

## DIE SELECTION CHART

PLEASE NOTE:

1. Die Size (denoted by color) directly relates to the anvil depth.
2. Thicker the material the greater the anvil depth
3. All punches are same: 0.187 tip diameter, 0.015 chamfer radius.

### CONDENSED DIE / GAUGE CHART - REFERENCE

#50 DIE (red)	16-18 GAUGE	C/Q
#40 DIE (blue)	20-22-24-GAUGE	C/Q
#30 DIE (yellow)	26-28 GAUGE	C/Q
#30 DIE (yellow)	30* GAUGE	*D/Q (recommended)

C/Q-Commercial Quality Mild Steel  
D/Q-Drawing Quality Mild Steel

DETAILED DIE SELECTION CHART - For reference only. Drawing Quality of material will determine the most successful die/gauge combination. This chart is a guide only. Some materials will require a different anvil depth.

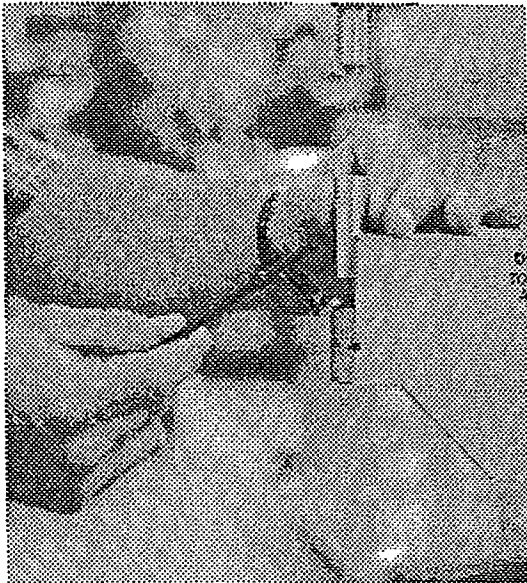
<u>MATERIAL THICKNESS (TOP - BOTTOM)</u>	<u>GAUGE (TOP - BOTTOM)</u>	<u>DIE (ANVIL DEPTH)</u>	<u>MATERIAL</u>
.063 - .063	16-16	#50 (Red)	C/Q
.063 - .052	16-18	#50 (Red)	C/Q
.063 - .040	16-20	#50 (Red)	C/Q
.052 - .052	18-18	#50 (Red)	C/Q
.052 - .040	18-20	#50 (Red)	C/Q
.040 - .040	20-20	#40 (Blue)	C/Q
.040 - .034	20-22	#40 (Blue)	C/Q
.040 - .028	20-24	#40 (Blue)	C/Q
.034 - .034	22-22	#40 (Blue)	C/Q
.034 - .028	22-24	#40 (Blue)	C/Q
.034 - .022	22-26	#40 (Blue)	C/Q
.028 - .028	24-24	#40 (Blue)	C/Q
.028 - .022	24-26	#40 (Blue)	C/Q
.022 - .022	26-26	#30 (Yellow)	C/Q
.022 - .018	26-28	#30 (Yellow)	C/Q
.022 - .016	26-30*	#30 (Yellow)	C/Q -D/Q
.018 - .018	28-28	#30 (Yellow)	C/Q
.018 - .016	28-30*	#30 (Yellow)	C/Q - DQ
.016 - .016	30*-30*	#30 (Yellow)	D/Q

\*Drawing Quality Steel

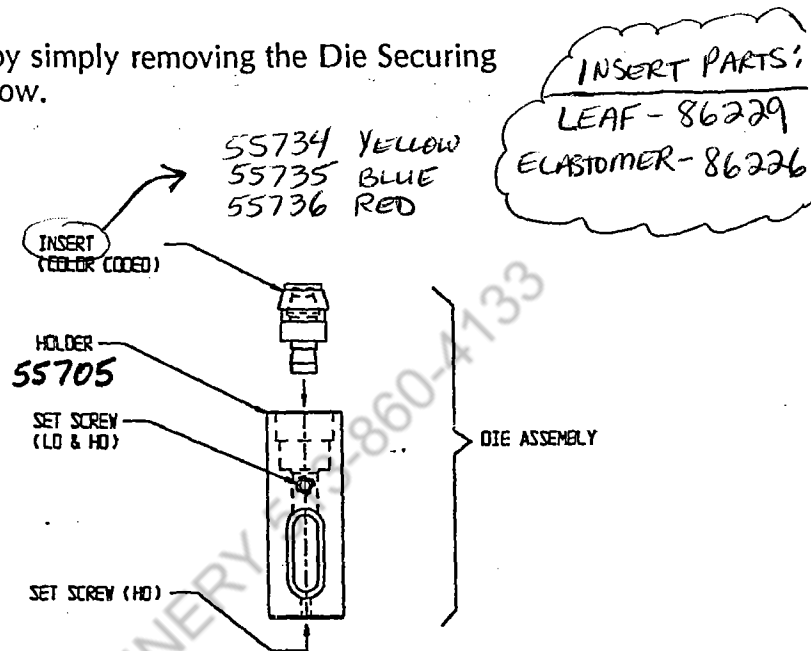
## REMOVING THE DIE ASSEMBLY

**CAUTION!** DISCONNECT AIR SUPPLY AND DRAIN TANK BEFORE REMOVING DIE!

The buttonlok die may be removed by simply removing the Die Securing Screw. See photo and illustration below.



DIE SECURING SCREW



DIE WITH HOLDER:

9955706 - #30 DIE YELLOW

9955707 - #40 DIE BLUE

9955708 - #50 DIE RED

## REPLACING THE DIE INSERT

1. Remove the Die Assembly.
2. Loosen the Die Insert Set Screw.
3. Insert an allen wrench up through the hole in the bottom of the die, and push the die insert out the top.
4. Install new die insert, and tighten the Die Insert Set Screw.
5. Install die in Quiclok, and tighten the Die Securing Screw. Lightly oil the die before replacing the die in the machine. The side of the die with the threaded set screw hole faces outward.
6. Replace the Plastic Guard (if removed).
7. Re-connect the Air Supply.

THE MACHINE IS NOW ASSEMBLED  
AND READY FOR DIE ADJUSTMENTS