

# KAKA Industrial®

## Unpacking

The Pneumatic Planishing Hammer is shipped from the manufacturer in a carefully packed Carton box. Thoroughly inspect the product upon opening the package.

After unpacking the unit, carefully inspect for any damage that may have occurred during transit. Check for loose, missing, or damaged parts. Shipping damage claims must be filed with the carrier and are the responsibility of the user.

## Specifications

Operating Air Pressur.....	50-100 (Max.) PSI
Air Inlet .....	1/4", 18 NPT, female
Maximum thickness.....	20 gauge
Throat Size.....	19-5/8"
Anvil Sizes.....	1", 2" & 3" Radius
Overall Size.....	28" x 16" x 46"
Weight .....	57 lbs



## Important:

The pneumatic planishing hammer is coated with a protectant. To ensure proper fit and operation, remove coating. Coating is easily removed with mild solvents, such as mineral spirits, and a soft cloth. Avoid getting cleaning solution on paint or any of the rubber or plastic parts. Solvents may deteriorate these finishes. Use soap and water on paint, plastic or rubber components. After cleaning, cover all exposed surfaces with a light coating of oil.

### ▲WARNING

Never use highly volatile solvents. Non-flammable solvents are recommended to avoid possible fire hazard.

## SAVE THESE INSTRUCTIONS

Thank you for purchasing PPH-500 Pneumatic Planishing Hammer machine. Before attempting to operate your new tool please read these instructions thoroughly. You will need these instructions for the safety warnings, precautions, assembly, operation, maintenance procedures, parts list and diagrams. Keep your invoice number with these instructions. Write the invoice number on the inside of front cover. Keep the instructions and invoice in a safe, dry place for future reference.

## General Safety Information

### ▲CAUTION

Always follow proper operating procedures as defined in this manual even if you are familiar with use of this or similar tools. Remember that being careless for even a fraction of a second can result in severe personal injury.

## SAFETY RULES

1. Wear proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets or other jewelry which may get caught in moving parts of machine.
2. Wear protective hair covering to contain long hair.
3. Wear safety shoes with non-slip soles.
4. Wear safety glasses complying with United States ANSI Z87.1.

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Everyday glasses have only impact resistant lenses. They are NOT safety glasses.

5. Be alert and think clearly. Never operate tools when tired, intoxicated or when taking medications that cause drowsiness.

6. Keep work area clean. Cluttered work areas invite accidents.

7. Work area should be properly lit.

8. Keep visitors at a safe distance from work area.

9. Keep children out of workplace. Make workshop childproof. Use padlocks to prevent any unintentional use of tools.

10. Assemble only according to these instructions. Improper assembly can create hazards.

11. When tools are not in use, store them in a dry, secure place out of the reach of children. Inspect the tools prior to storage and before reuse.

12. Maintain product labels and nameplates. These carry important safety information.

**▲ WARNING**

Before drilling the mounting holes, make sure that there is no electrical conduit or water pipes.

## Assembly

1. Assemble stand base using Attach Stand Base #30 to Base #28 using hardware indicated in Drawing, page 4 , Flat washer #24, lock washer #25, Hex nut #28 and Hex Bolt #29.

2. Set Planishing Hammer frame #1 on stand and attach using Hardware #25, #26, #27, and #28 See Drawing, page 4.

3. To prepare Air Hammer Assembly #10.#11, #12, #13, #14 and #16 for installation, refer to

Figure 1 below, also Drawing, page 4.



Figure 1

4. Separate Hammer head #3 from Air Hammer #10 with a twisting motion, (See Figure 2).



Figure 2

5. Insert the Air Hammer #10 into frame #1 and reconnect Hammer head #3 as shown in Figure 3.

Assembly is complete.



Figure 3

**▲ WARNING**

Do not planish a stock thicker than it's capacity. You will damage the hammer. Measure the thickness before use.

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## Operation

1. Connect quick connector #15 with air source.
2. Insert the workpiece between hammer head #3 and anvil #5, press the foot switch assembly #13, and move the workpiece to produce the desired shape, See Figure 4.



Figure 4

3. The tool position can be adjusted by loosening nut #23 and screw #8, turning range adjust block #6 at the same time.
4. Hold adjustable pole #7, remove stopper pin #9, the anvil #5 can be moved, and change the right size anvil you need (refer to Figure 5).



Figure 5

## Maintenance

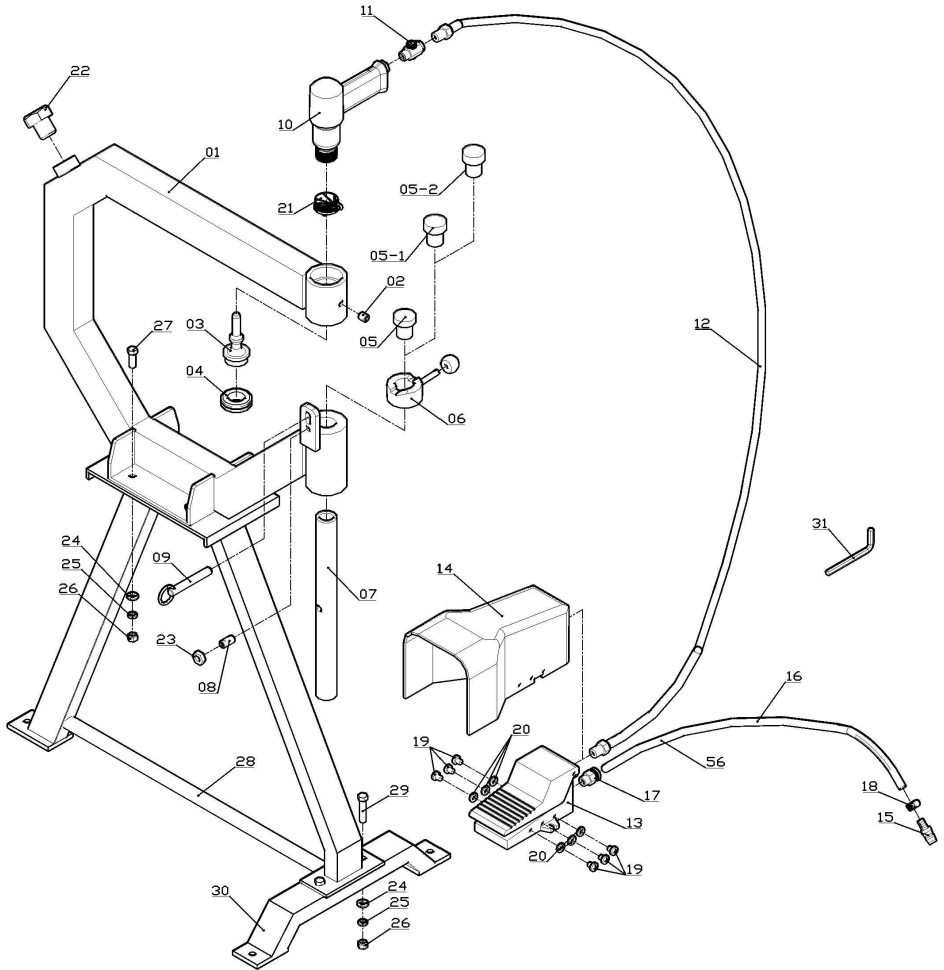
1. After each use, wipe all components of the planishing hammer with a clean cloth to remove any dirt and grease buildup.
2. To maintain tool life, always lubricate the air line by adding a few drops of pneumatic tool oil to the air line (or air inlet) before each use or install the automatic oiler-filter system as illustrated
3. Before each use, drain water out of the air compressor tank and condensation from the air lines. Refer to the Air Compressor Operation Manual.
4. Cover the Planishing Hammer and keep in a clean and dry location.

## Troubleshooting Chart

Problem	Probable Cause	Solution
Planishing Hammer does not operate when Switch pressed	No air pressure in air line	Check air line and compressor
Planishing Hammer operates at diminished pressure	Air pressure below normal operating pressure	Check regulator pressure setting at compressor and/or air line

# Model PPH-500

## Drawing



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## Parts List

Ref.No.	Description	QTY
1	"C" Frame	1
2	Inner Hex Screw M6x12	1
3	Hammer Head	1
4	Hammer Sleeve	1
5	1"Anvil	1
5-1	2"Anvil	1
5-2	3"Anvil	1
6	Range Adjust Block	1
7	Adjustable Pole	1
8	Screw M10x20	1
9	Stopper Pin	1
10	Air Hammer	1
11	Regulator	1
12	Rubber Hose $\Phi 16 \times 2-2.5m$	1
13	Foot Switch Assembly	1
14	Cover	1
15	Quick Connector	1
16	Air Hose $\Phi 12 \times 2-1m$	1
17	Male Thread Fitting	1
18	Hose Clamp	1
19	Screw M6x10	6
20	Flat Washer D6	6
21	Spring	1
22	Hex-headed Bolt M24x25	1
23	Nut M10	1
24	Flat Washer D8	6
25	Spring Washer D8	6
26	Nut M8	6
27	Hex-headed Bolt M8x25	4
28	Stand	1
29	Hex-headed Bolt M8x40	2
30	Stand Base	1
31	Hexagon wrench 5mm	1





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