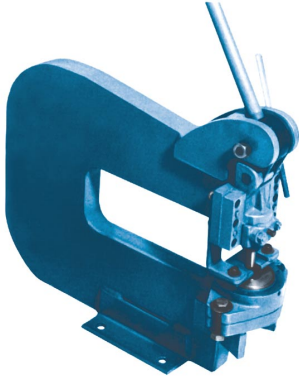


NOS. 118, 218 DEEP THROAT HAND PUNCHES

4 TONS PUNCHING POWER

2" HOLE THRU 24 GAUGE MILD STEEL

1/4" HOLE THRU 3/16" MILD STEEL



These deep throat hand punches are actuated by an eccentric cam rolling on a heavy duty bearing. Ram is held securely by the gibs. Die shoe is removable and adjustable, permitting the use of close fitting punches and dies. 3/16" adjustment in ram position is provided.

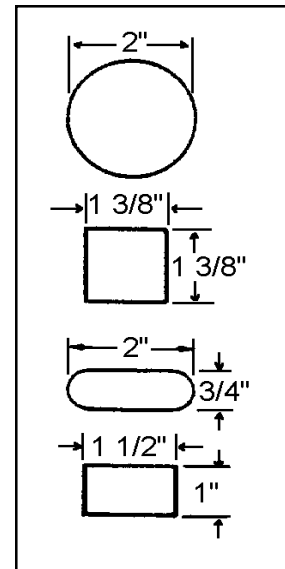
A wide range of punches and dies are available for the 118 and 218 bench punches.

- * Precision Work
- * Low Price
- * Works heavy to ultra-light materials
- * Any punchable material including steel, Aluminum or Brass
- * Wide range of hole sizes
- * Ideal for prototype and model shops
- * Use on medium to small production runs

LARGEST PUNCHES AND
DIES DEEPTHROAT HAND
PUNCH WILL ACCOMMODATE

SPECIFICATIONS

	118*	218
Depth of Throat	7"	12"
Die Space, Punch in Highest Position	3/4"	3/4"
Height of Throat, with Work Table	2 3/4"	2 3/4"
Height of Throat, without Work Table	4 1/2"	4 1/2"
Length of Stroke	3/4"	3/4"
Slug Hole Clearance	2 1/4"	2 1/4"
Diameter of Punch Shank Hole in Ram	1"	1"
Floor Space Required (Floor Model)	23" W x 14" D x 37"H	
Weight, Bench Model	103 lbs.	134 lbs.
Weight, Floor Model	200 lbs.	231 lbs.
Weight, Work Table	7 lbs.	7 lbs.



* No. 118 is obsolete but parts are common with the No. 218.

Standard equipment includes: One L8 Punch Holder, One No. 20 Die Adaptor, One No. 40 Die Adaptor, One 118 - 2 3/4" Die Shoe, Stripper Arms, One A Stripper Plate, Standard 1/2" Round Punch and Die. No Substitutions on Standard Equipment.



ROPER WHITNEY OF ROCKFORD, INC.

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Website: www.roperswhitney.com * Email: info@roperswhitney.com

INSTRUCTIONS

CARE: Oil ram slide, cam and punch point occasionally.

OPERATION: To change dies loosen two die shoe bolts and remove die shoe. Loosen die shoe set screw and push upward on die or die adaptor. If using No. 28 2-3/4 style die insert desired size of die in die shoe and tighten die shoe set screw. If 20 or 40 style dies are used, insert die into die adaptor, tighten die adaptor set screw, place in die shoe and tighten die shoe set screw.

Lower punch into die, check clearance and tighten die shoe bolts.

To change punches with die shoe removed, loosen punch retainer set screw and both punch retainer nuts. Remove punch or L8 punch holder. (No. 28 punches insert directly into ram and No. 8 style punches are inserted in L8 punch holder and then into ram.) When inserting punch or punch holder into ram be sure flat on shank is facing front of ram. Tighten punch retainer nuts and set screw.

Install proper stripper plate for punch size being used. Place a flat object (1/4" bar stock) on die and slide stripper plate down until it rests on the bar. Tighten stripper arm bolts and remove bar.

Punches should not enter die more than 1/16". To adjust loosen eccentric pin nut, adjust ram up or down with eccentric pin handle and tighten eccentric pin nut when desired adjustment is attained.

Two gib shims are between each gib and the frame face plate. Remove one or both shims on each side of ram to compensate for wear.

If necessary to replace the roller bearing place bearing with mounting plug in proper position. Drive the roller bearing pin through the frame and bearing forcing the mounting plug out of bearing and discard. Tighten roller bearing pin set screw.

FOR MAXIMUM OPERATOR SAFETY DO:

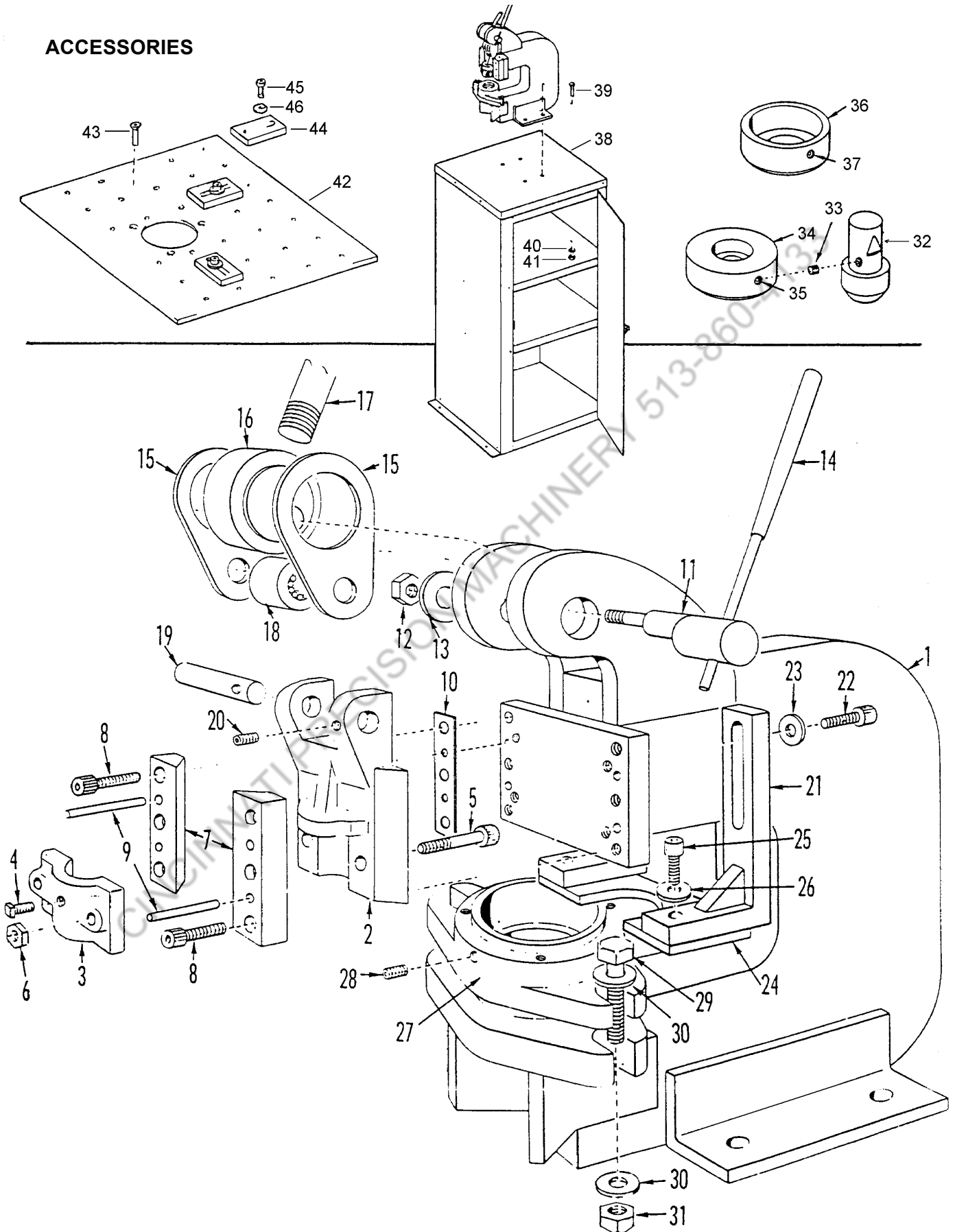
1. Read and understand this manual.
2. Use only punches and dies marked with a W or R-W designed for this tool.
3. Be sure you punch within the four ton capacity of this tool. Type and thickness of material versus final hole size will give you this tonnage.
4. Wear safety glasses.

FOR MAXIMUM OPERATOR SAFETY DO NOT:

1. Use punches and dies that are chipped or dulled.
2. Punch over capacity of the tool.
3. Nibble. Punch a full hole not a half hole as punch may contact die.

NOS. 118, 218 PARTS IDENTIFICATION CHART

ACCESSORIES



NOS. 118, 218 PARTS IDENTIFICATION LIST

ITEM NO.	PART NO.	PART NAME	NO. REQ.	OLD PART NO.
1	731140019	Frame (7" Depth Throat)	1	118-1
1	731140018	Frame (12" Depth Throat)	1	218-1
2	231940005	Ram with Punch Retainer	1	118-2
3	731600057	Punch Retainer	1	118-2-1R
4	633012131	Punch Retainer Set Screw (5/16-18 x 3/4)	1	WS 615
5	731650275	Punch Retainer Screw	2	118-17
6	600023026	Punch Retainer Nut (Acorn 5/16-18)	2	
7	731400020	Gibs	2	118-4
8	611012133	Gib Bolt (SHC 5/16-18 x 1)	6	WS 525
9	600043253	Gib Taper Pin (#5 x 1 1/4)	4	WS 1492
10	731720027	Gib Shims	4	118-18
11	731160022	Eccentric Pin	1	118-6
12	643023007	Eccentric Pin Nut (Hex Full 1/2-13)	1	WS 1356
13	679033107	Lock Washer (1/2)	1	WS 1731
14	600000463	Eccentric Pin Handle	1	118-16
15	731240023	Side Links	2	118-7
16	731210021	Cam	1	118-5
17	731460024	Operating Handle	1	118-8
18	240940006	Roller Bearing	1	100-17
19	731160025	Roller Bearing Pin	1	118-13
20	600325905	Roller Bearing Pin Set Screw (1/4-20 x 1/2)	1	WS 700
21	231940004	Stripper Arms (per set)	1	118-9
22	611012133	Stripper Arm Bolts (SHC 5/16-18 x 1")	4	WS 525
23	678033104	Stripper Arm Bolt Washer (Flat 5/16)	4	WS 1703
24	331200500	A6 Stripper Plate (Punch Size to 1/2")	1	118-14
24	331201000	B6 Stripper Plate (Punch Size to 1")	1	118-10
24	331202000	C6 Stripper Plate (Punch Size to 2")	1	118-15
25	611012131	Stripper Plate Bolt (SHC 5/16-18 x 3/4)	2	WS 524
26	678033104	Stripper Plate Washer (Flat 5/16)	2	WS 1703
27	139571180	Die Shoe	1	118-3
28	600325907	Die Shoe Set Screw (5/16-18 x 3/4)	1	WS 715
29	601012280	Die Shoe Bolt (HHC 1/2-13 x 2 1/4)	2	WS 68
30	678033107	Die Shoe Washer (Flat 1/2)	4	WS 1706
31	643023007	Die Shoe Bolt Nut (Hex Full 1/2-13)	2	WS 1356
32	136112808	L8 Punch Holder	1	118-20
33	621012125	Punch Holder Set Screw (5/16-18 x 5/16)	1	WS 828
34	136313020	No. 20 Die Adaptor	1	28-127
35	600325907	No. 20 Die Adaptor Set Screw (5/16-18 X 3/4)	1	WS 715
36	136323040	No. 40 Die Adaptor	1	28-126
37	600325904	No. 40 Die Adapter Set Screw (5/16-18 x 5/16)	1	WS 794
38	139001180	Stand	1	118-12

NOS. 118, 218 PARTS IDENTIFICATION LIST

ITEM NO.	PART NO.	PART NAME	NO. REQ.	OLD PART NO.
39	601012225	Punch Mounting Bolt (7/16-14 x 1 1/4)	4	WS 49
40	679033106	Punch Mounting Bolt Washer (Lock 7/16)	4	WS 1730
41	643023006	Punch Mounting Bolt Nut (Hex Full 7/16-14)	4	WS 1355
42	137001180	Work Table Complete	1	118-11
43	613012086	Work Table Mtg. Screw (SHF 1/4-20 x 1/2)	3	WS 2518
44	774420101	Work Table Gauges	3	241-5
45	611012084	Work Table Gauge Bolt (SHC 1/4-20 x 3/8)	3	
46	678033103	Work Table Gauge Washer (Flat 1/4)	3	WS 1714

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