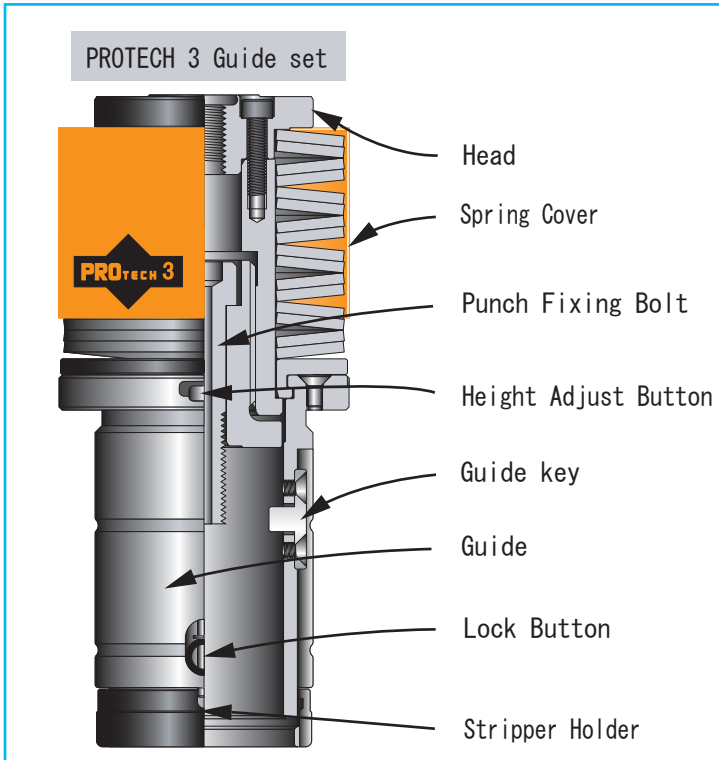


PROTECH 3 GUIDE SET TOOL MANUAL

Thank you very much for purchasing CONIC PROTECH 3 Guide set.
Please read this manual carefully and understand to use CONIC tool safety.

[Specification]

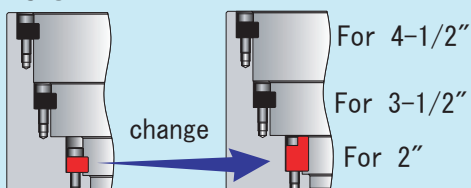


- (1) Please use OMP punch for this guide set.
Punch fixing bolt (M14) has small hole for oil through.
- (2) Please use OMP stripper plate for this guide set.
- (3) Regarding about maximum processing capacity, maximum processing thickness etc. Please refer to the specifications table that is attached to the spring cover of the guide set.
- (4) For ensuring accuracy, with the exception of the stripper holder, please do not disassemble. Please send to CONIC when maintain or repair guide set.

[Note]

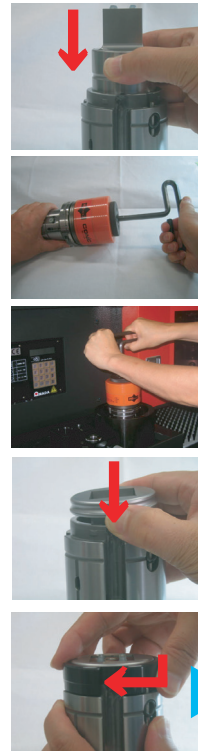
- (1) When change or assemble CONIC OMP tools by using tool change jigs attached on NC machines, Please change 2" station key of the tool change jigs to CONIC OMP key.
(It is not necessary to change other station key)

Tool change jigs



- (2) Please make sure that stripper holder is perfectly lock before use.

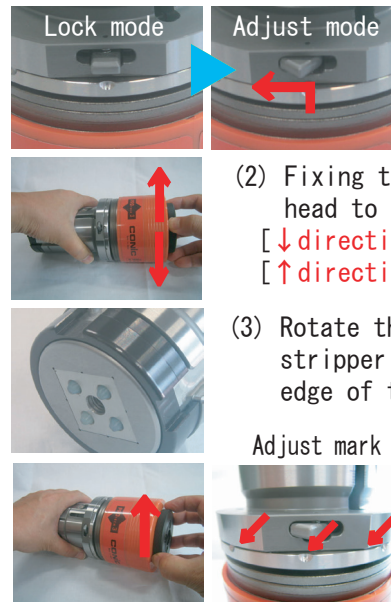
[How to assemble or disassemble punch]



- (1) Insert the punch into the guide.
- (2) Insert hexagonal wrench (for M14) from the head side and tighten the punch fixing bolt.
- (3) Set in a tool change jig and tighten more.
- (4) Set the stripper plate into guide set.
- (5) Set the stripper holder, and make sure the stripper holder locked perfectly.
Please see reverse side for details.

※ The procedure of disassemble is the reverse of this procedure.

[How to adjust punch height]



- (1) Set the height adjust button to "Adjust mode".

- (2) Fixing the guide and rotate the head to adjust height.
[↓ direction: Punch height extends]
[↑ direction: Punch height shrinks]

- (3) Rotate the head and align the stripper plate and the cutting edge of the punch.

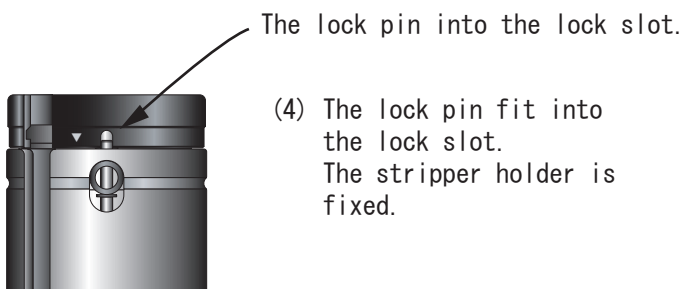
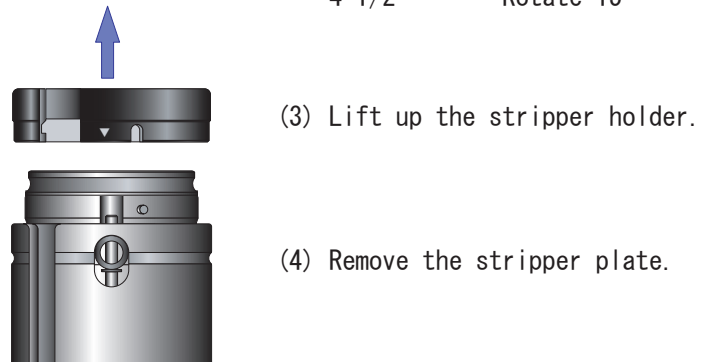
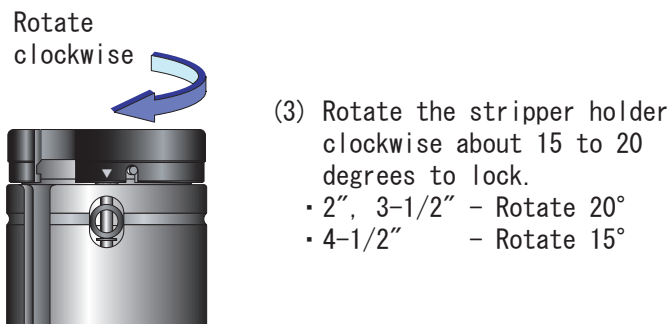
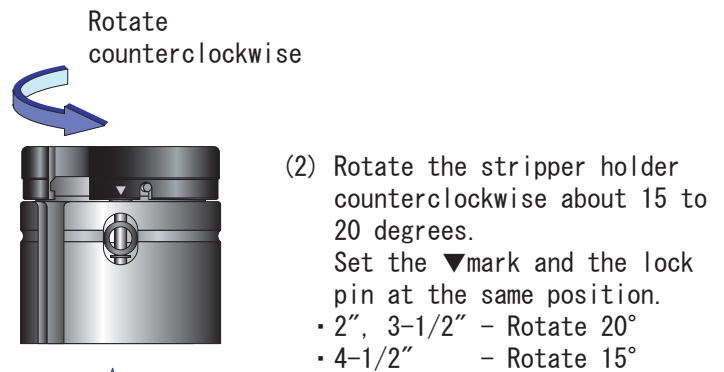
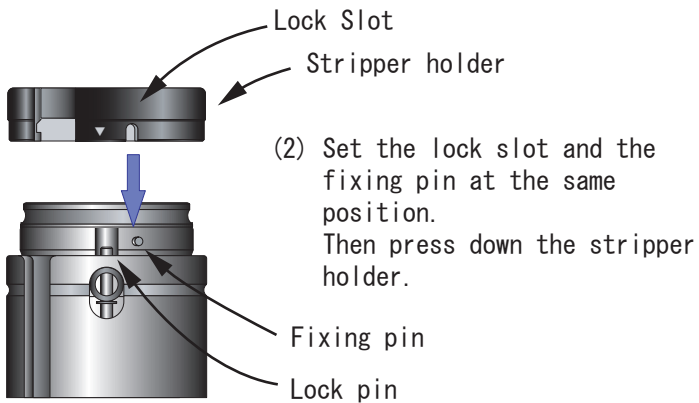
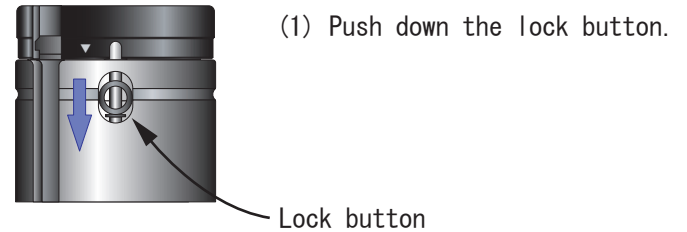
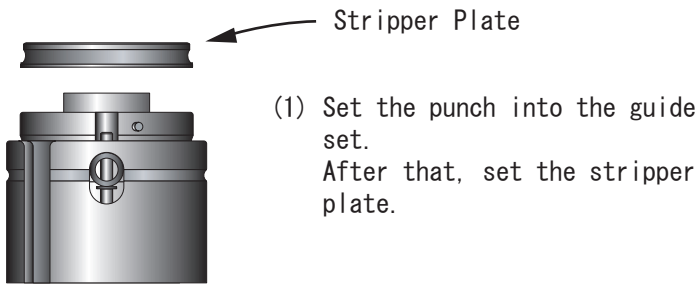
- Adjust mark
- Rotate the head in the "↑" direction and adjust the punch height to certain length.
- [2" : Adjust 5 step of "Adjust mark". (half round)]
 - [3-1/2" : Adjust 10 step of "Adjust mark". (one round)]
 - [4-1/2" : Adjust 5 step of "Adjust mark". (half round)]

- (5) Set the height adjust button to "Lock mode".

- (6) Rotate the head and the guide lightly and make sure that it is locked properly.

How to assemble stripper plate

How to disassemble stripper plate



【Note】
Please make sure that stripper holder is perfectly locked before use.

【How to check the punch life】

Punch can be re-grind up to 5mm when use the PROTECH 3 guide. The scale on the side of guide show the re-grinding amount.



More information,
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