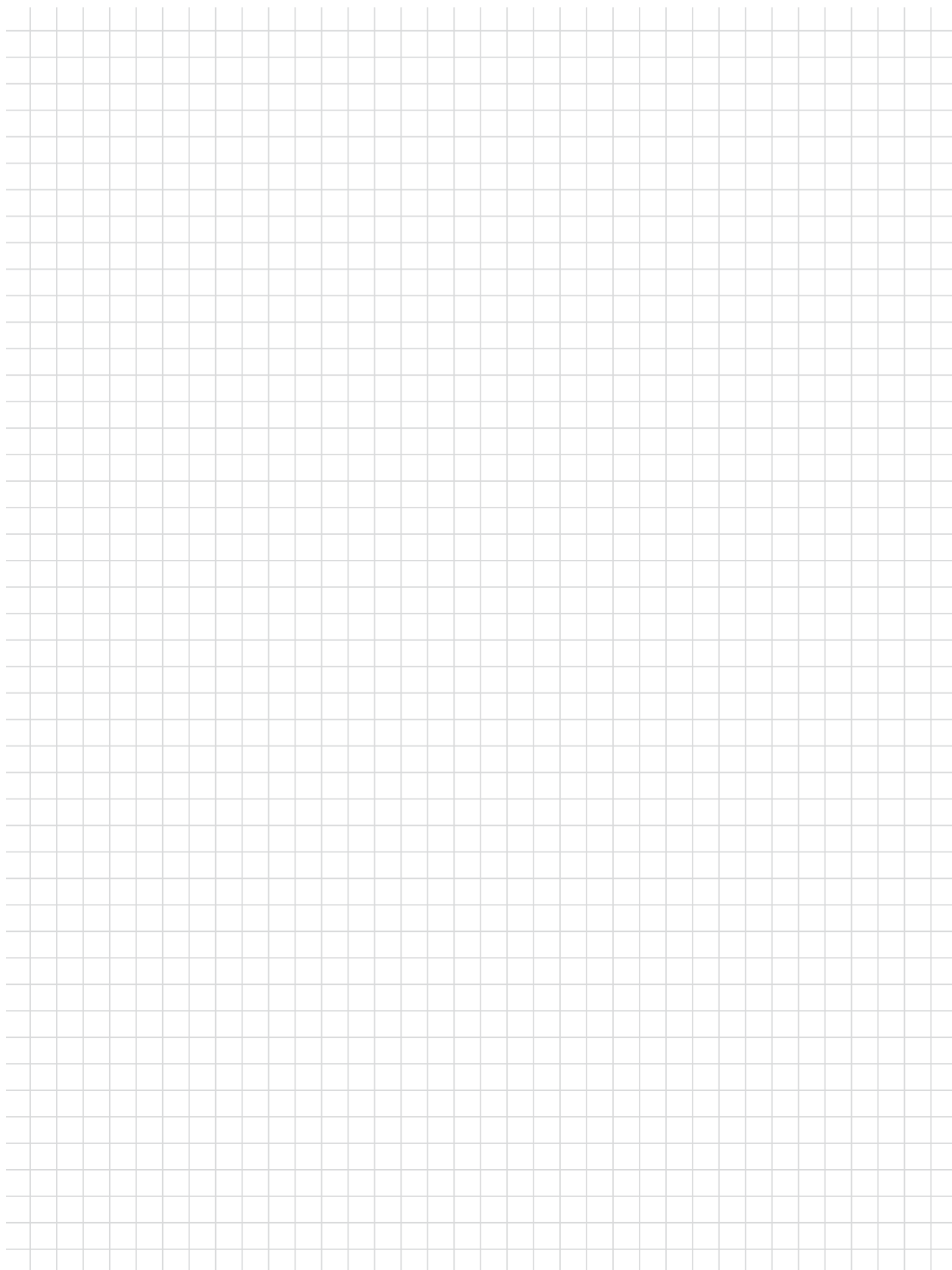
REGRINDING LENGTH

PUNCH		STAT. A
①	Regrinding length	10 mm
②	Complete length	107,8 mm
③	Minimal length	97,8 mm

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



NOTES



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



Am Steinkreuz 2
95473 Creußen | Germany

WEB: www.pass-ag.com
MAIL: info@pass-ag.com

FON: +49 (0) 92 70 / 9 85 - 0
FAX: +49 (0) 92 70 / 9 85 - 99