



OPERATION MANUAL 10/2019-WW

ps:[®]beta-V2[®]

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FOR MACHINE TYPE THICK TURRET - STATION A AND B

1.
Bring markings together



2.
Pull the guide from the head



3.
The punch has to be screwed off



4.
Remove the stripper



5.

New or regrinded punch has to be screwed up to approx. 5 to 15 mm



6.

Snap the stripper



7.

Clip the guide and align stripper to the punch



8.

Snap the guide (in correlation to the markings)



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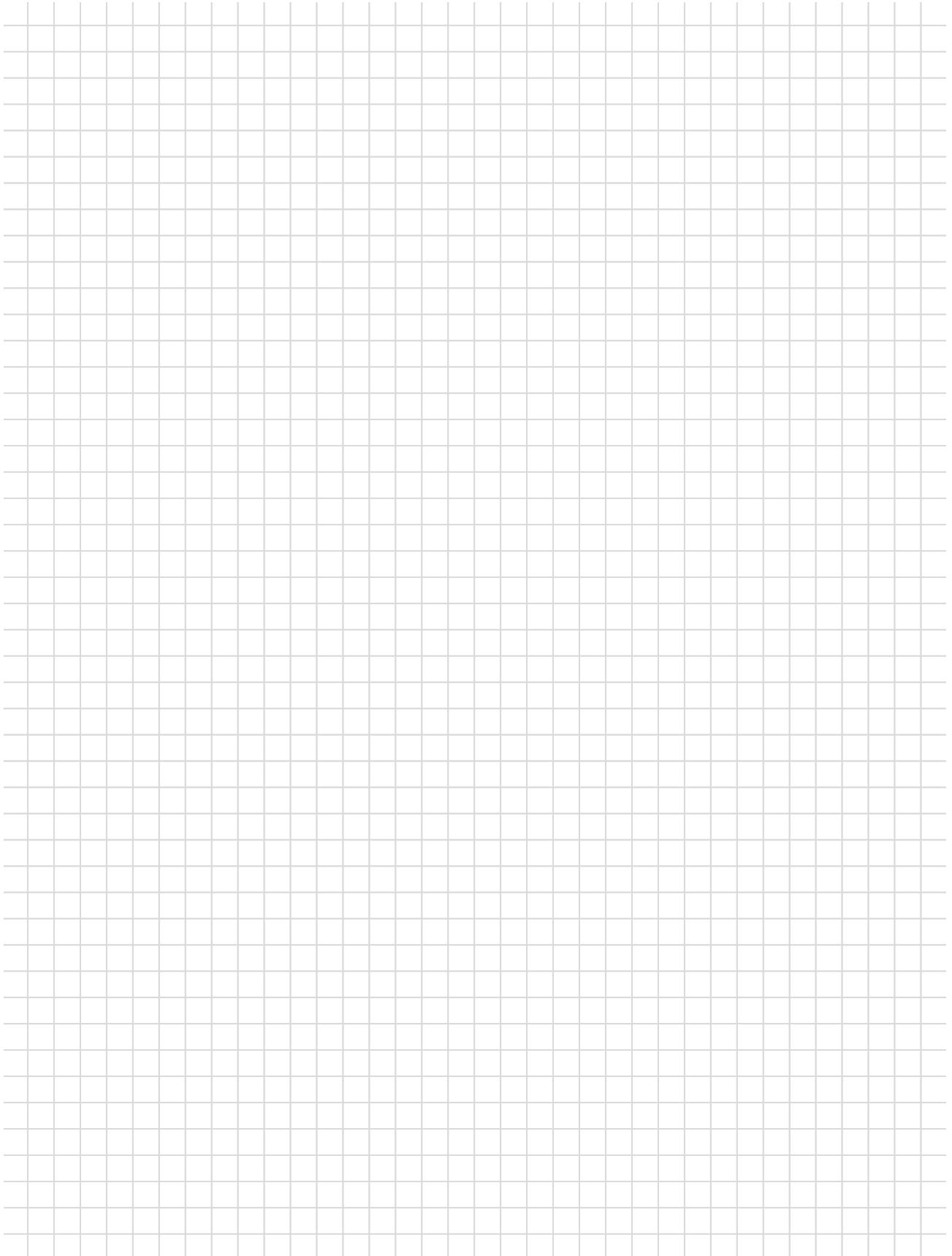
FOR MACHINE TYPE THICK TURRET - STATION A AND B

9.

Press the snap valve and adjust punch length by turning the head



NOTES



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FOR MACHINE TYPE THICK TURRET - STATION C, D, E

1.
Press the stripper clamping
(stripper jumps out)



2.
Remove
the stripper



3.
Tighten the PASS assembly adapter into the PASS assembling plate and put the guide assembly into the relevant PASS adapter.
Open the screw (hexagon key SW 10 mm)



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FOR MACHINE TYPE THICK TURRET - STATION C, D, E

4.
Remove
the punch



5.
Insert a new or a regrinded punch



6.
Tighten the screw
Recommended turning moment: 120 Nm

It is not allowed to dismantle
the head screws!!



7.
Insert the stripper



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FOR MACHINE TYPE THICK TURRET - STATION C, D, E

8.

Length can be adjusted by pressing the snap valve and turning the head, if necessary.

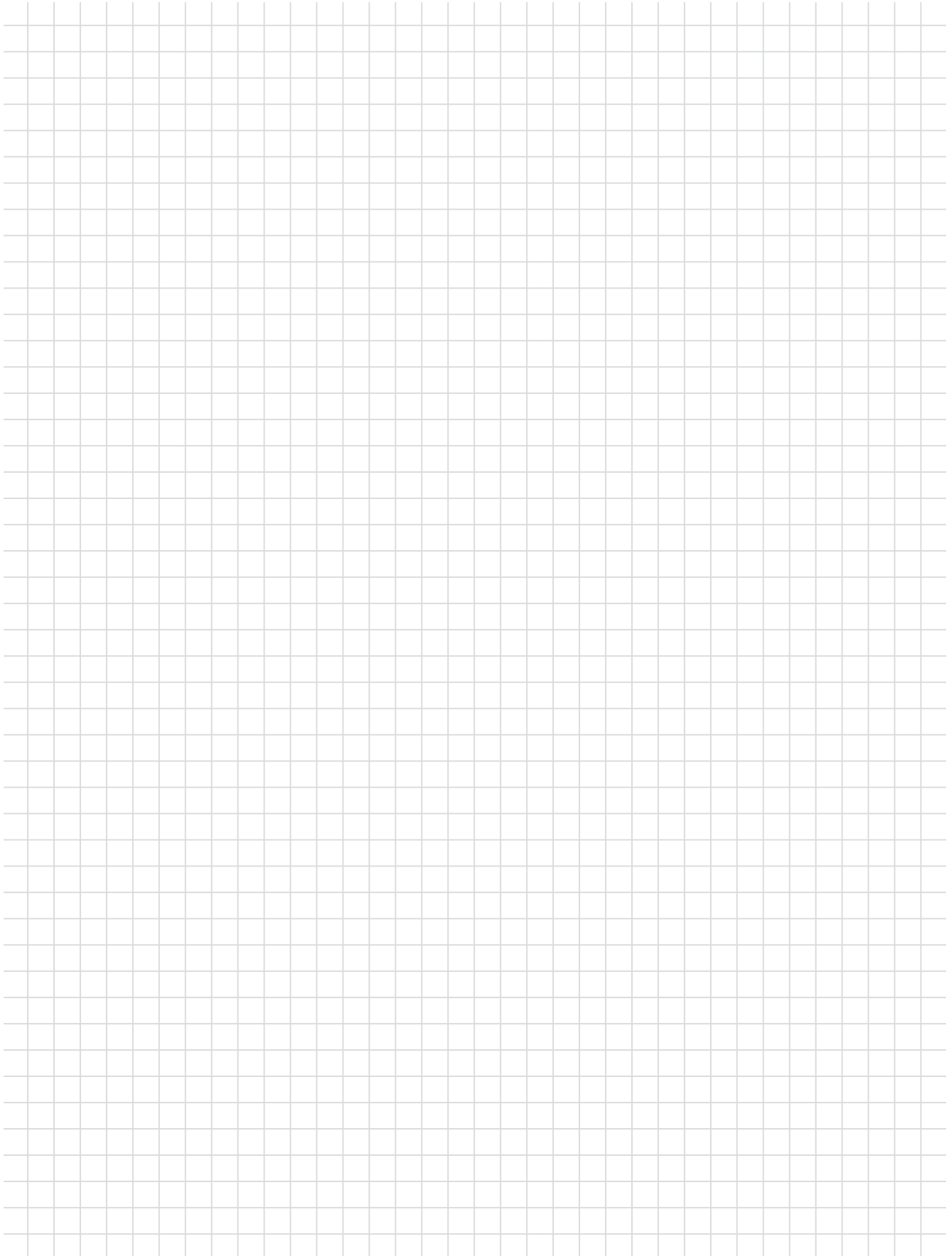
Punch approx. 0,5 - 1 mm behind the stripper



If there might be any problems (e.g. break of springs) we ask you to return the tool to us for repair.

Yours PASS Stanztechnik AG

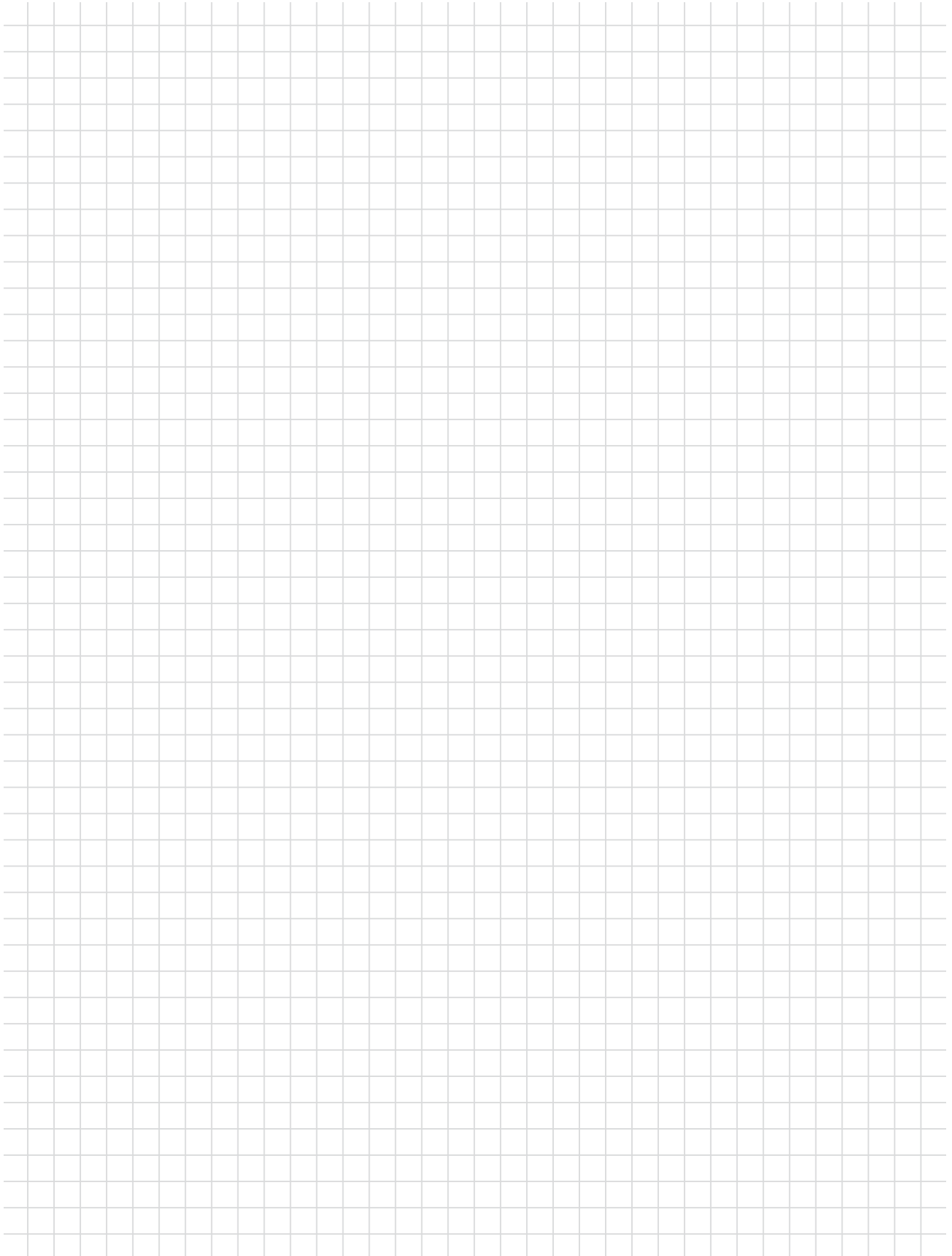
NOTES



NOTES

A large grid of graph paper for taking notes, consisting of 20 columns and 30 rows of small squares.

NOTES



SALVAGNINI | **THICK TURRET** | **TRUMPF**



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