

**Di-Acro<sup>®</sup>**

OPERATOR'S MANUAL & INSTRUCTIONS

# **NUMBER 2**

## **Di-Acro**

### **Hand Punch**



**Di-Acro, Incorporated**

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Revised 01/02

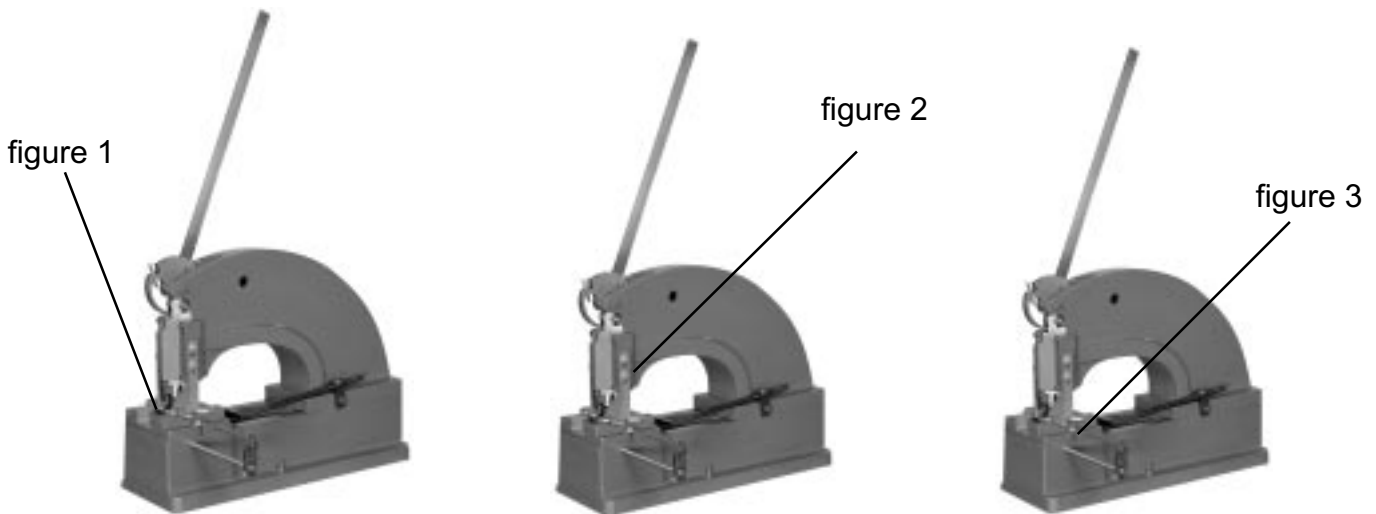
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### MOUNTING PUNCHES AND DIES

When mounting Punches and Dies on the hand operated Di-Acro Punch Press, the following procedure is recommended.

1. Remove both right and left hand Stripper Arms from Ram cap.
2. Insert Punch in Punch Holder and tighten set screw.
3. Insert Die in Die Holder, tighten set screw and mount on Punch Press. Do not tighten bolts on Die Holder.
4. Pull handle down until Punch enters Die to line up Punch in center of Die. Tighten bolts in Die Holder.
5. Test "lineup" of Punch and Die by inserting paper and punching by hand.
6. Select the notch in the Stripper V Plate that will provide the most support around the Punch for stripping, and bolt to Stripper Arms, and mount on Ram Cap\*. For Punches 5/16" in diameter and smaller a stripper Plate with three holes is provided. Special Stripper Plates for round, square, are available by special order.

\*Adjust Stripper Plate vertically as close to material as possible. Leave enough clearance for easy insertion of the material. When Stripper Plate is set too high, material may become distorted.



## CAUTION

TO PREVENT SERIOUS BODILY INJURY  
AND DAMAGE TO THE MACHINE

BOLT THE MACHINE TO THE STAND  
AND THE STAND TO THE FLOOR

### SPECIFICATIONS

	No. 2	
Model	in.	mm
Tonnage	4	3.6
Max. Punch Size	4	101.6
Punch Capacity	1-1/2 (38mm) dia. in 16 ga. (1.5mm) m.s.	
Throat Depth	12	304.8
Throat Height	3	76
Material Thickness	16 ga. m.s.	1.5
Stroke of Ram	5/8	15.9
Hole in Ram (dia.)	1	25.4
Shipping Weight	350 lbs.	159 kg.
Stand, Shipping Weight	95 lbs.	43 kg.

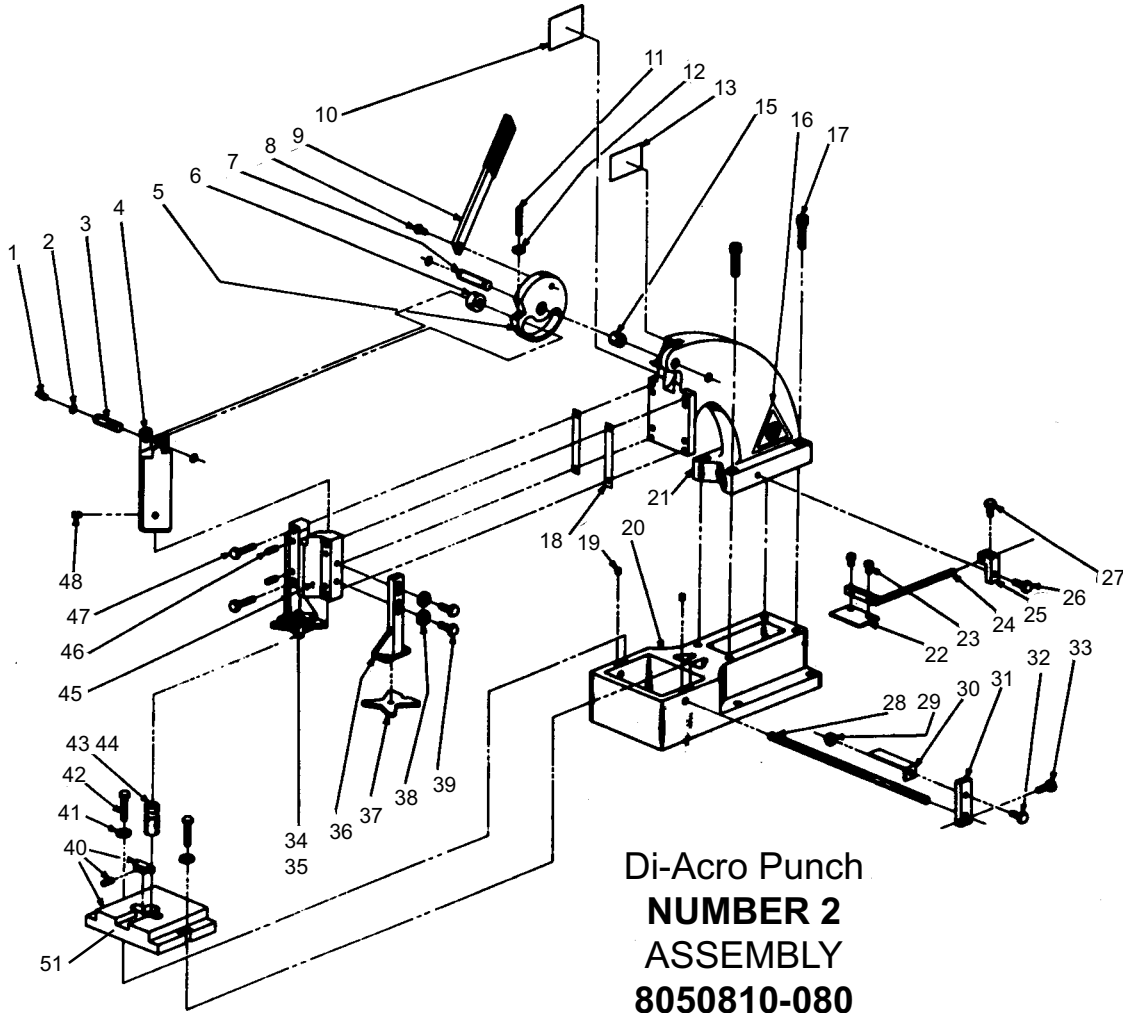
### CONSTRUCTION

**STRONG ALLOY CASTINGS** AND COLD ROLLED STEEL PARTS PROVIDE MAXIMUM STRENGTH AND RIGIDITY. ALL PARTS SUBJECT TO WEAR ARE PROPERLY HARDENED AND PRECISION GROUND.

TURRET STRIPPER CAN BE RAPIDLY POSITIONED FOR STRIPPING MATERIAL FROM ANY SIZE PUNCH UP TO 2 INCHES.

**ADJUSTABLE SIZE AND BACK GAUGES** ASSURE CONSISTENT GAUGING FOR EXACT DUPLICATING OPERATIONS. THE GAUGES AND TURRET STRIPPER ARE SUPPLIED AS STANDARD EQUIPMENT.

**TRIANGULAR RAM**, HARDENED AND PRECISION GROUND, POSITIVELY CONTROLS THE POSITION OF THE PUNCH HEAD THROUGHOUT THE ENTIRE STROKE ASSURING PERFECT ALIGNMENT AND ACCURACY.



ITEM	DESCRIPTION	PART NUMBER	QTY
1	DRIVE FTG.	8690100-200	1
2	RET RING	8470510-100	4
3	CAM ROLLER PIN	8060120-300	1
4	RAM	8040121-300	1
5	CAM	8030120-200	1
6	ROLLER	8156111-300	1
7	CAM PIN	030-1203020	1
8	SCREW	20B0516C0508	1
9	SHORT HANDLE ARM	8230120-800	1
9	LONG HANDLE ARM	8030120-800	1



## #2 PUNCH PARTS

ITEM	DESCRIPTION	PART NUMBER	QTY
10	CAUTION PLATE	8030650-300	1
11	SCREW	23C0516C2000	1
12	NUT	31X0516C	1
13	NAME PLATE	050-6501115	1
15	BRG.	8310410-100	1
16	SAFETY SIGN	8686503-025	1
17	SCREW	20A0102C1304	4
18	SHIM	8030570-101	
19	SCREW	23A0308C0104	2
20	BASE	8040110-100	1
21	UPPER CASTING	8050110-200	1
22	BACK MATERIAL GAUGE	8040140-101	1
23	SCREW	22BXX10C0102	2
24	BACK MATERIAL ROD ASSEMBLY - SUB C	8050140-101	1
25	BACK MATERIAL CLAMP	8200140-101	1
26	SCREW	21A0308C1000	1
27	SCREW	21A0516C0304	1
28	SIDE MATERIAL ROD	8000140-202	1
29	NUT	30X0516	1
30	SIDE MATERIAL GAUGE	8040140-202	1
31	SIDE MATERIAL CLAMP	8100140-202	1
32	SCREW	21A0516C1000	1
33	SCREW	21A0516C1000	1
34	SCREW	20A0104F0102	2
35	WASHER	61X0104	4
36	STRIPPER ARM	8040140-302	2
37	STRIPPER PLATE	8100140-302	2
38	WASHER	61X0516	4
39	SCREW	21A0516C1104	4
40	DIE HOLDER ASSY. A	8140150-270	1
40	DIE HOLDER ASSY. B	8240150-270	1
40	DIE HOLDER ASSY. C	8040150-270	1
40	DIE HOLDER ASSY. D	8340150-270	1
40	DIE HOLDER ASSY. E	8440150-270	1
41	WASHER	61X0308	2
42	SCREW	21A0308C1304	2
43	PUNCH HOLDER	8040150-102	1
44	SCREW	23A0516C0104	2
45	CAP	8040110-800	1
46	PIN	18A0516X1000	4
47	SCREW	21A0516C1304	4
48	SCREW	23A0516C0308	2
49	STRIPPER PLATE SMALL (NOT SHOWN)	8000140-302	1
50	SCREW (NOT SHOWN)	20A0104F0508	2
51	CLAMP	8066150-205	1

### 901 SERIES SINGLE STATION PUNCHES & DIES

#### SINGLE STATION PUNCHES

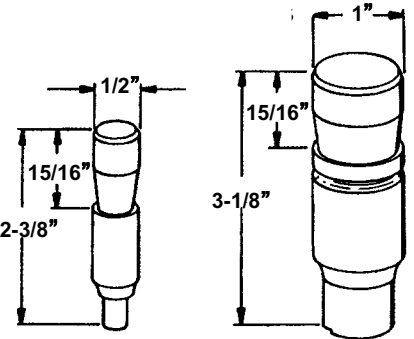
#### ROUND

##### PUNCHES

STYLE	SIZE	CAT. NO.
2	.063" -- .500"	901009-000
4	.501" -- 1.000"	901010-000
4	1.001" -- 1.437"	901011-000
4	1.438" -- 2.000"	901012-000
4	2.001" -- 2.500"	901013-000
4	2.501" -- 3.000"	901014-000
4	3.001" -- 3.500"	901015-000
4	3.501" -- 4.000"	901016-000

##### DIES

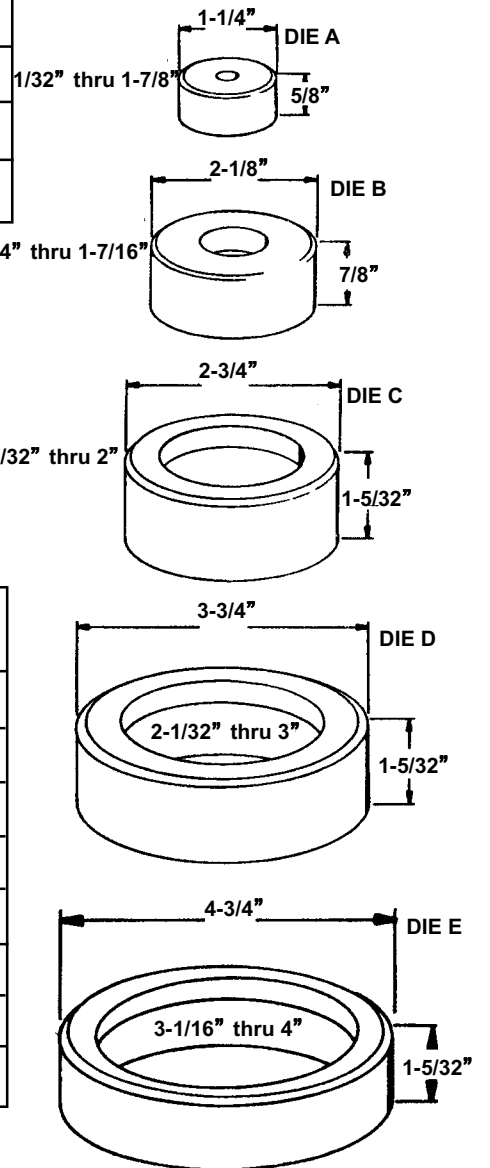
STYLE	MAX DIAM.	O.D.	CAT. NO.
A	.508"	1.250"	901030-000
A	.758"	1.250"	901030-000
B	1.445"	2.125"	901032-000
C	2.008"	2.750"	901034-000
D	2.508"	3.750"	901036-000
D	3.008"	3.750"	901036-000
E	3.508"	4.750"	901038-000
E	4.008"	4.750"	901038-000



NO. 2

NO. 4

#### SINGLE STATION DIES



#### SHAPED

##### PUNCHES

STYLE	DIAG. DIMENSION	CAT. NO.
2	.063" - .500"	901048-xxx
4	.501" - 1.000"	901050-xxx
4	1.001" - 1.4375"	901051-xxx
4	1.438" - 2.000"	901052-xxx
4	2.001" - 2.500"	901053-xxx
4	2.501" - 3.000"	901054-xxx
4	3.001" - 3.500"	901055-xxx
4	3.501" - 4.000"	901056-xxx

##### DIES

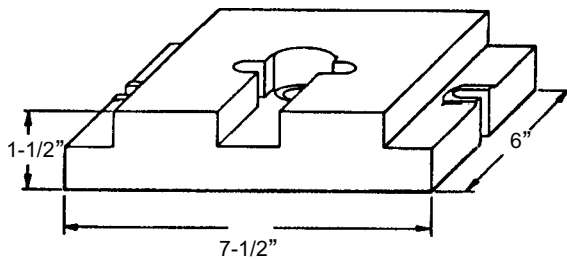
STYLE	MAX DIAG.	O.D.	CAT. NO.
A	.508"	1.250"	901070-xxx
A	.758"	1.250"	901070-xxx
B	1.445"	2.125"	901072-xxx
C	2.008"	2.750"	901074-xxx
D	2.508"	3.750"	901076-xxx
D	3.008"	3.750"	901076-xxx
E	3.508"	4.750"	901078-xxx
E	4.008"	4.750"	901078-xxx

# Di-Acro® #2 PUNCH COMMON SHAPES

## SINGLE STATION PUNCHES & DIES 901 SERIES

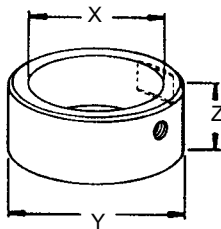
### DIE HOLDERS

The die holder is mounted on either the No. 1 or No. 2 Di-Acro punch press, and is available in sizes to accommodate the five die styles. Certain die holders with large I.D. s will utilize dies with a smaller O.D. if fitted with the proper adapter.



901 SERIES DIE HOLDER

DIE HOLDER STYLE	CAT. NO.	BORE IN HOLDER	ACCOMMODATES DIE STYLE
A	8140150-270	1 1/4"	A
B	8240150-270	2 1/8"	B
C	8040150-270	2 3/4"	C
D	8340150-270	3 3/4"	D
E	8440150-270	4 3/4"	E



ADAPTER

### DIE ADAPTERS

ADAPTER STYLE	CAT. NO.	X	Y	Z	FITS DIE HOLDER
A	8040150-375	1 1/4"	2 3/4"	1 5/32"	C
B	8000150-375	2 1/8"	2 3/4"	1 5/32"	C

### PUNCH HOLDERS

STYLE	CAT. NO.
1"	8040150-102

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## STANDARD SHAPED SERIES

Rectangle -300



Square -200



Round -000



Single D -400



Oblong -550



Oblong  
Center Radius -500



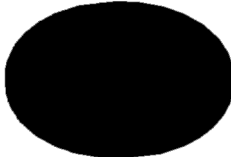
Hexagon -650



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## COMMON SHAPED SERIES

Ellipse -100



Lattice Bar -800



RS-232 -180



RS-232  
with slots -190



Keyhole -950



Double Keyhole  
with End Radii -120



Keyhole with  
End Radius -110



Corner  
Radius -170



Jail Bar -195



Teardrop -130



Hotdog -140



Elongated D -150



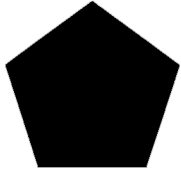
Gumdrop -160





## COMMON SHAPED SERIES

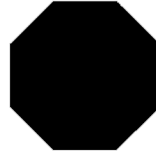
Pentagon -210



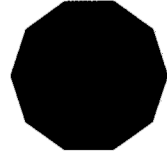
Heptagon -220



Octagon -230



Decagon -240



Rhombus -250



Rhomboid -260



Trapezoid -270



Trapezium -280



Equilateral  
Triangle -290



Isosceles  
Triangle -295



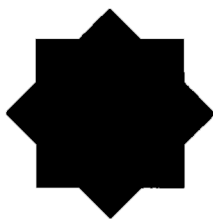
Right  
Triangle -310



Scalene  
Triangle -320



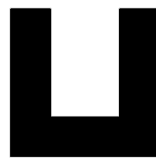
Point Star -330



L-Shape -340



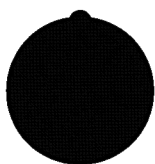
U-Shape -350



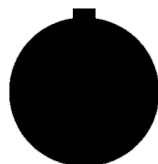
I-Shape -360



Cutler-Hammer<sup>™</sup>  
-370



General Electric<sup>™</sup>  
-380



Square D,  
Westinghouse<sup>™</sup>  
-390



Allen Bradley,  
Clark, General Electric,  
Westinghouse<sup>™</sup> -395

