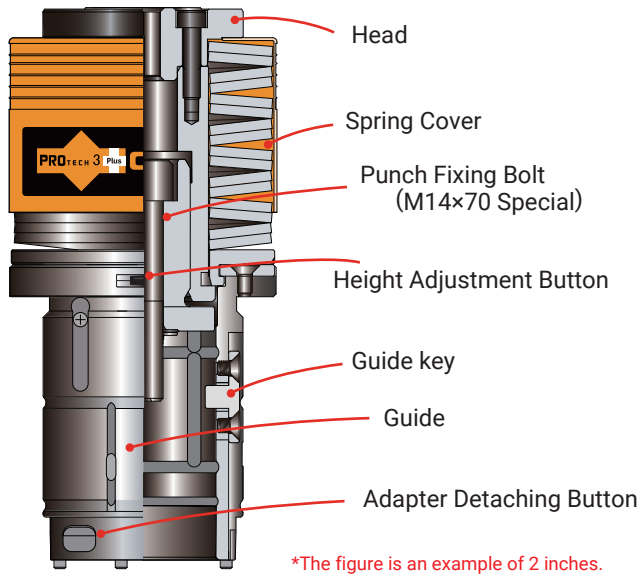


Thank you for purchasing the **PROTECH 3 Plus**.

When using the tool, please be sure to understand the following instruction and work safely.

Specification



This tool is designed to prevent sticking and improve durability by supplying oil mist to the punch's cutting edge and sliding parts.

Please make sure to operate it with the air blow function set to 'ON'.

1. Please use the Oil Mist Punch (OMP) for the punch. The punch fixing bolt is 'M14 (special with through holes)'.
2. A stripper plate with air blow holes can be installed even if it is from another manufacturer.
3. Please refer to the specification sheet attached to the spring cover of the guide set for the maximum processing capacity, maximum processing plate thickness, and punch sharpening specifications based on the plate thickness for this guide set.
4. To ensure accuracy, **please do not disassemble** the guide set. In case maintenance such as part replacement is necessary, we provide 'repair service upon receipt'.

Assembly (Disassembly) Method for Punch



1. To fit the punch onto the guide, align the punch keyway with the guide key for proper phasing.



2. Insert a hex wrench (for M14) from the head side and loosely tighten the punch fixing bolt.



3. Attach the Stripper Plate to the adapter. Install the parts designed to secure the Stripper Plate on the adapter side so that they fit into the grooves of the Stripper Plate. Adjust the position of the Stripper Plate to align with the punch tip.

The solid stripper and nesting stripper are integral, so there is no need to perform this operation.



4. Align the guide key groove with the adapter release button, insert the punch tip into the hole of the stripper, push in the adapter, and engage it with the adapter release button.



5. Please ensure that the adapter is securely locked onto the adapter detachment button.



6. Set it on the punch exchange jig that comes with the turret punch, and tighten the punch fixing bolts (tightening torque standard is 91N·m).

Adjustment Method for the Specified Punch Height



1. Pushing the height adjustment button located on the guide set's collar towards the punch tip side activates the height adjustment mode as shown in the picture.



2. By pressing the height adjustment button and rotating the head, you can adjust the height of the punch.



3. Rotate the head to align the punch tip with the stripper plate's clamping surface at the same height.

[↓ direction: Extend the punch height]

[↑ direction: Reduce the punch height]



4. Rotate the head in an ↑ direction until the punch tip is positioned 1mm inside the stripper plate.

The guideline is to rotate the head by five notches (equivalent to half a turn) marked by the concave shape on the guide.

Note: 0.2mm height changes per 1 mark.

5. Please lightly rotate the guide section and spring cover to the left and right to ensure they are locked before use.

*In the case of disassembly, it would involve the reverse procedure.