

XYZ OPERATOR'S MANUAL

Operating the Punch Station

All punch marking should be done before cutting the workpiece, because parts that have been cut may be located across the lead-in paths to the marking points. Also, small parts may not stay in place on the cutting table during the marking process as well as they do with a larger plate.

Punch Marking in Manual Mode

1. Depress and hold down the PUNCH MARK TEST button until the desired punch is made.

Note: For single-point marking, the depth of the punch depends on the length of time the button is held down.

2. Release the PUNCH MARK TEST button once the punch is made.

Punch Marking in Automatic Mode

Warning Before refilling the lubricator or changing the center-punch tool, turn OFF the air supply and bleed pressure off the lines. Failure to do so may result in personal injury.



Note: Set the air pressure at the regulator to 90 psi before using the punch marker.

Note: During punch operation, the lubricator on top of the lift station must be kept filled with an SAE10W nondetergent oil. The drip rate at the lubricator should be 90 drops per minute to allow 3 drops per minute to the marker.

1. Press the AHC ALLOW to permit operation of the Automatic Height Control.
2. Press the PUNCH AHC button on the Series 2000 CNC. This turns ON the Punch Automatic Height Control. The multi-impact hammer should be set to about 0.4 inch above the workpiece.