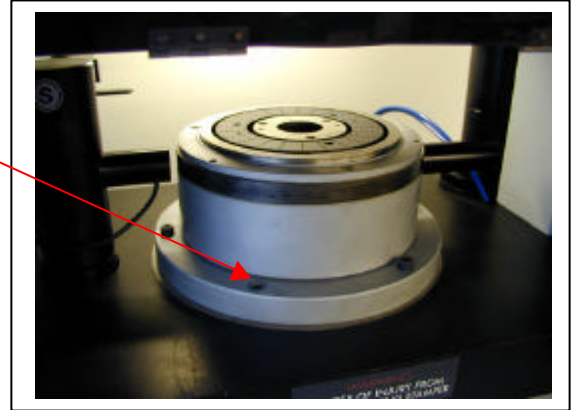


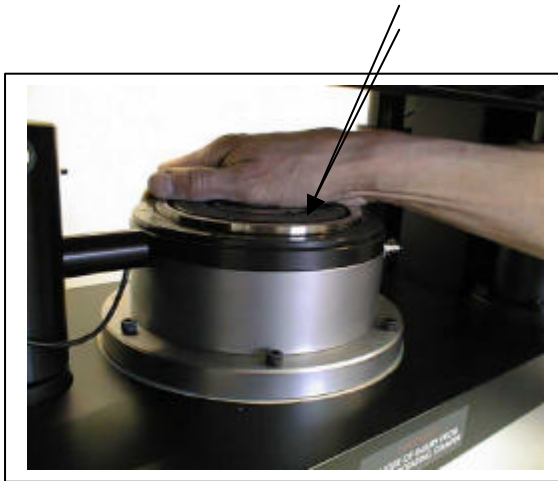
## PUNCH AND DIE REFITTING 1



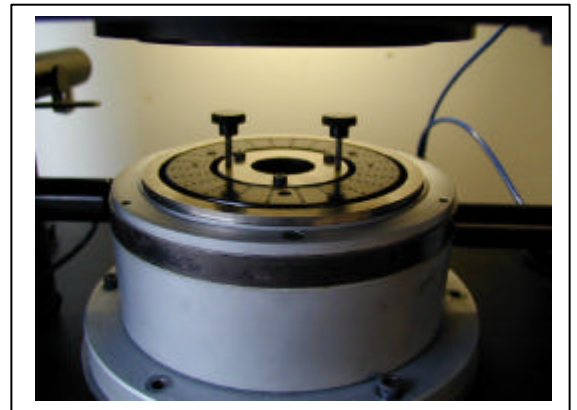
1. Bottom die ready to be fitted into comp machine.



2. Refit bottom die set into comp machine as shown above. Loosely fit 6 cap head screws around base, as shown by arrow.



3. Pull bottom die set towards front of machine as shown in the photo. This is to ensure correct clearance of drive gear.



4. Remove inner die set as shown in photo above.

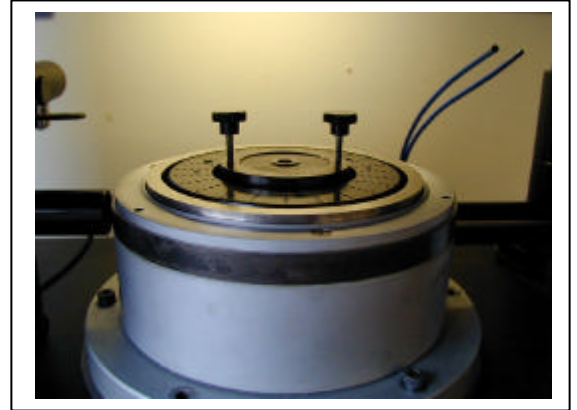


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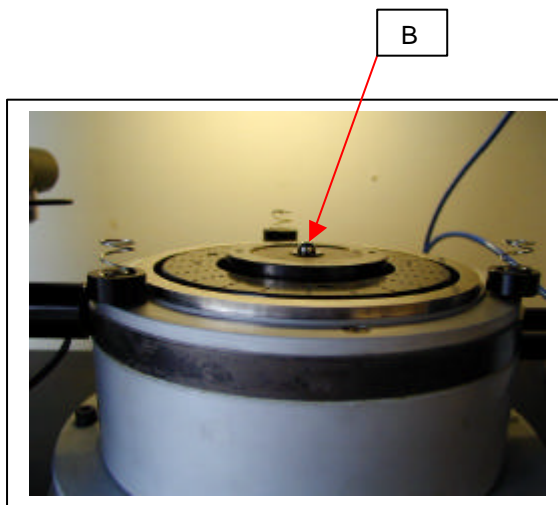
## PUNCH AND DIE REFITTING 2



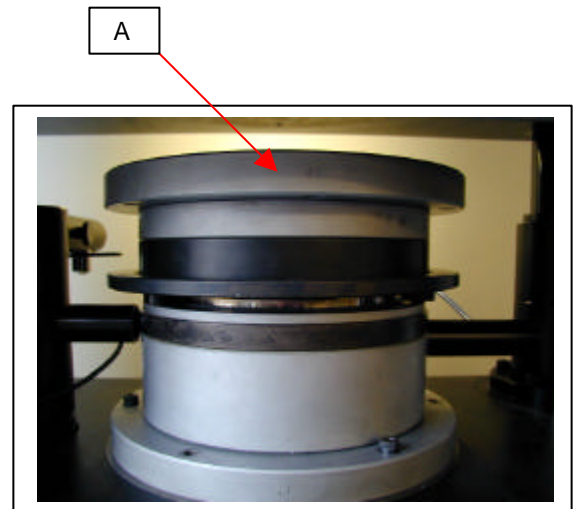
5. Fit die mount setting piece as shown in above photo into die set.



6. Bottom die set with die mount fitted and cap head screws tightened.



7. Fit Punch and die spacers 3 off to outside of die set as shown in photo above. Place 8mm harden ball in center. (B)

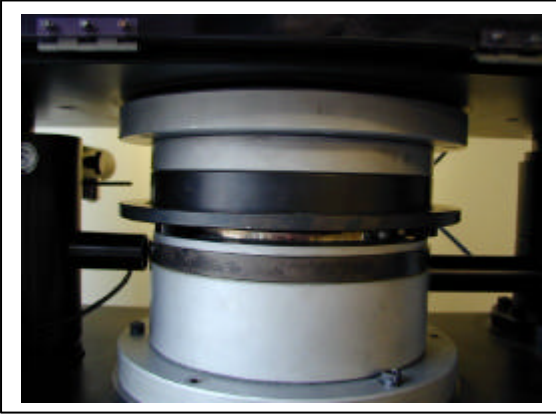


8. **Very carefully** rest the punch top half and clamp ring with serial number showing to the front (A) as shown above. Ensure punch and die has centred on the ball.

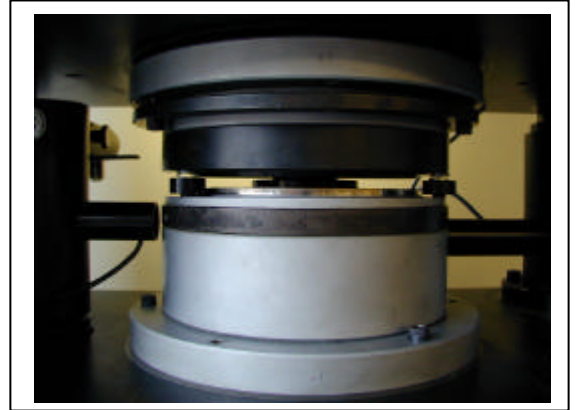


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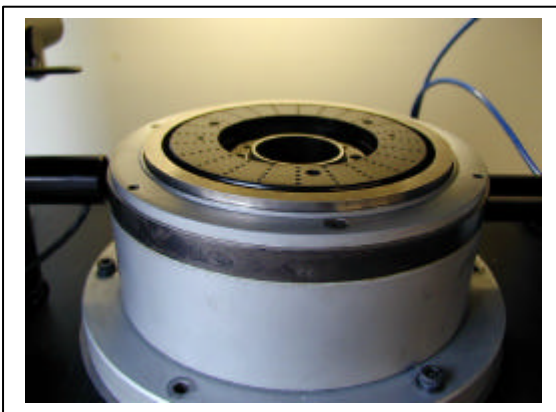
## PUNCH AND DIE REFITTING 3



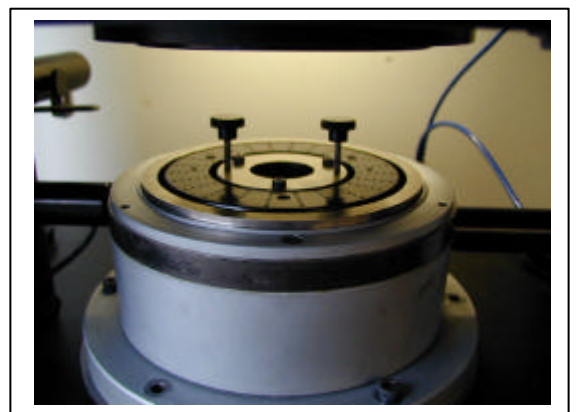
9. In manual mode lower top plate to just above plate, raise clamp ring and fit 6 off cap head screws loosely.



10. In manual mode lower top plate completely. Now tighten 6 screws completely.



11. In manual mode raise top plate and remove die mount setting piece. Refit inner die and refit air pipes.



12. In manual mode check cuttings parts pass over each other by lowering top punch over lower die. Check WARNING sheet before switching over in auto.