



Assembly Instructions Magnet Puncher

In order that the magnet puncher can carry out high quality marking it is important that the Assembly Instructions are carefully followed and that the indicated tolerances are observed.

In case of wear, where the indicated tolerances are exceeded, the worn parts should be replaced.

As loose bolts and screws can cause serious damage and operating trouble, it is important that the stated torque moments are observed and that bolts are after-tightened regularly.

Tools for Assembly

Torque wrench for 10 Nm - 15 Nm - 20 Nm

Ring/fork wrench: 8mm - 12mm - 18mm

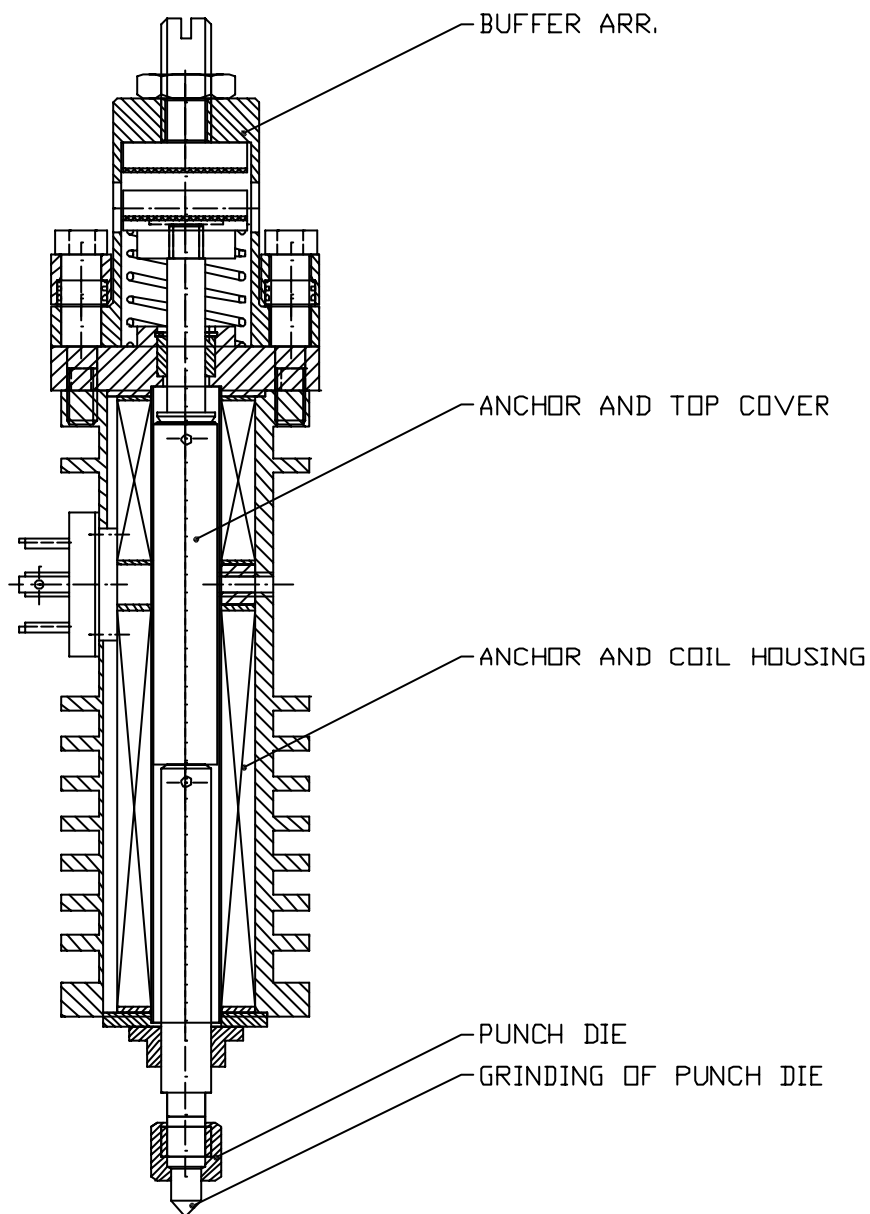
Hexagon socket wrench: 4mm - 5mm

Screwdriver

Safety:

It is important to read the Assembly Instructions before disassembly/assembly of the magnet puncher in the punch head.

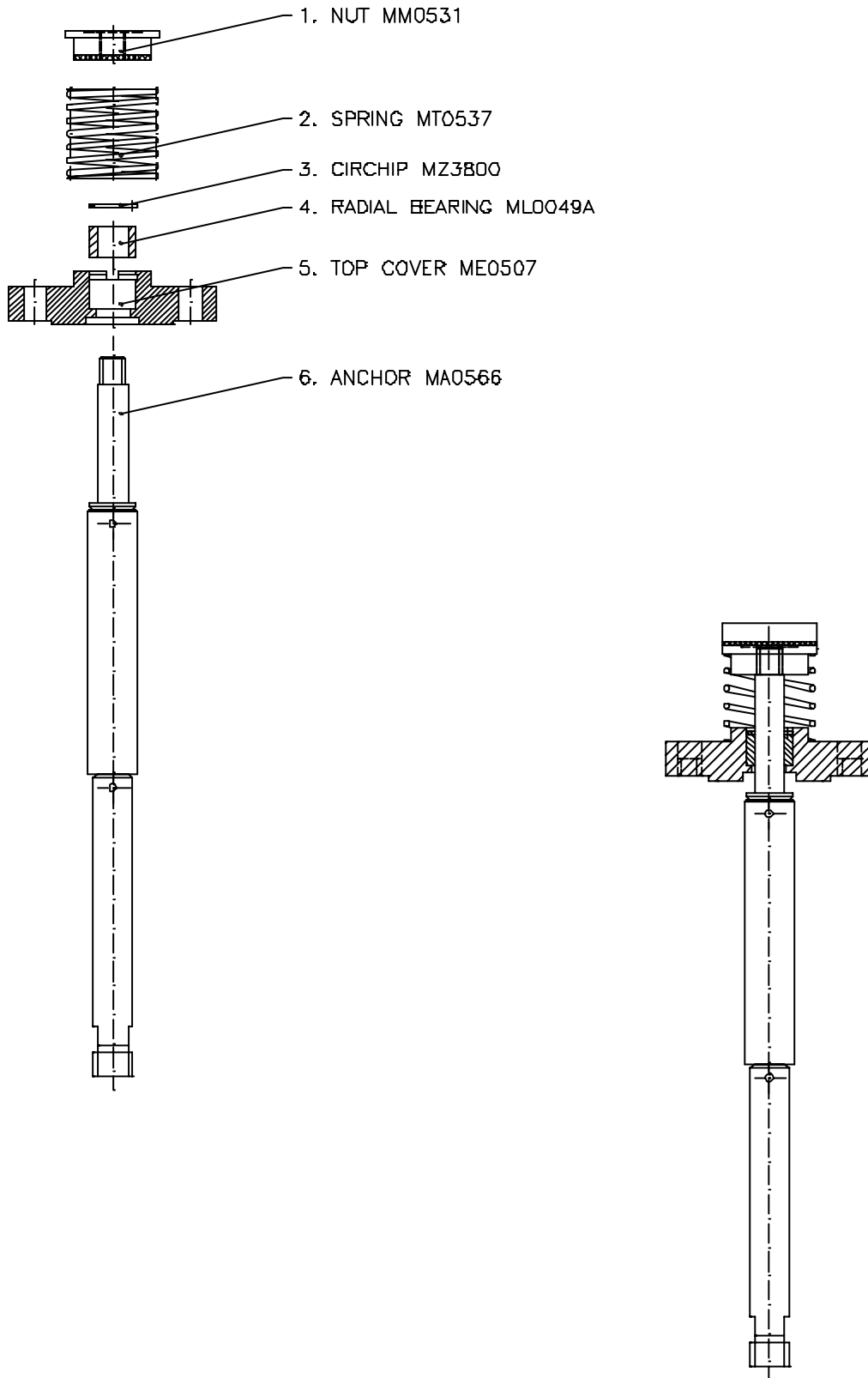
Assembly Instructions Magnet Puncher



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Assembly of Anchor and Top Cover



Assembly Instructions Magnet Puncher

Only original, approved and controlled components must be used.

Assembly of Anchor and Top Cover

1. Radial bearing Pos. 4 is pressed into the top cover Pos. 5.
2. Circlip Pos. 3 is assembled.
3. Top cover Pos. 5 is assembled on the anchor.
4. Spring Pos. 2 is placed on top cover Pos. 5.
5. Thread in top of anchor Pos. 6 is provided with LOCTITE 222 and nut Pos. 1 is screwed on and tightened with 15 Nm.



Important

The radial bearing Pos. 4 must be lubricated with a few drops of oil and the following must be checked:

The bushing slides easily on the anchor.

Radial slackness is max. 0.3 mm.

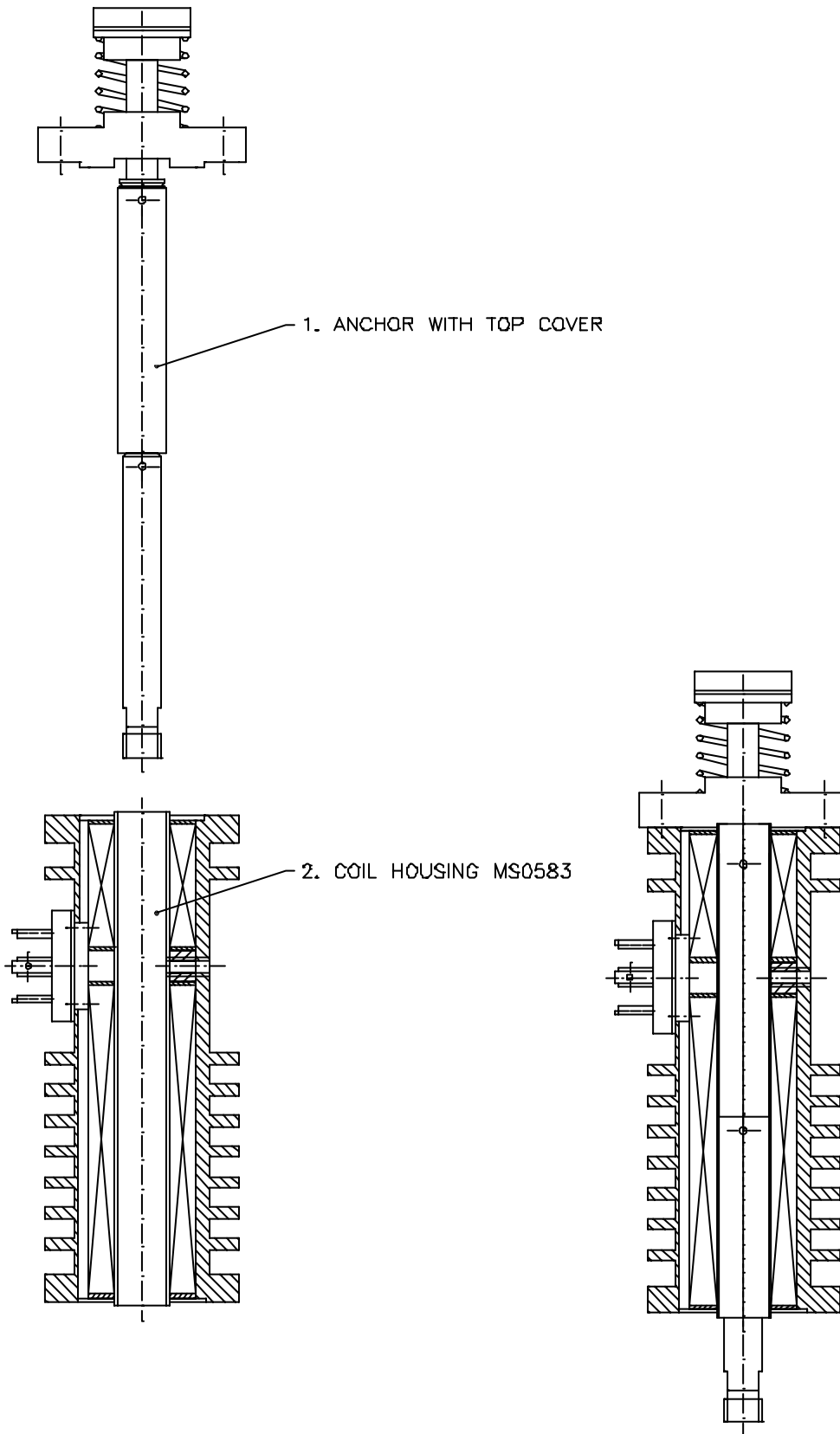
Wear Parts:

Pos. 1 Nut MM0531

Pos. 4 Radial bearing ML0049A

Pos. 6 Anchor MA0566

Assembly of Anchor and Coil Housing



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Assembly of Anchor and Coil Housing

1. Anchor with top cover Pos. 1 is assembled in coil housing Pos. 2.

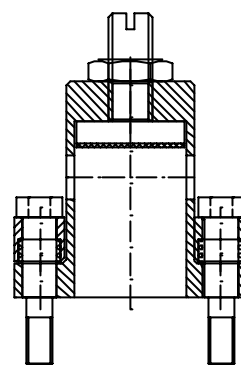
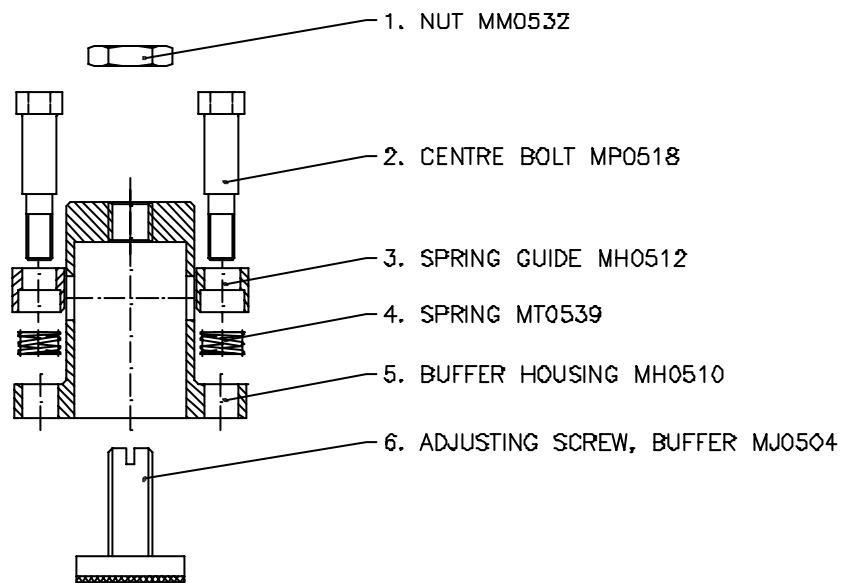


Important

Check that:

The top cover moves easily in the coil housing and abuts on the flange.

Assembly of Buffer Housing



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Assembly of Buffer Housing

1. Buffer Pos. 6 is assembled in buffer housing Pos 5.
2. Nut Pos. 1 is assembled on buffer Pos. 6.
3. Spring Pos. 4 is assembled in spring guide Pos. 3.
4. Centre bolts Pos. 2 are assembled in spring guide.



Important

It is important that:

Spring guide and centre bolts move easily in the buffer housing.

There is no squeezing.

Rubber cover on adjusting screw is min. 0.5 mm.

Wear marks between buffer housing and spring guide max. 0.3 mm.

Wear Parts:

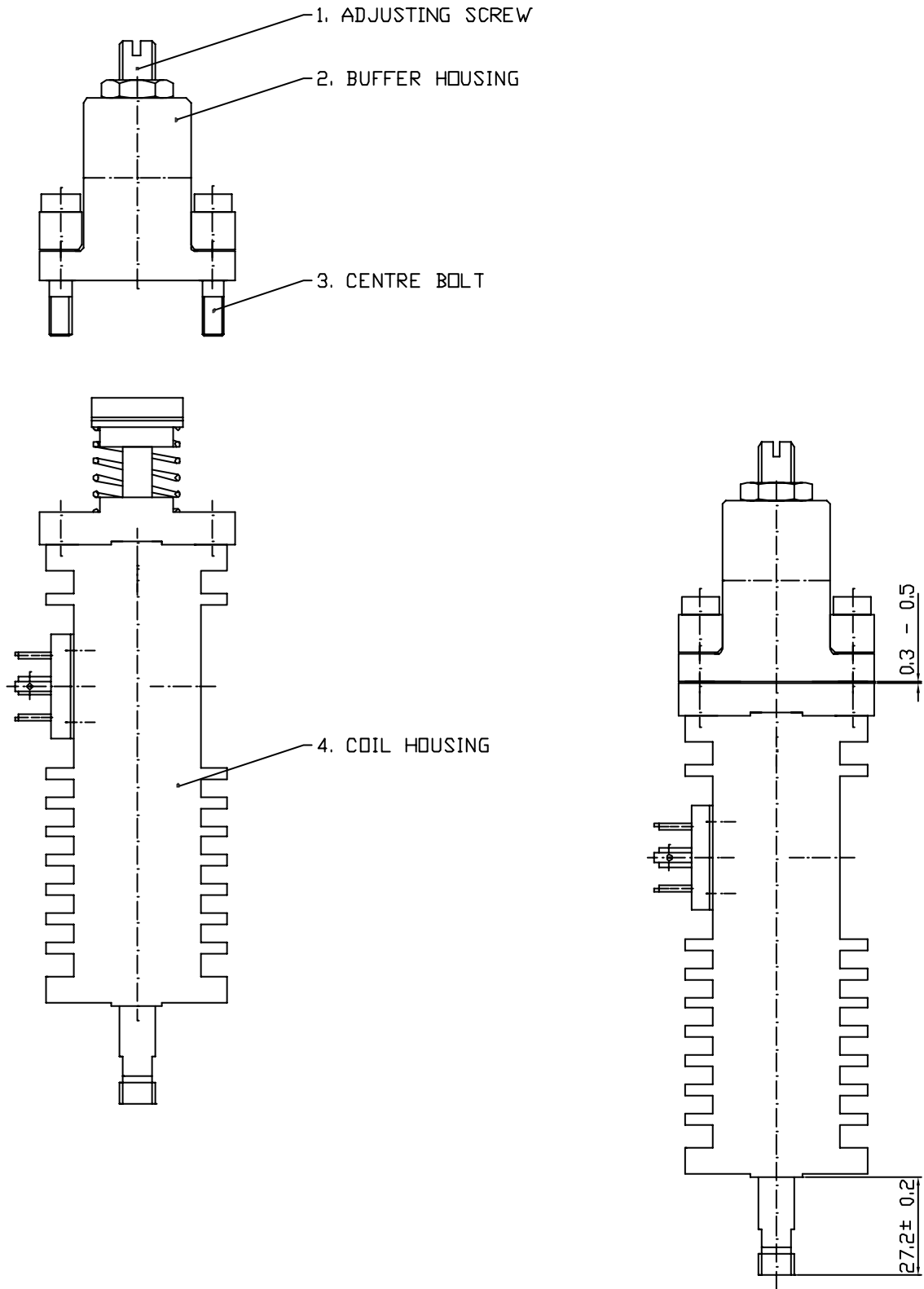
Pos. 2 Centre bolt MP0518

Pos. 3 Spring guide MH0512

Pos. 5 Buffer housing MH0510

Pos. 6 Adjusting screw, buffer MJ0504

Assembly of Buffer Housing and Coil Housing



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Assembly of Buffer Housing and Coil Housing

1. Thread on centre bolts Pos. 3 is provided with LOCTITE 222.
2. Buffer housing Pos. 2 is assembled on coil housing Pos.4.
3. Centre bolts Pos. 3 are tightened to 10Nm.
4. Distance to anchor is adjusted on adjusting screw Pos. 1. to $27.2 \text{ mm} \pm 0.2$.
5. Lock nut on adjusting screw is tightened to 20 Nm.



Important

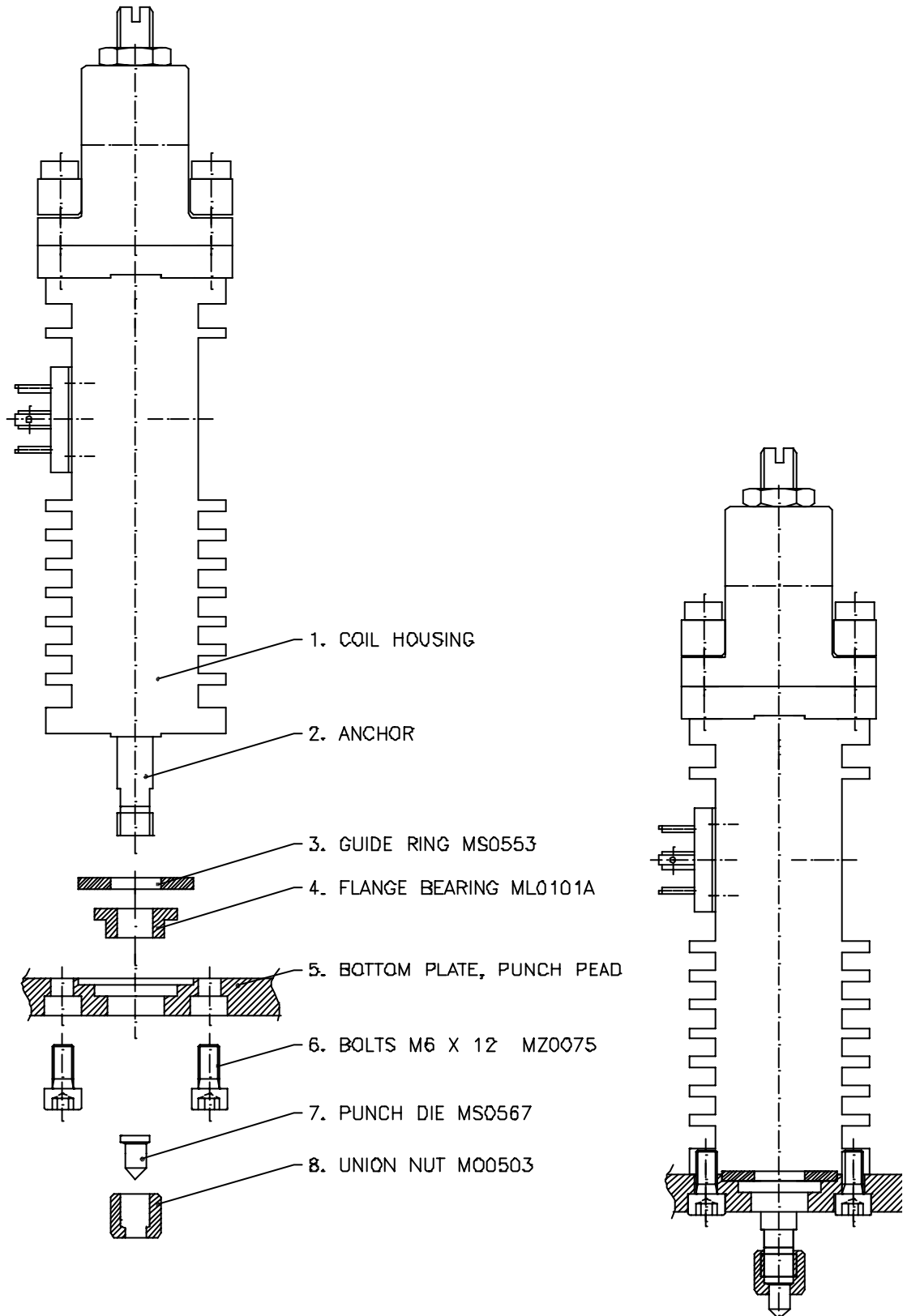
Check that:

The buffer housing can be lifted 0.3 - 0.5 mm by pressing the anchor.

The anchor can be moved easily in its full stroke length.

There is no squeezing.

Assembly of Punch Die and Radial Bearing



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Assembly of Punch Die and Radial Bearing

1. Guide ring Pos. 3 is assembled in coil housing Pos. 1.
2. Radial bearing Pos. 4 is assembled on anchor Pos. 2.
3. Coil housing Pos. 1 and bearing Pos. 4 are assembled in the bottom plate Pos. 5.
4. Bolts Pos. 6 are screwed into the coil housing Pos. 1 and tightened to 10 Nm.
5. Punch die Pos. 7 is assembled on anchor Pos. 2 and tightened with a nut Pos. 8.



Important

Check that:

The anchor can be moved easily in its full stroke length.

Radial slackness in bearing Pos. 4 is max. 0.3 mm.

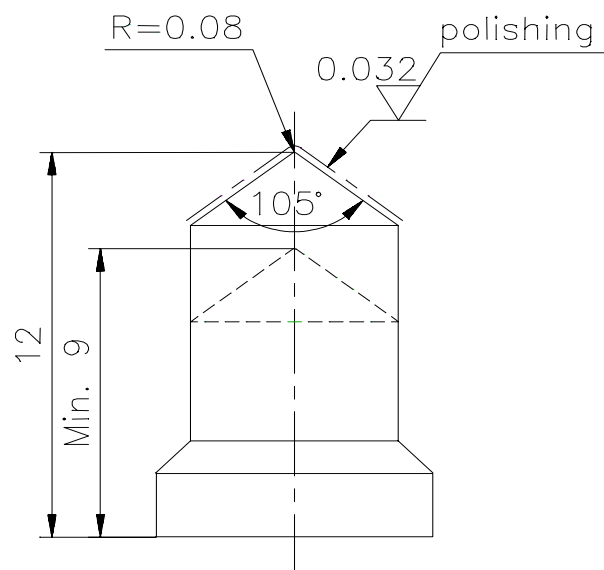
Punch die is highly polished.

Wear Parts:

Pos. 4 Flange bearing MLO101A

Pos. 7 Punch die MS0567

Polishing of punch die



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Grinding of Punch Die

A new punch die is supplied highly polished.

1. Mount the punch die, which is made of hard metal, in a retainer, which can rotate the punch die, so that it is uniformly grinded.
2. The angle, which the punch die is to be grinded to, is shown on the drawing.
3. Grinding of the punch die is carried out with a diamant grinding stone medium or fine.
4. After grinding the punch die is polished with a felt disc with diamant wax.



Important

It is important that:

The punch die is highly polished. If this is not the case the lifetime is considerably reduced.

The punch die can be grinded/polished many times, however, max. 3 mm of the height.

It is recommended that the height difference does not exceed 1.5 mm of polished punch dies.