

SECTION "J"- TROUBLE SHOOTING

<i>PROBLEM</i>	<i>CAUSE</i>	<i>SOLUTION</i>
<i>LOOSE PUNCHES</i>	<ul style="list-style-type: none"> - INCORRECT INSTALLATION - NO LOCTITE USED - NOT SNUGGED AGAINST DRIVER FACE WHEN INSTALLED - STRIPPED THREADS ON STUD OR CAPTIVE SCREW OR IN PUNCH 	<ul style="list-style-type: none"> - <i>INSTALL PER SECTION "G"</i> - <i>REASSEMBLE WITH LOCTITE</i> - <i>REPLACE FASTENER OR PUNCH</i>
<i>GUIDES BREAK</i>	<ul style="list-style-type: none"> - PUNCH RADIUS ON BODY CONTACTS SHAPE HOLE IN GUIDE - GUIDE NOT FULLY SUPPORTED BY WORKPIECE (E.G. SIDE NOTCH OR CORNER NOTCH) 	<ul style="list-style-type: none"> - <i>INCREASE SHUT HEIGHT, REPLACE PUNCH, SHARPEN AND THEN SHIM PUNCH</i> - <i>ADD MATERIAL THICKNESS PATCH TO UNSUPPORTED AREA ON GUIDE FACE OR TOP OF DIE BUSHING</i>
<i>POST WILL NOT WORK PROPERLY</i>	<ul style="list-style-type: none"> - BROKEN SPRING 	<ul style="list-style-type: none"> - <i>REPLACE SPRING</i>
<i>EXCESSIVE BURR ON WORKPIECE</i>	<ul style="list-style-type: none"> - DULL PUNCHES OR DIES - 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>REPLACE WORN POST PARTS</i> - <i>STOP PRESS AT BOTTOM OF STROKE. MEASURE RAM TO BED DIMENSION AT 4 CORNERS. USE STOP BLOCKS OR REPAIR PRESS.</i> - <i>MOVE XimmiX SETUP TO CENTER LOAD</i> - <i>VERIFY PUSHERS ARE INSTALLED AND FUNCTIONING</i> - <i>CHECK DIE CLEARANCE. IMPROPER PUNCH TO DIE SIZES USED. REPLACE WITH PROPER DIE SIZE.</i>

<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 - STRIPPED THREADS ON STUD OR CAPTIVE SCREW OR IN PUNCH 	<ul style="list-style-type: none"> - CHECK TONNAGE REQUIREMENT - CENTER TOOLING LOAD UNDER RAM - ADD SHIM TO PUNCH(S) - REPLACE DRIVER ASSEMBLY OR PUNCH
<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 GUIDE/PUNCH</i>	<ul style="list-style-type: none"> - TONNAGE - FATIGUED STRIPPERS -PUNCH TO GUIDE CLEARANCE TOO TIGHT - IF PUNCHING GALVANIZED MATERIAL, PUNCH GALLING WILL JAM GUIDE OPENING 	<ul style="list-style-type: none"> - RECALCULATE TONNAGE -REPLACE PUNCH HEAD URETHANE - INCREASE CLEARANCE - INCREASE GUIDE CLEARANCE
<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 POD 	<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