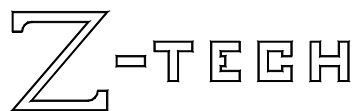


READ THIS FIRST

SAFETY RULES

- **Always wear safety glasses, gloves, and protective clothing.** Any metal cutting tool may chip or fracture in use.
- **Never use around “live” electrical equipment.** Observe all appropriate industry “lock out” and life safety procedures.
- **Always maintain a clean and well organized work area.**
- **Never strike, hammer, or apply any blows to the die sets with any kind of instrument.** All of our dies are manufactured from high-grade tool steel, are hardened through out, and can shatter if struck. **Abuse of this nature will void ALL warranties expressed or implied.**
- **Never overload any die.** Use only the approved model and pulling method for the gauge and type of material you wish to punch.
- **Never use a punch to “nibble” a larger opening.** Always make sure you have a full cut around the perimeter of the punch. Always use the proper size die for the opening you wish to produce.
- **Always abort any abnormal punch operation.** If operation of the die set becomes difficult or hard, cease operation. You can call our technical support at 815-335-7395 for assistance.
- **Always apply a light lubrication to sliding components.** Cutting tools always work better with a light coating of oil. Make sure the dowel pins or stripper bolts are always lubricated. Regular #30 motor oil will work fine.
- **Never attempt to use a die set with damaged components.** Dowel pins, stripper bolts, draw bars, and draw bolts are considered consumable components and may be ordered as replacement items.

Follow these basic rules and your Z-Tech, Inc. panel punch will provide you with years of safe and reliable service.



1958 South Winnebago Road
Winnebago, IL 61088
815-335-7395

WWW.PANELPUNCHES.COM

Care and Use Instructions

Dandy Die Series – Hydraulic Operation

WARNING – ALWAYS REVIEW SAFETY RULES FIRST

STEP 1.

Locate your desired instrument opening location and centrally locate two (2) 1/2" starter holes. These holes should be either 1" or 1 - 3/4" apart depending upon your **Dandy Die** model.



STEP 2.

Assemble the punch with the two supplied 3/8" stripper bolts as shown and insert into the starter holes. Make sure the stripper bolts are lightly lubricated, any grade of motor oil will work fine. On the opposite side of the panel, slide the die portion of the punch over the stripper bolts.



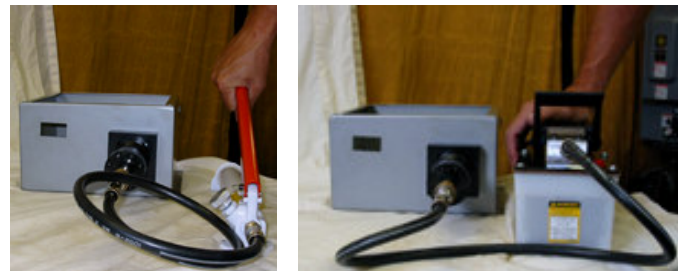
STEP 3.

Thread the stripper bolts into the **Dandy Die Draw Cylinder** using the supplied hex wrench. Make sure they're fully inserted, but finger tight is fine.



STEP 4.

Connect the **Dandy Die Draw Cylinder** to one of our hydraulic hand or pneumatic / hydraulic pumps. Our **Dandy Die Draw Cylinder** may also be used with other manufactures' pumps with the proper couplings.



STEP 5.

Operate the pump until the punch has been completed. Make sure you hold the punch / die / cylinder assembly as it will free itself from the panel as the punching operation is completed.



STEP 6.

Disassemble your Dandy Die, shake out the knock out "slug" and you're ready to begin another opening.