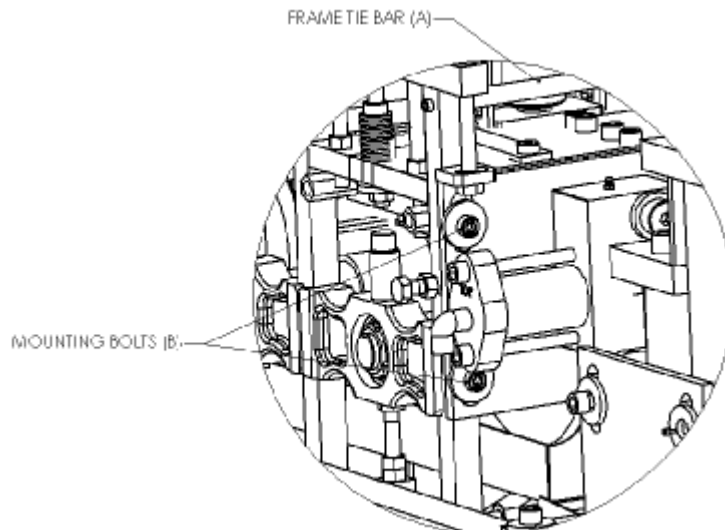


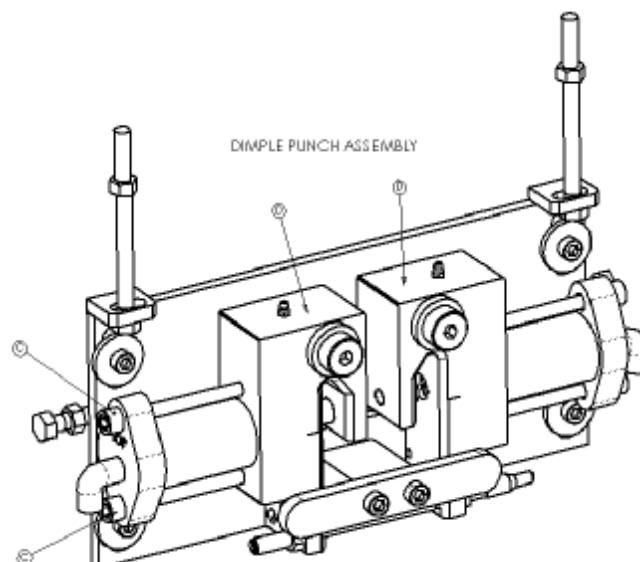
How to Replace the Dimple Punch Tool

TOOLS REQUIRED: Soft Hammer, Metric Allen Key Set, 11/16" Open Ended Spanner or Adjustable Spanner

- 1 Turn off Machine
- 2 Remove Hydraulic Hosing from Elbow Fitting on Cylinder End Caps.
Note: A small amount of hydraulic fluid will seep from end of hose .
- 3 Remove Tie Bar (A) Above Dimple Punch Assembly.



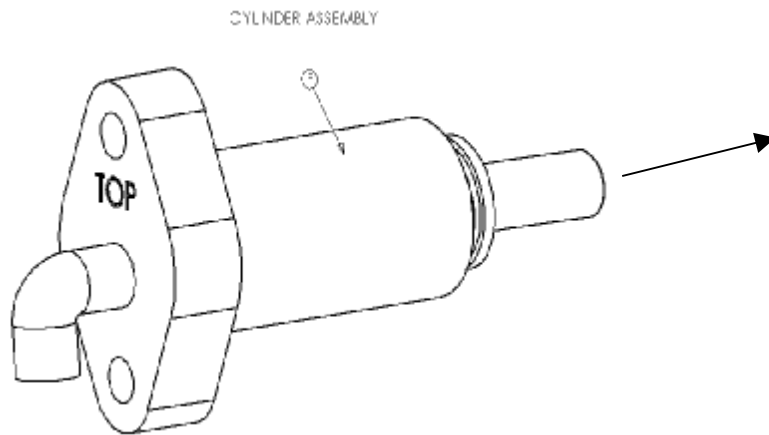
- 4 Unplug Proximity Sensor From Dimple Punch Assembly
- 5 Remove 4 Mounting Bolts (B) holding Dimple Punch Assembly to Machine Frame.
- 6 Lift Dimple Punch Assembly up and then out of Machine to a suitable Work Area.



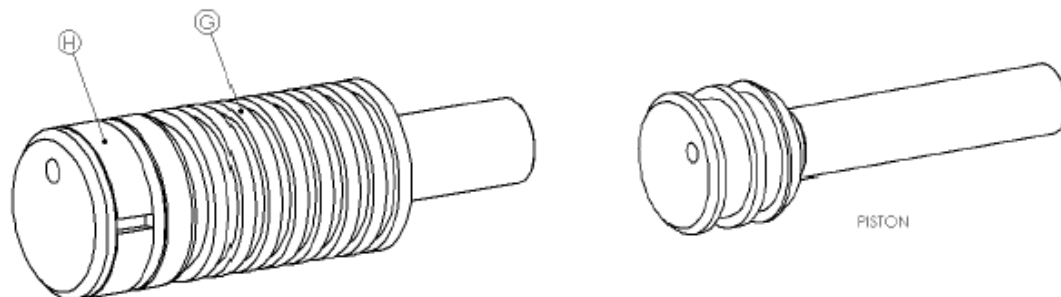
- 7 Undo Capscrews (C) on Cylinder End Cap and remove Cylinder Assembly from Punch Block (D).

PISTON

- 8 Pull Piston Assembly out of Cylinder (F) in Direction of arrow as shown



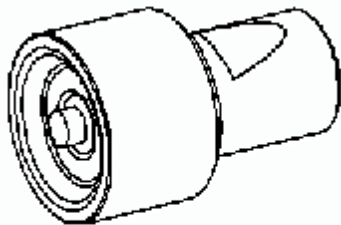
- 9 Remove Spring (G) Off Piston
- 10 Remove Wear Strip (H) Off Old Piston and Place in Groove on New Piston



- 11 Wipe all Components with a clean rag before re-assembly
- 12 Push Spring (G) onto New Piston
- 13 Push Piston into the End of the Cylinder making sure the hole in top of Piston lines up with the Pin in End Cap (E). (The Scrap exit hole should be at the bottom).
- 14 Carefully Tap Piston into Cylinder With Soft Hammer (It will Be a Tight Fit)

PROFILE PUNCH

- 15 Undo the Grubscrew Holding Profile Punch into Punch Block (D)
- 16 Lever and Tap Profile Punch out through the hole the Piston was removed from.



PROFILE PUNCH

- 17 Place new Profile Punch in Hole with Flat on stub facing Grubscrew Hole, Tap into position using old piston.
- 18 Tighten Grubscrew
- 19 Place Cylinder Assembly Back into Punch Block (D)
- 20 Replace and Tighten Capscrews (C)
- 21 Place Dimple Assembly back into machine and replace and tighten mounting screws (B), Hydraulics and Proximity Sensor.

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