

# 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.**

Z-TECH

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# Care and Use Instructions

## Standard Die Series – Hydraulic Operation

**WARNING – ALWAYS REVIEW SAFETY RULES FIRST**

### STEP 1.

Locate your desired instrument location and layout the location for the three 7/8" holes for the guide and draw bolt holes. The "punch" portion of the die set can be used as a template for locating these holes.



### STEP 2.

Assemble the die set with the "Punch" portion on one side of the panel and the "Die" portion on the other with the locating pins of the "Die" portion sliding into the locating holes of the "Punch" portion.



### STEP 3.

Insert the pulling stud of the hydraulic puller through the center hole of the die set and apply the pulling nut to the stud.



### STEP 4.

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. Be careful not to continue operation and "bottom out" the die set. If, for any reason, the cutting operation "stalls", binds, or is taking more effort than usual, release the hydraulic pressure and inspect for the cause.



### STEP 5.

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