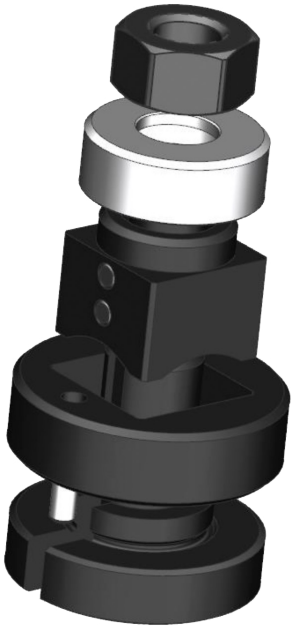
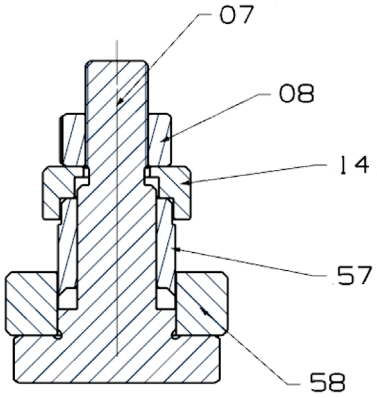
Square and rectangular Knockout punches

Contains



Reference	Dimensions (mm)	Screw	Ø Previous
54C22	22 x 22	M12 x 1,75	› 16
54C25	25 x 25	M12 x 1,75	› 16
54R2517	25 x 17	M8 x 1,25	› 12
54R3022	30 x 22	M8 x 1,25	› 12

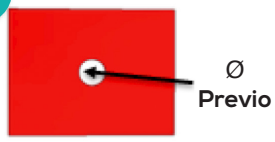


Cut capacity of 2 mm on steel sheet plate. 1.5 mm* in stainless steel

*This is a general recommendation; there is a wide range of steels an stainless steels.
It is strongly recommended to use oil in the steel plate before cutting (e.g. using protoolube).
In case of any doubt, it is recommended to use serie 56 (more cutting capacity)

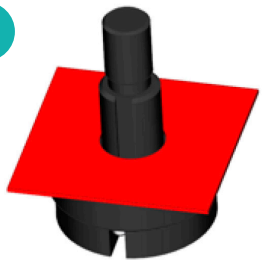
Instructions

1



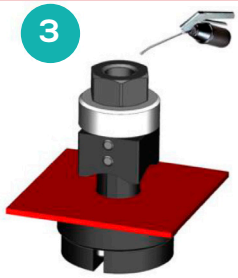
Make a hole in the sheet plate bigger than the diameter of the knock-out punch screw.

2



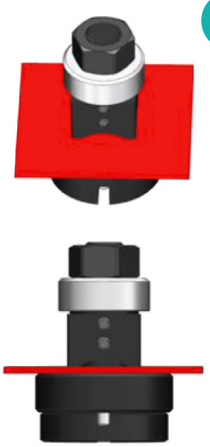
Place the sheet plate between the male and die.

3

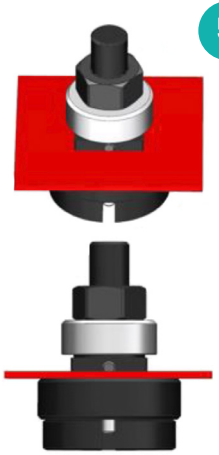


Grease the knock pout punch and the sheet plate in order to simplify the cut.

4



5



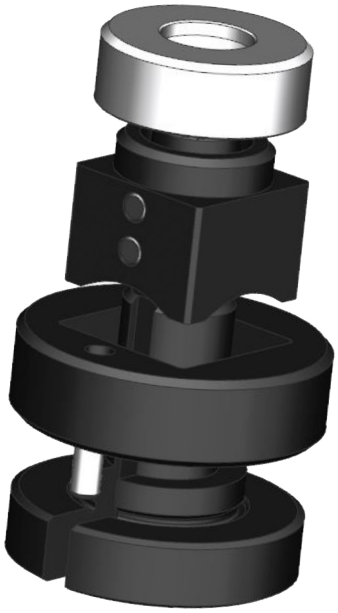
Adjust the screw by hand until the male and the die touch the sheet plate.

Turn the screw with a wrench until the cutting surface of the male pierce the sheet plate. Then, the sheet plate can be completely remove from the knock-out punch.

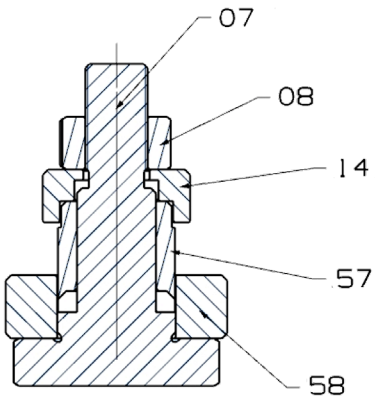
Note: If the hole is made with a drill, be careful of avoiding any burring. If this goes into the thread of the screw, the knock put punch can be seized up.

Hydraulic square and rectangular Knockout punches

Contains



Reference	Dimensions (mm)	Screw	Ø Previous
54C22H	22 x 22	M12 x 1,75	> 16
54C25H	25 x 25	M12 x 1,75	> 16
54R2517H	25 x 17	M8 x 1,25	> 12
54R3022H	30 x 22	M8 x 1,25	> 12

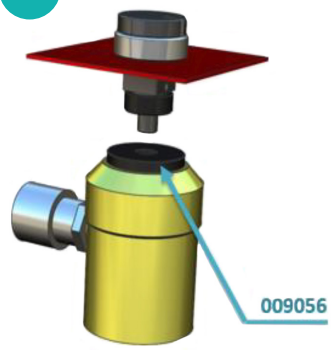


Cut capacity of 2 mm on steel sheet plate. 1.5 mm* in stainless steel

*This is a general recommendation; there is a wide range of steels an stainless steels.
It is strongly recommended to use oil in the steel plate before cutting (e.g. using protoolube).
In case of any doubt, it is recommended to use serie 56 (more cutting capacity)

Instructions

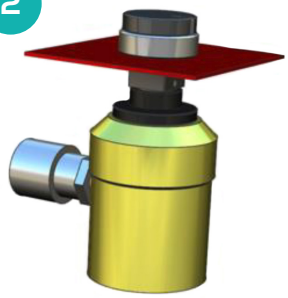
1



Make a hole in the sheet plate as shown in the previous page and place the sheet plate between the male and the die as shown in the picture.

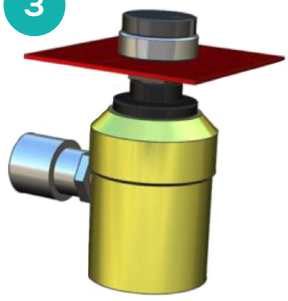
Do not forget the washer 009056 of 12Ø, which is include in the hydraulic equipment.

2



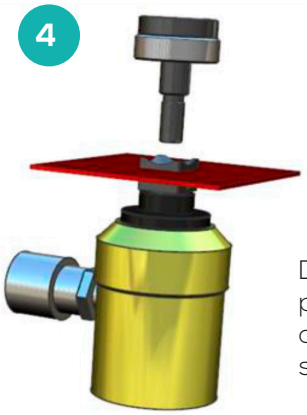
Place the knockout punch in the hydraulic cylinder.

3



Apply pressure with the pump which is include in the hydraulic equipment.

4



Disassemble the knockout punch from the hydraulic cylinder and extract the sheet plate.