#2780 PUNCH & THREADING TOOL

Labels: HOUSING, MAIN SHAFT, REMOVABLE HANDLE (USE FOR THREADING), RECESSED FOR VISE MOUNTING, MAIN SHAFT HEAD, DIE HOLDER, PUNCHES, KEY HINGE BASES, ANVIL, LEAD BLOCK, HAMMER PUNCH
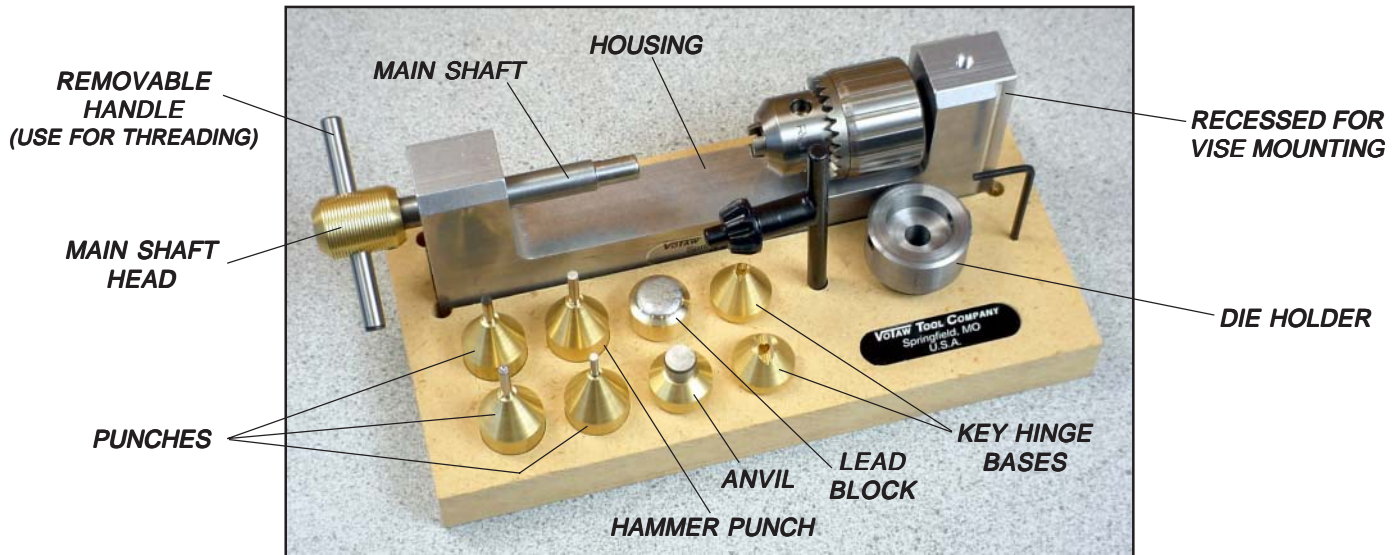
PUNCH

For most punch applications clamp the housing (recessed area) in a standard bench vise.

KEY PIN REMOVAL & INSTALLATION

Choose the appropriate Key Hinge Base or Lead Block to securely support key hinge. Open the drill chuck jaws enough to accommodate bottom of key hinge base, insert base, and hand tighten drill chuck (drill key is not necessary).

With Main Shaft mounted in Housing, choose appropriate punch and attach punch to end of main shaft and secure with set screw using enclosed allen wrench.

Position key hinge in base and bring end of punch against end of pin. Using a mallet, lightly tap the Main Shaft Head to install or dislodge pin.

FLATTENING NEEDLE SPRINGS

As above, place the Anvil into drill chuck and attach Hammer Punch onto end of main shaft. Using pliers or vise grips, securely hold needle spring, positioning the end of spring on anvil and under hammer punch. Strike shaft head with mallet to flatten spring end.

FLATTENING NEEDLE SPRINGS

THREADING

Insert thread cutting die into Die Holder and secure with set screws. With Main Shaft mounted in Housing, attach Die Holder to main shaft and secure with set screw. Insert hinge rod into drill chuck and lock down with drill chuck key, with approx. 1" (25.4mm) of rod extending beyond chuck jaws. Insert Threading Handle into Head of main shaft and slide shaft forward to contact rod.

Begin cutting threads by applying slight forward pressure and rotating shaft clockwise approx. 1/2 revolution and then slightly back off by turning counterclockwise. Continue in this manner, 1/2 revolution clockwise and slight back off counterclockwise (to break chip), until desired number of threads are cut.

Our Punch & Threading Tool is designed to work with standard thread cutting dies with a 13/16" outside diameter. See our catalog or web site for compete selection.

For clean cutting threads use our #3092 Acculube.