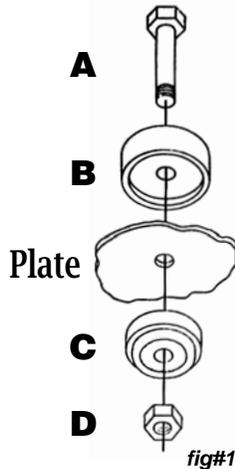




# 61-327 Panel Punch Hole Punching Instructions

To cut aluminum or magnesium up to 1/16" thick, the following procedure is recommended:



1. Drill a 5/8" pilot hole in the center of the area to be punched.
2. Mount the punch in the pilot hole as shown in fig#1 (shows the mounting for a 3-1/8" hole). To cut a 2-1/4" hole mount the male punch "B" and the female die "C" with the opposite sides of the die toward each other.
3. Tighten the drawbolt "D" until the punch cuts completely through the metal.

To cut heavy stock up to 1/16 to 1/8" thickness it is recommended that the hole be started with a series of smaller bites using the following procedure:

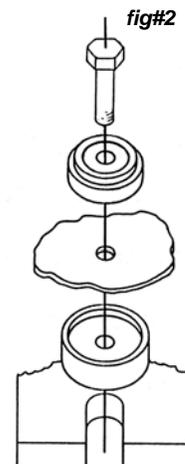
1. Mount the punch in the pilot hole and tighten the drawbolt "D" snugly.
2. Tighten the drawbolt one additional turn to make the punch bite into the metal.
3. Loosen the drawbolt partially and rotate the male punch "B" approximately 30° clockwise.
4. Tighten the drawbolt snugly and then tighten it one additional turn to bite the metal.
5. Repeat steps 3-4 until seven bites are completed.
6. On the seventh bite continue to tighten the drawbolt until the punch cuts completely through the metal.

## Cutting with a hydraulic press:

The Panel Master may be used in a hydraulic press when mounted as shown in fig#2. 1/8" stock may be cut in one pass on a hydraulic press without the series of small bites recommended for hand cutting. Care should be taken not to bottom the punch in high pressure presses. Four to five tons are necessary to pierce 1/8" aluminum (6061 series).

Extended tool life and ease of operation will be obtained with a light coating of grease on the threads and a film of oil on the cutting surfaces.

This tool has been designed to give long lasting and satisfactory service.



**Caution:**  
Do Not Use  
on Iron or  
Steel or  
Any Stock  
Over 1/8"

Toll Free Nationwide & Canada: **800-645-8180**

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