



OPERATION MANUAL 04/2020-WW

ps:® marking-all-in-one

OPERATION MANUAL

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FOR MACHINE TYPE THICK TURRET / PRIMA POWER

SHEET QUALITY: **all sheet materials** SHEET THICKNESS: **from s = 0,8 mm**

THANK YOU VERY MUCH,

for purchasing **ps:®marking-all-in-one** engineered and produced by PASS Stanztechnik AG.

It is our utmost intention to guarantee you a long-term service with your new PASS product: **ps:®marking-all-in-one**.

Therefore we created a short manual with technical data and service notes.

Please feel free to contact us in any case of questions.

Yours

PASS Stanztechnik AG

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FOR MACHINE TYPE THICK TURRET / PRIMA POWER

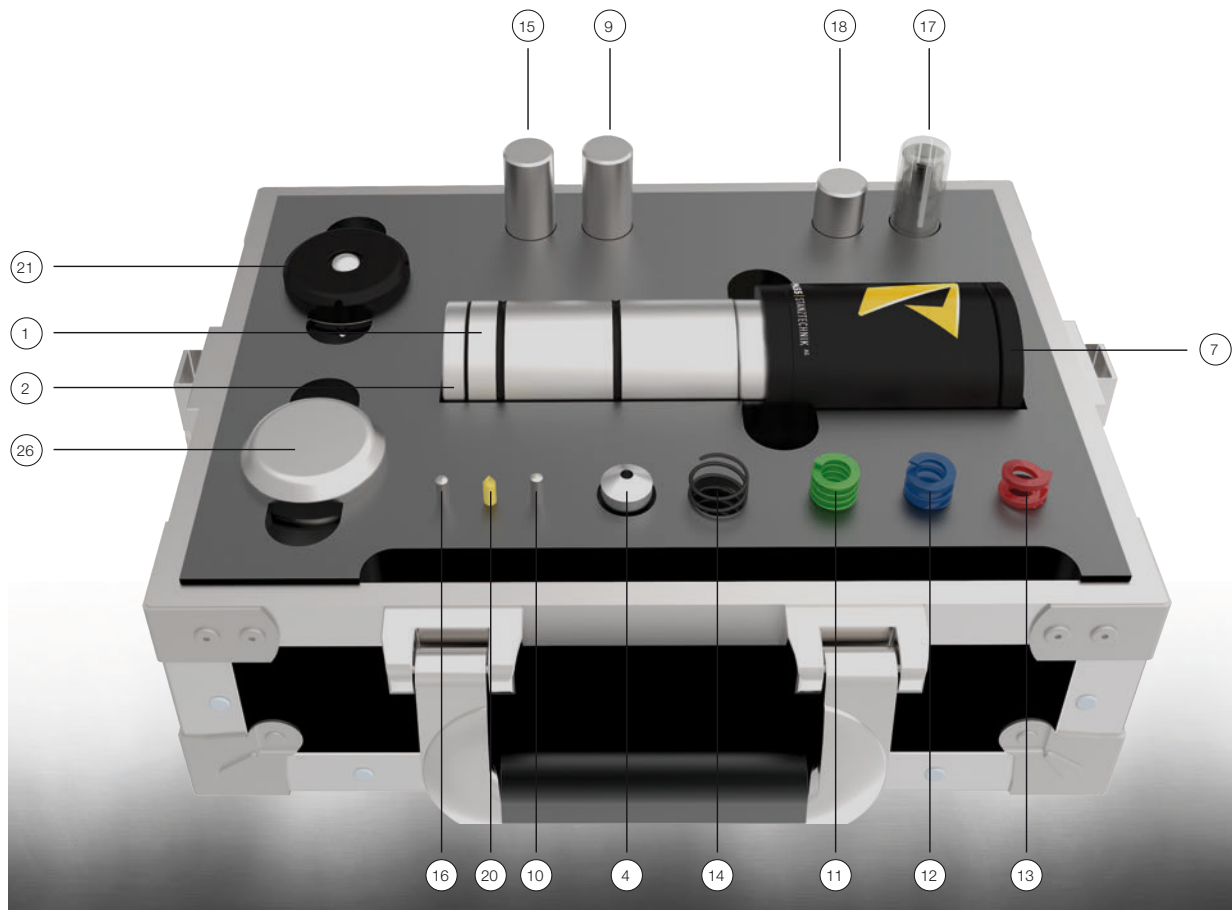
A

SHEET QUALITY: **all sheet materials**SHEET THICKNESS: **from s = 0,8 mm**

A. SCOPE OF DELIVERY

The scope of delivery includes:

- | | | | |
|---|---|---|---|
| ① | 1 punch guide | ⑭ | 1 spring black (extra soft: for aluminium anodised or foil tearing) |
| ② | 1 guide plate | ⑮ | 1 pressure bar center punch |
| ④ | 1 needle holder | ⑯ | 1 center punch needle made of H-PM [®] |
| ⑦ | 1 punch head | ⑰ | 1 marking pen |
| ⑨ | 1 pressure bar engraving function | ⑱ | 1 weight for marking pen |
| ⑩ | 1 engraving needle with diamond point | ⑳ | 1 foil tearing needle made of brass |
| ⑪ | 1 spring green (soft: for aluminium) | ㉑ | 1 ball roller die |
| ⑫ | 1 spring blue (middle: for stainless steel or mild steel) | ㉒ | 1 die |
| ⑬ | 1 spring red (hard: for stainless steel) | | |



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B. METHOD OF OPERATION

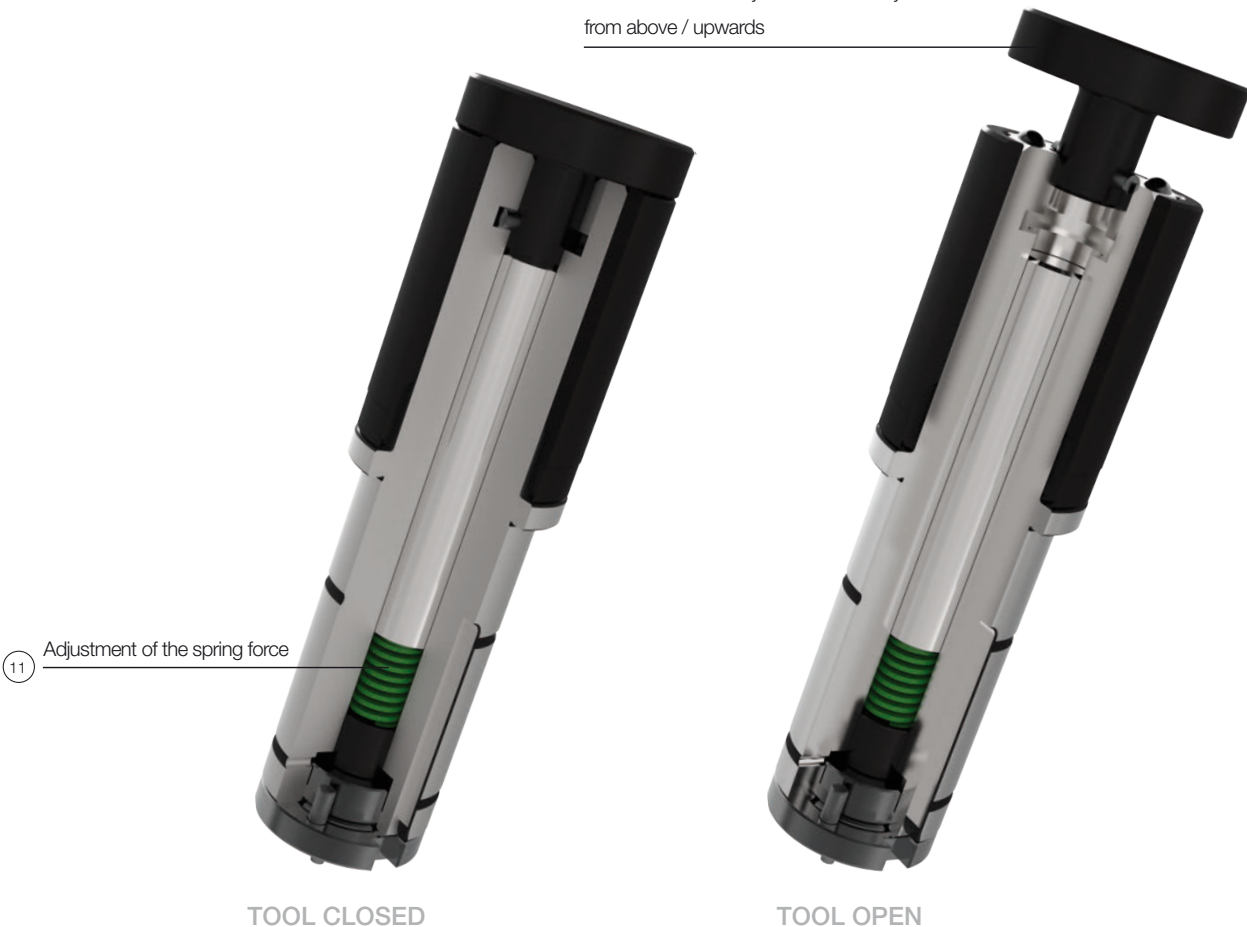
The tool can be modified for the various marking options by easy handling.

The inserts are changed via the head screw. Therefore, the head screw must be turned 90° and, depending on the application, the appropriate inserts have to be installed in the needle holder.

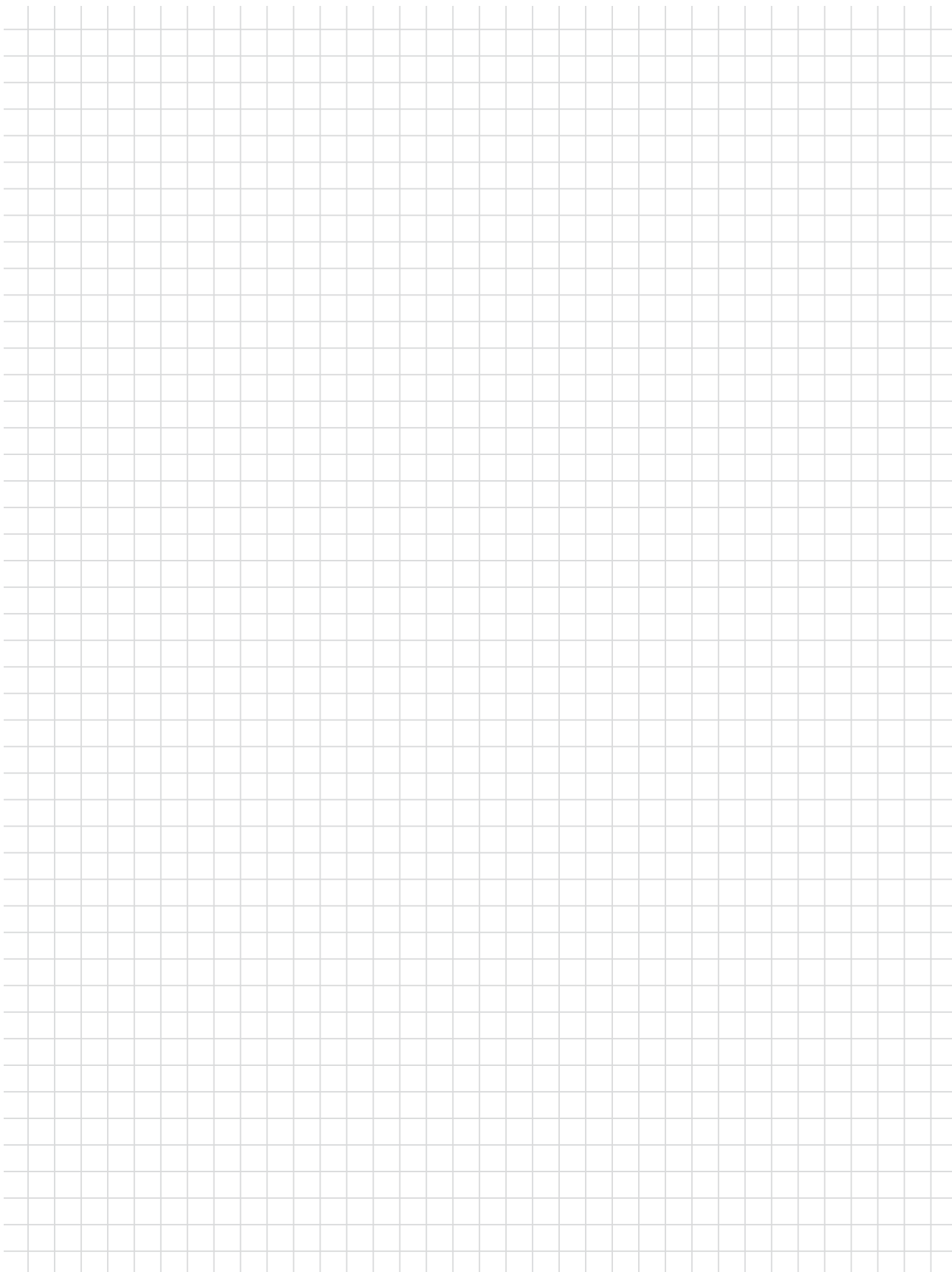
The spring force for engraving or foil tearing is adjusted via the springs (pos. 11, 12, 13, 14):

- green spring (pos. 11): soft for aluminium
- blue spring (pos. 12): middle for stainless steel and mild steel
- red spring (pos. 13): hard for stainless steel
- black spring (pos. 14): extra soft for aluminium anodised and foil tearing

Twist lock - Assembly and disassembly of the inserts
from above / upwards



NOTES

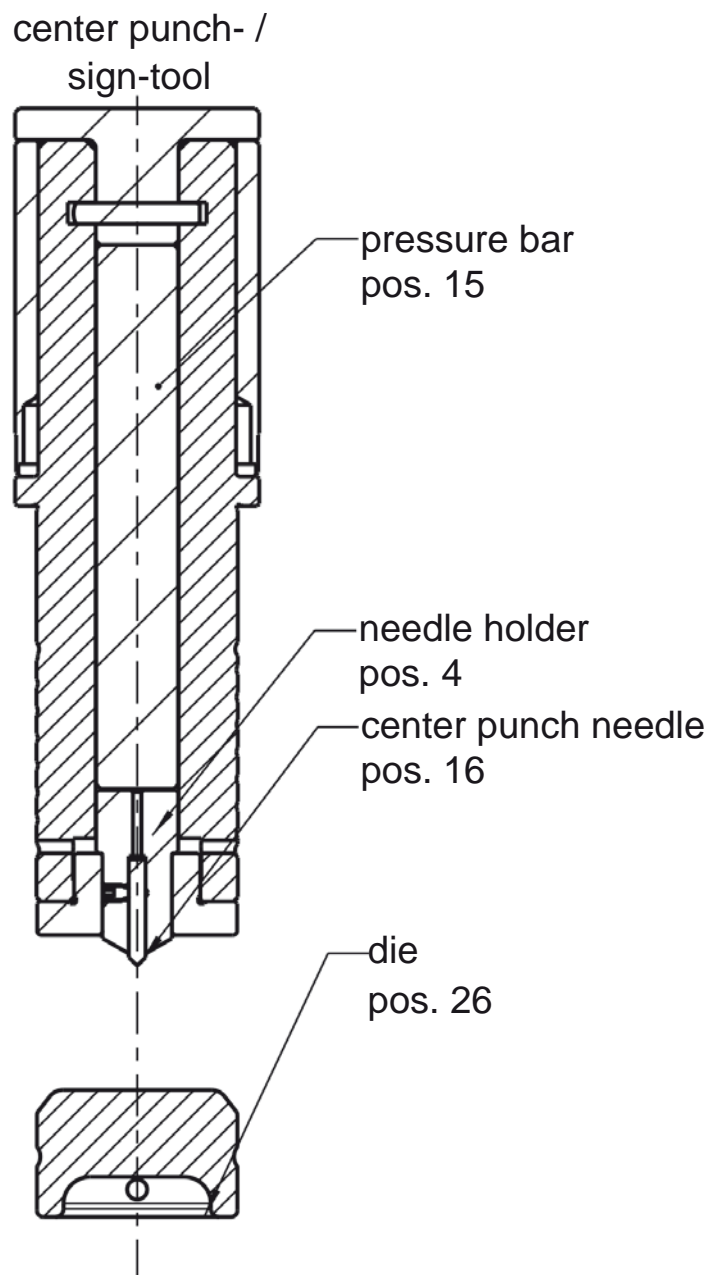


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C. CENTER PUNCHING / SIGNING



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Station: 12 - SIGNIERWERKZEUG (0,2mm/0°)

Save tool

Basic tool settings | Tool parameters

Mode

Sheet marking

Kein Schutz erforderlich

Tool measurements

Tool length: - 203 + mm

Punch stripper compensation: - 0 + mm

Stripper distance: - 5 + mm

Lower limit: - -0,1 + mm

Axis speed: - 250 + mm/min

Tool grinding alert: 500000 hits

Tool lubrication interval: 0 hits

Hit counts: 106318 / 106318 [Reset](#)

mm

200

150

100

50

0

203 mm

-0,1 mm

C

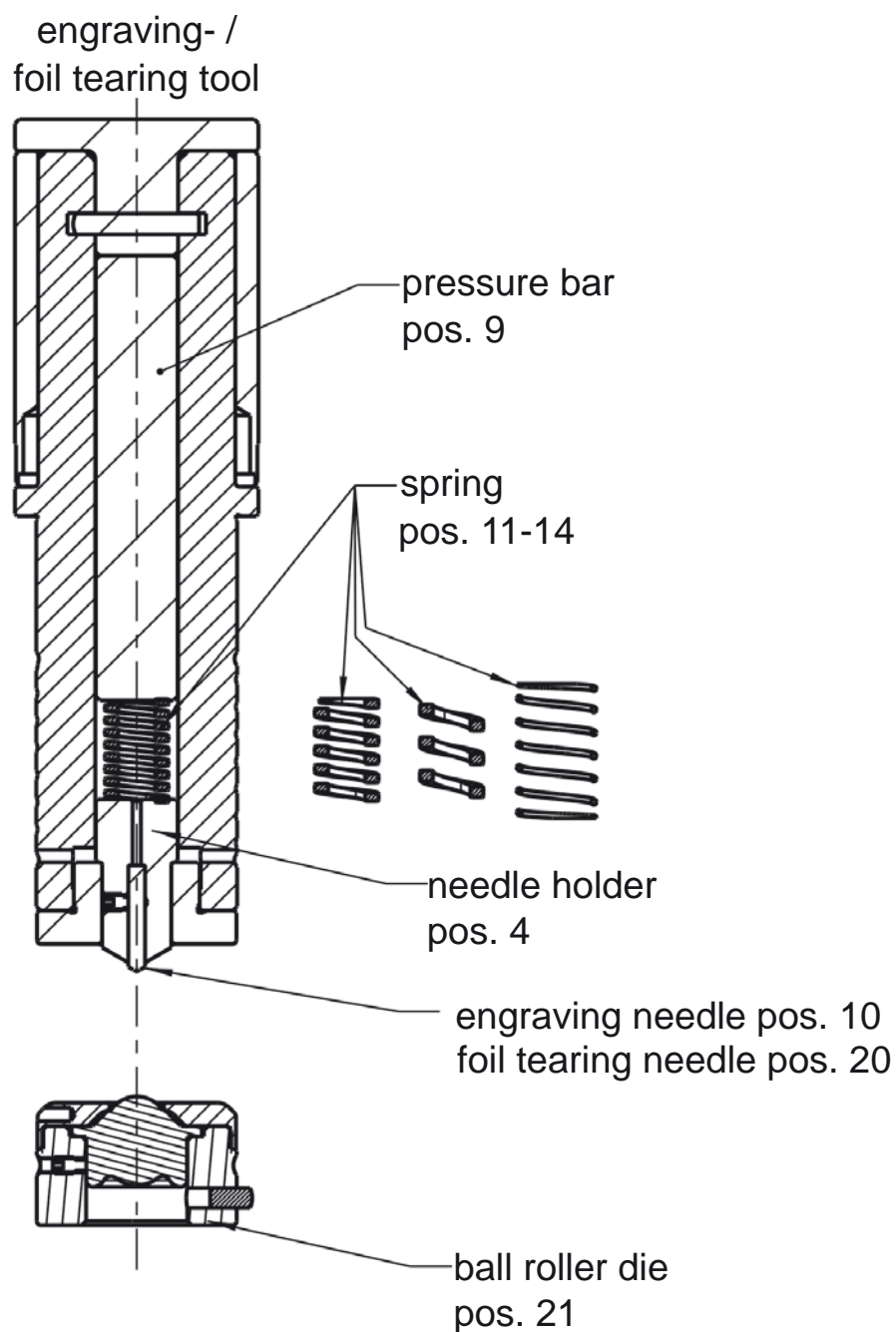
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C. ENGRAVING / FOIL TEARING



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Station: 12 - GRAVIERWKZ (0,2mm/0°)
X

Save tool

Basic tool settings

Tool parameters

Mode

Diamond marking ▼

Kein Schutz erforderlich ▼

Tool measurements

Tool length - 203 + mm

Punch stripper compensation - 0 + mm

Stripper distance - 4 + mm

Lower limit - 0 + mm

Axis speed - 5000 + mm/min

Ram speed - 100 + %

Tool grinding alert 500000 hits

Tool lubrication interval 0 hits

Hit counts **420 / 420** [Reset](#)

CONTACT: +49 92 70 / 9 85 - 0

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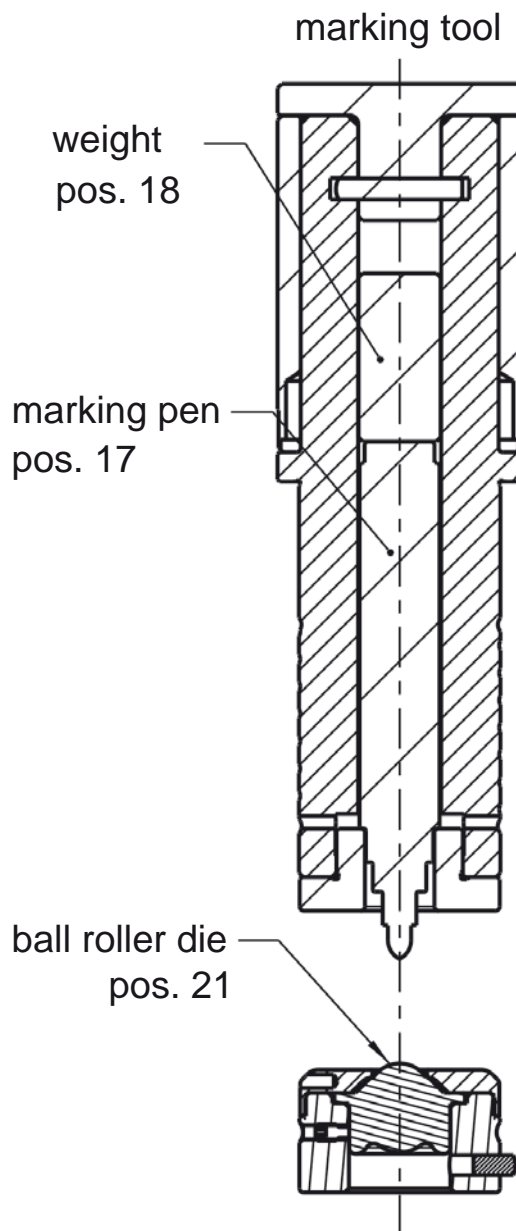
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C. MARKING



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Tool measurements

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D. TOOL SPECIFICATIONS



NOTE

Heavily oiled sheets cannot be marked with the marking pen!

Otherwise this leads to a greatly reduced lifetime of the pen!

E. CLEANING & CARE

We recommend to check and if necessary to clean the tool daily.



NOTE

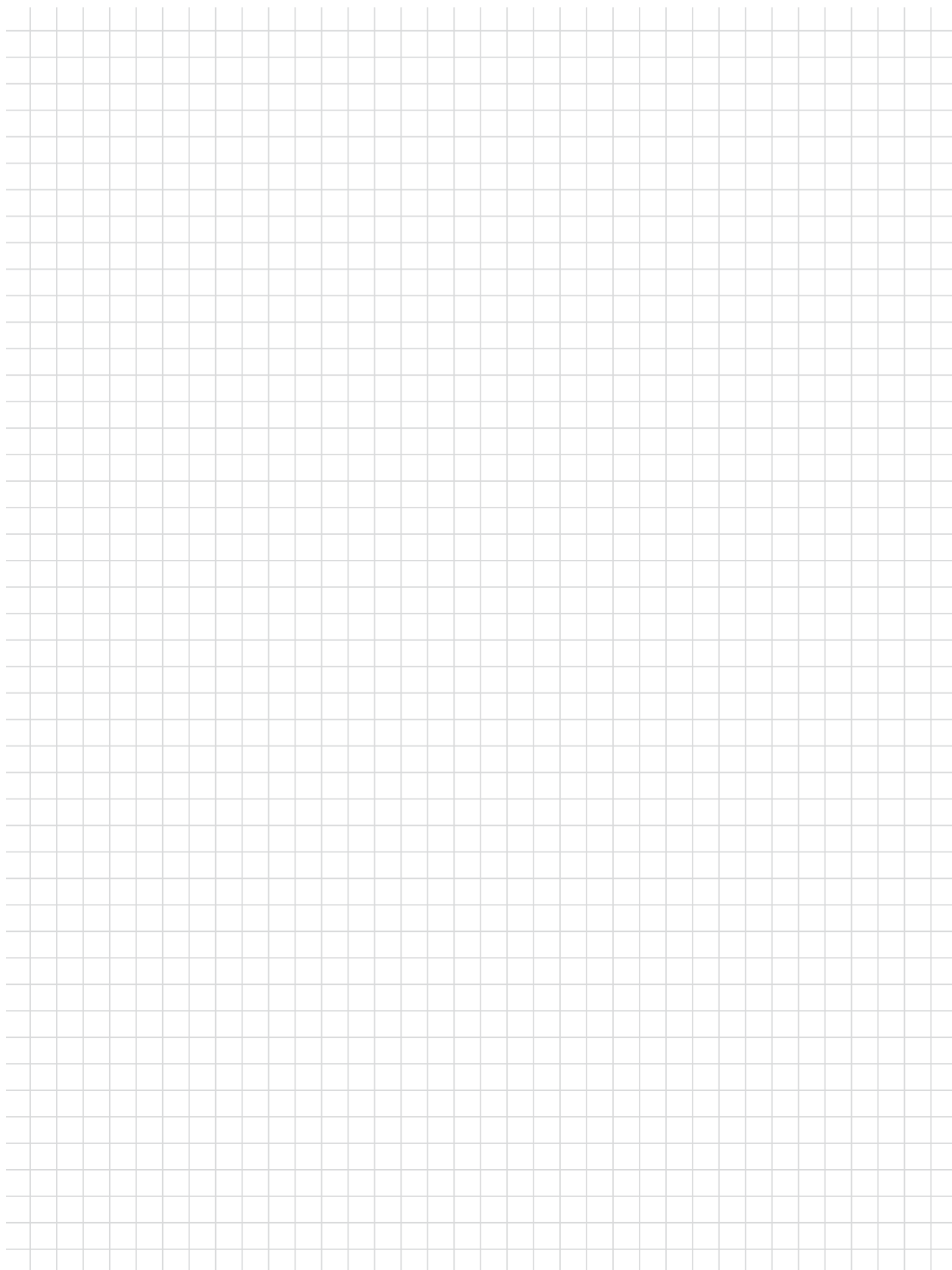
Carry out periodic visual inspections and clean the tool if necessary!

Especially when soft and galvanized or foil-coated sheets are processed, abrasion of material, zinc or foils can get into the tool and can lead to a damage of the tool!

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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