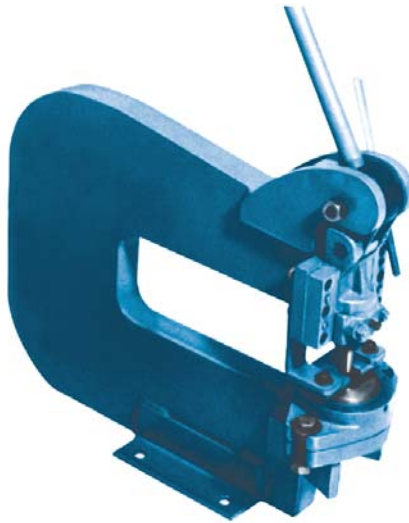


ROPER WHITNEY.



**MODELS NO. 118, NO. 218
DEEP THROAT HAND PUNCH**

OPERATION, PARTS & MAINTENANCE MANUAL

Model:	Purchased From:
Serial #:	Date Received:

USA  MADE



Trick-Tools.com

75 Truman Road

Pella, IA 50219

Phone: 1-877-VAN-SANT

E-mail: sales@trick-tools.com



FOREWORD

This manual has been prepared for the owner and operators of Roper Whitney No. 118 and No. 218 Deep Throat Hand Punch. Its purpose, aside from operations instructions, is to promote safety through the use of accepted operating procedures. Read all instructions thoroughly before operating the hand punch.

Also contained in this manual is the parts list for your hand punch. It is recommended that only Roper Whitney or factory authorized parts be used as replacements.



Warranty Statement:

3 YEAR LIMITED WARRANTY

Roper Whitney ("Manufacturer") warrants, commencing with the date of shipment to first end-user ("Customer") and for a period of thirty-six (36) months thereafter, all machinery and parts manufactured by Manufacturer to be free of defects in workmanship and material. **This warranty remains in force for the above time period only if all of Manufacturer's operational procedures are followed and recommended maintenance is performed.** If, within such warranty period, any machinery or parts manufactured by Manufacturer shall be proved to Manufacturer's satisfaction to be defective, such machinery or parts shall be repaired or replaced, at Manufacturer's option. All warranty claims are made F.O.B Manufacturer's plant, providing such machinery or parts are returned freight prepaid to Manufacturer's plant or designated service center for Manufacturer's inspection. All failed parts or components must be returned to Manufacturer prepaid for inspection before credit will be issued for new parts or components. Manufacturer's obligation hereunder shall be confined to such repair or replacement and does not include any charges, direct or indirect, for removing or replacing defective machinery or parts. No warranty shall apply to machinery, or parts or accessories, which have been furnished, repaired, or altered by others so as, in Manufacturer's judgment, to affect the same adversely or which shall have been subject to negligence, accident or improper care, installation, maintenance, storage, or other than normal use or service, during or after shipment. No warranty shall apply to the cost of repairs made or attempted outside of Manufacturer's plant or designated service center without Manufacturer's authorization. No warranty shall apply with respect to machinery or part not manufactured by Manufacturer, including but not limited to motors, accessories, electrical and hydraulic components, if such machinery or part is subject to warranty by the manufacturer of such machinery or part. No warranty claims by Customer will be honored with respect to any machinery or part from which the name and date plate has been removed or is otherwise no longer located or exhibited on such machinery or part. **THE FOREGOING WARRANTIES ARE IN LIEU OF ALL OTHER WARRANTIES EXPRESSED OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY AND IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE. MANUFACTURER SHALL NOT BE SUBJECT TO ANY OTHER OBLIGATIONS OR LIABILITIES WHATSOEVER WITH RESPECT TO MACHINERY, PARTS, ACCESSORIES, OR SERVICES MANUFACTURED OR FURNISHED BY IT OR ANY UNDERTAKINGS, ACTS, OR OMISSIONS RELATING THERETO. UNDER NO CIRCUMSTANCES SHALL MANUFACTURER BE LIABLE FOR ANY CONSEQUENTIAL OR OTHER DAMAGES, EXPENSES, LOSSES, OR DELAYS HOW SO EVER CAUSED.**

THERE ARE NO WARRANTIES THAT EXTEND BEYOND THE DESCRIPTION ON THE FACE HEREOF.

Note: Consumable tooling is not covered under the 3 year manufacturer's warranty.

RETURN OF THE PRODUCT REGISTRATION CARD FURNISHED WITH THE PRODUCT IS NECESSARY TO OBTAIN WARRANTY COVERAGE THEREON. CARD MUST BE FULLY COMPLETED, SIGNED BY THE PURCHASER, AND IF APPLICABLE, SIGNED BY THE DISTRIBUTOR. RETURN REGISTRATION CARD TO:

SAFETY INSTRUCTIONS

FOR MAXIMUM OPERATOR SAFETY DO:

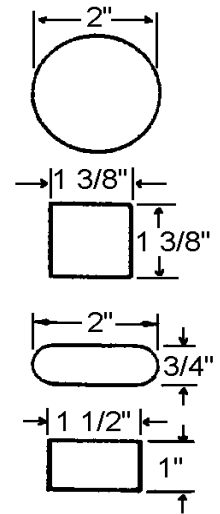
1. Read and understand this manual.
2. Use only punches and dies marked with a **W** or **R-W** designed for this tool.
3. Be sure you punch within the four ton capacity of this tool. Type and thickness of material versus final hole size will give you this tonnage.
4. Wear safety glasses.

FOR MAXIMUM OPERATOR SAFETY DO NOT:

1. Use punches and dies that are chipped or dulled.
2. Punch over capacity of the tool.
3. Nibble. Punch a full hole not a half hole as punch may contact die.

SPECIFICATIONS

	118*	218
Depth of Throat	7"	12"
Die Space, Punch in Highest Position	3/4"	3/4"
Height of Throat, with Work Table	2 3/4"	2 3/4"
Height of Throat, without Work Table	4 1/2"	4 1/2"
Length of Stroke	3/4"	3/4"
Slug Hole Clearance	2 1/4"	2 1/4"
Diameter of Punch Shank Hole in Ram	1"	1"
Floor Space Required (Floor Model)	23" W x 14" D x 37"H	
Weight, Bench Model	103 lbs.	134 lbs.
Weight, Floor Model	200 lbs.	231 lbs.
Weight, Work Table	7 lbs.	7 lbs.
* No. 118 is obsolete but parts are common with the No. 218.		

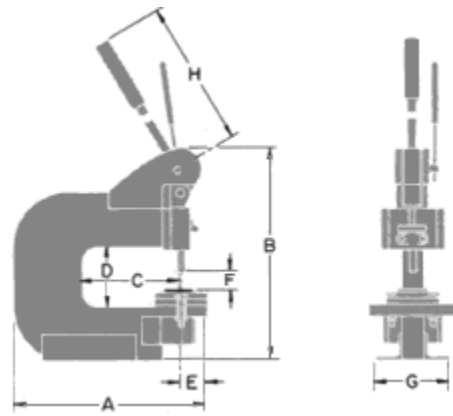


Largest punches and dies deepthroat hand punch will accommodate

Standard equipment includes: one L8 Punch Holder, one No. 20 Die Adaptor, one No. 40 Die Adaptor, one 118 - 2 3/4" Die Shoe, Stripper Arms, one A Stripper Plate, Standard 1/2" Round Punch and Die. No substitutions on standard equipment.

DIMENSIONS

Reference	No. 218	
	IN.	MM
A	21 1/2	546.1
B	17 5/8	447.68
C	12 1/4	311.15
D	4 1/2	114.3
E	2 1/16	52.39
F	3/4	19.05
G	5	127
H	24	609.6



INSTRUCTIONS

CARE: Oil ram slide, cam and punch point occasionally.

OPERATION: To change dies loosen two die shoe bolts and remove die shoe. Loosen die shoe set screw and push upward on die or die adaptor. If using No. 28 2-3/4 style die insert desired size of die in die shoe and tighten die shoe set screw. If 20 or 40 style dies are used, insert die into die adaptor, tighten die adaptor set screw, place in die shoe and tighten die shoe set screw.

Lower punch into die, check clearance and tighten die shoe bolts.

To change punches with die shoe removed, loosen punch retainer set screw and both punch retainer nuts. Remove punch or L8 punch holder. (No. 28 punches insert directly into ram and No. 8 style punches are inserted in L8 punch holder and then into ram.) When inserting punch or punch holder into ram be sure flat on shank is facing front of ram. Tighten punch retainer nuts and set screw.

Install proper stripper plate for punch size being used. Place a flat object (1/4" bar stock) on die and slide stripper plate down until it rests on the bar. Tighten stripper arm bolts and remove bar.

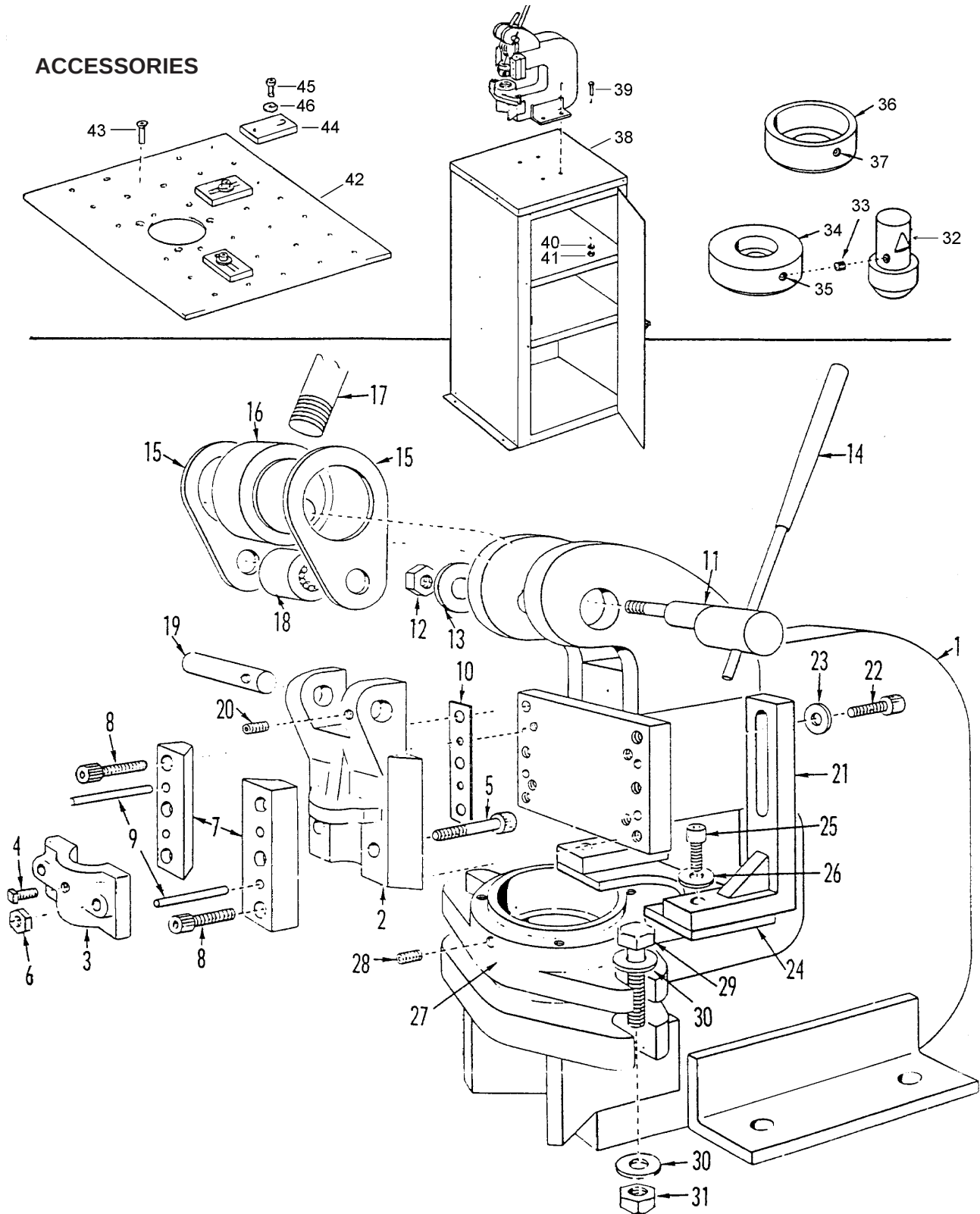
Punches should not enter die more than 1/16". To adjust loosen eccentric pin nut, adjust ram up or down with eccentric pin handle and tighten eccentric pin nut when desired adjustment is attained.

Two gib shims are between each gib and the frame face plate. Remove one or both shims on each side of ram to compensate for wear.

If necessary to replace the roller bearing place bearing with mounting plug in proper position. Drive the roller bearing pin through the frame and bearing forcing the mounting plug out of bearing and discard. Tighten roller bearing pin set screw.

NOS. 118, 218 PARTS LIST

ACCESSORIES



NOS. 118, 218 PARTS LIST

ITEM NO.	PART NO.	PART NAME	NO. REQ.	OLD PART NO.
1	731140019	Frame for No. 118 (7" Depth Throat)	1	118-1
1	731140018	Frame for No. 218 (12" Depth Throat)	1	218-1
2	231940005	Ram with Punch Retainer	1	118-2
3	731600057	Punch Retainer	1	118-2-1R
4	633012131	Punch Retainer Set Screw (5/16-18 x 3/4)	1	WS 615
5	731650275	Punch Retainer Screw	2	118-17
6	600023026	Punch Retainer Nut (Acorn 5/16-18)	2	
7	731400020	Gibs	2	118-4
8	611012133	Gib Bolt (SHC 5/16-18 x 1)	6	WS 525
9	600043253	Gib Taper Pin (#5 x 1 1/4)	4	WS 1492
10	731720027	Gib Shims	4	118-18
11	731160022	Eccentric Pin	1	118-6
12	643023007	Eccentric Pin Nut (Hex Full 1/2-13)	1	WS 1356
13	679033107	Lock Washer (1/2)	1	WS 1731
14	731000281	Eccentric Pin Handle	1	
15	731240023	Side Links	2	118-7
16	731210021	Cam	1	118-5
17	731460024	Operating Handle	1	118-8
18	240940006	Roller Bearing	1	100-17
19	731160025	Roller Bearing Pin	1	118-13
20	600325905	Roller Bearing Pin Set Screw (1/4-20 x 1/2)	1	WS 700
21	231940004	Stripper Arms (per set)	1	118-9
22	611012133	Stripper Arm Bolts (SHC 5/16-18 x 1")	4	WS 525
23	678033104	Stripper Arm Bolt Washer (Flat 5/16)	4	WS 1703
24	331200500	A6 Stripper Plate (Punch Size to 1/2")	1	118-14
24	331201000	B6 Stripper Plate (Punch Size to 1")	1	118-10
24	331202000	C6 Stripper Plate (Punch Size to 2")	1	118-15
25	611012131	Stripper Plate Bolt (SHC 5/16-18 x 3/4)	2	WS 524
26	678033104	Stripper Plate Washer (Flat 5/16)	2	WS 1703
27	139571180	Die Shoe	1	118-3
28	600325907	Die Shoe Set Screw (5/16-18 x 3/4)	1	WS 715
29	601012280	Die Shoe Bolt (HHC 1/2-13 x 2 1/4)	2	WS 68
30	678033107	Die Shoe Washer (Flat 1/2)	4	WS 1706
31	643023007	Die Shoe Bolt Nut (Hex Full 1/2-13)	2	WS 1356
32	136112808	L8 Punch Holder	1	118-20
33	621012124	Punch Holder Set Screw (5/16-18 x 1/4)	1	

Parts list continued on page 7

NOS. 118, 218 PARTS LIST

ITEM NO.	PART NO.	PART NAME	NO. REQ.	OLD PART NO.
34	136313020	No. 20 Die Adaptor	1	28-127
35	600325907	No. 20 Die Adaptor Set Screw (5/16-18 X 3/4)	1	WS 715
36	136323040	No. 40 Die Adaptor	1	28-126
37	600325904	No. 40 Die Adapter Set Screw (5/16-18 x 5/16)	1	WS 794
38	139001180	Stand	1	118-12
39	601012225	Punch Mounting Bolt (7/16-14 x 1 1/4)	4	WS 49
40	679033106	Punch Mounting Bolt Washer (Lock 7/16)	4	WS 1730
41	643023006	Punch Mounting Bolt Nut (Hex Full 7/16-14)	4	WS 1355
42	137001180	Work Table Complete	1	118-11
43	613012086	Work Table Mtg. Screw (SHF 1/4-20 x 1/2)	3	WS 2518
44	774420101	Work Table Gauges	3	241-5
45	611012084	Work Table Gauge Bolt (SHC 1/4-20 x 3/8)	3	
46	678033103	Work Table Gauge Washer (Flat 1/4)	3	WS 1714

AVAILABLE TOOLING

LARGE PRESS TOOLING

Punches and Dies for 127, 129, 130, 150, 230, 231 and 331.
& 134 Power Presses

Kick & Lever Presses No. 15, 811, 118, 218, 32, 34, 29, 58, 68

TYPE O ROUND PUNCHES AND DIES

Standard Sizes

Fractional, Drill or Millimeter	Decimal Equiv.	Punch Part Number	Die Part Number	Set Part Number	Dealer Code
1/16	.063	300270063	310210063	200270063	T-7
5/64	.078	300270078	310210078	200270078	T-7
3/32-42 DS	.094	300270094	310210094	200270094	T-7
40 DS-2.5MM	.098	300270098	310210098	200270098	T-7
7/64	.109	300270109	310210109	200270109	T-7
1/8	.125	300270125	310210125	200270125	T-7
30 DS	.129	300170129	310210129	200270129	T-7
29 DS	.136	300270136	310210136	200270136	T-7
9/64-28 DS	.141	300270141	310210141	200270141	T-7
5/32	.156	300270156	310210156	200270156	T-7
11/64	.172	300270172	310210172	200270172	T-7
3/16	.188	300270188	310210188	200270188	T-7
10 DS	.194	300270194	310210194	200270194	T-7
13/64	.203	300270203	310210203	200270203	T-7
7/32	.219	300270219	310210219	200270219	T-7
15/64-A DS	.234	300270234	310210234	200270234	T-7
1/4-E DS	.250	300270250	310210250	200270250	T-7
17/64-H DS	.266	300270266	310210266	200270266	T-7
9/32-K DS	.281	300270281	310210281	200270281	T-7
19/64	.297	300270297	310210297	200270297	T-7
5/16	.313	300270313	310210313	200270313	T-7
21/64	.328	300270328	310210328	200270328	T-7
11/32	.344	300270344	310210344	200270344	T-7
23/64	.359	300270359	310210359	200270359	T-7
3/8	.375	300270375	310210375	200270375	T-7
25/64	.391	300270391	310210391	200270391	T-7
13/32	.406	300270406	310210406	200270406	T-7
27/64	.422	300270422	310210422	200270422	T-7
7/16	.438	300270438	310210438	200270438	T-7
29/64-11.5MM	.453	300270453	310210453	200270453	T-7
15/32	.469	300270469	310210469	200270469	T-7
31/64	.484	300270484	310210484	200270484	T-7
1/2	.500	300270500	310210500	200270500	T-7
33/64	.516	300280516	310210516	200280516	T-7
17/32-13.5MM	.531	300280531	310210531	200280531	T-7

AVAILABLE TOOLING

LARGE PRESS TOOLING

Punches and Dies for 127, 129, 130, 150, 230, 231 and 331.

& 134 Power Presses

Kick & Lever Presses No. 15, 811, 118, 218, 32, 34, 29, 58, 68

TYPE O ROUND PUNCHES AND DIES

Standard Sizes

Fractional, Drill or Millimeter	Decimal Equiv.	Punch Part Number	Die Part Number	Set Part Number	Dealer Code
35/64	.547	300280547	310210547	200280547	T-7
9/16	.563	300280563	310210563	200280563	T-7
37/64	.578	300280578	310210578	200280578	T-7
19/32	.594	300280594	310210594	200280594	T-7
39/64	.609	300280609	310210609	200280609	T-7
5/8	.625	300280625	310210625	200280625	T-7
41/64	.641	300280641	310210641	200280641	T-7
21/32	.656	300280656	310210656	200280656	T-7
43/64	.672	300280672	310210672	200280672	T-7
11/16	.688	300200688	310210688	200280688	T-7
45/64	.703	300280703	310210703	200280703	T-7
23/32	.719	300280719	310210719	200280719	T-7
47/64	.734	300280734	310210734	200280734	T-7
3/4	.750	300280750	310210750	200280750	T-7
49/64	.766	300280766	310210766	200280766	T-7
25/32	.781	300280781	310210781	200280781	T-7
51/64	.797	300280797	310210797	200280797	T-7
13/16	.813	300280813	310210813	200280813	T-7
53/64	.828	300280828	310410828	200280828	T-7
27/32	.844	300280844	310410844	200280844	T-7
55/64	.859	300280859	310410859	200280859	T-7
7/8	.875	300280875	310410875	200280875	T-7
57/64	.891	300280891	310410891	200280891	T-7
29/32-23MM	.906	300280906	310410906	200280906	T-7
59/64	.922	300280922	310410922	200280922	T-7
15/16	.938	300280938	310410938	200280938	T-7
61/64	.953	300280953	310410953	200280953	T-7
31/32	.969	300280969	310410969	200280969	T-7
63/64-25MM	.984	300280984	310410984	200280984	T-7
1-25.5MM	1.000	300281000	310411000	200281000	T-7
1-1/32	1.031	300281031	310411031	200281031	T-7
1-1/16	1.063	300281063	310411063	200281063	T-7
1-3/32	1.094	300281094	310411094	200281094	T-7
1-1/8	1.125	300281125	310411125	200281125	T-7
1-5/32	1.156	300281156	310411156	200281156	T-7

AVAILABLE TOOLING

LARGE PRESS TOOLING

Punches and Dies for 127, 129, 130, 150, 230, 231 and 331.
& 134 Power Presses

Kick & Lever Presses No. 15, 811, 118, 218, 32, 34, 29, 58, 68

TYPE O ROUND PUNCHES AND DIES

Standard Sizes

Fractional, Drill or Millimeter	Decimal Equiv.	Punch Part Number	Die Part Number	Set Part Number	Dealer Code
1-3/16	1.188	300281188	310411188	200281188	T-7
1-7/32	1.219	300281219	310411219	200281219	T-7
1-1/4	1.250	300281250	310411250	200281250	T-7
1-9/32	1.281	300281281	310411281	200281281	T-7
1-5/16	1.313	300281313	310411313	200281313	T-7
1-11/32	1.344	300281344	310411344	200281344	T-7
1-3/8	1.375	300281375	310411375	200281375	T-7
1-13/32	1.406	300281406	310411406	200281406	T-7
1-7/16	1.438	300281438	310411438	200281438	T-7
1-15/32	1.469	300281469	310311469	200281469	T-7
1-1/2	1.500	300281500	310311500	200281500	T-7
1-17/32	1.531	300281531	310311531	200281531	T-7
1-9/16	1.563	300281563	310311563	200281563	T-7
1-19/32	1.594	300281594	310311594	200281594	T-7
1-5/8	1.625	300281625	310311625	200281625	T-7
1-21/32	1.656	300281656	310311656	200281656	T-7
1-11/16	1.688	300281688	310311688	200281688	T-7
1-23/32	1.719	300281719	310311719	200281719	T-7
1-3/4	1.750	300281750	310311750	200281750	T-7
1-25/32	1.781	300281781	310311781	200281781	T-7
1-13/16	1.813	300281813	310311813	200281813	T-7
1-27/32	1.844	300281844	310311844	200281844	T-7
1-7/8	1.875	300281875	310311875	200281875	T-7
1-29/32	1.906	300281906	310311906	200281906	T-7
1-15/16	1.938	300281938	310311938	200281938	T-7
1-31/32	1.969	300281969	310311969	200281969	T-7