

SECTION "J"- TROUBLE SHOOTING

<i>PROBLEM</i>	<i>CAUSE</i>	<i>SOLUTION</i>
<i>UNEVEN PENETRATION DEPTH</i>	<ul style="list-style-type: none"> - INADEQUATE TONNAGE - RAM NOT PARALLEL TO BED - PUNCHES SHARPENED BUT NOT SHIMMED 	<ul style="list-style-type: none"> -CHECK TONNAGE REQUIREMENT - ADJUST PRESS GIBBS. - CENTER TOOLING LOAD UNDER RAM - ADD SHIM TO PUNCH (ES)
<i>KNOCKOUTS CUT THROUGH</i>	<ul style="list-style-type: none"> - RAM DEPTH SET TO DEEP - RAM OVER TRAVEL 	<ul style="list-style-type: none"> - INCREASE SHUT HEIGHT - ADD PRESS STOP BLOCKS
<i>HOLE PATTERN NOT CONSISTANT WITH EDGE OF SHEET</i>	<ul style="list-style-type: none"> - GAGE POSITION - PART LOADING - IMPROPER GAGE POSITION 	<ul style="list-style-type: none"> - RECHECK BLANK SHEAR SIZE - REVIEW PART DESIGN PRINT AND TEMPLATE LAYOUT - VERIFY GAGE LOCATIONS
<i>STRIP FEED STICKS TO DIE BUSHING</i>	<ul style="list-style-type: none"> - STRIP BURR CATCHES IN DIE 	<ul style="list-style-type: none"> - ADD LIFTERS TO RAISE STRIP WHEN MOVING
<i>WORKPIECE DOES NOT STRIP FROM PUNCH</i>	<ul style="list-style-type: none"> - TONNAGE - FATIGUED STRIPPERS 	<ul style="list-style-type: none"> - RECALCULATE TONNAGE -REPLACE STRIPPER OR SPRINGS
<i>BROKEN PUNCHES</i>	<ul style="list-style-type: none"> - ROCKING OF PUNCH DURING PUNCHING - TEMPLATE BENT SO PUNCHES ARE NOT VERTICAL -SLUGS UNDER DIE RETAINER 	<ul style="list-style-type: none"> - RAM MOVING F-B, OR L-R UNDER LOAD. STOP BLOCKS AND CENTER LOAD UNDER RAM -STRAIGHTEN / REPLACE TEMPLATES - CLEAN PRESS BED SURFACE THOROUGHLY

<i>PROBLEM</i>	<i>CAUSE</i>	<i>SOLUTION</i>
<i>EXCESSIVE BURR ON WORKPIECE</i>	<ul style="list-style-type: none"> -DULL PUNCHES OR DIES -EXCESSIVE DIE CLEARANCE - WORN POST ASSEMBLIES - RAM/BED OF PRESS NOT PARALLEL UNDER LOAD -WORKPIECE MOVING DURING PUNCHING 	<ul style="list-style-type: none"> - <i>REPLACE OR SHARPEN PUNCHES OR DIES</i> -<i>CHECK MATERIAL TYPE & THICKNESS ADJUST CLEARANCE AS NECESSARY.</i> - <i>STOP PRESS AT BOTTOM OF STROKE. MEASURE RAM TO BED DIMENSION AT 4 CORNERS. USE STOP BLOCKS OR REPAIR PRESS.</i> -<i>VERIFY PUSHERS ARE INSTALLED AND FUNCTIONING</i>