

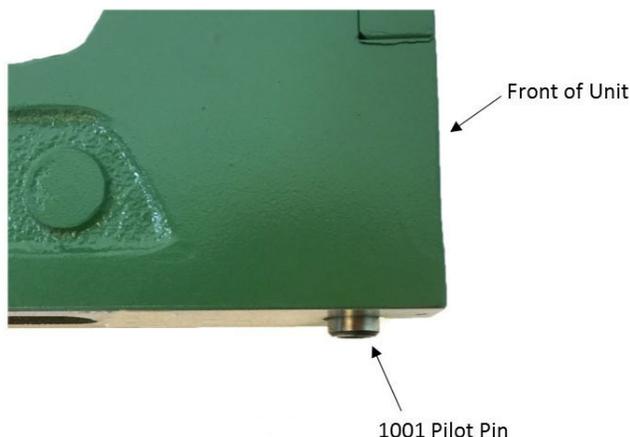
A-8 Unit (For Round Holes)

Assembly and Punch and Die Replacement

Lower Arm Assembly

Pilot Pin Removal: To remove the pilot pin, thread the 1/4-20 x 1/2 set screw into the holder to back the pilot pin out of its hole.

Pilot Pin Installation: Use a brass or aluminum hammer to install the pilot pin assembly (P/N 1001) into the hole on the bottom of the holder under the die. Ensure the pilot pin is perpendicular to the bottom and extends 3/32" from the bottom surface. Thread the 1/4-20 x 1/2 set screw (P/N 91332), supplied with pilot pin), until it touches the bottom of the hole, being careful not to push the pilot pin back out.



Die Removal: To remove the die, loosen the two button head screw (P/N 91130) and the guide retainer (P/N 1018) from the upper arm of unit. Lift the top punch and guide assembly out of the unit to allow clearance for the die. Then loosen the die set screw (P/N 91350 5/16-18 x 3/8) in the front corner of the holder and, if necessary, push the die up out of the holder from the slug chute.

Die Installation: First make sure the die and die seat are free of debris. Then insert the die (P/N 1420) with the cutting edge on the top, being sure the die is fully seated in the lower arm of the holder and tighten the die set screw to secure the die in place. **Useful tip:** reinsert the guide assembly and push down on the guide to help tap the die down into the die seat to make sure it is fully seated.

Upper Arm Assembly

Punch, Guide and Spring Assembly: First check punch and die alignment. Externally lubricate punch body (P/N 1410) with a thin even coat of lubricant (e.g. P/N 8007 Molykote® type G-N metal assembly paste). Insert punch (threads facing up) into the punch driver (P/N 1474). Externally lubricate the bottom punch driver and insert the punch driver into the shaped guide (P/N 1485), making sure the keyway on the punch driver aligns with the guide key (P/N 2878) on the top of the guide. Externally lubricate outside diameter of guide body. Molykote® type GN metal assembly paste or die grease is recommended. Loosely thread the S.H.C.S. (P/N 91072) only a few threads, by hand, into the punch. Now using the punch screw as a handle, drop this punch and guide assembly through the guide bore of the holder, gradually lowering the punch into the die. Visually look to see that the die clearance is even all the way around. If the die clearance is uneven, contact UniPunch.

Pull this assembly back out once die clearance is visually verified and remove the punch screw leaving the punch and punch driver in the guide.



Assemble the (4) lifter springs (P/N 1470) into the four pockets on the upper arm of the holder. Then assembly the (4) spring cages (P/N 6043) on top of the lifter springs as shown in the picture on the left. Insert the (2) guide retainers (P/N 1018) into the two corner pockets of the upper arm of holder, making sure the flat on the guide retainer is facing the center of the guide bore of the holder.

Insert the (9) stripping springs (P/N 2240) into the pockets on the top of the guide. Then assembly the punch plate (P/N 1473) to the punch driver using (4) S.H.C.S. (P/N 91047). Assemble the S.H.C.S. (P/N 91072) thru the punch plate into the punch and tighten.

Assemble the punch and guide assembly into the holder. Insert the (2) B.H.C.S. (P/N 91130) into the guide retainers by inserting the screws down thru the hole openings in the punch plate as shown in the picture on the right, making sure the flats on the guide retainer are aligned with the flats on the guide.

Converting a Round Unit to a Shaped Unit

Purchase a key kit (P/N 9338) and the appropriate shaped punch and die.

