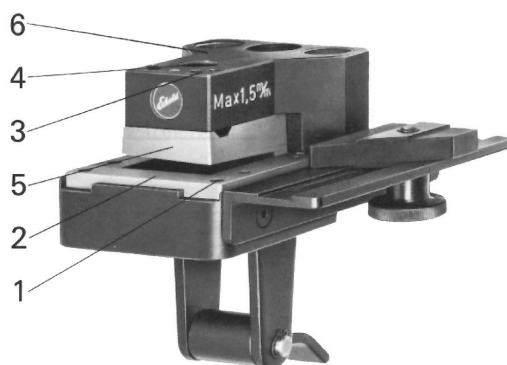


Anleitung zum Auswechseln und Einrichten des Messersatzes beim ECKOLD Ausschneidwerkzeug ASW 42

Instruction Chart for changing and adjusting of Die Plate and Knife on ECKOLD Notching Tool ASW 42

Instruction pour le changement et l'ajustage de couteau et plaque de découpage de l'outil à gruger ASW 42

Indicazioni per sostituire e regolare la matrice e la lama tranciatrice dell'utensile per tranciare ASW 42



A) Demontage

1. Werkzeug aus dem Handformer ausbauen
2. 6 Zylinderschrauben (1) herausdrehen.
3. Schneidplatte 3-teilig (2) abnehmen.
4. 4 Gewindestifte (3) 1 mm herausdrehen.
5. Zylinderschraube (4) herausdrehen.
6. Messer (5) abnehmen.

B) Montage

7. Neues Messer (5) einlegen und festhalten, so dass die Kanten 1 mm über dem Messerträger (6) herausragen.
8. Zylinderschraube (4) eindrehen, bis Messer leicht anliegt.
9. Neue Schneidplatte 3-teilig (2) einlegen.
10. 6 Zylinderschrauben (1) eindrehen und anziehen.
11. Werkzeug in Schraubstock spannen und zusammendrücken, bis das Messer (5) ganz in der Schneidplatte (2) liegt.
12. Messer (5) bis auf 0,1 mm Distanz an die vordere Schnittkante vorschieben.
13. Zylinderschraube (4) fest anziehen.
14. 4 Gewindestifte (3) leicht anziehen.
15. Werkzeug in den Handformer einbauen und beim 1. Schnitt überprüfen, ob das Werkzeug einwandfrei schneidet.

A) Dismantling

1. Take tool out of Handformer machine.
2. Remove the six cylindrical screws (1).
3. Take off all three parts of die plate (2).
4. Loosen the four threaded pins (3) by 1 mm.
5. Remove cylindrical screw (4).
6. Take off the knife (5).

B) Mounting

7. Insert new knife (5) into tool and hold it in a way that the edges jut out by 1 mm over edges of knife support (6).
8. Fasten cylindrical screw (4) a bit so that the knife is just touching the knife support (6).
9. Insert the three parts of the new die plate (2).
10. Screw in and tighten all six cylindrical screws (1).
11. Clamp tool into vice and press it together so that knife (5) is completely between die plate (2).
12. Push knife forward until a distance of 0.1 mm to front cutting edge of die plate has been reached.
13. Tighten cylindrical screw (4).
14. Tighten the four threaded pins (3) lightly.
15. Insert tool into Handformer machine and check correct operation of tool during first cut.

A) Démontage

1. Enlever l'outil du formeur à main.
2. Dévisser les 6 vis cylindriques (1).
3. Oter la plaque de découpage divisée en trois (2).
4. Dévisser les 4 goupilles filetées (3) de 1 mm env.
5. Dévisser la vis cylindrique (4).
6. Oter le couteau (5).

B) Montage

7. Mettre le couteau neuf (5) et fixer de façon que le bord dépasse le support-couteau (6) de 1 mm.
8. Poser la vis cylindrique (4) jusqu'à l'appui du couteau.
9. Mettre la nouvelle plaque de découpage divisée en trois (2).
10. Poser et serrer les 6 vis cylindriques (1).
11. Serrer l'outil dans l'étau et comprimer jusqu'à l'introduction complète du couteau (5) dans la plaque de découpage (2).
12. Avancer le couteau (5) jusqu'à 0,1 mm de distance de la ligne de coupe de devant.
13. Serrer fortement la vis cylindrique (4).
14. Serrer légèrement les 4 goupilles filetées (3).
15. Monter l'outil dans le formeur à main et contrôler la première coupe.

A) Smontaggio

1. Smontare l'utensile dalla sagomatrice a mano.
2. Svitare le 6 viti a testa cilindrica (1).
3. Togliere la matrice (3 pezzi) (2).
4. Svitare di circa 1 mm le 4 spine filettate (3).
5. Svitare la vite a testa cilindrica (4).
6. Togliere la lama tranciatrice (5).

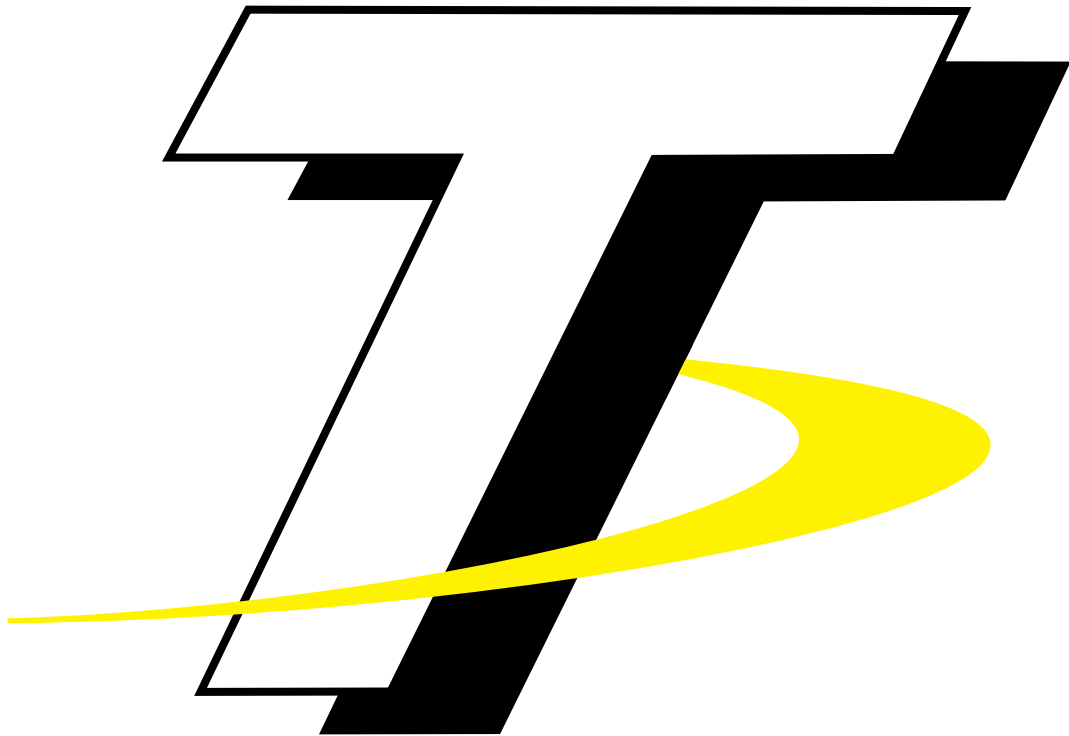
B) Montaggio

7. Inserire la nuova lama (5) lasciando che sporga di circa 1 mm dal portalama (6).
8. Avvitare la vite a testa cilindrica (4) fintanto che la lama riscontra leggermente il portalama.
9. Inserire la nuova matrice (3 pezzi) (2).
10. Avvitare la massimo le 6 viti a testa cilindrica (1).
11. Chiudere in una morsa l'utensile fintanto che la lama (5) entra nella matrice (2).
12. Posizionare il coltello ad una distanza di 0,1 mm dallo spigolo di taglio della matrice.
13. Avvitare al massimo la vite a testa cilindrica (4).
14. Avvitare leggermente le 4 spine filettate (3).
15. Montare l'utensile sulla sagomatrice e controllare al primo taglio il suo funzionamento.

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Trick-Tools
75 Truman Road
Pella, IA 50219

Phone: 1-877-VAN-SANT
E-mail: sales@trick-tools.com



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