Your TRU PUNCH®, punch & die set is made with extreme accuracy. Note: If your punch & die set has been exposed to excessive hot or cold temperatures, it should be allowed to adjust to room temperature before using.

This set is designed for making washers, shims and gaskets from steel, brass, stainless steel, blue tempered, copper, and aluminum shim stock and other light gauge material such as rubber, plastic, paper, etc. It is advised not to exceed .025"/.635mm thickness in steel, brass, copper or aluminum and .010"/.254mm thickness in stainless steel or blue tempered shim stock.

INITIAL ADJUSTMENT

If you find the punches have a tight fit, are difficult to insert through the PLEXIGLAS® top and cannot be moved by firm hand pressure, turn over the punch & die set and lightly tap each punch through the appropriate die from the tool steel plate toward the PLEXIGLAS® top. Always insert punches with the cutting edge first. The hammerhead should always squarely strike the punches on top of the beveled end. NEVER strike the cutting edge end of the punch with a hammer. Repeat this procedure several times until the fit becomes workable. Insertion of the punches will become easier after continued use.

TO PUNCH A HOLE:

1. Position the material to be punched between the tool steel base and the PLEXIGLAS® top.
2. Before striking the punch, make sure the punch has been pushed through the PLEXIGLAS® top and the cutting edge of the punch is touching the material.
3. Strike the beveled end of the punch squarely with the hammer face. Use enough force to penetrate the material with one blow. Striking the punch at an angle can damage the PLEXIGLAS® top.
4. To remove the punch from the die, tap the punch completely through the bottom of the set with a hammer.

TO MAKE A WASHER:

1. Punch the I.D. hole first, see instructions above.
2. Then attach the appropriate I.D. pilot to the O.D. punch.
3. Move the material so the I.D. hole is beneath the O.D. guide hole on the PLEXIGLAS® top.
4. Insert the O.D. punch so that the I.D. pilot moves into the I.D. hole which should automatically center the material. Make sure the O.D. punch has been pushed through the PLEXIGLAS® top and is touching the material.
5. Strike the punch squarely with enough force to push it through the material with one blow.