

Here are the steps to assemble UniPunch tooling and punch a specific hole pattern.

1.

These example parts have a basic five hole pattern in a 3" x 12" x .060" sheet metal blank. Hole sizes are (4) .2656 diameter holes and (1) .3750" diameter hole.



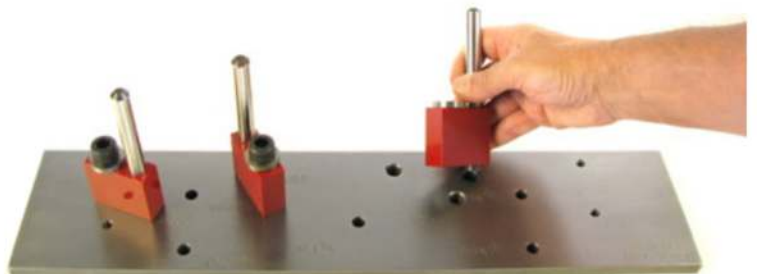
2.

Here is the Mounting Template, designed by UniPunch. The template precisely locates the tooling and part gauging so your part is the same every time.



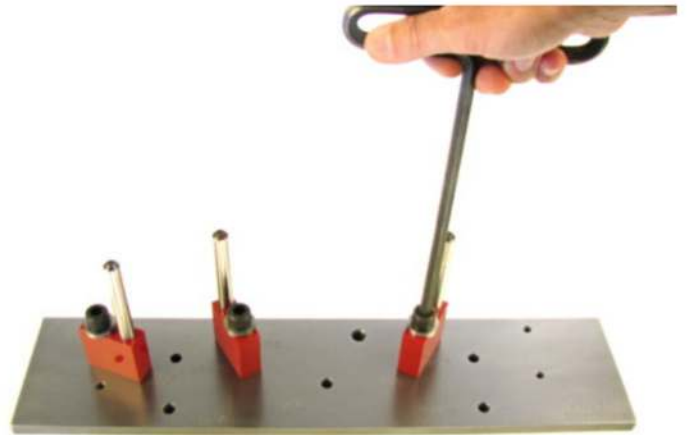
3.

Begin by locating the dowel pin stops in the 1/2" reamed holes on the template.



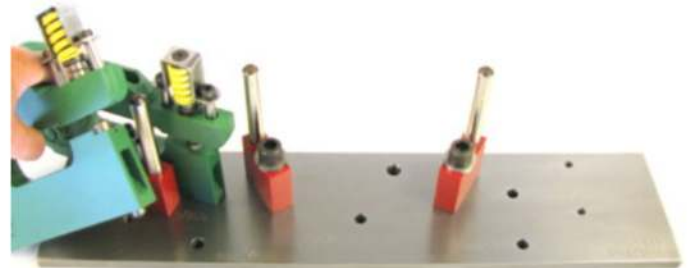
4.

Tighten the pin stops to the template with the hex key wrench.



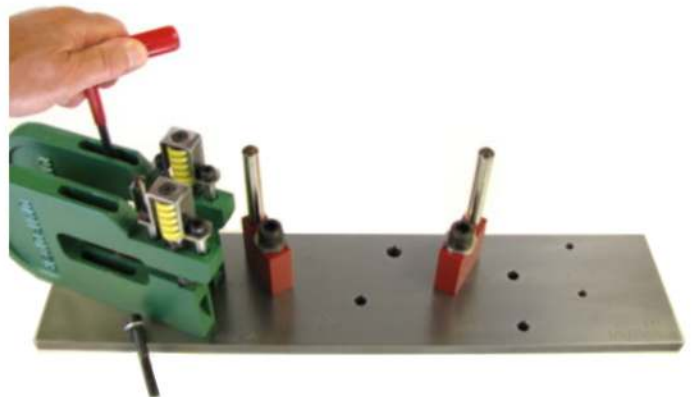
5.

Position the UniPunch units in the holes on the template. A 3/8" diameter pilot pin at the base of the unit goes into the 3/8" reamed hole on the template.



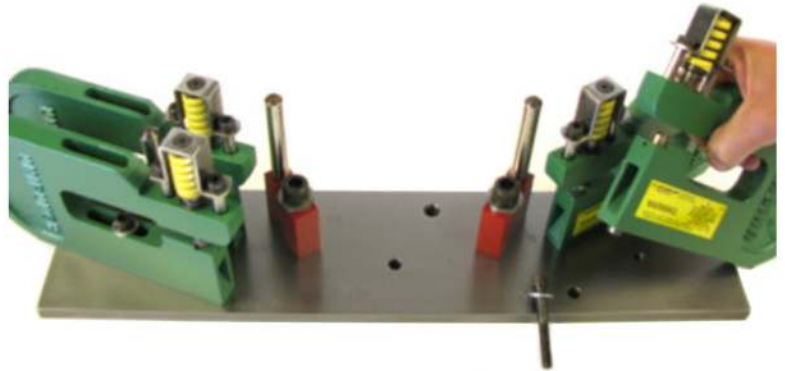
6.

Tighten the UniPunch units to template with the hex key wrench.



7.

Position two units on opposite sides of the template and tighten the bolts.



8.

The pin gauges will locate the part and the four UniPunch units will produce the outer hole pattern.



9.

Position the remaining unit onto the template. This unit will punch the center hole in the part.



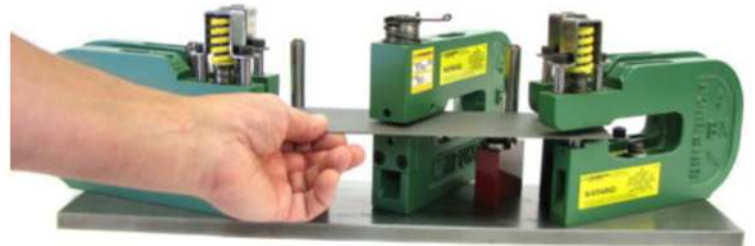
10.

Now the part gauges and UniPunch units are fully assembled and ready to produce parts.



11.

Insert the part blank and ensure that the part engages against dowel pin stops prior to punching.



12.

Here is the view of part blank correctly positioned against the pin stops.



13.

Punch a test part for inspection. UniPunch recommends checking hold down bolts at frequent intervals during part runs to insure accuracy.



14.

You now have a UniPunch tooling system that punches five holes in one stroke of the press!



15.

The hole pattern is always the same, which makes assembly easier. If your design changes, simply adjust the location of the punching units. Store complete setups on the shelf for quick and easy installation.

