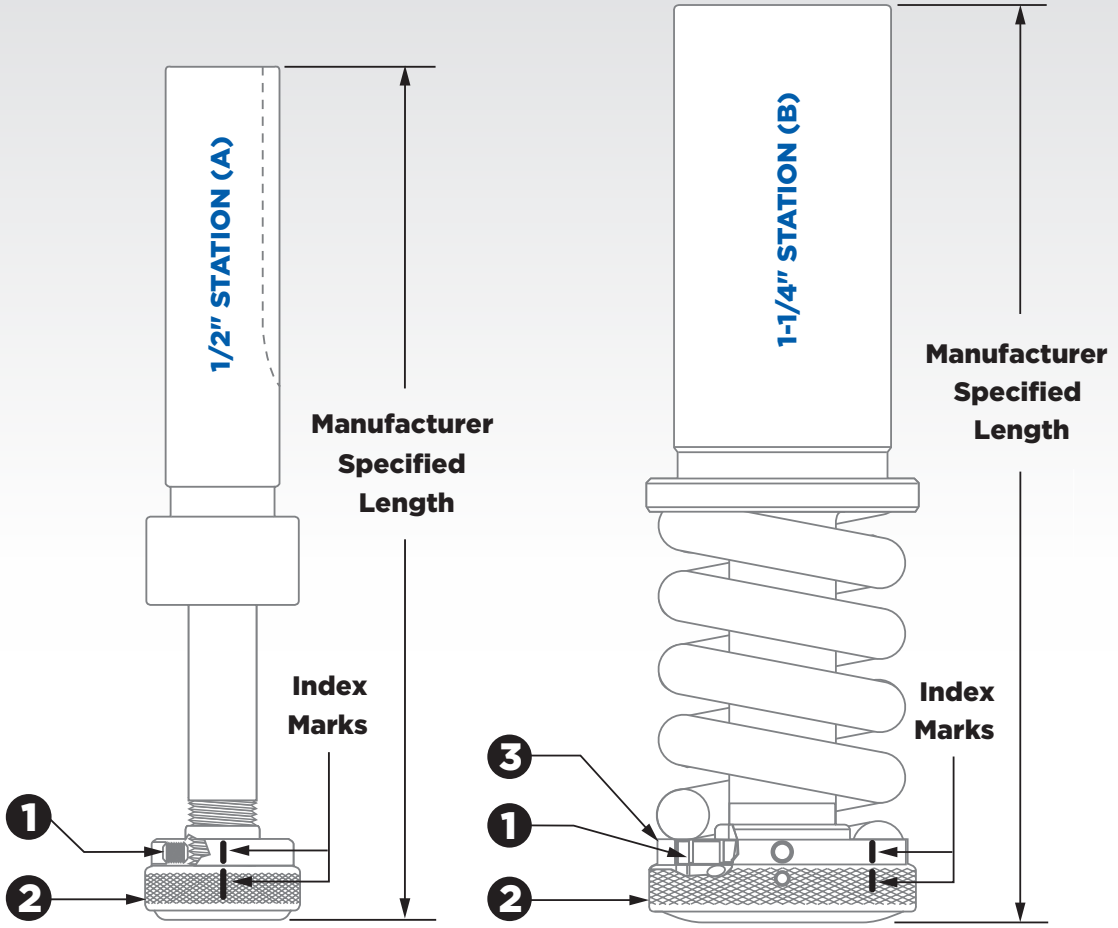
E-Z SET PUNCH HEAD INSTRUCTIONS



How to Install and Adjust your EZ Set Punch Head

	1/2" STATION (A)	1-1/4" STATION (B)
Step 1	Align index marks on the two pieces of the E-Z Set punch head.	
Step 2	Holding the two pieces together, install the punch head onto the punch shank by turning head clockwise to the manufacturer's specified length.	Holding the two pieces together, install the punch head onto the punch shank with a spring or urethane. Use a spanner wrench in one of the two set screw holes in the lower part (Detail 3) and turn head clockwise to the manufacturer's specified length.
Step 3	Tighten the two 5mm set screws (Detail 1).	
Step 4	To increase length (DO NOT loosen set screws), just lift outer ring (Detail 2) and turn counter clockwise. Each click provides a .0035" [0.09mm] incremental change in tool length. The maximum length adjustment is approximately .125" [3.18mm]. When limit is reached, head will rotate freely for approximately one quarter turn.	
Step 5	On forming tools made for more than one material thickness, set the manufacturer's specified length to the thicker material and adjust for the thinner material. *NOTE: Resetting the head for further adjustment is NOT RECOMMENDED because of reduced thread engagement. DAMAGE MAY OCCUR.*	

For more information, visit wilsontool.com/punching, call our tooling technicians at 800.328.9646 or contact your sales engineer.

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