

BRAKE PRESS LOUVER SET UP INSTRUCTIONS



IMPORTANT!

READ INSTRUCTIONS BEFORE SET UP

STEP #1



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.

STEP #2



2. ADJUST TOOL UNTIL CUTTING EDGE IS AGAINST THE SET-UP SHIM TO MINIMIZE CLEARANCE.

STEP #3



3. PLACE MATERIAL UNDER TOOL AND PERFORM TEST PUNCH.

CAUTION

CYCLING PUNCH INTO DIE WITHOUT MATERIAL MAY CAUSE DAMAGE TO CUTTING EDGES

STEP #4



4. MEASURE DEPTH.

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

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**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 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

