

BRAKE PRESS LOUVERS SET UP INSTRUCTIONS

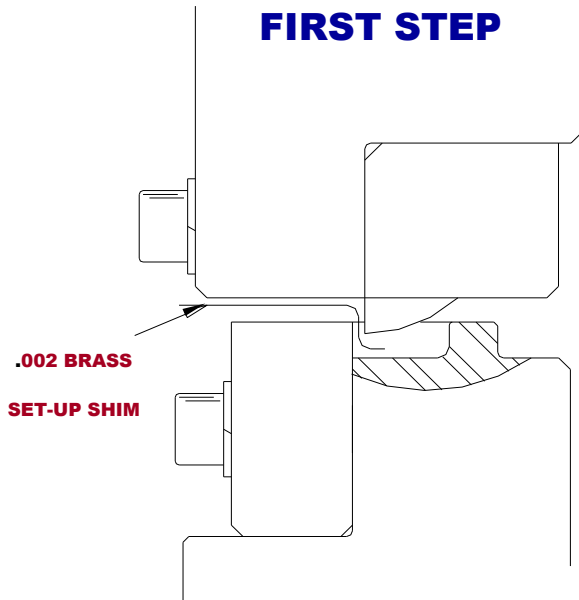


IMPORTANT!!

READ INSTRUCTIONS BEFORE SET UP LOUVERS

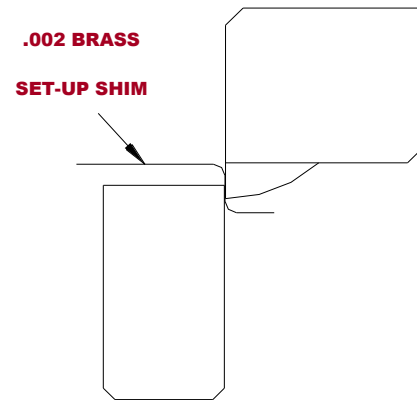


FIRST STEP



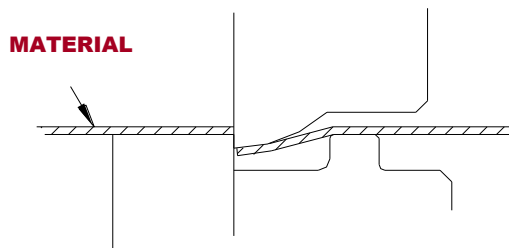
1.- INSTALL TOOL IN PRESS ADJUSTING FOR MAXIMUM CLEARANCE BETWEEN PUNCH AND DIE CUTTING BLADES.
LOWER PRESS SO PUNCH BLADES ENTER DIE BY 1/16 TO 3/16.

SECOND STEP



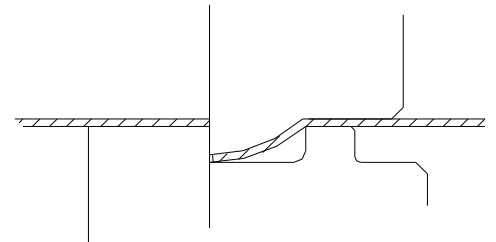
2.- ADJUST TOOL UNTIL CUTTING EDGE IS AGAINST SHIM.

THIRD STEP



3.- PLACE MATERIAL UNDER TOOL AND PERFORM TEST PUNCH.
CAUTION!!
CYCLING PUNCH INTO DIE WITHOUT MATERIAL MAY CAUSE DAMAGE TO CUTTING EDGES.

FOURTH STEP



4.- MEASURE DEPTH
ADJUST STROKE UNTIL PROPER DEPTH IS ACHIEVED. RE - TEST USING NEW MATERIAL. NEVER RE-PUNCH OLD FORM.

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CAUTION!!

CLEARANCES BETWEEN THE PUNCH AND DIE

ARE MINIMAL AND EXTREME CARE MUST BE TAKEN WHEN INSTALLING INTO BRAKE



THERE ARE 3 IMPORTANT STEPS TO FOLLOW WHEN SETTING UP YOUR PRESS BRAKE LOUVERS.

1

CLAMP UPPER PUNCH INTO RAM AND LOCK IT DOWN, THEN SET LOWER DIE INTO BED AND PLACE SHIMS BEHIND LOWER TANG "A" TO CREATE GAP BETWEEN CUTTING BLADES.

2

CAREFULLY LOWER RAM TO BRING PUNCH ABOUT 1/8" INTO DIE POCKET. STANDARD CLEARANCE BETWEEN BLADES IS ABOUT .002 TO .003

REMOVE SHIMS FROM BEHIND LOWER TANG TO ACHIEVE PROPER CLEARANCE. IF NEEDED ADD SHIMS BEHIND UPPER TANG TO MINIMIZE CLEARANCE.

3

NEXT, LOOSEN SET SCREWS HOLDING DIE BASE AND SLIDE DIE BASE TO THE RIGHT UNTIL IT STOPS .

ON THE RIGHT SIDE OF THE DIE BASE , MARK A LINE ON THE PRESS BED, SLIDE THE DIE BASE TO THE LEFT UNTIL IT STOPS.

SLIDE THE DIE BASE BACK TO THE RIGHT HALF DISTANCE TO THE MARK ON THE DIE PRESS BED. THE DIE BASE IS NOW CENTERED BELOW THE PUNCH. RE-TIGHTEN THE SET SCREWS.

