

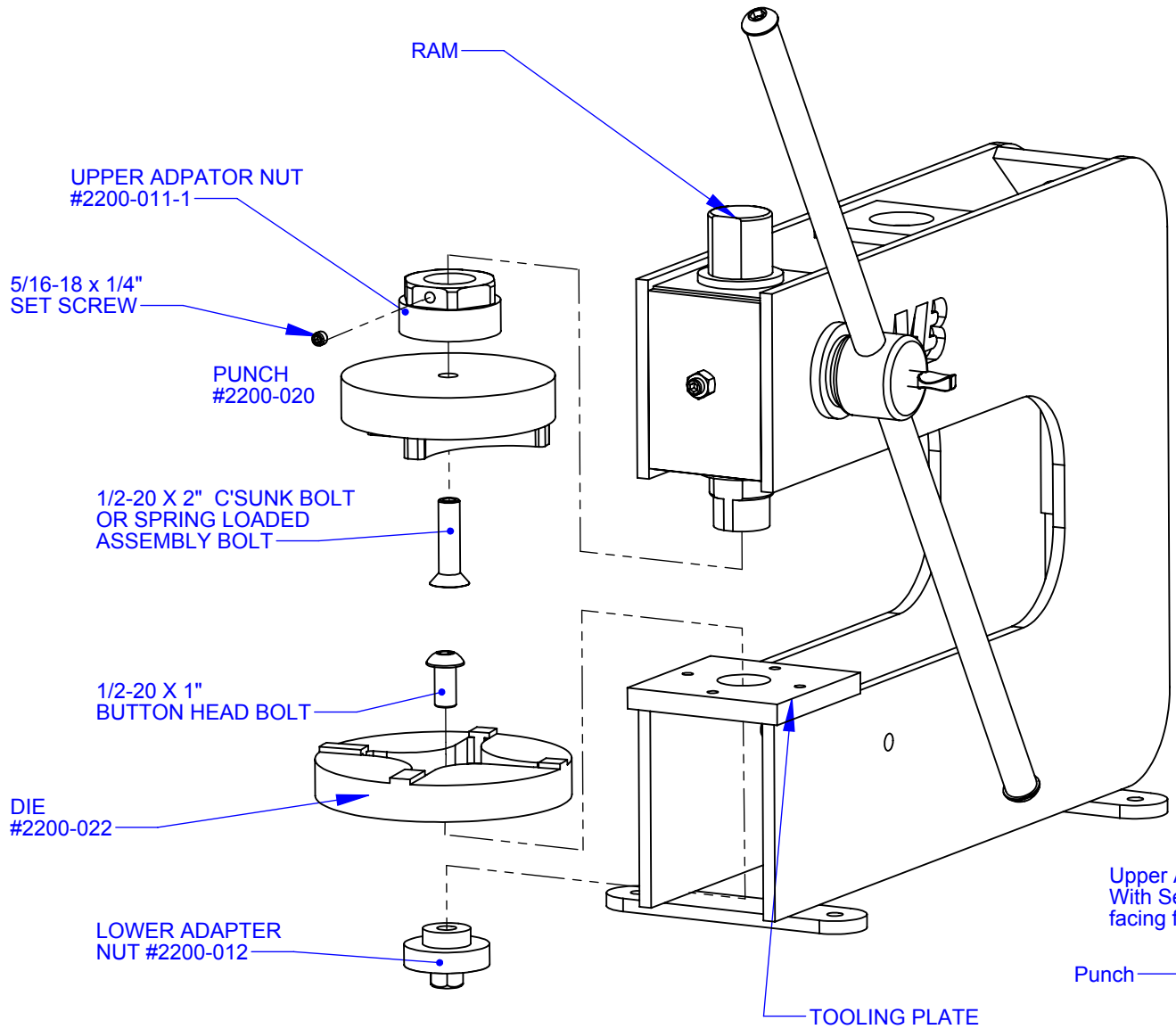
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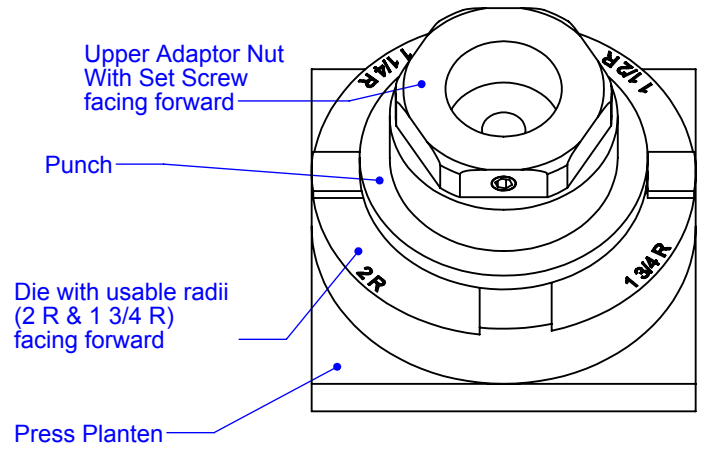
DRAWING 2200-020-A

Procedure for Aligning Radius Corner Punch

1. Install the Punch on the Upper Adaptor (#2200-011) using the 1/2" -20 x 2" flat head bolt
2. Install Upper Adaptor on threaded bung of ram
3. Align the set screw in Upper Adaptor with flat on Threaded Ram - with desired radius pointing forward.
4. Install Lower Adaptor (#2200-012) through hole in Press Lower Platen
5. Install 1/2" -20 x 1" button head bolt through die into Lower Adaptor.
6. Start Bolt approximately 2 threads only
7. Lower the Upper Punch & Ram Assembly until approximately 1/4" from die
8. Lift Die to align with Punch
9. Lower Punch & Die onto Lower Press Platen.
10. Tighten Lower Adaptor with 3/4" hex wrench.

Procedure for Rotating Punch & Die to Different Radius:

1. Lower Punch into Die.
2. Loosen setscrew on Upper Adaptor. Do not remove.
3. Loosen Lower Adaptor under press platen. Do not remove.
4. Rotate Punch & Die together until desired radius is forward.
5. Tighten setscrew in Upper Adaptor against the Ram flat surface.
6. Tighten the Lower Adaptor under the platen.



View of Punch Lowered into Die