

PUNCH & DIE REPLACEMENT

1. Turn machine upside down, letting it rest on the hand-wheel with the base table facing you.
2. Rotate machine until character to be replaced aligns with cutout portion in base providing access for removal.
3. With screwdriver, remove two screws securing the die and slide die out, being careful not to drop the screws or die into the confines of the machine.
4. Insert screwdriver through holes in die carrier and remove two screws securing punch, being careful not to drop the screws or punch into the confines of the machine.
5. Note the positioning of the color coded markings on the new punch and die, and separate them by carefully prying them apart.
6. Place punch screws into new punch and carefully slide punch into its mounting position with color code facing outward from center of machine. Tighten screws with screwdriver inserted through holes in die carrier.
7. Carefully place die on punch and make certain color coded markings are aligned. Apply very slight pressure to start the die mating with the punch.
8. Raise punch until die is against the die carrier, insert die mounting screws and washers, and tighten screws alternately, a little at a time.

