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PRACTICAL PUNCH AND SHEAR

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PRACTICAL PUNCH AND SHEAR

❶

Fix the Practical Punch/Shear
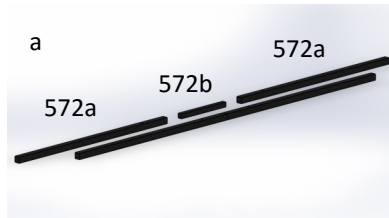Tool to your work bench using
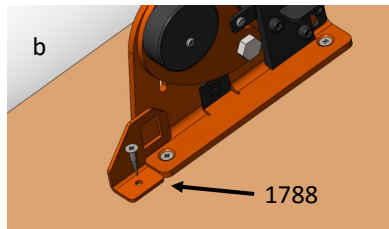2 nuts and bolts (not supplied).

❷
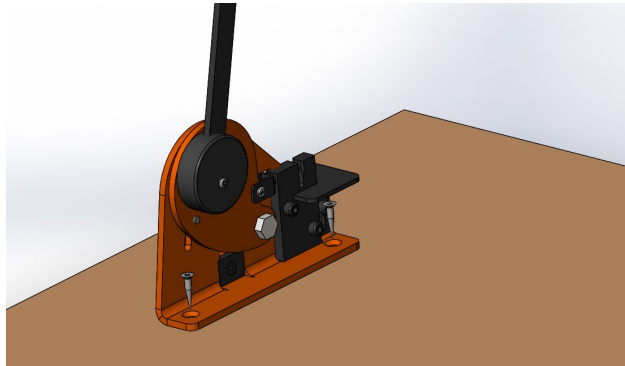
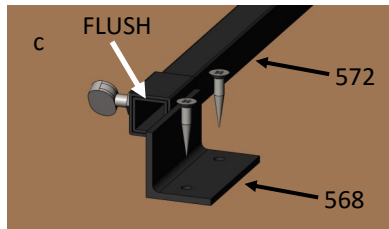## MEASURING DEVICE (OPTIONAL)

Assembly and Setup

(a) Assemble the tape measuring device by first
hammering the spigot (572b) half way into the
dimpled end of one of the measuring bars (572a),
then hammer the remaining measuring bar (572a)
at the dimpled end into the other half of the spigot
(572b)

(b) Attach the locator bracket (1788) to the bench
towards the back of the PPS tool with nuts & bolts
(not supplied). Place the assembled measuring
bar into the slot of (1788) and make sure it sits
tight up against the body, also making sure the
measuring bar is at a right angle to the PPS tool.

(c) Attach the bench mounting bracket (568) using
nuts & bolts (not supplied) to the bench, then line
up the measuring bar so that the back of (568) sits
flush with the end of the measuring bar (572).
Once the two (2) brackets have been fitted remove
the measuring bar and feed the tape and holder
(1786*) over the measuring bar (572) and then
place the end of the tape over the measuring bar
and through (1788) and then up against the PPS
tool body (d), lock the measuring bar in place by
tightening (569*) on part (568)

*

See exploded view of Tape Measuring device on page 4.

a

572a

572b

572a

572a

b

1788

c

FLUSH

572

568

d

572

1788

❹
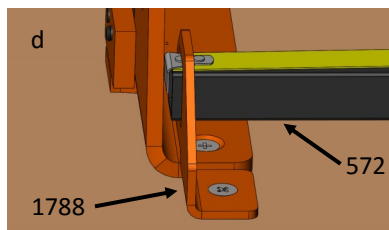
PUNCHING <u>without the use of the Measuring Bar</u>.

Mark the edge of the flat metal
strip where the hole is to be
punched. Push/pull the handle
back (away from punch block) so
that the punch pin retracts into
the punch block - thus leaving the
punch block slot clear. Next place
the metal so that the mark you
made on the edge is located in
the center of the punch block slot,
then push/pull the handle toward
the punch block.

REMEMBER - to always support
the flat metal strip you are
punching. Keep it level with the
punch block so as not to break
the punch pin.

Once hole is punched, push/pull
handle ALL THE WAY back (away from punch block) BEFORE removing metal.

WARNING: During punching steel a pellet may be ejected at high speed from the punch block. Eye protection is recommended.

Ejection of
steel pellet

Always support the
bar when punching.

❹
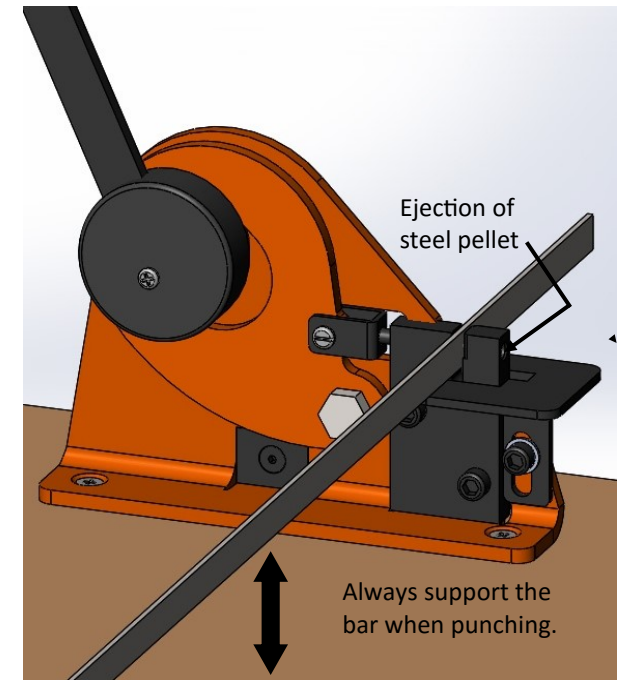
ADJUSTABLE PLATFORM

This mechanism can be fixed at
different heights to enable the tool
to punch holes at consistent
distances from the edge or in the
center of various widths of flat
metal strip.
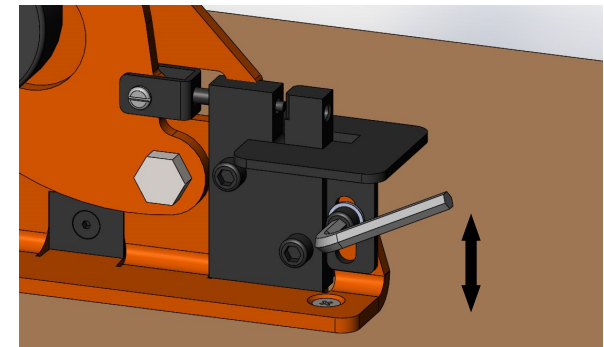
❸ SHEARING (cutting) METAL

Start by setting the tape measuring holder (1786) to the correct length by undoing the thumb screw (569) and locking in place. If your Practical Punch/Shear does not have a tape measuring device, simply mark the metal to the desired length. Next open the gap between the blades by pushing/pulling handle toward the punch block. Insert metal between upper and lower shear blades (mark you made should be at the edge of the lower shear blade). Now push/pull handle back away from punch block until the blades close and shear the metal. Trim the corners of the metal for a more professional finish (a)

a

a
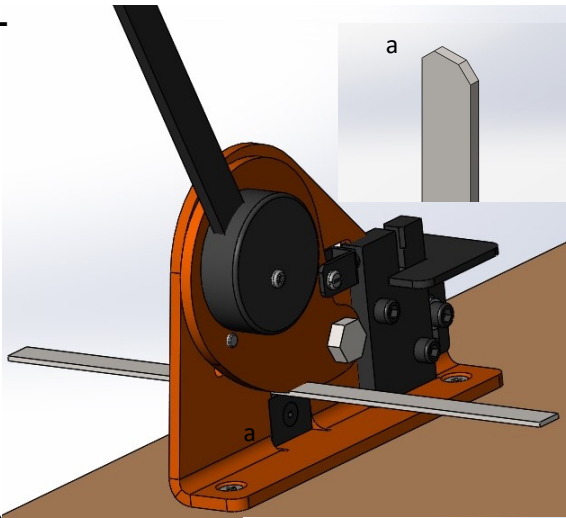
CHANGING THE SMALL BLADE

The lower blade (246) has 4 cutting edges (photo b) and can be rotated when one edge wears. To change the lower shear blade, bring the large blade up then loosen the two grub screws (253) (photo c). Next remove the screw (247) on opposite side (photo d) and then rotate the blade and place back in position. Tighten the screw (247) then back this off approximately 1 full rotation. Now bring the large blade down, tighten both grub screws (253) - this will push the lower blade up against the upper blade. Tighten (247). There should be NO gap between the two blades. If there is, keep the upper blade in the down position, loosen (253), then loosen (247) slightly. Next tighten up both grub screws (253) If there is still a gap, repeat this process.

b

246

c

253

d

247
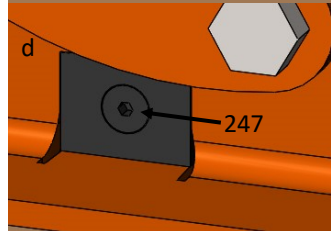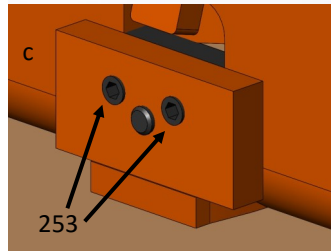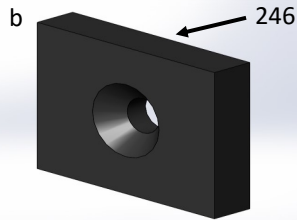
Maximum Working Capacity:

Shearing: 3/4"wide x 1/8" thickness (flat metal strip)
3/16" solid round rod and solid square bar

**Punching:** 1/8" diameter round hole in up to 1/8" thick material (flat metal strip)

IMPORTANT NOTES:

Sizes stated are for hot rolled, mild steel or annealed metal.
Ensure all moving parts are regularly lubricated.
Working beyond the maximum working capacity stated above or with materials with greater strength or hardness will reduce the operational life of the tool.
Please SAVE THESE instructions for future reference.

The Practical Punch and Shear Tape Measuring Device will help to achieve consistent cut lengths of steel every time and also produce accurate distances between your punched holes.

SET THE LENGTH TO CUT

(e) Undo the thumb screw (569) on the tape holder, this will enable the carriage to move up and down the bar. Set the desired measurement taking note of what the tape measurement reads (f). Once locked you are set to cut metal at set length. To cut, push/pull handle to open upper & lower shear blades. Feed metal between blades until metal rests against the stop (g). Next push/pull handle to cut the metal - always making sure the metal is pushed up against the stop.
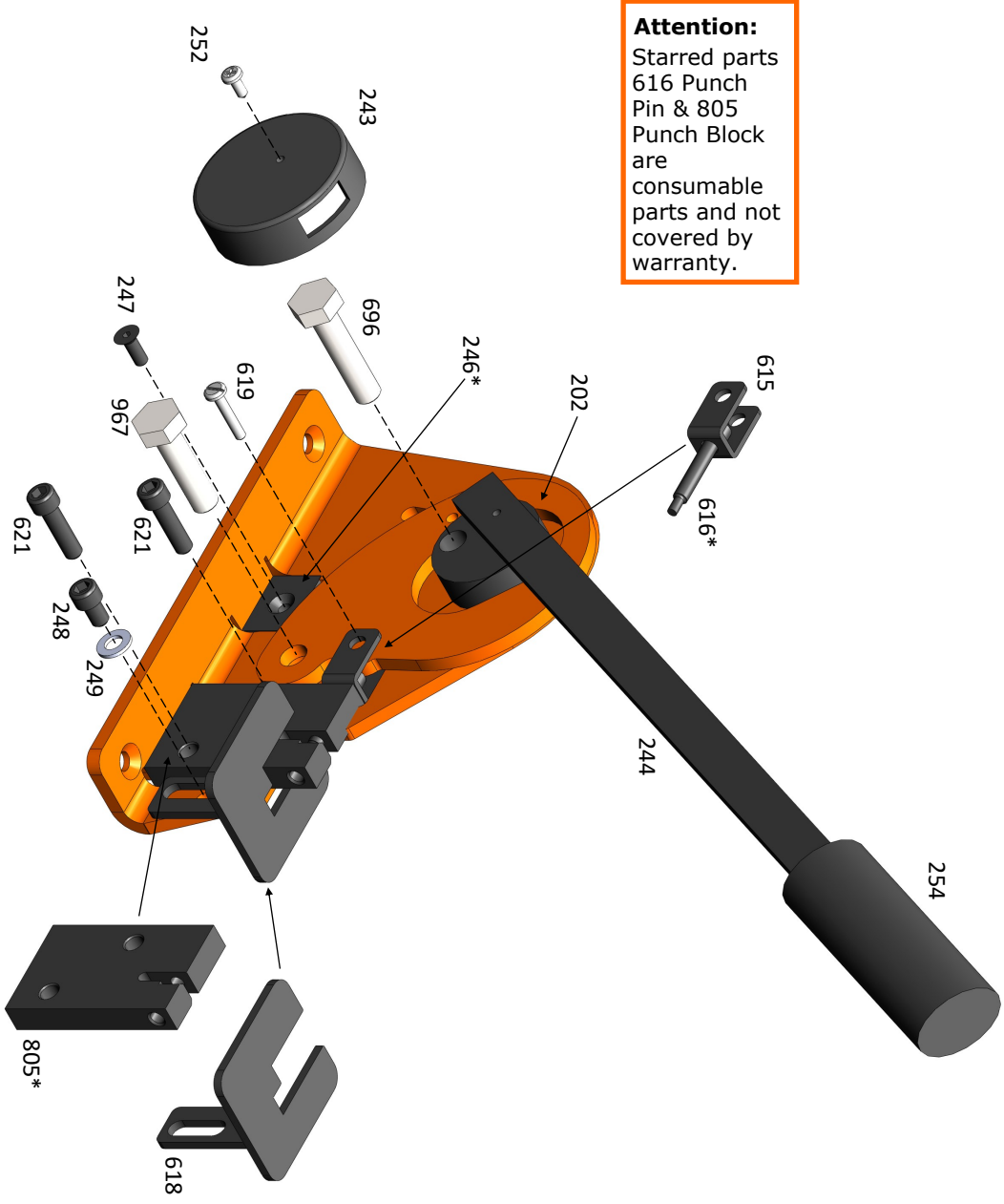
e

f

g
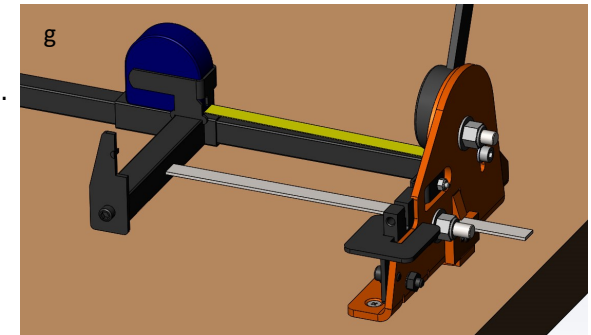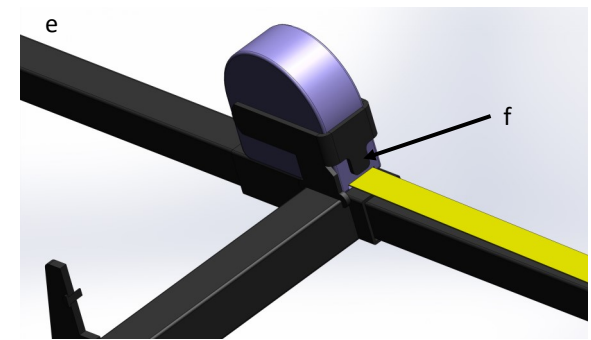
SET THE DISTANCE FROM THE CENTER OF THE PUNCHED HOLE TO THE END OF THE FLAT METAL STRIP

To set your punched hole move the carriage to the desired length and lock off using (569). Once your measurement is chosen, push/pull handle to retract punch pin into punch block which opens up punch slot. Now feed metal (with the platform set to the correct size of metal) through the punch block and up against the punch stop (h). Keeping the flat strip tight against the stop, push/pull the handle toward the punch block to punch hole.

h
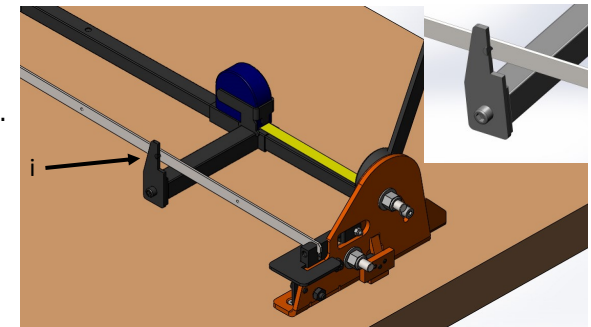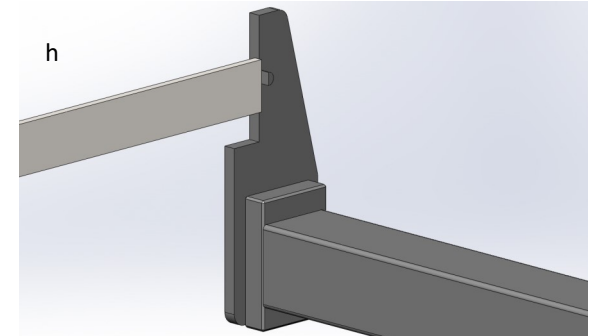
SET THE DISTANCE BETWEEN PUNCHED HOLES

Set the tape measure to the desired length, lock off using (569), then place the already punched hole over the location pin (i) and punch the hole.

i

252

243

247

696

246*

202

615

616*

967

619

621

621

248

249

244

254

805*

618

3

249

930

698

213

620

253

253

698

213

237

217

237

217

1779

Optional tape measuring device

1788

573(a)

1787

259

572(b)

573(a)

573

1786

568

569

4