

THE INSTRUCTION MANUAL FOR THE PUNCH EXCHANGE JIG(PUNCH ASSEMBLY)  
WHICH ATTACHED ON PUNCH PRESS MACHINE THE LARGE-DIAMETER  
**PROTECH 3 Plus /PROTECH 3 Standard Plus** GUIDE SET.

Thank you very much for purchasing the large-diameter **PROTECH 3 Plus / PROTECH 3 Standard Plus** guide set.  
When using the tool, please be sure to understand the following instruction and work safely.

Customers purchasing  
the **2-inch** size guide set.

For those purchasing a guide set  
other than the **2-inch** size.

The following procedure is not necessary, so please  
continue to use it as is.

If using a punch exchange jig (Punch assembly fixture), it is necessary to replace the key of fixture.  
We kindly ask you to follow the instruction below.



If punches are assemble with original key, there is a possibility that our adapter part may deform,  
resulting in the inability to set it up.

**[Important]**

Please use the key (Image 2) included in the guide set  
when assemble our 2-inch **PROTECH 3 Plus** or  
**PROTECH 3 Standard Plus** guide sets into the punch  
exchange jig on the turret punch press machine  
(Image 1). It is necessary to replace the original key  
with the new included key.

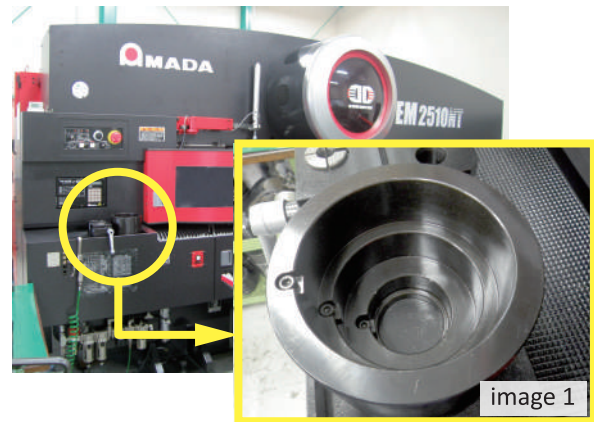


image 1

**[The method for replacing built-in fixture keys]**



Remove the 2-inch punch  
fixture key (arrow position)  
using an M6 hex wrench.



The key to be exchanged

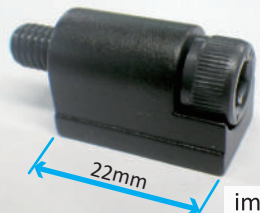


image 2



Install the included key and  
tighten using an M6 hex  
wrench.