

# Hydraulic hole puncher operation Instructions

## Survey

Hydraulic hole puncher is an advanced manual hydraulic tool to tap a hole on a metal plate with the thickness of below 3mm, which is impossible for ordinary punching machine to do so. It has the characteristics of easy and convenient operation, high speed, even and tidy processed surface, good quality, safety, reliability and without the limit of location and site. It's of portable structure, artistic and is easy to carry. It's can be used to hole for installing and repairing wire pipe line, signal lamp and instrument in metallurgy, petrol, chemical industry, electronics, electrical appliance, plate, base plate and walls of switch box and distribution box.

## Technical Parameters

Model No.	SKP-8	SKP-15
Max hydraulic shear force	120KN	150KN
Piston stroke	25mm	25mm
Hydraulic oil	20#lubricant	20#lubricant
Holing range	Φ 16 ~ Φ 60.5	Φ 16 ~ Φ 114

## Operation method

1. Before holing on a piece of workpiece, make a 11.5mm guide hole by hand electrical driller first.
2. Turn the pulling rod of piston into the screw thread of piston cylinder, then cover washer on piston pulling rod, then put it in cavity die. Stretch the piston pulling-rod into guide hole, at last, twist cavity die in to make blade of cavity and the surface to be processed close tightly. At the moment, convex die, workpiece and cavity die has been fixed firmly.
3. Switch off spill valve clockwise, then press step-up handle repeatedly to make plunger pump begin working, thus, oil pressure goes up, the shearing force between convex and cavity dies increase, and the mould is holing on the workpiece till it shear through the workpiece.
4. Loosen spill valve anti-clockwise to unload oil pressure. After operating according to above-mentioned four procedures, holing is finished.
5. Dismount convex die, clear waste plate in cavity die, then wipe the mould clean.