



# Replace the bender with the hole punch

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## Introduction

### **You must know how to operate the ironworker before completing this training**

This is a guide to replacing the break (the flat plate bender) to the hole punch. Complete this guide in reverse if swapping punch to brake.

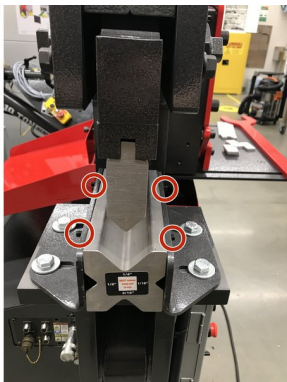
## Step 1 — What you will need to complete the swap



**⚠ Ensure power is disconnected & E-stop is engaged**

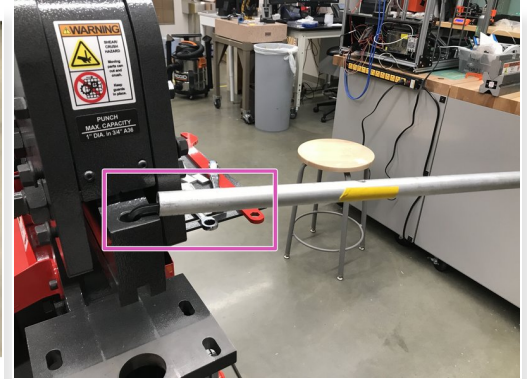
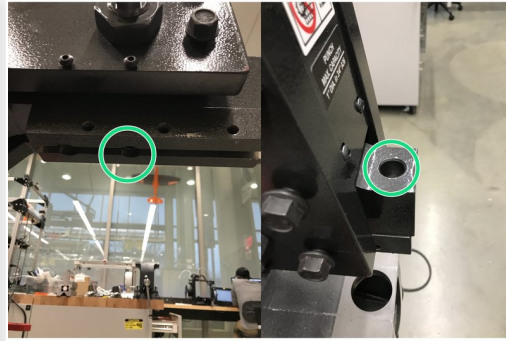
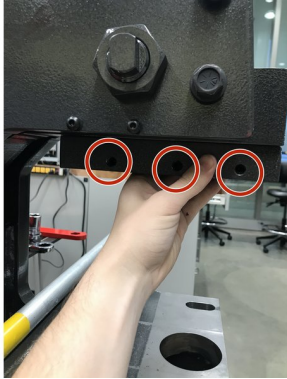
- Breaker Bar
- 3/4 in wrench
- 3/8 allen key (both T handle and L handle)
- 3/16th T handle allen key
- 9/64th T handle allen key
- 3/4 in socket and associated driver
- Safety Glasses

## Step 2 — Removing the bottom fixture



- Undo the grub screws with the 9/64th
- Remove the x block from the stand
- Remove the 4 bolts holding in the brackets

## Step 3 — Removing the top fixture



- Loosen the grub screws with the 3/16ths T handle. Careful keep your hand under the die however it is heavy so be prepared to catch it.
- Remove these two bolts with the 3/8ths L handle
- this is were you will need to use the breaker bar
- **NOTE:** the front bolt is shorter the the rear one make sure it stays like that.

## Step 4 — Adding in the punch top



- Tighten these bolts with the breaker bar
- **NOTE:** the front bolt is shorter the the rear one make sure it stays like that.



## Step 5 — Add in Die bottom



- Place platon on the table with the proper die you want. Make sure the die is facing forward.
- Then do up the bolts. Note the order of the washers. Make sure the bolts are loose for later alignment

## Step 6 — Punch Installation



- Screw on the large nut containing the die
- Tighten with big red wrench.

## Step 7 — Aligning punch and die



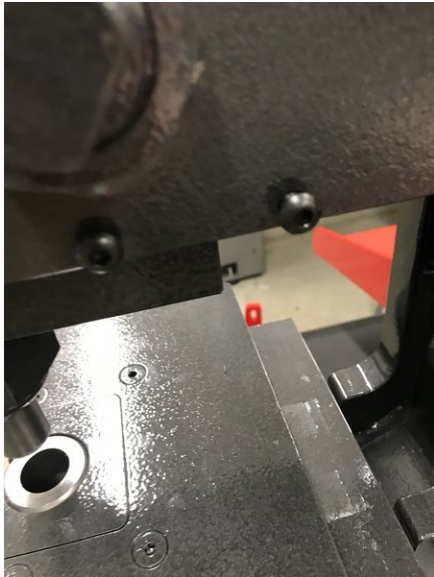
- Turn on the machine
- Lower the top limit switch all the way down.

**⚠ SLOWLY lower the press** and with your fingers holding a far corner of the the table ensure the punch will go in the die.

- Hold the press in the down position and finger tighten the bolts.
- Then give a full tightening to the platon bolts using the 3/4in socket

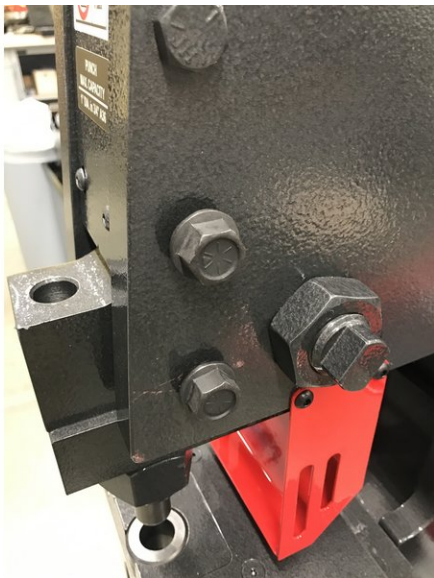


## Step 8 — Putting on the rear guard



- Use the 9/64th T handle to remove the screws and then tighten the guard back into place.

## Step 9 — Putting on the front Guard



- Use the 3/4in socket to remove and replace the bolts