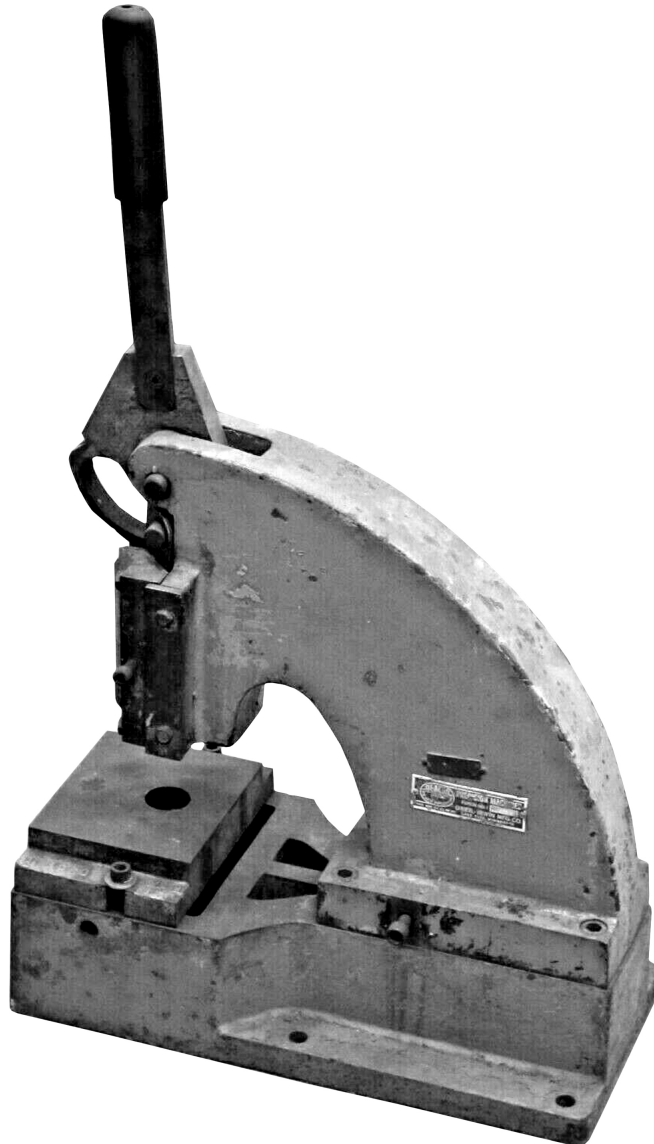


DiAcro[®]

HAND OPERATED NO. 1 PUNCH

OPERATING INSTRUCTIONS



DiAcro[®]
METAL FABRICATION EQUIPMENT

579 SCHOMMER DR - STE C
HUDSON, WI 54016
651.342.1756 (P)

DISCLAIMER

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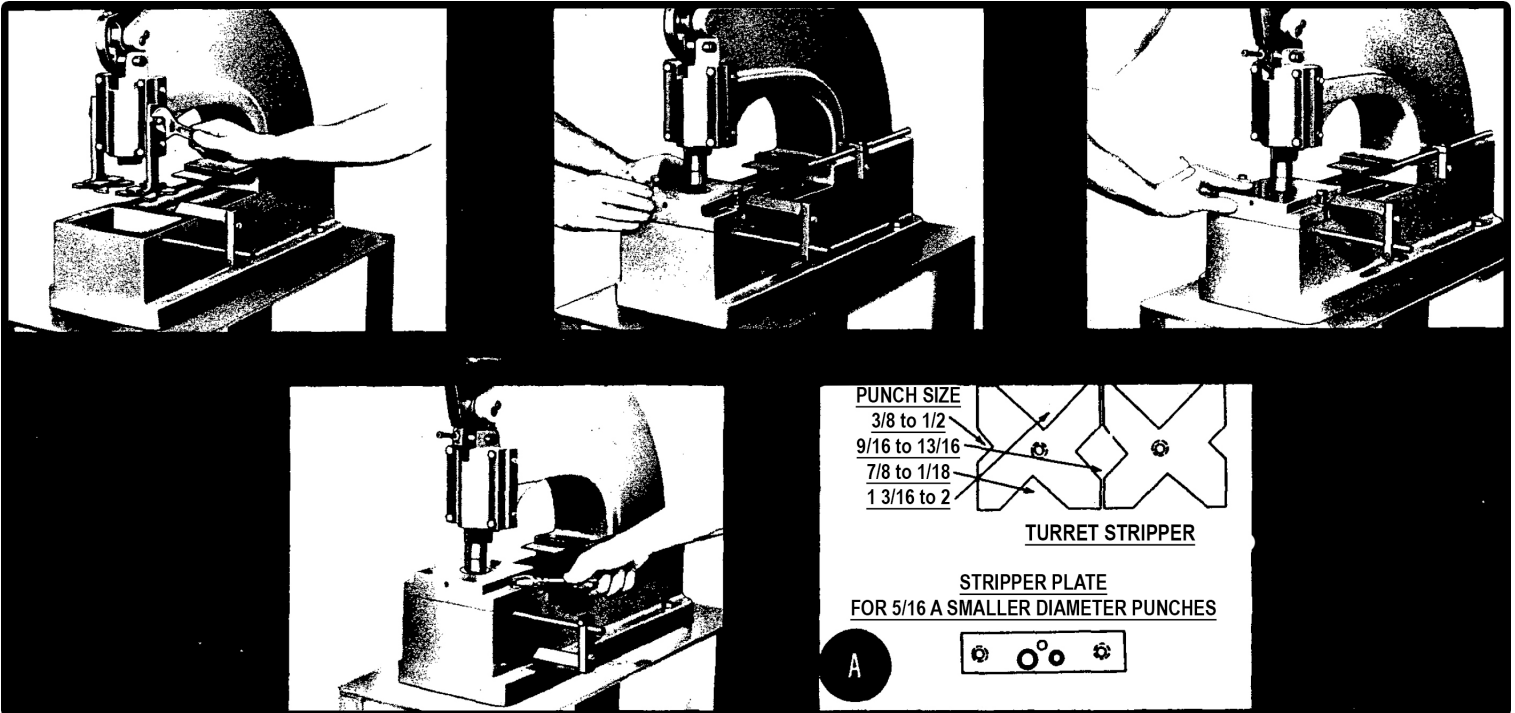
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MOUNTING PUNCHES AND DIES

When mounting Punches and Dies on the hand operated Di-Acro Punch Press, the following procedure is suggested.

1. Remove both right and left hand Stripper Arms from Ram Cap (photo 1).
2. Insert Punch in Punch Holder and tighten set screws.
3. Insert Die in Die Holder, tighten set screw and mount on Punch Press. Do not tighten bolts or, Die Holder.
4. Pull handle down until Punch enters Die to line up Punch in center of Die (photo 3). Tighten bolts in Die Holder (photo 4).
5. Test "lineup" of Punch and Die by inserting paper and punching by hand.
6. Select the notch in the Stripper V Plate (diagram A) that will provide the most support around Punch for stripping, and bolt to Stripper Arms, and mount on Ram Cap*. For punches 5/16" in diameter and smaller, a Stripper Plate with 3 holes is provided (diagram A). Special Stripper Plates for round, square, oval and rectangular Punches to 4" x 4" are available on quotation.



*Adjust Stripper Plate vertically as close to material as possible, yet leave enough clearance for easy insertion of the material. When Stripper Plate is set too high, material may become distorted.

CONSTRUCTION FEATURES

DI-ACRO PUNCH	NO. 1	NO.2	DI-ACRO PUNCH	NO. 1	NO.2
Depth of Throat	6 1/4"	12 1/4"	Stroke of Ram	5/8"	5/8"
Net Weight	170 lbs.	340 lbs.	Hole in Ram	1" Diameter	1" Diameter
Material Capacity - 4" Diameter hole in 16 Gauge sheet steel (.062") 1/4" hole in 3/16" steel plate.	Both Models		Dimensions of Bed	6" x 7 1/2"	6" x 7 1/2"
Rated Capacity	4 tons	4 tons	Slug-Waste Hole	4 1/4" x 5 3/4"	4 1/4" x 5 3/4"
Height of Throat	3"	3"	Punch Press Stand	95 lbs.	125 lbs.

Construction

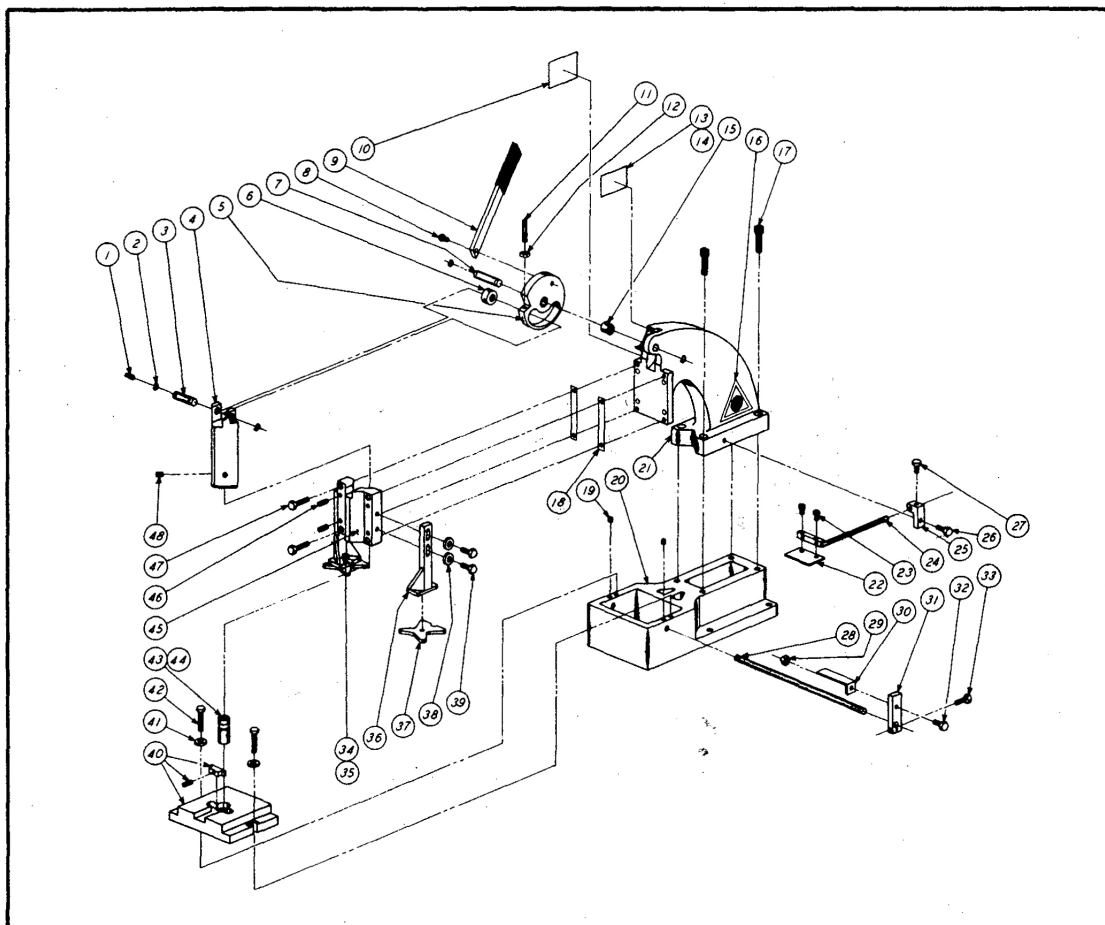
STRONG ALLOY CASTINGS and cold rolled steel parts provide maximum strength and rigidity. All parts subject to wear are properly hardened and precision ground.

TURRET STRIPPER can be rapidly positioned for stripping material from any size punch up to 2 inches.

ADJUSTABLE SIDE AND BACK GAUGES assure precision gauging for exact duplicating operations. The Gauges and Turret Stripper are supplied as standard equipment.

TRIANGULAR RAM, hardened and precision ground, positively controls the position of the Punch Head throughout the entire stroke assuring perfect alignment and accuracy.

EXPLODED ASSEMBLY HAND OPERATED PUNCH



050-8100800

Item No.	Part No.	Description	No. 1 Punch Qty	No. 2 Punch Qty
1	6901002	Drive Ftg. 3/16	1	1
2	4705101	Retaining Ring	4	4
3	060-1203003	Cam Roller Pin	1	1
4	040-1213008	Ram	1	1
5	030-1202004	Cam	1	1
6	156-1113005	Roller	1	1
7	030-1303020	Cam Pin	1	1
8	20B0516C0508	But Hd Cap Scr	1	1
9	030-1208006	Short Handle Arm	1	1
	030-1208007	Long Handle Arm	1	1

Item No.	Part No.	Description	No. 1 Punch Qty	No. 2 Punch Qty
10	030-6504001	Caution Plate	1	1
11	23C0516C2000	Sq Head Set Screw	1	1
12	31X0516C	Jam Nut	1	1
13	040-6501116	Nameplate	1	1
	050-6501115	Nameplate	1	0
14	29AXXX0X0108C	Drive Screw	2	2
15	3104101	Brg 5/8 x 13/16 x 3/4	1	1
16	068-6503003	Safety Sign	1	1
17	20A-0102C1304	Socket Head Cap Screw	4	4
18	030-5701017	Shim	2	2
	030-5701018	Shim	2	2
	030-5701019	Shim	1	1
	030-5701020	Shim	1	1
19	23A0308C0104	Socket Set Screw	2	2
20	040-1101001	Base	1	0
	050-1101001	Base	0	1
21	040-1102002	Upper Casting	1	0
	050-1102002	Upper Casting	0	1
22	040-1401017	Back Material Gauge	1	1
23	22BXX10C0102	Fill Head Machine Screw	2	2
24	040-1401018	Back Material Rod Assembly	1	0
	050-1401018	Back Material Rod Assembly	0	1
25	050-1401019	Back Material Clamp	0	1
26	21A0308C1000	Hex Head Cap Screw	1	1
27	21A0516C0304	Hex Head Cap Screw	1	1
28	040-1402025	Side Material Rod	1	1
29	30X0516F	Hex Nut	1	1
30	040-1402024	Side Material Gauge	1	1
31	040-1402026	Side Material Clamp	1	1
32	21A0516F0708	Hex Head Cap Screw	1	1
33	21A0516C1000	Hex Head Cap Screw	1	1
34	20A0104C0102	Socket Head Cap Screw	2	2
35	4901103	Flat Washer 1/4	4	4
36	040-1403020	Stripper Arm	2	2
37	040-1403023	Stripper Plate	2	2
38	4901107	Flat Washer 5/16	4	4
39	21A0516C1104	Hex Head Cap Screw	4	4
40	040-1502701	Die Holder Assembly A	1	1
	040-1502702	Die Holder Assembly B	1	1
	040-1502703	Die Holder Assembly C	1	1
	040-1502704	Die Holder Assembly D	1	1
	040-1502705	Die Holder Assembly E	1	1
41	4901101	Flat Washer 3/8	2	2
42	21A0308C1304	Hex Head Cap Screw	2	2
43	040-1501027	Punch Holder	1	1
44	23A0516C0104	Socket Set Screw	2	2
45	040-1108006	Cap	1	1
46	1203102	Spring Pin 5/16 x 1	4	4
47	21A0516C1304	Hex Head Cap Screw	4	4
48	23A0516C0308	Socket Set Screw	2	2
49	040-1403021	Stripper Plate SM (not shown)	1	1
50	20A0104C0508	Socket Head Cap Screw (not shown)	2	2