

TOOLING MAINTENANCE

STEPS TO LUBRICATE TOOLING

1

Disassemble unit. Clean and inspect internal components.



2

Externally lubricate outside diameter of guide body. Type GN metal assembly paste or die grease is recommended.



3

Reassembly of UniPunch unit. Place conical lifter spring over outside of guide body.



4

Reassemble guide body with lifter spring into holder guide bore.



5

Align guide flat with retainer flat in holder.



6

Secure retainer and guide with fastener.



7

Insert punch body into stripping spring.



8

Externally lubricate punch body with Molykote GN metal assembly paste.



9

Align punch flat with retainer pin hole in guide. Insert punch retainer pin.



10

Tighten die fastener with hex key wrench.



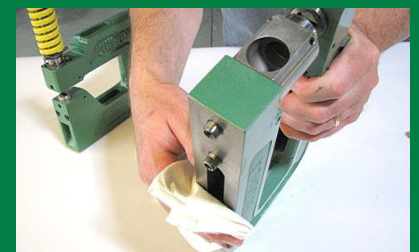
11

Check pilot pin die adapter fastener, securing it to holder. retainer flat in holder.



12

Wipe all debris from bottom of unit machine surface before mounting.



CONTACT UNIPUNCH TO LEARN MORE ABOUT PUNCHING PARTS FAST

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