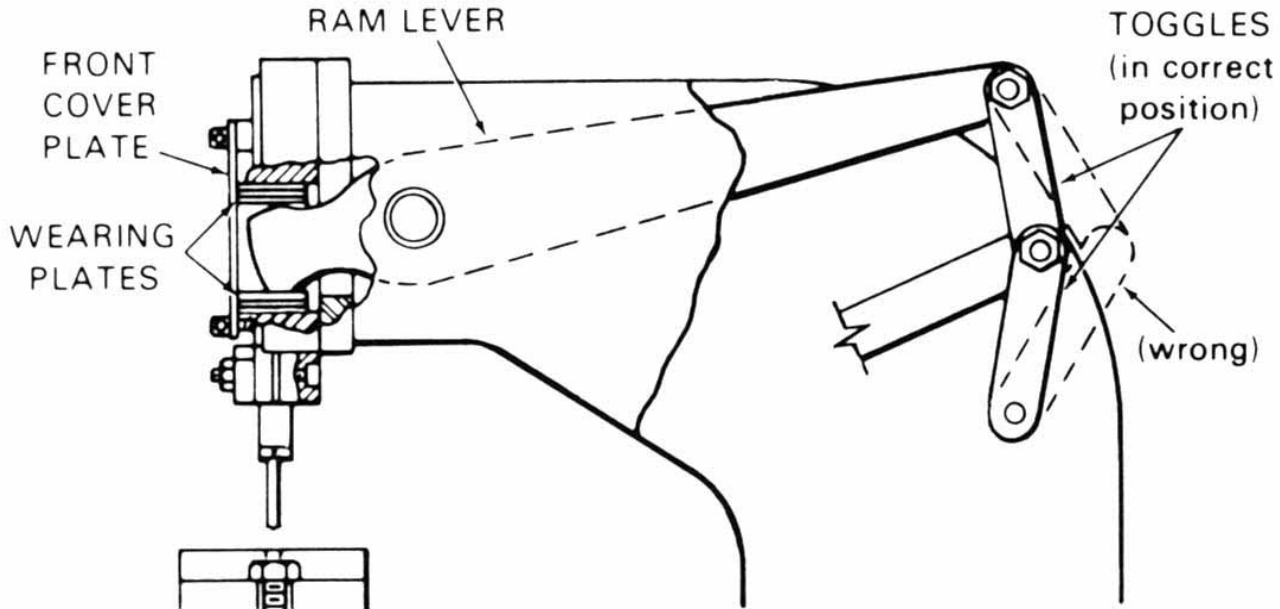


Instructions and Parts List for No 34 Press

CARE: Oil ram gibs and toggle assembly daily.

OPERATION: To change punches, loosen punch retainer bolt nuts and punch retainer set screw. Remove punch holder. To change dies, pivot die shoe forward. Remove die or die adaptor and replace with desired die or die adaptor. Return die shoe to proper position. Lower punch thru die. Align die so clearance is evenly distributed around punch. Tighten die shoe bolt nuts and recheck alignment.

TOGGLE CONNECTING LINKS: If toggles are not positioned correctly the press will punch hard or lock. See Ram Adjustment for correction procedure.



RAM ADJUSTMENT: Punch should enter die approximately 1/16". Toggle connecting links should be in the correct position as shown in the illustration. To correct adjustment:

1. Check to see that connecting link toggle position is correct.
2. Remove front cover plate and reposition wearing plates to achieve correct penetration.

RAM LOOSENESS: Loosen gib bolts on R.H. gib and remove one gib shim. If still loose, repeat on L.H. gib.

WARNING - SAFETY INSTRUCTIONS

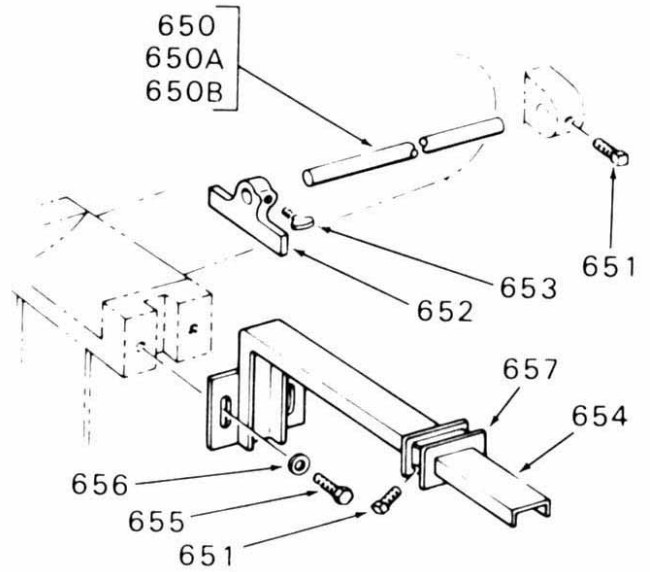
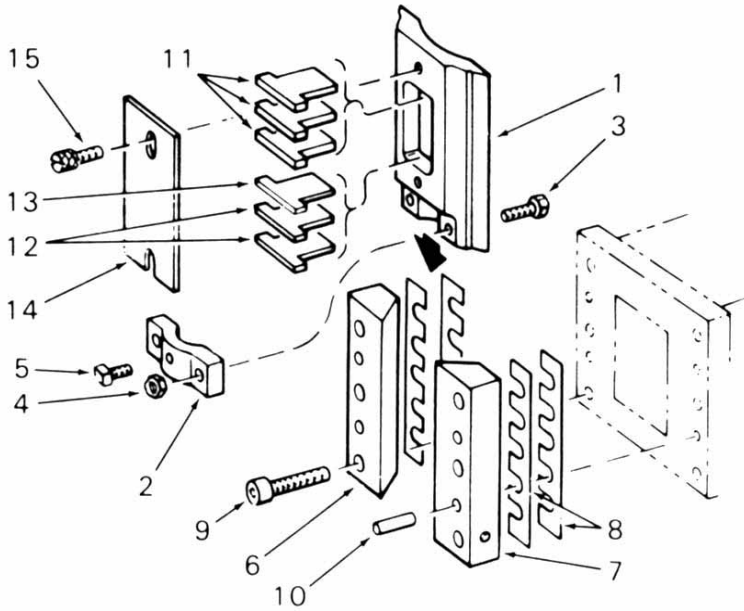
Read and understand these instructions before operating machine. The following punch press safety rules apply:

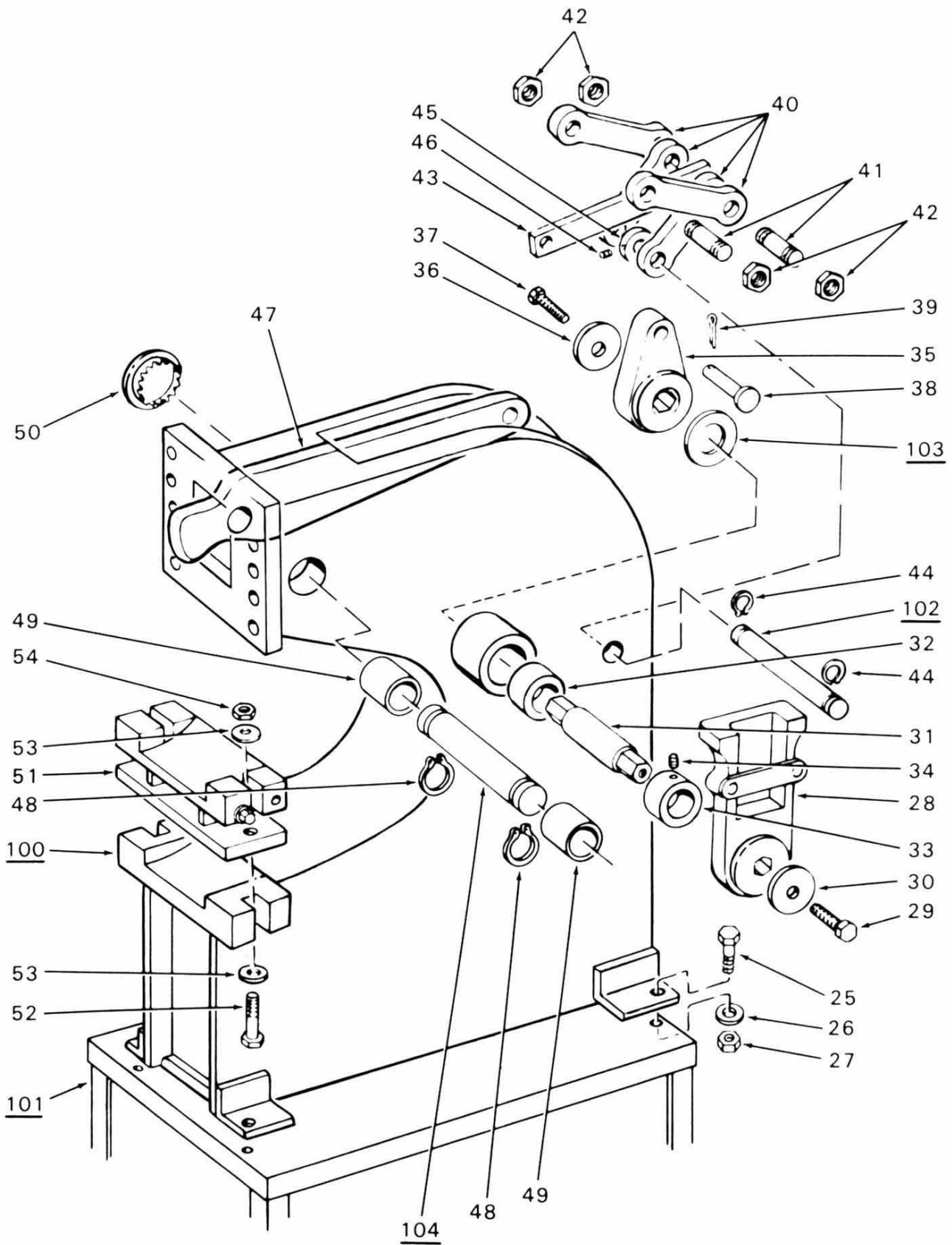
1. MECHANICAL DANGER – Keep hands and fingers clear of the stripper and punch area, and never operate punch press without all guards attached and effective. Failure to comply or misuse of the notcher may result in accidental personal injury; i.e., loss of fingers.
2. Do not operate the punch press without reading the Operators Manual, and without proper supervisory instructions.
3. Punch press to be operated by authorized personnel who have been trained by their supervisor with the working and safety features of the machine, and by reading and understanding the Operators Manual.
4. Never operate punch press with any guard removed; i.e., all required guarding to be installed and effective.
5. Operate the press within the tonnage capacity of the machine. Type and thickness of material versus final hole size will give this tonnage.
6. Use only punches and dies marked with a "W" in a circle or R-W that are designed for the press.
7. Do not use chipped or dull punches and dies.
8. Punch a full hole and not a half hole. Use punches for nibbling.
9. Use safety glasses and other protective devices.

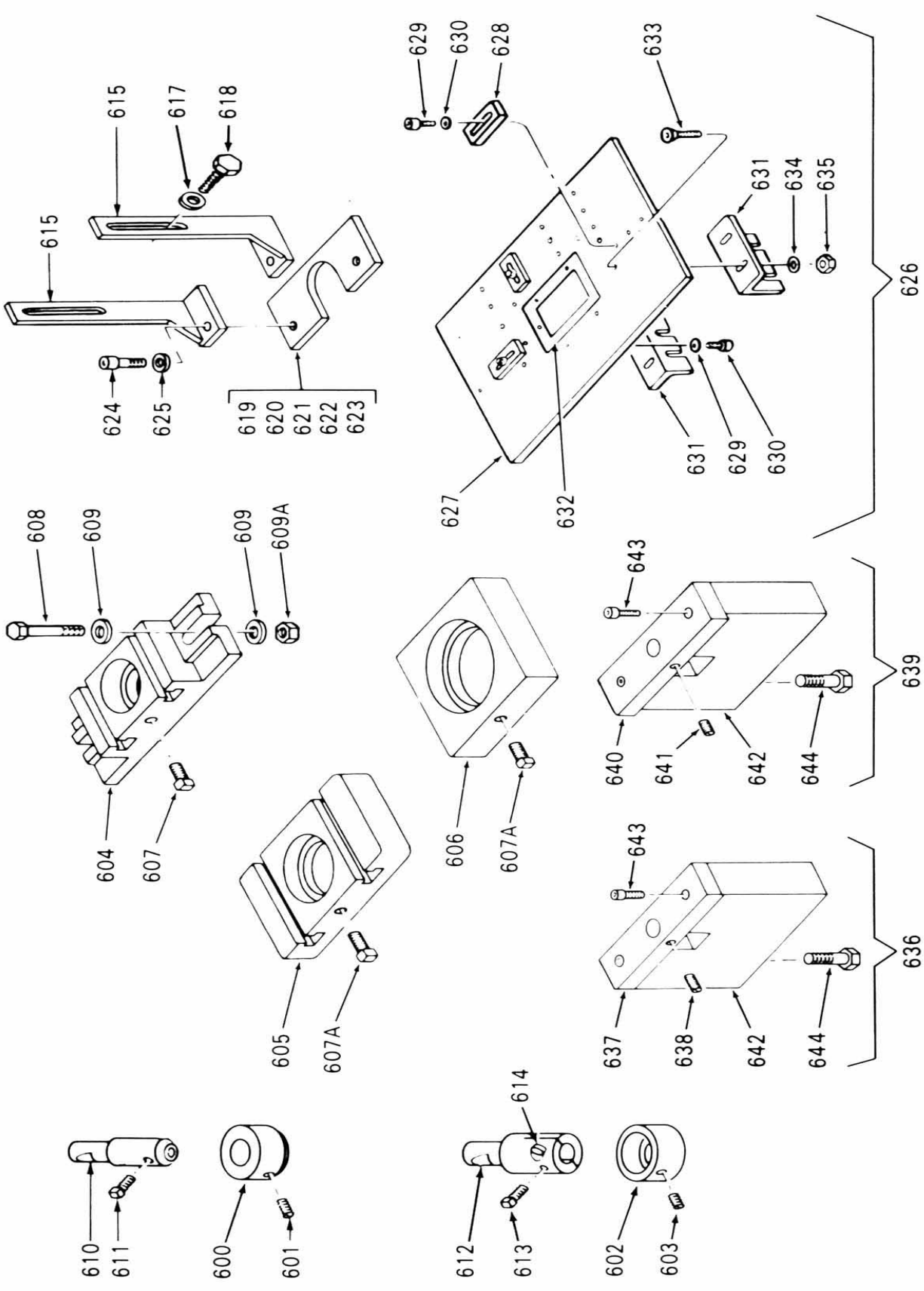
Item No.	Part Name	No. Req.	Part No.	Item No.	Part Name	No. Req.	Part No.
1	Ram w/Punch Retainer	1	232940001	650	Depth Gauge Rod	1	731030092
2	Punch Retainer	1	731600134		For No. 32 Press Only		
3	Punch Retainer Screw	2	600000106	650A	Depth Gauge Rod	1	731030101
4	Punch Retainer Screw Nut	2	643023004		For No. 33 Press Only		
	5/16-18 Regular Hex Nut			650B	Depth Gauge Rod	1	731030108
5	Punch Retainer Set Screw	1	633012131		For No. 34 Press Only		
	5/16-18 x 3/4 Square Head Screw			651	Depth Gauge Rod and Side Gauge	2	633012172
6	LH Gib	1	731400085		Casting Screw		
7	RH Gib	1	731400085		3/8-16 x 5/8 Square Head		
8	Gib Shim	4	731720086	652	Depth Gauge Casting	1	731420078
9	Gib Bolt	6	611012181	653	Depth Gauge Casting Thumb Screw	1	641012088
	3/8-16 x 1-3/4 Socket Cap				1/4-20 x 5/8 Screw		
10	Gib Taper Pin - #6 x 2 Pin	4	600043266	654	Side Gauge	1	731420079
11	1/8" Wearing Plate	4	731060073	655	Side Gauge Mounting Screw	2	601012173
12	3/32" Wearing Plate	2	731060081		3/8-16 x 3/4 Hex Head Cap Screw		
13	1/16" Wearing Plate	1	731060074	656	Side Gauge Mounting Screw Washer	2	678033105
13A	1/4" Wearing Plate	1	731060151		3/8 Flat Washer		
14	Front Cover Plate	1	731060072	657	Side Gauge Casting	1	731730080
15	Front Cover Plate Screw	2	731650077	100	Frame	1	731140141
25	Stand Mounting Bolts	4	601012273	101	Stand	1	34-2
	1/2-13 x 1-1/4 Hex Head			102	Connecting Link Stud	1	33-6
26	Stand Mounting Bolt Washer	4	679033107	104	King Pin	1	33-5
	1/2 Lock Washer			600	No. 20 Die Adaptor	1	136313020
27	Stand Mounting Bolt Nut	4	643023007	601	Die Adaptor Set Screw	1	600325907
	1/2-13 Hex Full Nut				5/16-18 x 3/4 Headless Set Screw		
28	Operating Handle	1	731460156	602	No. 40 Die Adaptor	1	136323040
29	Operating Handle Screw	1	601012128	603	Die Adaptor Set Screw	1	600325904
	5/16-18 x 1/2 Hex Head Cap Screw				5/16-18 x 5/16 Headless Set Screw		
30	Operating Handle Screw Washer	1	678033116	604	F 2-3/4 Die Shoe	1	139404030
31	Actuating Cam Drive Shaft	1	731680154	605	F 3-3/4 Die Shoe	1	139415050
32	Drive Shaft Bushing	2		606	F 4-3/4 Die Shoe	1	139426060
33	Drive Shaft Collar	1	731260147	607	Die Shoe Set Screw	1	621012173
34	Drive Shaft Collar Set Screw	1	621012082		3/8-16 x 3/4 Square Head Screw		
	1/4-20 x 1/4 Socket Set Screw			607A	Die Shoe Set Screw	1	633012179
35	Actuating Cam	1	731210153		3/8-16 x 1-1/2 Square Head Screw		
36	Actuating Cam and Shaft Washer	1	678033116	608	Die Shoe Bolt	2	601012377
37	Actuating Cam and Shaft Screw	1	603012131		5/8-11 x 3-1/2 Hex Head		
	5/16-18 x 3/4 Hex Head Cap Screw			609	Die Shoe Bolt Washer	4	678033119
38	Actuating Cam Pin	1	731160148	609A	Die Shoe Bolt Nut	2	643023009
39	Actuating Cam Pin Cotter Key	1	600073528		5/8-11 Hex Full Nut		
	1/8 x 1-1/4 Cotter Pin			610	F 8 Punch Holder	1	136122808
40	Connecting Link	4	731240070	611	Punch Holder Set Screw	1	633012131
41	Connecting Link Stud	2	731160075		5/16-18 x 3/4 Square Head Screw		
42	Connecting Link Stud Nut	4	730560055	612	F 28 Punch Holder	1	136132828
43	Connecting Link Draw Bar	1	731670149	613	Punch Holder Set Screw	1	633012172
44	Connecting Link Retaining Ring	2	600164304		3/8-16 x 5/8 Square Head		
	5/8 Tru Arc Ring				Set Screw		
45	Connecting Link Spacer	1	731630150	614	Punch Holder Cap Screw	2	611012135
46	Connecting Link Spacer Set Screw	1	621012082		5/16-18 x 1-1/4 Socket Cap Screw		
	1/4-20 x 1/4 Socket Set Screw			615	Stripper Arm	2	731780130
47	Ram Operating Lever	1	731030146	617	Stripper Arm Mounting Bolt	2	601012173
48	King Pin Retaining Ring	2	600164307		3/8-16 x 3/4 Hex Head Cap Screw		
	1-1/8 Tru Arc Ring			618	Stripper Arm Mounting Bolt Washer	2	678033105
49	King Pin Bushing	2	600194617		3/8 Flat Washer		
50	Assembly Cap	1	600000027	619	A-7 1/2" Stripper Plate	1	332200500
51	Die Shoe Support	1	731320145	620	B-7 1" Stripper Plate	1	332201000
52	Die Shoe Support Bolt	2	601012374	621	C-7 2" Stripper Plate	1	332202000
	5/8-11 x 2-3/4 Hex Head Cap			622	D-7 3" Stripper Plate	1	332203000
53	Die Shoe Support Washer	8	678033119	623	E-7 4" Stripper Plate	1	332204000
54	Die Shoe Support Nut	2	643023009	624	Stripper Plate Screw	2	601012131
	5/8-11 Hex Full Nut				5/16-18 x 3/4 Hex Head Cap Screw		
--	48" Bar Handle (Not Shown)	1	731460152	625	Stripper Plate Screw Washer	2	678033104
					5/16 Flat Washer		

Item	No.	Part
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No.	Part Name	Req.	No.
626	Work Table Assy. Complete	1	137000320
627	Work Table Plate	1	731090122
628	Work Table Gauge	3	774420101
629	Work Table Gauge and Insert Screw	7	611012086
	1/4-20 x 1/2 Socket Head Cap Screw		
630	Work Table Gauge and Insert Washer	7	678033103
	1/4 Flat Washer		
631	WorkTable Clamp Bracket	2	731200124
632	Work Table Insert	1	731670123
633	Work Table and Clamp Bracket Screw	4	605012131
	3/8-16 x 3/4 Flat Head Machine Screw		
634	Work Table and Clamp Bracket Washer	4	678033104
	5/16 Flat Washer		
635	Work Table and Clamp Bracket Nut	4	649023004
	5/16-18 Jam Nut		
636	No. 10 Die Shoe Complete	1	139541010
637	No. 10 Die Shoe	1	731570156
638	Die Shoe Set Screw	1	621012083
	1/4-20 x 5/16 Set Screw		
639	No. 20 Die Shoe Complete	1	139552020
640	No. 20 Die Shoe	1	731570157
641	Die Shoe Set Screw	1	623012081
	1/4-20 x 1/4 Set Screw		
642	Die Shoe Block	1	731130155
643	Shoe and Block Screw	2	621012083
	3/8-16 x 1 - 1/2 Socket Head Cap Screw		
644	Shoe Mounting Screw	2	601012281
	1/2-13 x 2-1/2 Hex Cap Scre		







Auxiliary Attachments