



Metal Hand Punch

Operating Manual



Please read through this manual carefully before using these products, and retain it for future reference. Protect yourself and others by observing all safety information, warnings, and cautions. Failure to comply with instructions could result in personal injury and/or damage to product or property.

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Key Features

1. Constructed with cast steel body for durable operation.
2. Perfect for auto body repair, aviation application and general shop use.
3. Punch round holes with clean cut.
4. Adjustable depth gauge guarantees accurate punch position.
5. Dies and punches are made of tool steel and hardened with heat treatment.
6. Mild steel, copper or brass, aluminum and plastic sheet is recommended working materials.
7. Handles with dipped rubber for comfortable grip.

Specifications

1. Max. pressure is about 1.2 ton.
2. Max. Throat Depth is 3-1/4" and Max. Jaw Opening is 5/8".
3. Includes 6 dies and punches in 1/8", 3/16", 1/4", 5/16", 3/8" and 7/16" respectively.
4. Overall dimensions are 10-1/4" long x 1-5/8" wide x 6-1/4" height.

Safety and Precautions

For reducing the risk of personal injury and damage to this tool, always pay an attention to general safety rules.

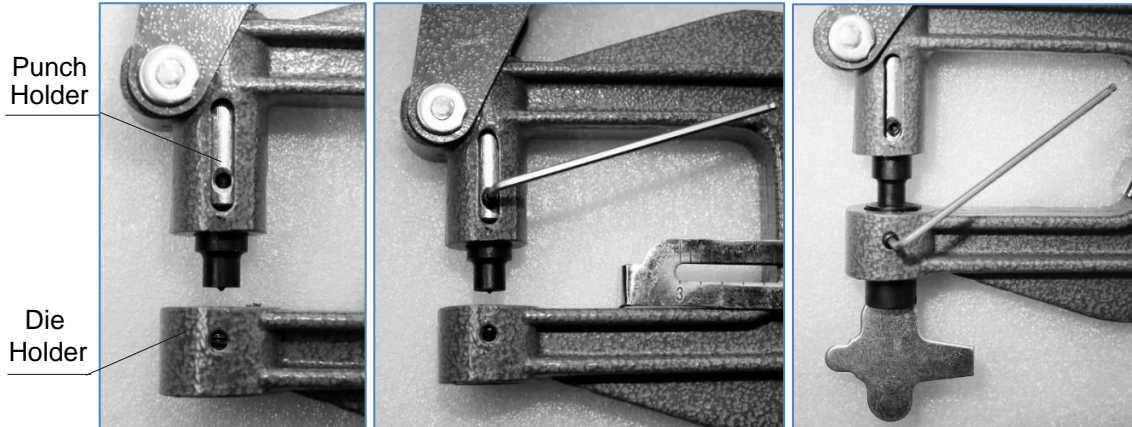
1. When using this tool, always wear ANSI approved eye protection and work gloves.
2. Check the tool before operation and do not use it if crack or defect is observed.
3. Do not try to reach fingers and hands into jaw opening area as well as all moving parts.
4. Never place hands between the Upper lever and the Body.

Operation

1. Check the thickness of the material to be punched. Do not exceed the recommended Max. thickness / gauge. Refer to the table below (for mild steel):

Punch/Die Size	Material Thickness	Punch/Die Size	Material Thickness
1/8"	Up to 16Gauge	5/16"	Up to 20Gauge
3/16"	Up to 18Gauge	3/8"	Up to 20Gauge
1/4"	Up to 18Gauge	7/16"	Up to 22Gauge

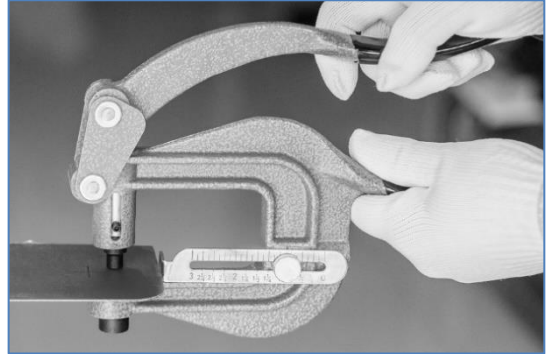
2. Choose designed size of the Punch (PN#05,07,09,11,13,15) and the Die (PN#06,08,10,12,14,16).
3. Insert the Punch into the Punch Holder through the Die Holder and secure the Punch with the Flat Set Screw (PN#18).
4. Screw the Die into the Die Holder with the Key (PN#04) and secure it with the Conical End Set Screw (PN#17).



5. Lift the Upper Handle up and then press it very slowly to check if the Punch and the Die is match to each other.
6. It is recommended that the material to be punched should be secured firmly and to operate the tool with both hands.

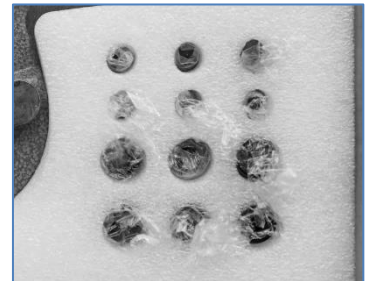


7. To mark the hole position with measurements before punching is a good idea.
8. Locate the Punch over the material and squeeze the Upper Handle downwards with one hand while other hand holds the Body (PN#01) steadily. This will drive the Punch into the Die through the material.
9. Lift the Upper Handle and move the tool away carefully.
10. If you prefer to make a hole at accurate distance from the edge, set the Gauge (PN#03) with the Adjusting Bolt (PN#02).
11. For changing the Die and the Punch, loose the Conical End Set Screw (PN#17) first and remove the Die with the Key (PN#04). Then loose the Flat Set Screw (PN#18) and remove the Punch through the Die Holder.

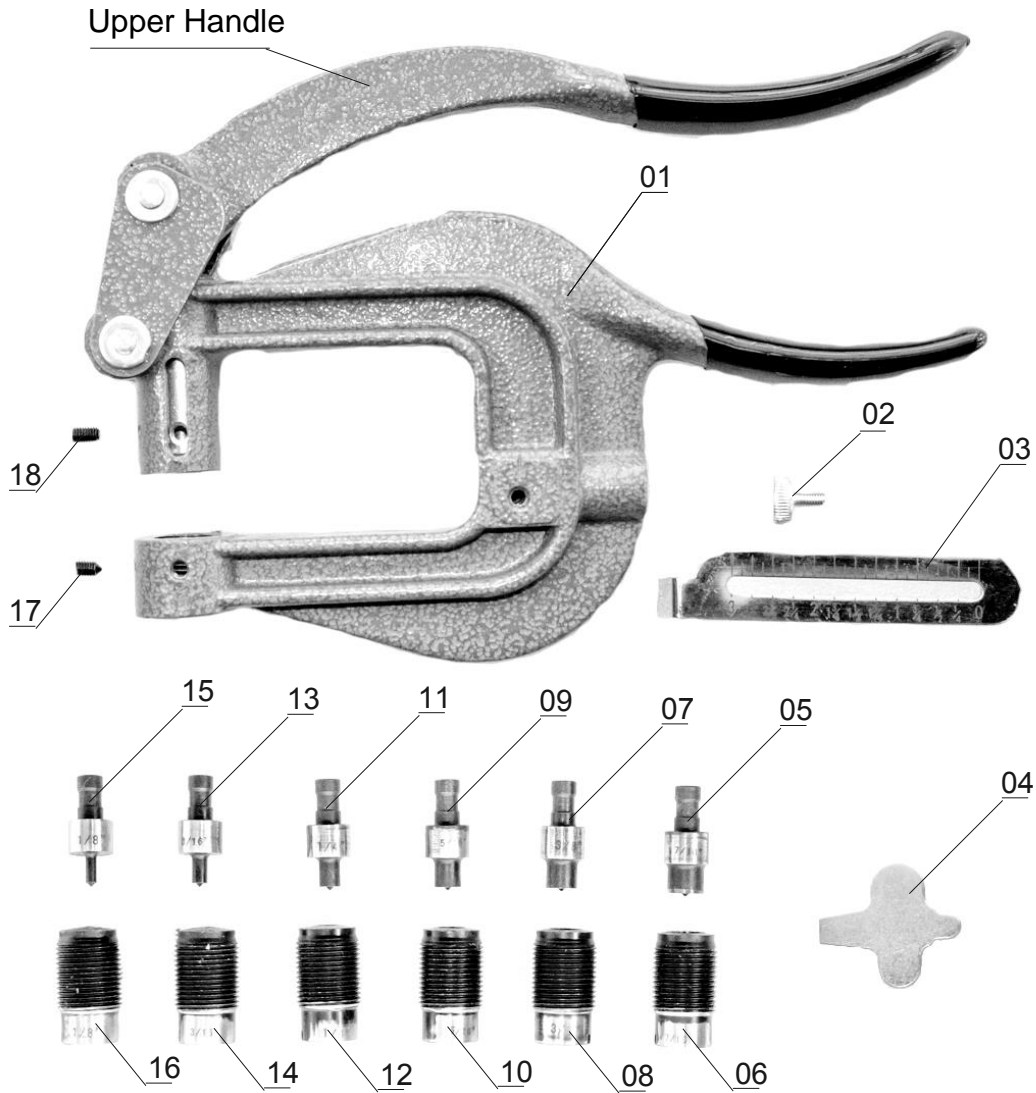


Maintenance

Store the tool in a clean and dry place to prevent rust occurs. Brush the Punches and Dies with a little of clean machine oil and then wrap with clear film for long term storage. Lubricate the Punch Holder and hinges with grease if necessary.



Assembly Diagram



Parts List					
No.	Description	Qty	No.	Description	Qty
1	Body	1	10	5/16" Die	1
2	Adjusting Bolt M5	1	11	1/4" Punch	1
3	Gauge	1	12	1/4" Die	1
4	Key	1	13	3/16" Punch	1
5	7/16" Punch	1	14	3/16" Die	1
6	7/16" Die	1	15	1/8" Punch	1
7	3/8" Punch	1	16	1/8" Die	1
8	3/8" Die	1	17	Conical End Set Screw M5x6	1
9	5/16" Punch	1	18	Flat End Set Screw M5x8	1