

## Instructions and Parts List for No. 218 Bench Punch

CARE: Oil ram slide, cam and punch point occasionally-

OPERATION: To change dies loosen two die shoe bolts and remove die shoe, Loosen die shoe set screw and push upward on die or die adaptor. If using No. 28 2-3/4 style die insert desired size of die in die shoe and tighten die shoe set screw. If 20 or 40 style dies are used, insert die into die adaptor, tighten die adaptor set screw, place in die shoe and tighten die shoe set screw.

Lower punch into die, check clearance and tighten die shoe bolts.

To change punches with die shoe removed, loosen punch retainer set screw and both punch retainer nuts. Remove punch or L8 punch holder. (No. 28 punches insert directly into ram and No. 8 style punches are inserted in L8 punch holder and then into ram.) When inserting punch or punch holder into ram be sure flat on shank is facing front of ram. Tighten punch retainer nuts and set screw.

Install proper stripper plate for punch size being used. Place a flat object (1/4" bar stock) on die and slide stripper plate down until it rests on the bar. Tighten stripper arm bolts and remove bar.

Punches should not enter die more than 1/16". To adjust loosen eccentric pin nut, adjust ram up or down with eccentric pin handle and tighten eccentric pin nut when desired adjustment is attained.

Two gib shims are between each gib and the frame face plate. Remove one or both shims or each side of ram to compensate for wear.

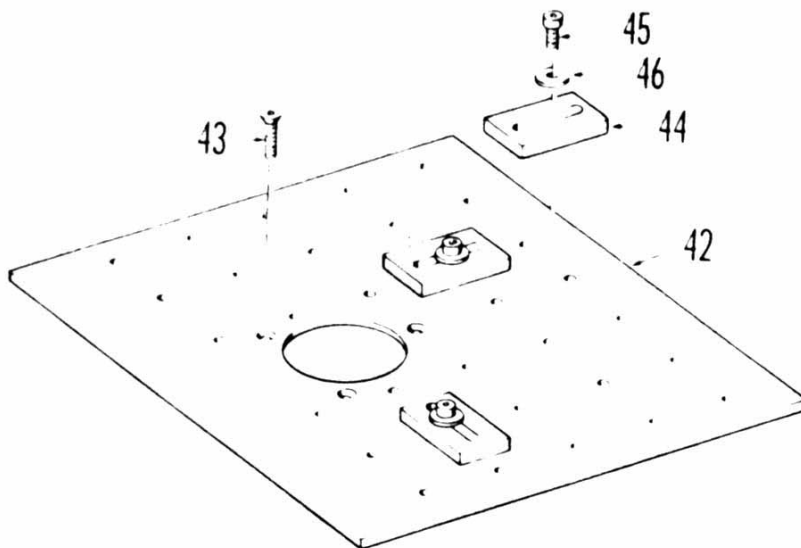
If necessary to replace the roller bearing place bearing with mounting plug in proper position. Drive the roller bearing pin through the frame and bearing forcing the mounting plug out of bearing and discard. Tighten roller bearing pin set screw.

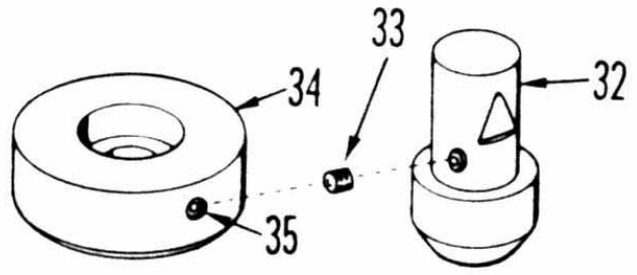
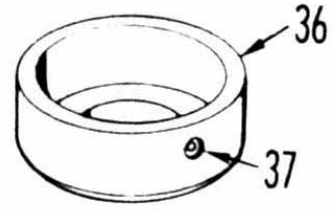
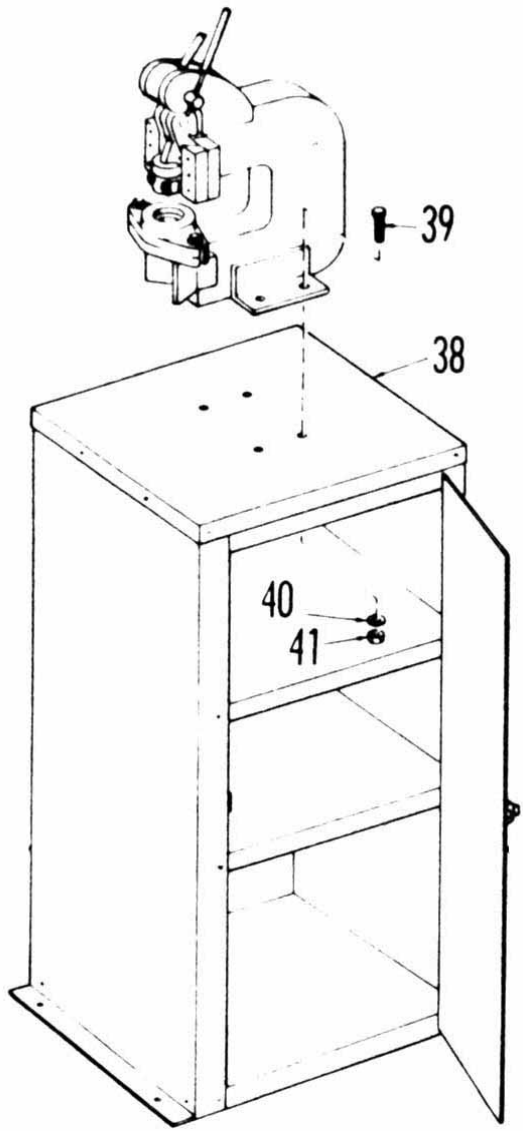
### FOR MAXIMUM OPERATOR SAFETY DO:

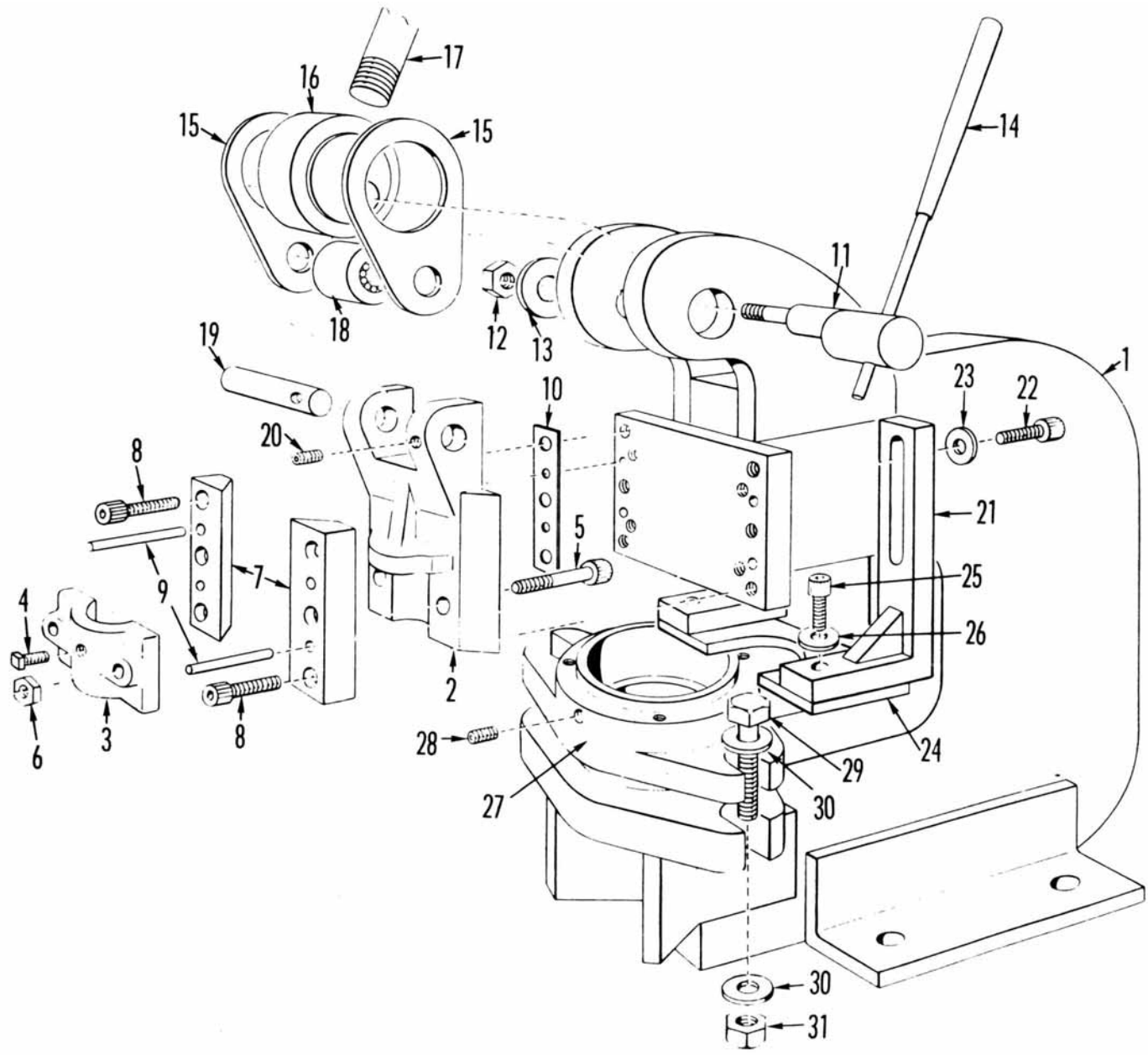
1. Read and understand this manual.
2. Use only punches and dies marked with a "W" in a circle or R-W designed for this tool.
3. Be sure you punch within the four ton capacity of this tool. Type and thickness of material versus final hole size will give you this tonnage.
4. Wear safety glasses.

### FOR MAXIMUM OPERATOR SAFETY DO NOT:

1. Use punches and dies that are chipped or dulled.
2. Punch over capacity of the tool.
3. Nibble. Punch a full hole not a half hole as plinch may contact die.







Item No.	Part No.	Part Name	No. Req'd.	No.	No.	Part Name	Req'd.
				34	28-127	No. 20 Die Adaptor1	
1	11 8-1	Frame (7" Depth Throat)	1	35	WS 715	No. 20 Die Adaptor Set	1
1	21 8-1	Frame 12" Depth Throat)	1			Screw	
2	118-2	Ram with Punch Retainer	1			5/16-18 x 3/4 Headless Set	
3	118-2-1	Punch Retainer	1	36	28-126	No. 40 Die Adaptor1	
4	WS 615	Punch Retainer Set Screw	1	37	WS 794	No. 40 Die Adaptor Set	1
		5/16-18 x 3/4 Square Head				Screw	
5	118-17	Punch Retainer Screws	2			5/16-18 x 5/16 Headless Set	
6	WS 1353	Punch Retainer Nuts	2	38	118-12	Stand	1
		5/16-18 Hex Nuts		39	WS 49	Punch Mounting Bolts	4
7	118-4	Gibs	2			7/16-14 x 1-1/4 Hex	
8	WS 525	Gib Bolts	6	40	WS 1730	Punch Mounting Bolt	4
		5/16-18 x 1 SocketCap				Washers 7/16 Lock	
9	WS 1492	Gib Taper Pins	4	41	WS 1355	Punch Mounting Bolt Nuts	4
		5/16 x 1-1/4				7/16-14 Hex Full	
10	118-18	Gib Shims	4	42	118-11	Work Table Complete	1
11	118-6	Eccentric Pin	1	43	WS 2518	Work Table Mounting	5
12	WS 1356	Eccentric Pin Nut	1			Screws	
		1/2-13 Hex Full				1/4-20 x 1/2 Flat Head Socket	
13	WS 1706	Eccentric Pin Washer	1	44	241-5	Work Table Gauges	3
		1/2 Flat		45	WS 509	Work Table Gauge Bolts	3
14	118-1 6	Eccentric Pin Handle	1			1/4-20 Socket Cap	
15	11 8-7	Side Links	2	46	WS 1714	Work Table Gauge Washers	3
16	11 8-5	Cam	1			1/4 Flat	
17	1 18-8	Operating Handle	1				
18	100-1 7	Roller Bearing	1				
19	11 8-1 3	Roller Bearing Pin	1				
20	WS 700	Roller Bearing Pin Set Screw	1				
		1/ 4-20 x 1/2 Headless					
21	118-9	Stripper Arms (per set)	1				
22	WS 525	Stripper Arm Bolts	4				
		5/16-18 x 1 Socket Cap					
23	WS 1703	Stripper Arm Bolt Washers	4				
		5/16 Flat					
24	11 8-14	A6 Stripper Plate (Punch	1				
		Size to 1 / 2 ")					
24	11 8-10	86 Stripper Plate (Punch	1				
		Size to 1 ")					
24	1 18-1 5	C6 Stripper Plate (Punch	1				
		Size to 2")					
25	WS 524	Stripper Plate Bolts	2				
		5/16-18 x 3/4 Socket Cap					
26	WS 1703	Stripper Plate Washers	2				
		5/16 Flat					
27	118-3	Die Shoe	1				
28	WS 715	Die Shoe Set Screw	1				
		5/16-18 x 3/4 Headless					
29	WS 68	Die Shoe Bolts	2				
		1/2-13 x 2-1/4 Hex Head					
30	WS 1706	Die Shoe Washers	4				
		1/2 Flat					
31	WS 1356	Die Shoe Bolt Nuts	2				
		1/2-13 Hex Full					
32	11B-20	L8 Punch Holder	1				
33	WS 828	Punch Holder Set Screw	1				
		5/16-18 x 5/16 Socket Set					
<b>Item</b>	<b>Part</b>		<b>No.</b>				