

NOS. 32, 33, AND 34 LEVER PRESS

INSTRUCTIONS AND PARTS LIST

NO. 34 -- 8 TON PUNCHING POWER 1 3/4" HOLE THRU 12 GAUGE MILD STEEL



SPECIFICATIONS

34

Capacity	8 tons
Depth of Throat	24"
Height of Throat	10"
Length of Stroke	1"
Adjustment of Ram	3/4"
Die Space with Stroke Down and Adjustment Up	---
Die Space less Die Shoe Support	10"
Die Space with Die Shoe Support in Position	6"
Diameter of Punch Shank Hole in Ram	1"
Depth of Punch Shank Hole in Ram	1 1/4"
Slug Hole Clearance	3" x 5"
Bed Plate Holes --- Center to Center	6 3/4"
Floor Space Required	18" x 44"
Weight	735 lbs.

Standard equipment includes (all presses): One side gauge, one depth gauge, one F8 and F28 Punch Holder, One 20 and 40 Die Adaptor, One F 2 3/4 die shoe, One set 1/2" punch and die, One set stripper arms, A7 stripper plate. 34 press in addition to above; One die shoe support, 48" bar handle. No substitutions on standard equipment.



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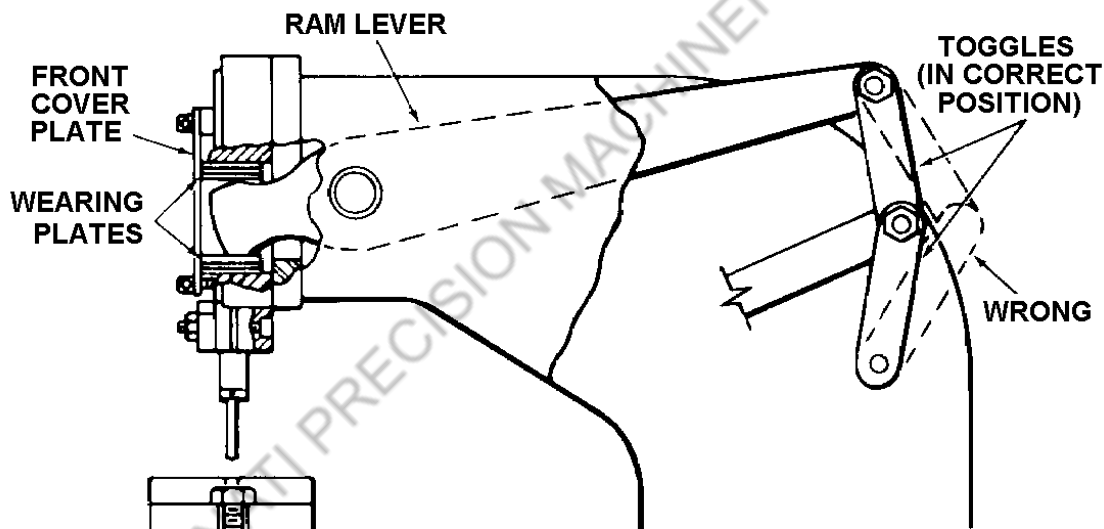
NOS. 32, 33, 34 LEVER PRESS INSTRUCTIONS

CARE: Oil ram gibs and toggle assembly daily.

OPERATION: To change punches, loosen punch retainer bolt nuts and punch retainer set screw. Remove punch holder.

To change dies, pivot die shoe forward. Remove die or die adaptor and replace with desired die or die adaptor. Return die shoe to proper position. Lower punch thru die. Align die so clearance is evenly distributed around punch. Tighten die shoe bolt nuts and recheck alignment.

TOGGLE CONNECTING LINKS: If toggles are not positioned correctly the press will punch hard or lock. See Ram Adjustment for correction procedure.



RAM ADJUSTMENT: Punch should enter die approximately 1/16". Toggle connecting links should be in the correct position as shown in the illustration. To correct adjustment:

1. Check to see that connecting link toggle position is correct.
2. Remove front cover plate and reposition wearing plates to achieve correct penetration.

RAM LOOSENESS: Loosen gib bolts on R. H. gib and remove one gib shim. If still loose, repeat on L.H. gib.

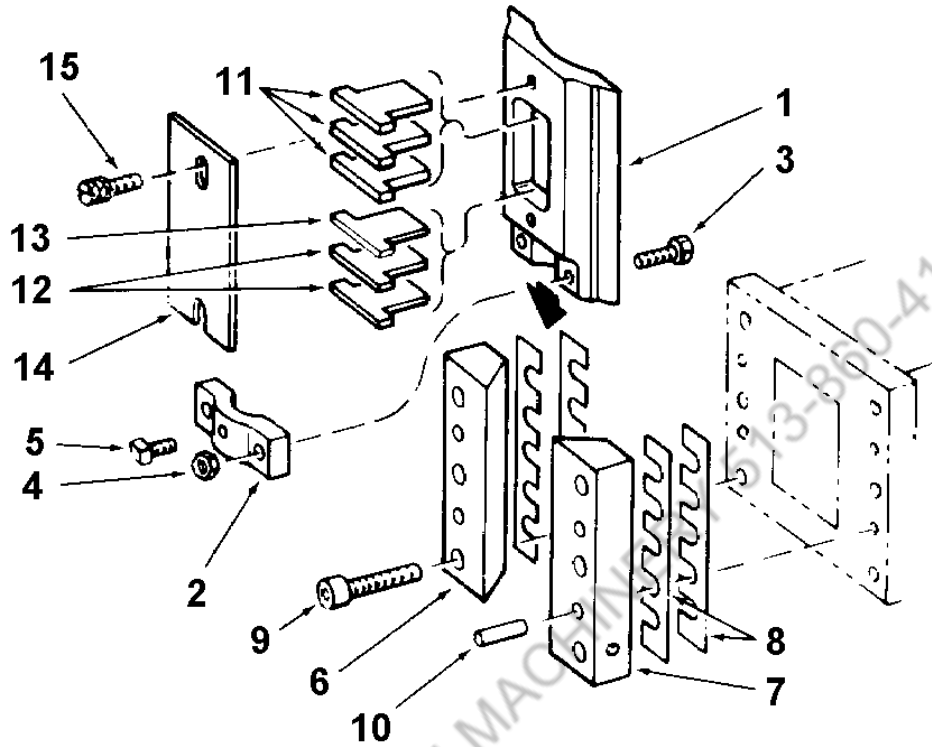
WARNING --- SAFETY INSTRUCTIONS

Read and understand these instructions before operating machine. The following punch press safety rules apply:

1. **MECHANICAL DANGER** -- Keep hands and fingers clear of the stripper and punch area, and never operate punch press without all guards attached and effective. Failure to comply or misuse of the notcher may result in accidental personal injury; i.e., loss of fingers.
2. Do not operate the punch press without reading the Operators' Manual, and without proper supervisory instructions.
3. Punch press to be operated by authorized personnel who have been trained by their supervisor with the working and safety features of the machine, and by reading and understanding the Operators' Manual.
4. Never operate punch press with any guard removed; i.e., all required guarding to be installed and effective.
5. Operate the press within the tonnage capacity of the machine. Type and thickness of material versus final hole size will give this tonnage.
6. Use only punches and dies marked with a W or RW that are designed for the press.
7. Do not use chipped or dull punches and dies.
8. Punch a full hole and not a half hole. Use punches for nibbling.
9. Use safety glasses and other protective devices.

NOS. 32, 33, 34 LEVER PRESS PARTS IDENTIFICATION

RAM; WEARING PLATES



ITEM NO.	PART NO.	PART NAME	QTY.
1	232940001	Ram w/Punch Retainer	1
2	731600134	Punch Retainer	1
3	731650275	Punch Retainer Screw	2
4	600023026	Punch Retainer Screw Nut High Crown Acorn 5/16-18	2
5	633012131	Punch Retainer Set Screw SHSCP 5/16-18 x 3/4	1
6	731400085	L. H. Gib	1
7	731400085	R. H. Gib	1
8	731720086	Gib Shim	4
9	611012181	Gib Bolt SHC 3/8-16 x 1 3/4	6
10	600043266	Gib Taper Pin #6 x 2	4
11	731060073	1/8" Wearing Plate	4
12	731060081	3/32" Wearing Plate	2
13	731060074	1/16" Wearing Plate	1
13A	731060151	1/4" Wearing Plate (not shown)	1
14	731060072	Front Cover Plate	1
15	611012090	Front Cover Plate Screw SHC 1/4-20 x 7/8	2

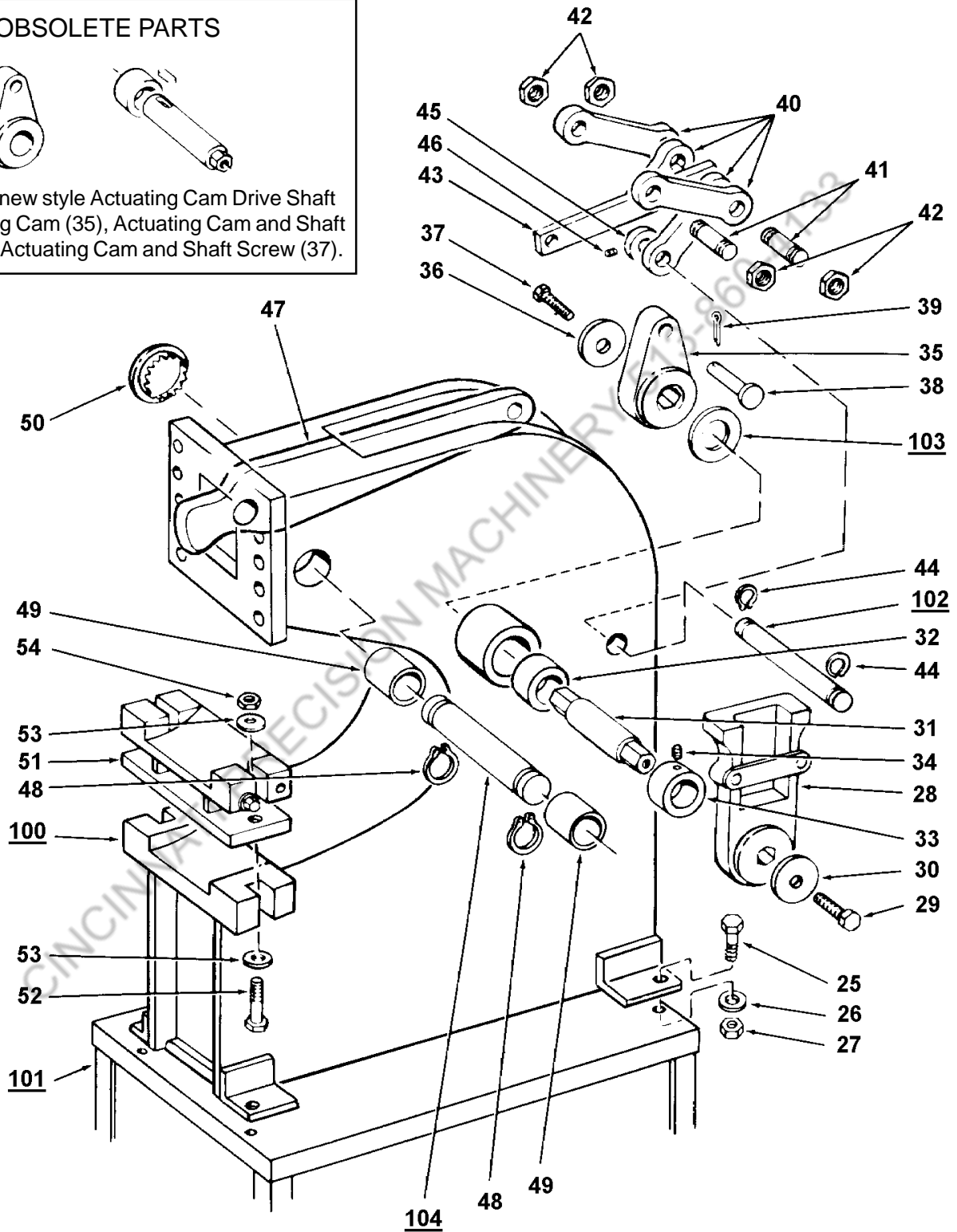
NOS. 32, 33, 34 LEVER PRESS PARTS IDENTIFICATION CHART

FRAME; BASE; CONNECTING LINKS

OBSOLETE PARTS



Replace with new style Actuating Cam Drive Shaft (31), Actuating Cam (35), Actuating Cam and Shaft Washer (36), Actuating Cam and Shaft Screw (37).



Item Nos. 100 thru 104 vary in size per each model of press
See parts list (pg. 6) for these items

NOS. 32, 33, 34, PARTS IDENTIFICATION LIST

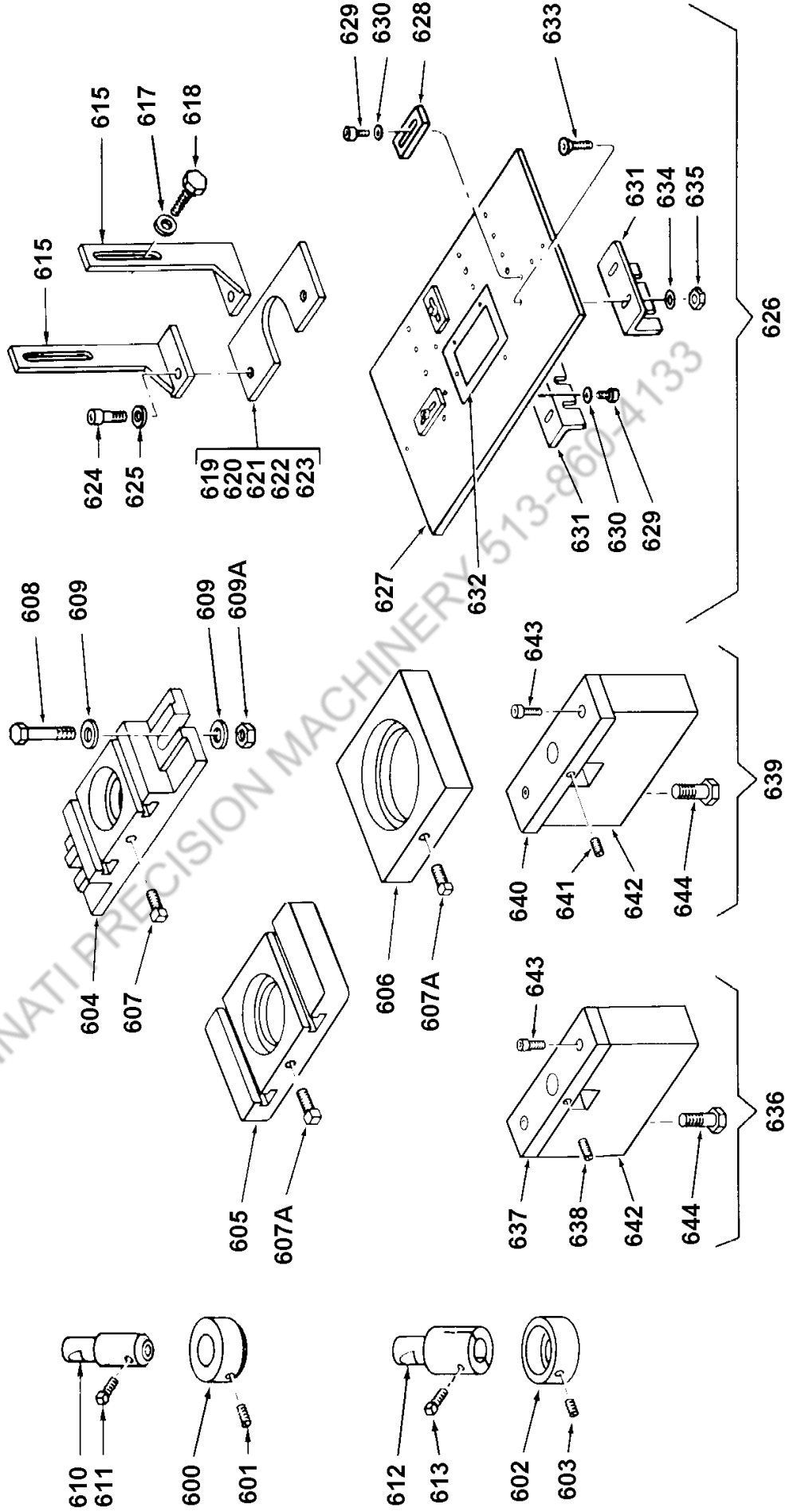
FRAME; BASE; CONNECTING LINKS

ITEM #	PART NO.	PART NAME	QTY.
25	601012273	Stand Mounting Bolts 1/2-13 x 1 1/4 Hex Hd.	4
26	679033107	Stand Mounting Bolt Washer 1/2 Lock	4
27	643023007	Stand Mounting Bolt Nut 1/2-13 Hex Full	4
28	731460159	Operating Handle	1
29	601012128	Operating Handle Screw 5/16-18 x 1/2 HHC	1
30	678033116	Operating Handle Screw Washer	1
31	731680154	Actuating Cam Drive Shaft	1
32	600194618	Drive Shaft Bushing	1
33	731260147	Drive Shaft Collar	1
34	621012082	Drive Shaft Collar Set Screw 1/4-20 x 1/4	1
35	731210153	Actuating Cam	1
36	678033116	Actuating Cam & Shaft Washer	1
37	603012131	Actuating Cam & Shaft Screw 5/16-18 x 3/4 HHC	1
38	731160148	Actuating Cam Pin	1
39	600073528	Actuating Cam Pin Cotter Key 1/8 x 1 1/4	1
40	731240070	Connecting Link	4
41	731160075	Connecting Link Stud	2
42	730560055	Connecting Link Stud Nut	4
43	731670149	Connecting Link Draw Bar	1
44	600164304	Connecting Link Retaining Ring 5/8 Tru Arc	2
45	731630150	Connecting Link Spacer	1
46	621012082	Connecting Link Spacer Set Screw 1/4-20 x 1/4	1
47	731030146	Ram Operating Lever	1
48	600164307	King Pin Retaining Ring 1 1/8 Tru Arc	2
49	600194617	King Pin Bushing	2
50	600000027	Assembly Cap	1
51	731320145	Die Shoe Support	1
52	601012374	Die Shoe Support Bolt 5/8-11 x 2 3/4 Hex Hd Cap	2
53	678033119	Die Shoe Support Washer	8
54	643023009	Die Shoe Support Nut 5/8-11 Hex Full	2
---	731460152	48" Bar Handle (Not Shown)	1

			No. 32	No. 33	No. 34
Item No.	Part Name	No. Req.	Part No.	Part No.	Part No.
100	Frame	1	731140100	33-1M	731140141
101	Stand	1	731060137	33-2	731060142
102	Connecting Link Stud	1	731160140	33-6	731160144
103	Actuating Cam Spacer	1	731630138	not used on 33	not used on 34
104	King Pin	1	731160139	33-5	731160143

NOS. 32, 33, 34 PART IDENTIFICATION CHART

AUXILIARY ATTACHMENTS



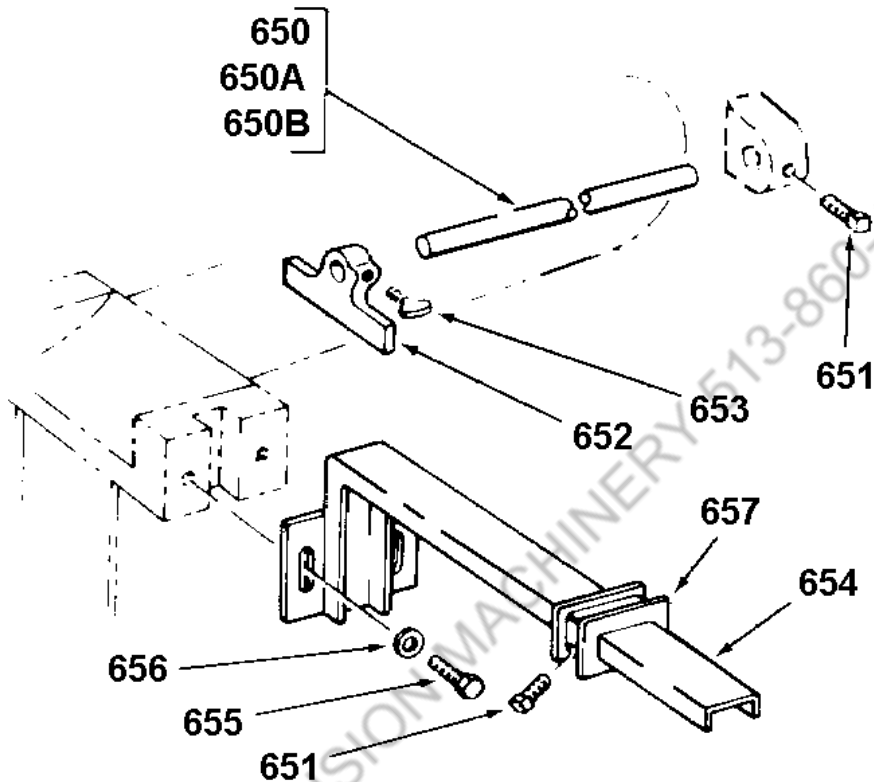
NOS. 32, 33, 34 PARTS IDENTIFICATION LIST

AUXILIARY ATTACHMENTS

ITEM #	PART NO.	PART NAME	QTY.
600	136313020	No. 20 Die Adaptor	1
601	621012125	Die Adaptor Set Screw 5/16-18 x 5/16 SSCP	1
602	136323040	No. 40 Die Adaptor	1
603	621012124	Die Adaptor Set Screw 5/16-18 x 1/4 SSCP	1
604	139404030	F 2 3/4 Die Shoe	1
605	139415050	F 3 3/4 Die Shoe	1
606	139426060	F 4 3/4 Die Shoe	1
607	633012175	Die Shoe Set Screw 3/8-16 x 1" SHSCP	1
607A	633012175	Die Shoe Set Screw 3/8-16 x 1" SHSCP	1
608	601012377	Die Shoe Bolt 5/8-11 x 3 1/2 Hex Head	2
609	678033119	Die Shoe Bolt Washer	4
609A	643023009	Die Shoe Bolt Nut 5/8-11 Hex Full	2
610	136122808	F 8 Punch Holder	1
611	633012131	Punch Holder Set Screw 5/16-18 x 3/4 Sq. Head	1
612	136132828	F 28 Punch Holder	1
613	633012173	Punch Holder Set Screw 3/8-16 x 3/4 SHSCP	1
615	731030265	Stripper Arm	2
617	601012173	Stripper Arm Mounting Bolt 3/8-16 x 3/4 Hex Hd Cap	2
618	678033105	Stripper Arm Mounting Bolt Washer 3/8 Flat	2
619	332200500	A-7 1/2" Stripper Plate	1
620	332201000	B-7 1" Stripper Plate	1
621	332202000	C-7 2" Stripper Plate	1
622	332203000	D-7 3" Stripper Plate	1
623	332204000	E-7 4" Stripper Plate	1
624	601012131	Stripper Plate Screw 5/16-1 x 3/4 Hex Hd Cap	2
625	678033104	Stripper Plate Screw Washer 5/16 Flat	2
626	137000320	Work Table Assy. Complete	1
627	731090122	Work Table Plate	1
628	774420101	Work Table Gauge	3
629	611012084	Work Table Gauge Insert Screw 1/4-20 x 3/8 SHC	7
630	678033103	Work Table Gauge Insert Washer 1/4 Flat	7
631	731200124	Work Table Clamp Bracket	2
632	731670123	Work Table Insert	1
633	605012131	Work Table Clamp Bracket Screw 3/8-16 x 3/4 FHM	4
634	678033104	Work Table Clamp Bracket Washer 5/16 Flat	4
635	649023004	Work Table Clamp Bracket Nut 5/16-18 Jam	4
636	139541010	No. 10 Die Shoe Complete	1
637	731570156	No. 10 Die Shoe	1
638	621012083	Die Shoe Set Screw 1/4-20 x 5/16 Set	1
639	139552020	No. 20 Die Shoe Complete	1
640	731570157	No. 20 Die Shoe	1
641	621012082	Die Shoe Set Screw 1/4-20 x 1/4 SSCP	1
642	731130155	Die Shoe Block	1
643	611012179	Shoe Block Screw 3/8-16 x 1 1/2 SHC	2
644	601012281	Shoe Mounting Screw 1/2-13 x 2 1/2 Hex Cap	2

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GAUGES



ITEM #	PART NO.	PART NAME	QTY.
650	731030092	Depth Gauge Rod (For No. 32 Press Only)	1
650A	731030101	Depth Gauge Rod (For No. 33 Press Only)	1
650B	731030108	Depth Gauge Rod (For No. 34 Press Only)	1
651	633012172	Depth Gauge Rod/Side Gauge Casting Screw 3/8-16 x 5/8 Sq. Hd.	2
652	731420078	Depth Gauge Casting	1
653	641012088	Depth Gauge Casting Thumb Screw 1/4-20 x 5/8	1
654	731420079	Side Gauge	1
655	601012173	Side Gauge Mounting Screw 3/8-16 x 3/4 HHC	2
656	678033105	Side Gauge Mounting Screw Washer 3/8 Flat	2
657	731730080	Side Gauge Casting	1