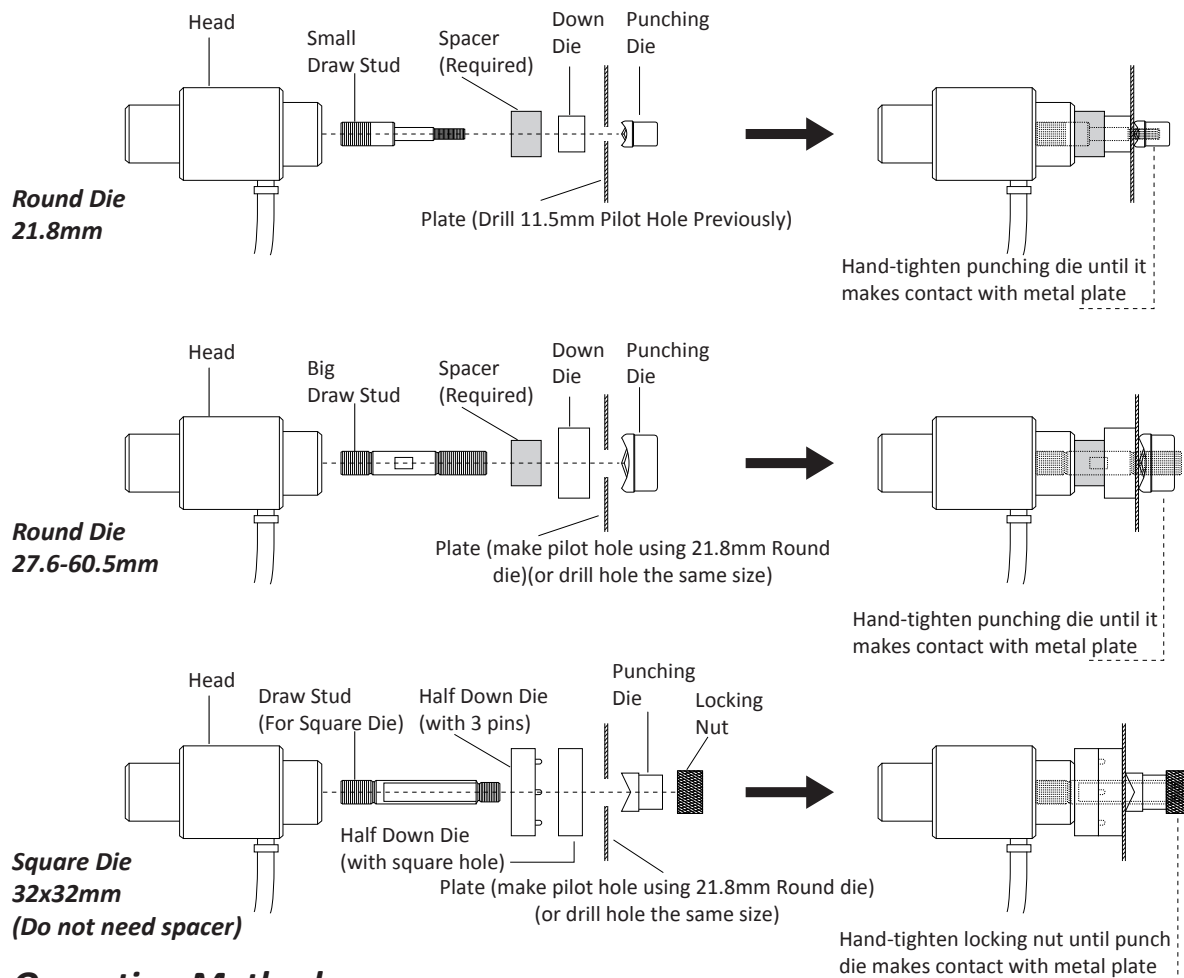


## SET UP PUNCHING TOOLS SKP-15



### Operation Method

- (1) Completely turn release button on hand pump counter-clockwise, make sure ram is in the return position, and there is no pressure inside the oil pipe.
- (2) Connect head and hand pump: push male coupler into female coupler in, then hand-tighten.
- (3) Make pilot hole: for 21.8mm round die, drill 11.5mm hole in metal plate. For 27.6-60.5mm round dies or 32x32mm square dies, use 21.8mm round die to make a pilot hole.
- (4) Set up dies, draw stud, spacer, locking nut, metal plate as per the above pictures. Note that the 32x32mm square die does not need a spacer.
  - Choose draw stud according to die size, then thread it completely onto tool head.
  - Slide the spacer over draw stud
  - Slide the die down over the draw stud. The open side of the down die should face away from tool head.
  - Insert draw stud through the pilot hole.
  - Thread the round punching die onto draw stud until hand-tighten (the shape side of punching die should face toward the metal plate). For 32x32mm square punching die, slide it over the draw stud, then hand-tighten the locking nut; the punching die must make contact with the metal plate.
- (5) Fully turn the hand pump release button clockwise. Now pump the handle up and down to begin the punching operation.
- (6) Stop pumping once the punching dies have gone through the metal plate.
- (7) Release pressure by turning release button counter-clockwise.
- (8) Remove plate, scrap, dies from tool head, check hole condition.

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