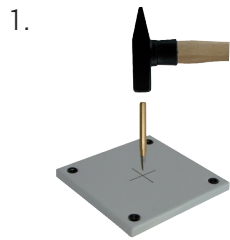
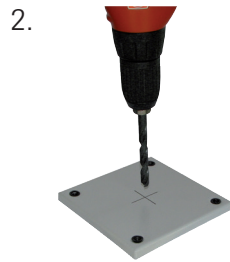


# Note – Working with Punching Pumps

## General instructions when working with hydraulic punching pumps



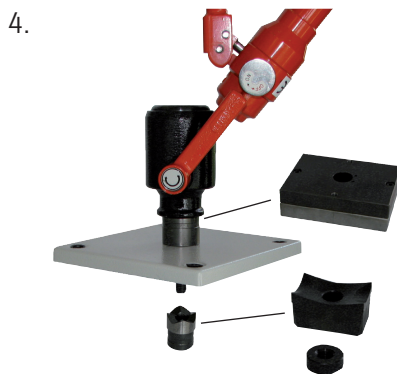
Make punch mark on cross mark.



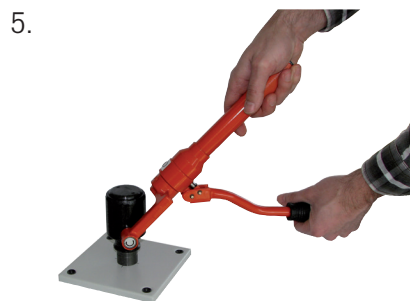
Pre-drill:  
 - for stud  $\varnothing$  9.5 mm (3/8") use  $\varnothing$  10.5 mm (0.41")  
 - for stud  $\varnothing$  11.1, mm use  $\varnothing$  12 mm (0.47")  
 - for stud  $\varnothing$  19 mm (3/4") use  $\varnothing$  20 mm (0.79")  
 - for stud  $\varnothing$  19 mm (3/4"), may also be pre-drilled with  $\varnothing$  20.4 mm (0.80").



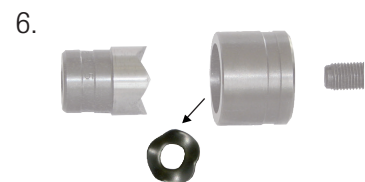
Fix the stud into the hydraulic cylinder and attach the die. Insert the stud through the pre-drilled hole.



For round punches: screw on the punch.  
 For square and shaped punches: attach the punch and screw on stud. Align with cross mark.



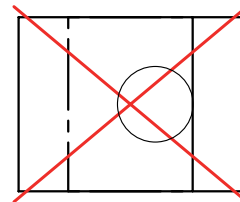
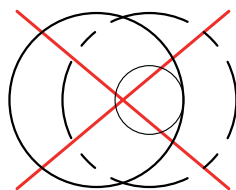
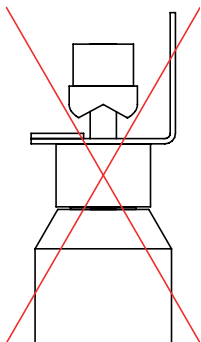
Close the return fitting on the device. Operate the pump until the material is completely punched (audible cracking). After the audible cracking apply 2-3 pump strokes until the scraps drop into the free die area.



Open the return fitting to release the pump. Punch returns spring-loaded. Remove punch, die and scraps.

### Important:

- Use only matching punch tools
- Always use cutting oil to extend the service lifetime (2684-0700-25-00)
- Always lubricate thread of wrench-operated draw studs
- Sharpen punching tools regularly
- Do not apply force!





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