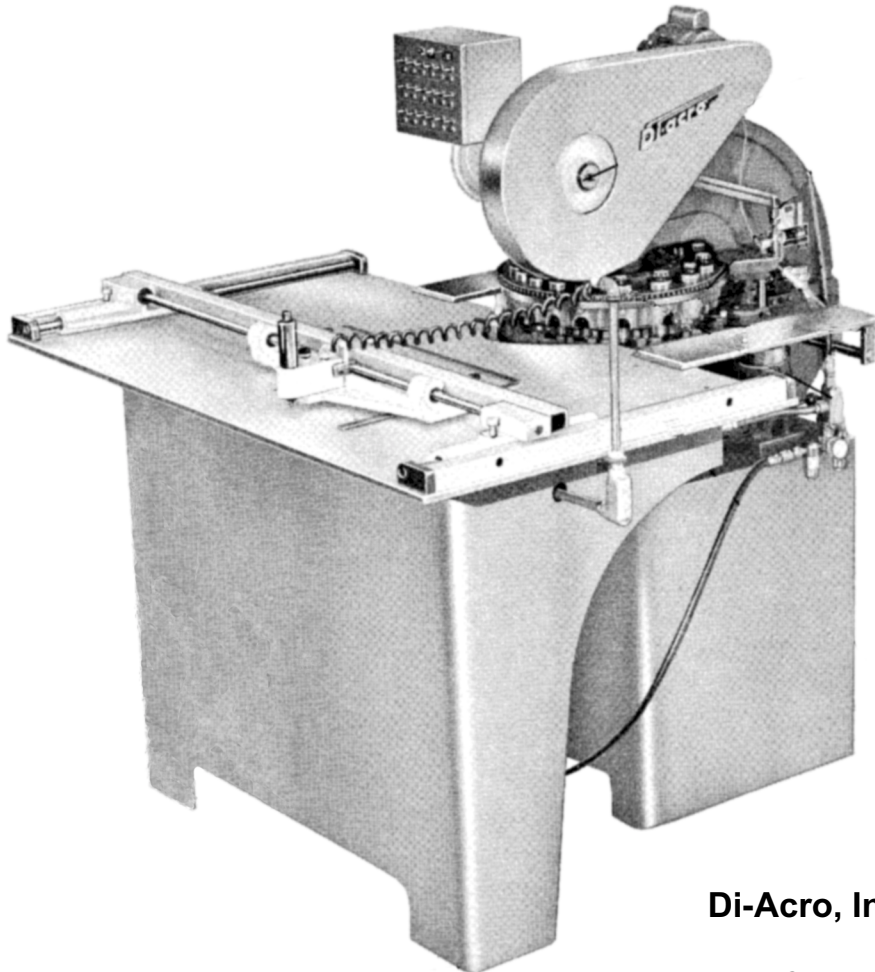


OPERATOR'S MANUAL & INSTRUCTIONS

# Di-Acro 18E Stylus Turret Punch Press



**Di-Acro, Incorporated**

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Revised 01/02

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**Di-Acro<sup>®</sup>**

**STYLUS  
OPERATED TURRET  
PUNCH PRESS  
PARTS LIST**

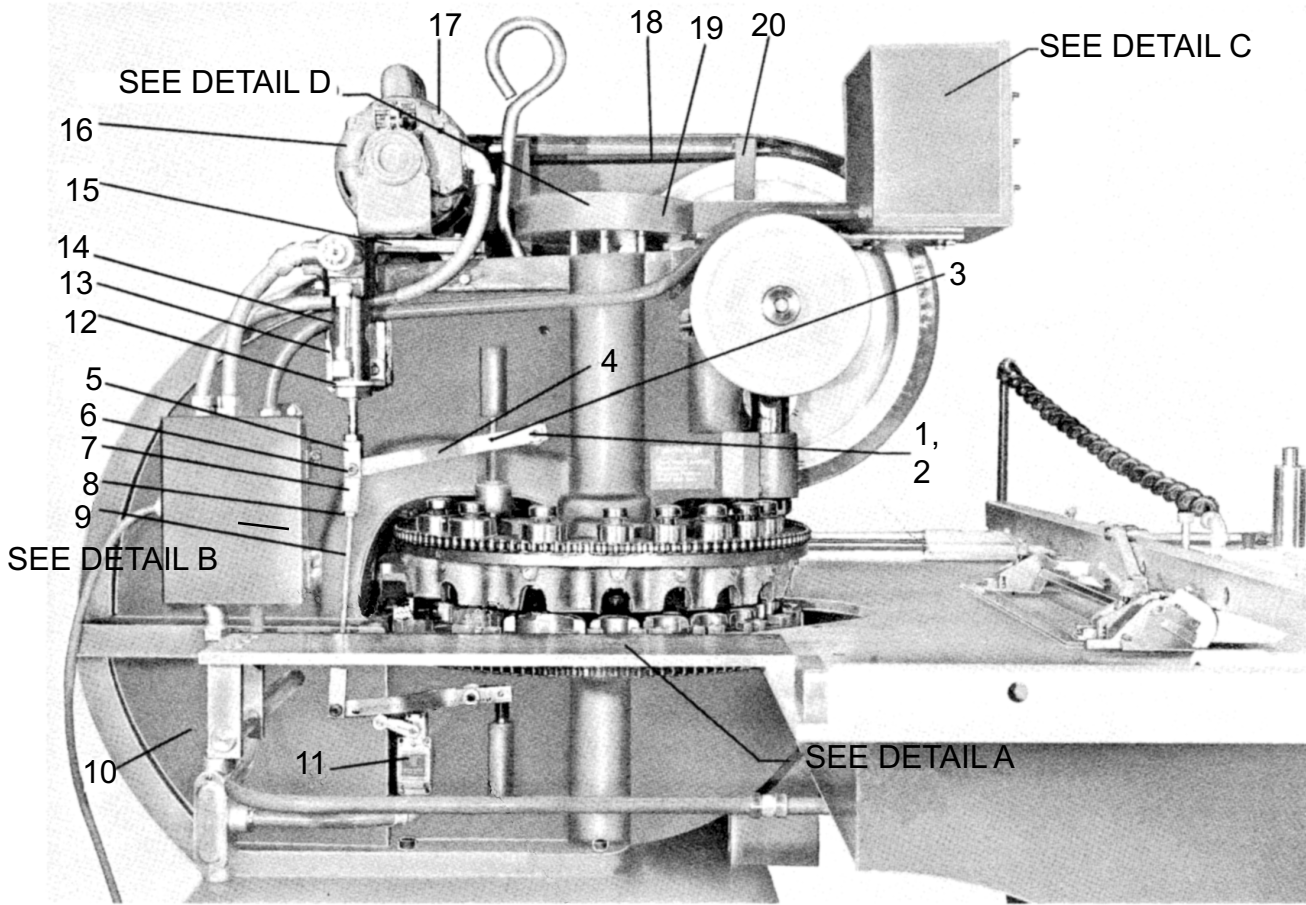
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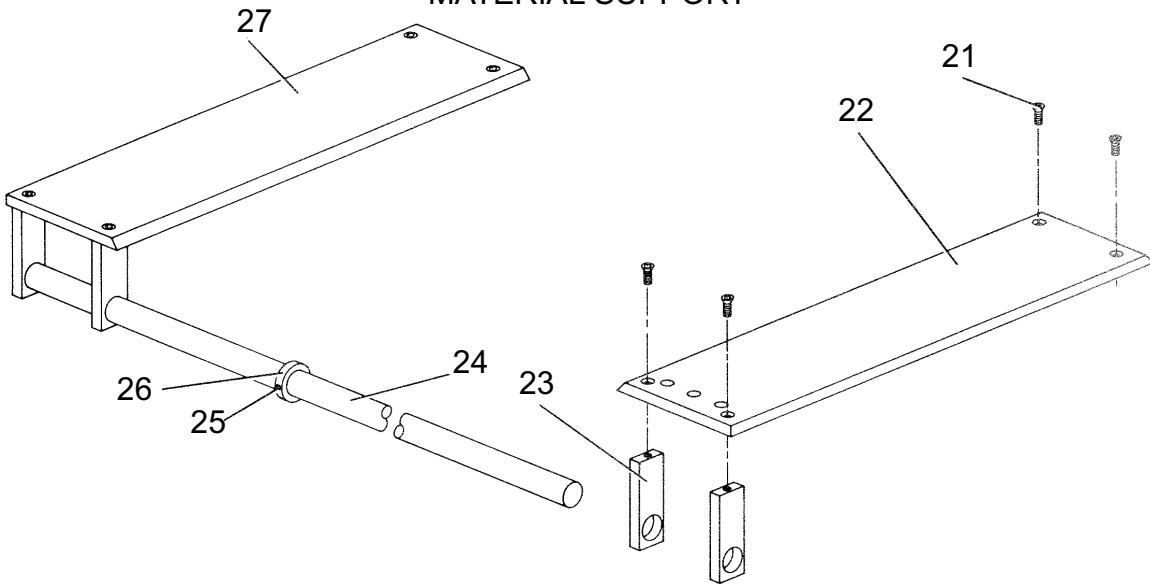
**SPECIFICATIONS**

<b>MODEL</b>	<b>Standard</b>	<b>Metric</b>
Punching Pressure	7-1/2 tons	6804 Kg
Punching Capacity	2" in 16-gauge mild steel	50.8 mm in 1.5 mm mild steel
Throat Depth	19"	483 mm
Number of Stations	18	
Workpiece Size*	19" x 24"	483 mm x 610 mm
Material Capacity (maximum)	1/8"	3.2 mm
Table Size*	19" x 24"	483 mm x 610 mm
Carriage Travel*	19" x 24"	483 mm x 610 mm
Punching Speeds	up to 140 holes per minute dependent on operator proficiency	
Crankshaft Speed	245 strokes per minute	
Dependable Accuracy	+-.005"	+-.127 mm
Height	68"	1730 mm
Width*	60"	1520 mm
Depth	60"	1520 mm
Shipping Weight	1875 lbs.	851 Kgs
Motor	1/2-hp, 800 rpm (specify 230 or 460 volts) A.C. 3-phase, 60 cycle dual V-belt	

18E STYLUS LEFT SIDE



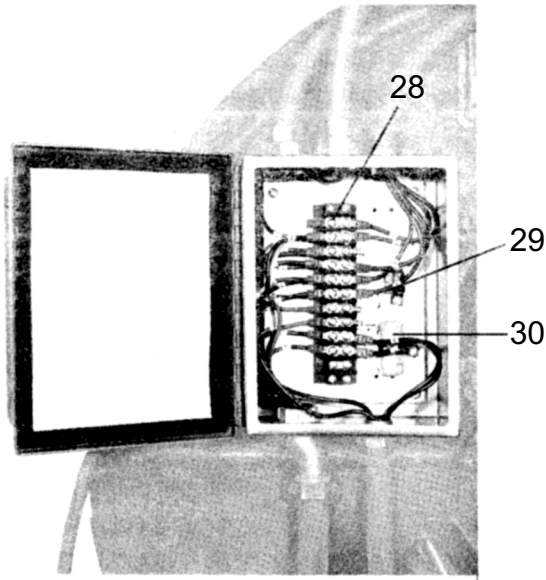
MATERIAL SUPPORT



DETAIL A

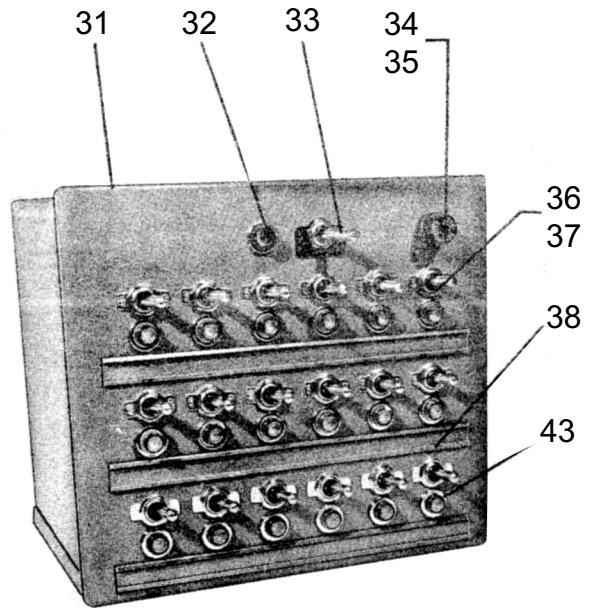
Di-Acro 18E Stylus (Part 1 of 2)  
Figure 1

ELECTRICAL BOX



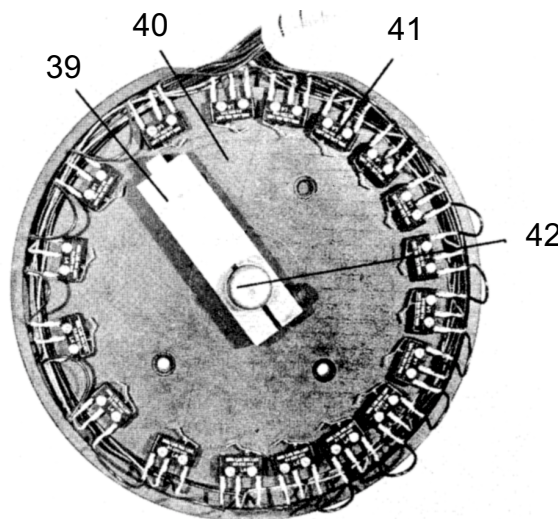
DETAIL B

SWITCH MOUNT ASSEMBLY



DETAIL C

SWITCH MOUNT

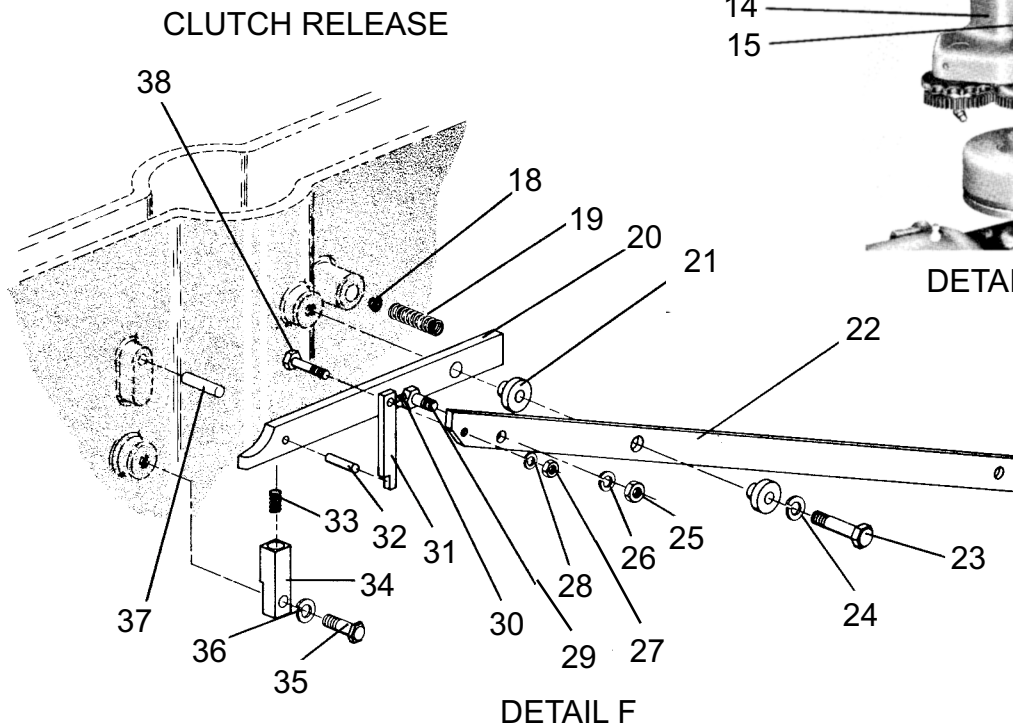
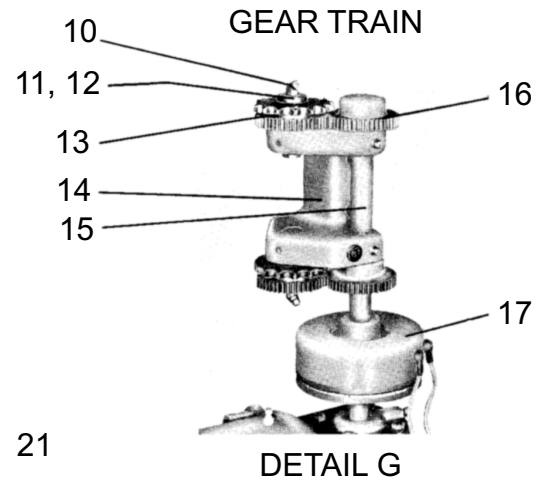
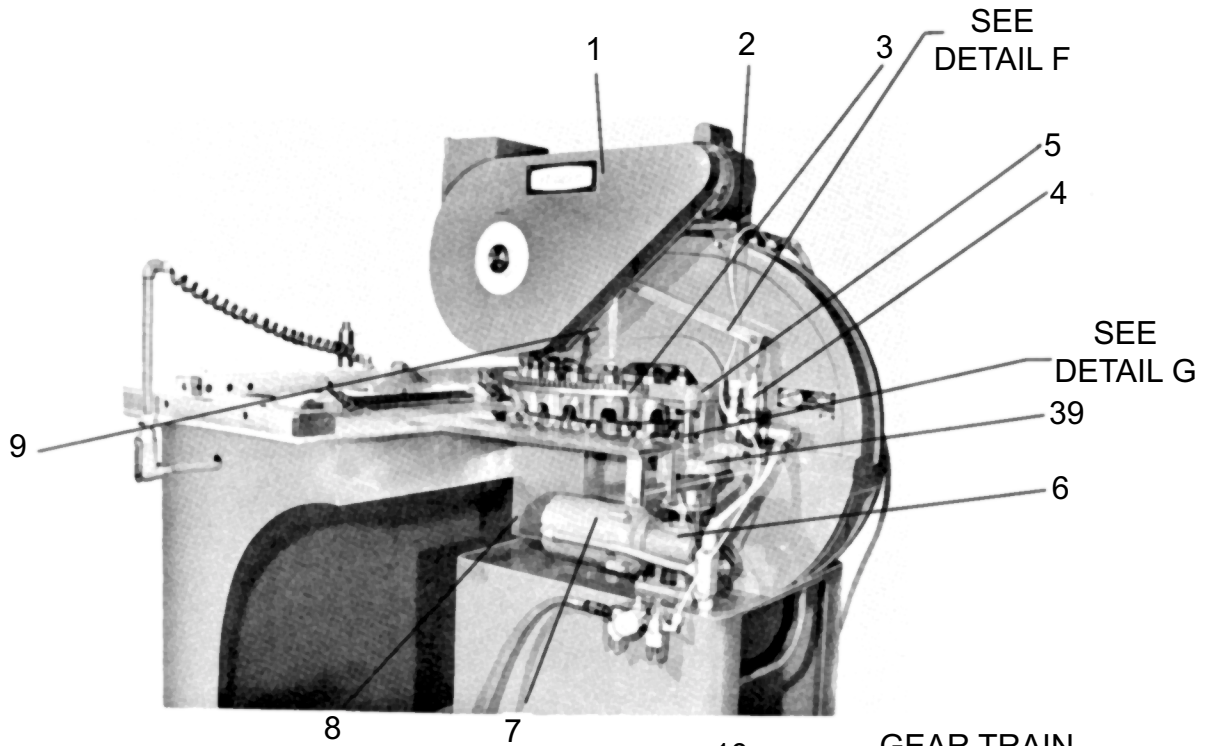


DETAIL D

Di-Acro 18E Stylus (Part 2 of 2)  
Figure 2

Item No.	Part No.	Description	Qty Used
1	21A0104C1104	Hex Head Cap Screw	1
2	066-3110002	Sleeve	1
3	1203175	Pin	2
4	066-1325024	Index Arm (upper)	1
5	066-1324005	Clevis	1
6	25X0308C1000	Shoulder Screw	1
7	066-1301101	Clevis	3
8	31X0308C	Nut	2
9	066-1301113	Rod	1
10	066-1103720	Frame Assembly	1
11	3305038	Micro Switch	1
12	3307004	Foot Mount	1
13	066-1110106	Cylinder Mount	1
14	3507002	Allen Air Cylinder	1
15	065-1110048	Motor Mount	1
16	3301020	Motor	1
17	3325010	Thermal Overload Protector	1
18	4401003	V-Belts	
19	066-1106034	Switch Cover Assembly	1
20	065-1106055	Guard Mount	2
21	20C0104C0304	Flat Head Soc Set Screw	1
22	066-1105014	Material Support "L"	1
23	066-1105012	Material Support Block	4
24	066-1105011	Material Support Rod	1
25	23A0308C0104	Allen Set Screw	1
26	150-1301087	Collar	1
27	066-1105013	Material Support "Right"	1
28		Terminal	1
29	3309001	Capacitor	1
30	3310003	Rectifier	1
31	066-3399717	SWITCH MOUNT ASSEMBLY	1
32	3302012	Glo-lite (Red)	1
33	3303035	Toggle Switch	1
34	3308108	Fuse Holder	1
35	3308103	Fuse Slow Burn	1
36	3303036	Toggle Switch	18
37	3303049	Locking Ring	19
38	6999105	Card Holder	3
39	066-1301108	Switch Actuator	1
40	066-1301109	Switch Mount	1
41	3305012	Microswitches	18
42	066-1211044	Shaft	1
43	3302011	Glo-lite (Amber)	18

### 18E STYLUS RIGHT SIDE

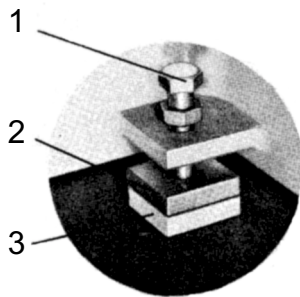
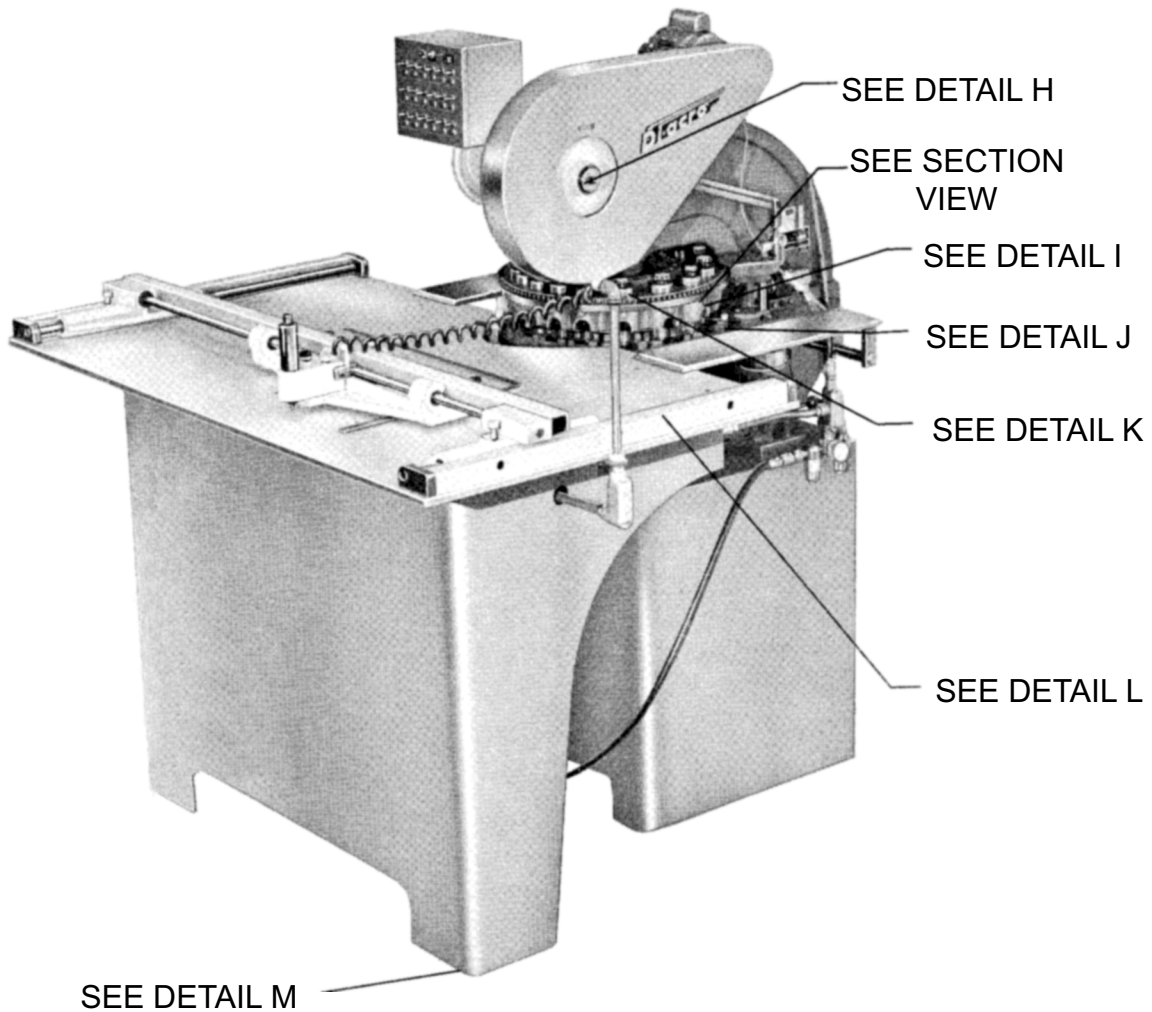


Di-Acro 18E Stylus (Part 1 of 1)  
Figure 3

Item No.	Part No.	Description	Qty Used
1	065-1106083	Guard Assembly	1
2	3509902	Polyethylene Tubing	1
3	066-4301013	Chain	1
4	066-9300811	Punch Cycle Mod Kit	1
5	066-1106031	Guard Assembly "Upper"	1
6	1223002	Gear Reducer	1
7	3301017	Motor	1
8	066-1109109	Chute Assembly	1
9	056-1110088	Bracket "B"	1
10	6901002	Grease Fitting	2
11	3104125	Pin	2
12	062-1203039	Bearing Sleeve	2
13	066-5301072	Index Idler	2
14	066-1110104	Index Mount	1
15	066-1211006	Index Shaft	1
16	066-3901001	Gear	2
17	3322007	Warner Clutch Coupling	1
18	238-1301026	Slug	1
19	5102102	Spring	1
20	056-1301096	Clutch Release Lever	1
21	250-1108069	Link Spacer Sleeve	2
22	065-1301038	Trip Lever	1
23	21A0308C1304	Hex Hd Cap Screw	1
24	62X0308	Lock Washer	1
25	30X0308C	Nut	1
26	62X0308	Lock Washer	1
27	30X0104C	Nut	1
28	62X0104	Spring Lock Washer	1
29	035-1301093	Spring Bolt	1
30	120-5102022	Spring	1
31	056-1301094	Safety Link	1
32	1203171	Pin	1
33	5102110	Spring	1
34	056-1301091	Spring Container	1
35	21A0308C1104	Hex Head Cap Screw	1
36	62X0308	Lock Washer	1
37	1203171	Pin	1
38	21A0104C1000	Hex Head Cap Screw	1
39	066-1106037	Guard Assembly "Lower"	1

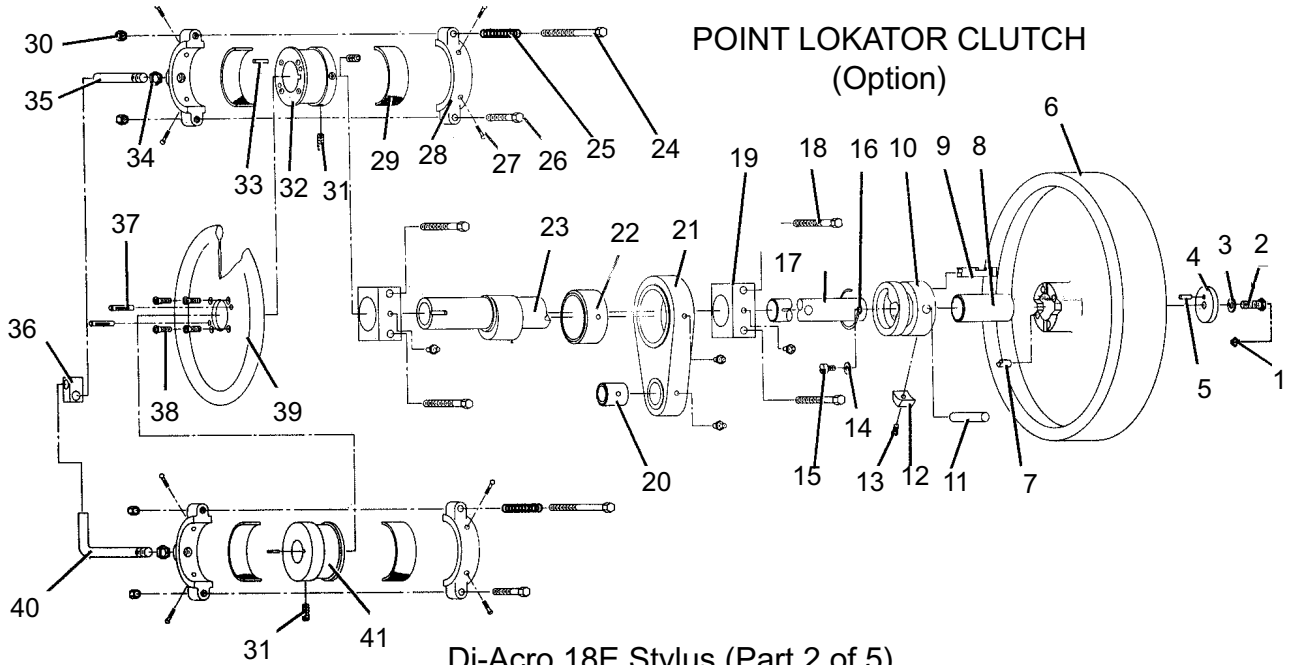
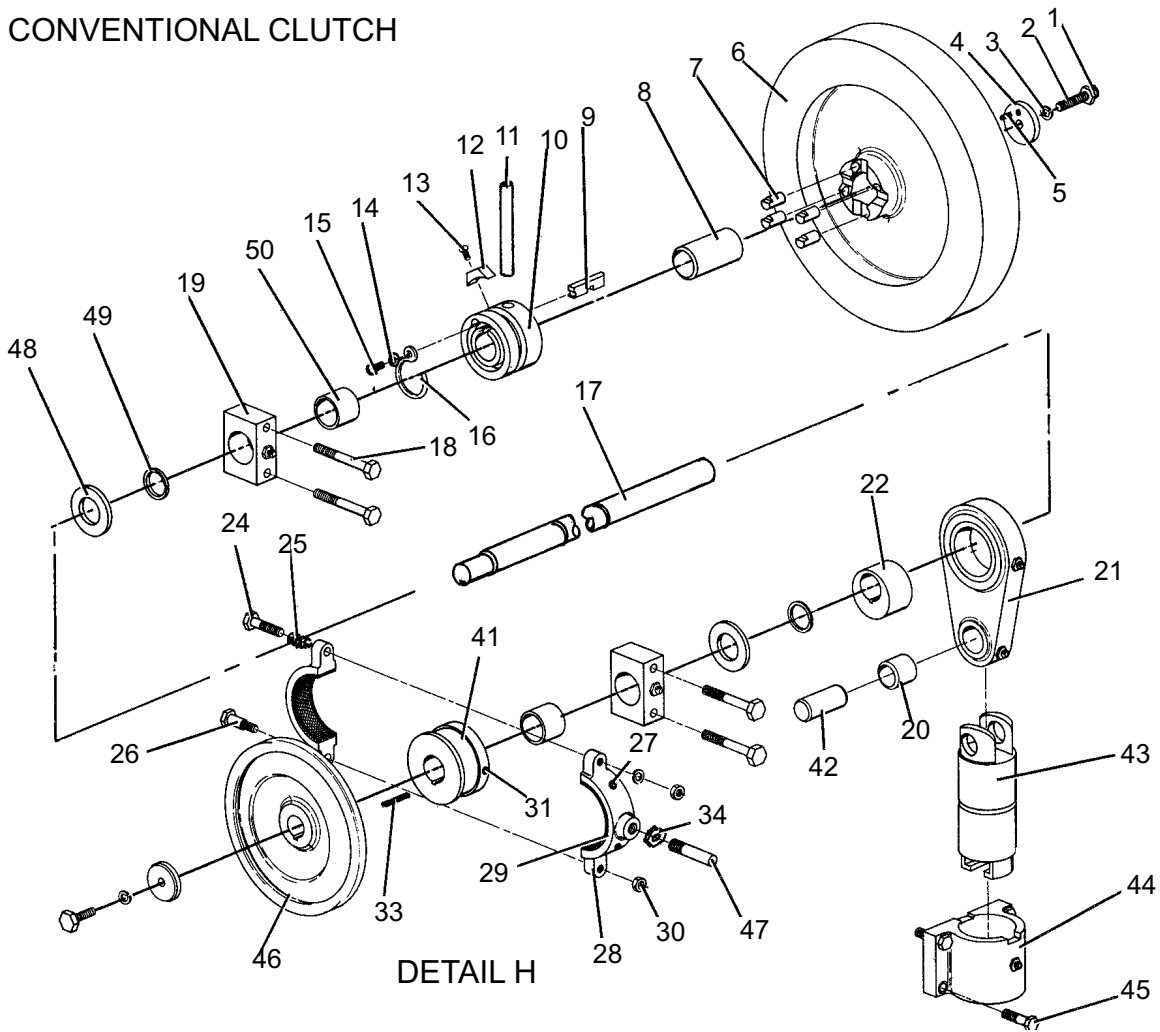


### PAD PLATE ASSEMBLY



Di-Acro 18E Stylus (Part 1 of 5)  
Figure 4

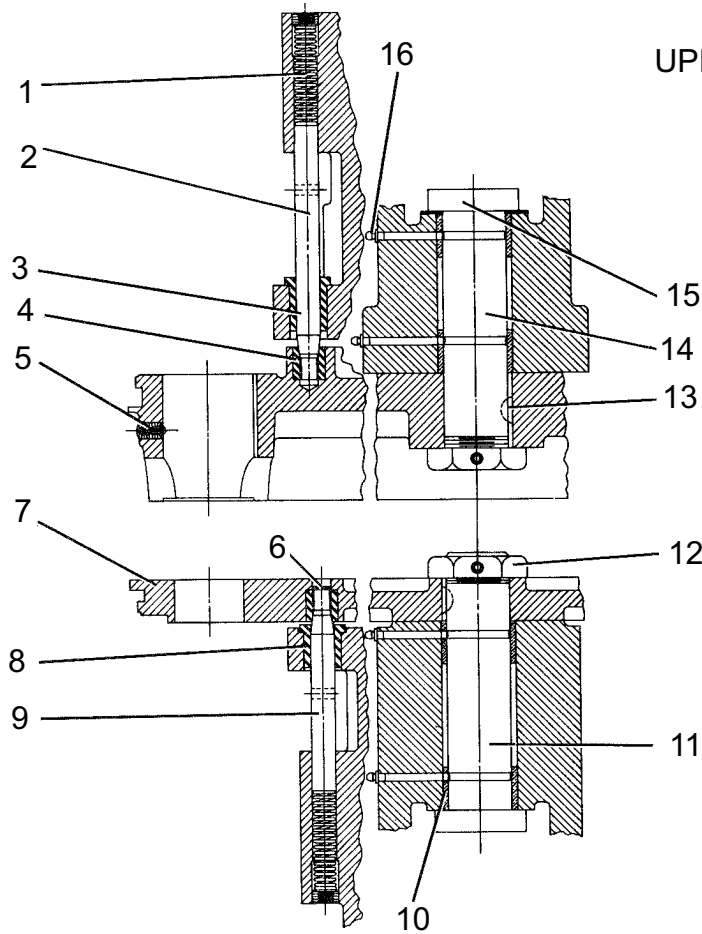
### CONVENTIONAL CLUTCH



Di-Acro 18E Stylus (Part 2 of 5)  
Figure 5

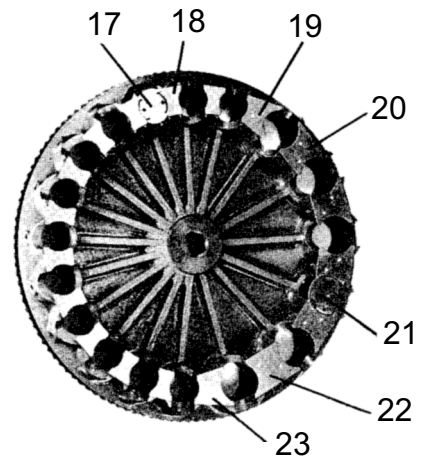
Item No.	Part No.	Description	Qty Used
1	6901002	Grease Fitting	6
	6901002	Grease Fitting (Optional)	4
2	056-4701087	Hex Head Cap Screw	1
	056-4701087	Hex Head Cap Screw (Optional)	1
3	62X0508	Lock Washer	1
	62X0508	Lock Washer (Optional)	1
4	250-4901067	Shaft Washer	1
	250-4901067	Shaft Washer (Optional)	1
5	1203105	Pin	1
	1203105	Pin (Optional)	1
6	056-1204086	Fly Wheel	1
	056-1204089	Fly Wheel (Optional)	1
7	250-1203074	Drive Pin	4
	250-1203074	Drive Pin (Optional)	4
8	056-3106092	Fly Wheel Bearing	1
	056-3106092	Fly Wheel Bearing (Optional)	1
9	8000120-603	Clutch Dog	1
	250-1206039	Clutch Dog (Optional)	1
10	250-1206038	Clutch	1
	065-1206008	Clutch (Optional)	1
11	1203104	Pin	1
	1203104	Pin (Optional)	1
12	056-1201069	Non Repeat Cam	1
	056-1201069	Non Repeat Cam (Optional)	1
13	20C0104C0304	Flat Hd Soc Set Screw	1
	20C0104C0304	Flat Hd Soc Set Screw (Optional)	1
14	61X0104F0102	Flat Washer	1
	61X0104F0102	Flat Washer (Optional)	1
15	22B0104C0308	Fillister Head Screw	1
	22B0104C0308	Fillister Head Screw (Optional)	1
16	250-5103040	Clutch Spring	1
	250-5103040	Clutch Spring (Optional)	1
17	066-1201061	Crankshaft	1
	065-1211007	Camshaft (Optional)	1
18	21A0308C2304	Hex Head Cap Screw	4
	21A0308C2304	Hex Head Cap Screw (Optional)	4
19	065-3106015	Main Bearing	2
	065-3106015	Main Bearing (Optional)	2

Item No.	Part No.	Description	Qty Used
20	065-3106063	Bearing	1
	065-3106063	Bearing (Optional)	1
21	065-1201062	Connecting Arm	1
	065-1201062	Connecting Arm (Optional)	1
22	065-1202061	Eccentric	1
	650-3106036	Main Bearing (Optional)	1
23	065-1202004	Cam (Optional)	1
	270-1207710	BRAKE SHOE ASSEMBLY	
24	21A0516C2102	Hex Head Cap Screw	1
	21A0516C2102	Hex Head Cap Screw	2
25	5102110	Spring	1
	510211	Spring (Optional)	2
26	21A0516C1102	Hex Head Cap Screw	1
	21A0516C1102	Hex Head Cap Screw (Optional)	2
27	4703001	Rivet	4
	4703001	Rivet (Optional)	8
28	270-1207055	Brake Shoe	1
	270-1207055	Brake Shoe (Optional)	2
29	6999005	Brake Lining	2
	6999005	Brake Lining (Optional)	4
30	30X0516C	Hex Nut	2
	30X0516C	Hex Nut (Optional)	4
31	23A0516C0102	Socket Set Screw	1
	23A0516C0102	Socket Set Screw (Optional)	3
32	065-1207030	Brake Drum (Optional)	1
33	5501008	Key (Optional)	1
34	31X0102F	Jam Nut	1
	31X0102F	Jam Nut (Optional)	2
35	065-1207032	Brake Rod Inner (Optional)	1
36	065-1207031	Brake Stop (Optional)	1
37	1203171	Drive Lok Pin (Optional)	2
38	20C0104C0308	Flat Hd Soc Cap Screw (Optional)	4
39	065-1208007	Hand Wheel (Optional)	1
40	065-1207033	Brake Rod Outer (Optional)	1
41	066-1207053	Brake Collar	1
	066-1207053	Brake Collar (Optional)	1
42	065-1203006	Wrist Pin	1
43	065-1213008	Ram	1
44	060-1108006	Cap	1
45	21A0516C1708	Hex Head Cap Screw	4
46	066-1208001	Hand Wheel	1
47	056-1207056	Brake Rod	1
48	3107101	Thrust Bearing	2
49	4705102	Retaining Ring	2
50	620-3106011	Main Bearing	2

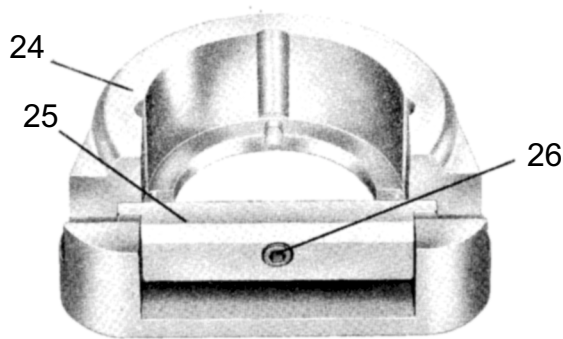


SECTION VIEW

UPPER & LOWER TURRETS



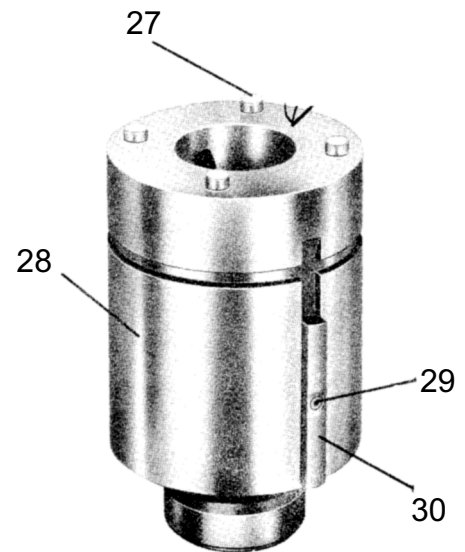
DETAIL I



DETAIL J

DIE HOLER ASSEMBLY

066-1502706 (A)  
066-1502707 (B)  
066-1502708 (C)

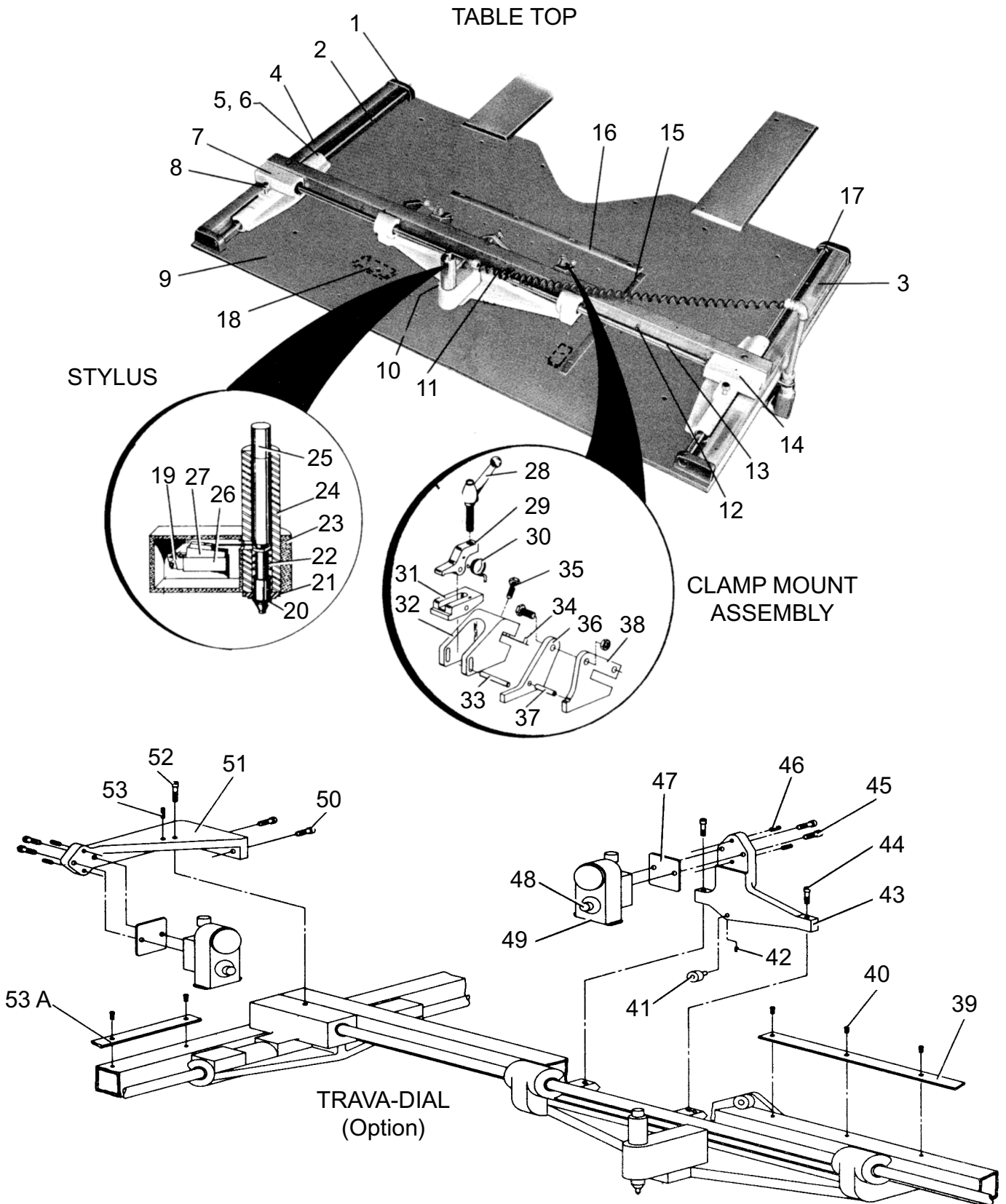


DETAIL K

PUNCH HOLDER ASSEMBLY

066-1501709 (S)  
066-1501710 (L)

Item No.	Part No.	Description	Qty Used
1	5102007	Spring	2
2	066-1327001	Index Pin (Upper)	1
3	3110004	Bushing	1
4	066-1108041	Tapered Bushing	18
5	6999020	Ball Plunges	18
6	3709067	Plug	18
7	066-1111002	Lower Turret	1
8	3110005	Bushing	1
9	066-1327002	Index Pin (Lower)	1
10	066-3104127	Bearing	4
11	060-4701029	Lower Turret Bolt	1
12	060-4704013	Turret Nut	2
13	5501103	Woodruff Key	2
14	060-4701028	Upper Turret Bolt	1
15	3107103	Thrust Bearing	1
16	6901002	Grease Fitting	4
17	060-1403042	Stripper "Small"	12
18	062-1403050	Stripper Clip "A"	11
19	062-1403052	Stripper Clip "C"	1
20	062-1403053	Stripper Clip "D"	4
21	060-1403043	Stripper "Large"	6
22	062-1403054	Stripper Clip "E"	1
23	062-1403051	Stripper Clip "B"	1
24	066-1502056	Die Holder "A"	12
	066-1502057	Die Holder "B"	5
	066-1502058	Die Holder "C"	1
25	066-1502053	Clamp	12
	066-1502054	Clamp	5
	066-1502055	Clamp	1
26	23AXX10F0102	Soc Set Screw	1
	23AXX10F0102	Soc Set Screw	18
27	1203176	Pin	18
28	066-1501042	Punch Holder	12
	066-1501043	Punch Holder	6
29	1203176	Drive Pin	18
30	066-5501001	Key	18
1	4701142	Adjusting Bolt	6
2	066-6910701	Pade Plate Assembly	1
3	6910001	Air-Lok Pad	1

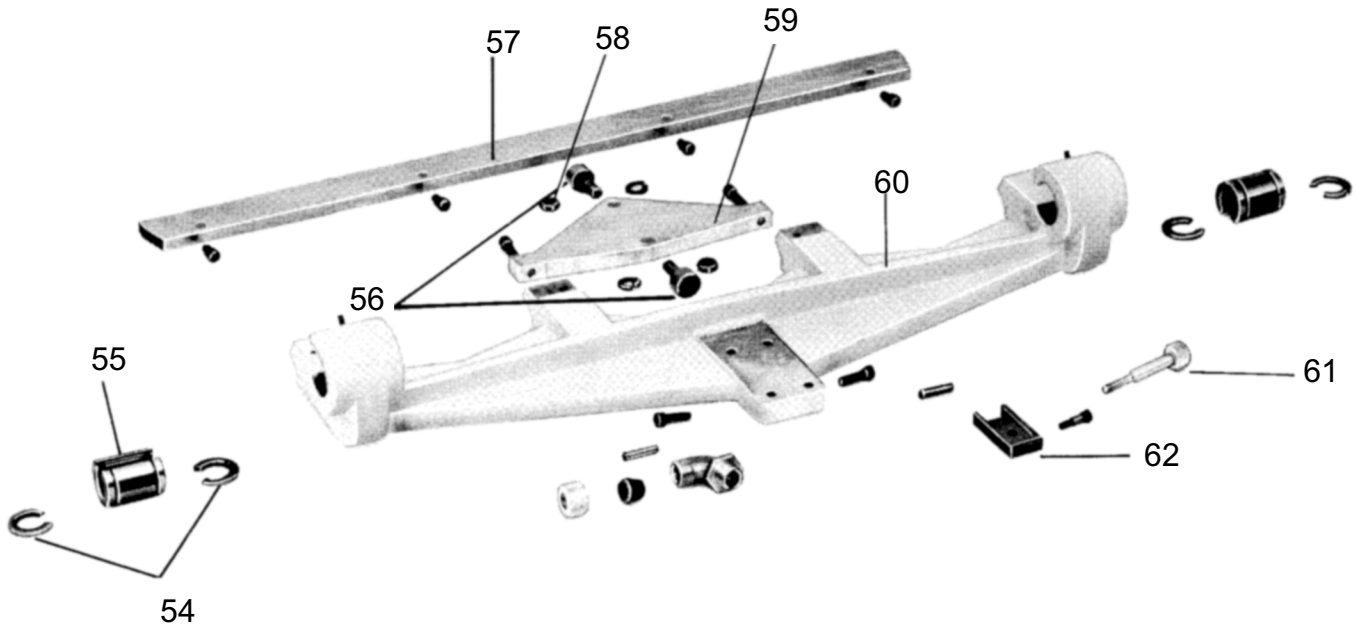


Di-Acro 18E Stylus (Part 4 of 5)  
Figure 7

Item No.	Part No.	Description	Qty Used
1	066-1113118	Block	4
2	066-1211001	Shaft	2
3	066-1113114	Support Bar "Right"	1
4	066-1113127	Support Bar "Left"	1
5	3102011	Seal	8
6	3102010	Ball Bearing	6
7	066-1113121	Bearing Housing Left	1
8	066-4701002	Screw	2
9	066-1105101	Table	1
10	066-1113126	Enclosure	1
11	3316926	Retractable Power Cord	1
12	066-4701001	Stud	2
13	066-1211002	Shaft	1
14	066-1113120	Bearing Housing Right	1
15	066-1105108	Side Bar	1
16	066-1105109	Base Bar	1
17	6999119	Neoprene Washer	6
18	066-1105110	Template Clamp	4
19	3305010	Microswitch Mounting Bracket	1
20	4705120	Retaining Ring	1
21	066-3110001	Bearing	1
22	620-5102054	Spring	1
23	066-1113104	Stylus Mount	1
24	066-1113105	Stylus Handle	1
25	066-1327701	Standard Stylus	1
	066-1327702	Small Stylus	1
26	3307113	Terminal Enclosure	1
27	3305009	Microswitch	1
	066-1113721	CLAMP MOUNT ASSEMBLY	
28	4710001	Adjustment Handle	1
29	066-1113004	Clamp	1
30	066-5103001	Spring	1
31	066-1113108	Clamp Support	1
32	066-1113109	Clamp Mount	1
33	1203162	Pin	1
34	066-1113128	Clamp Shoe	1
35	21A0104F	Hex Head Cap Screw	1
	066-1402707	END STOP ASSEMBLY	
36	066-1402038	Stop	1
37	1203192	Pin	1
38	066-1402040	Body	1
	066-1402039	Clamp (not shown)	1
	1203124	Pin (not shown)	1
	1203164	Pin (not shown)	1
39	066-1464001	Facing Strip	1
40	22CXX08F0308	Flat Head Machine Screw	11
41	3103016	Cam Follower	1
42	23A0104F0104	Socket Head Set Screw	1
43	066-1464003	Gage Support "Long"	1
44	20A0104C0708	Socket Head Cap Screw	2
45	20A0104C1000	Socket Head Cap Screw	4
46	23A0104C0102	Soc Set Cap Screw	4
47	0661464006	Sub Plate	2
48	066-1464007	Dial	2
49	1464005	Trav-A-Dial	2
50	20A0104C0102	Socket Head Cap Screw	2
51	066-1464004	Gage Support "Transverse"	1
52	20A0104C0304	Socket Head Cap Screw	1
53A	066-1464002	Facing Strip	1



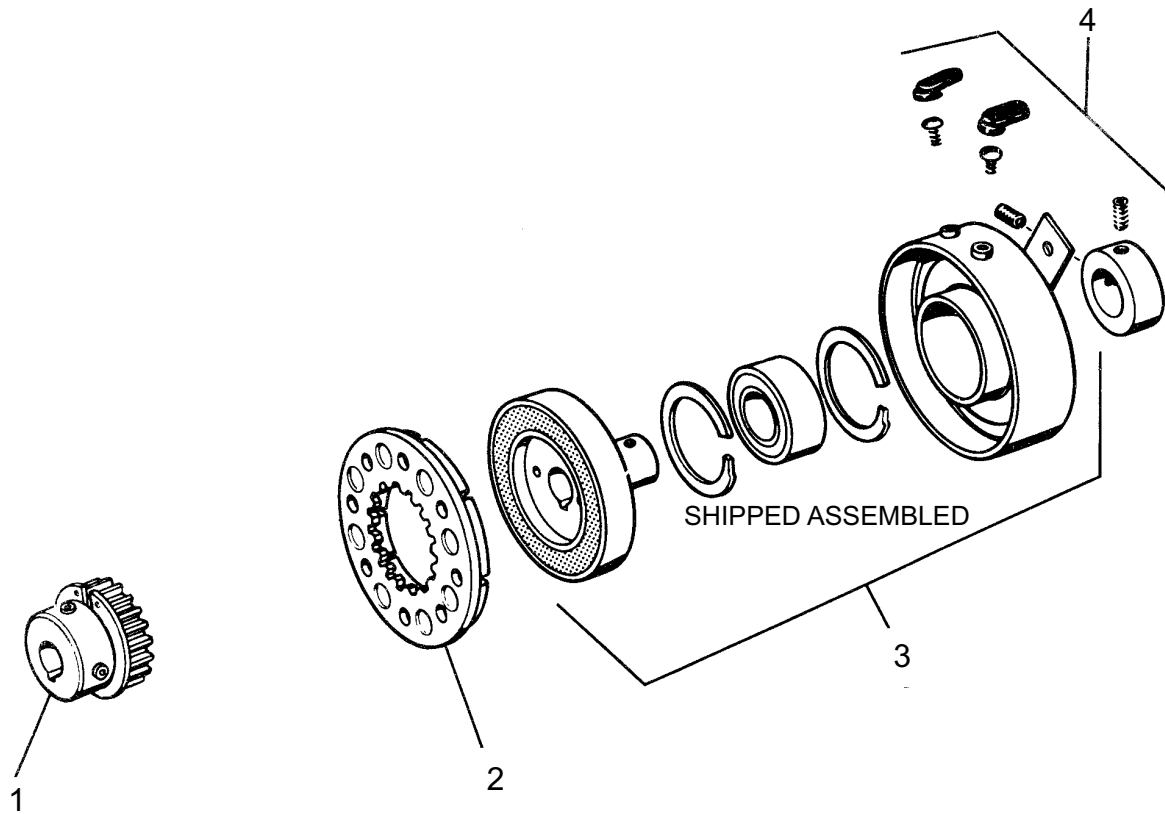
### CARRIAGE



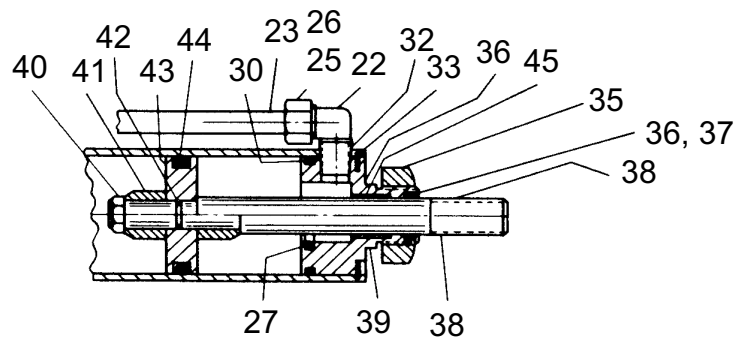
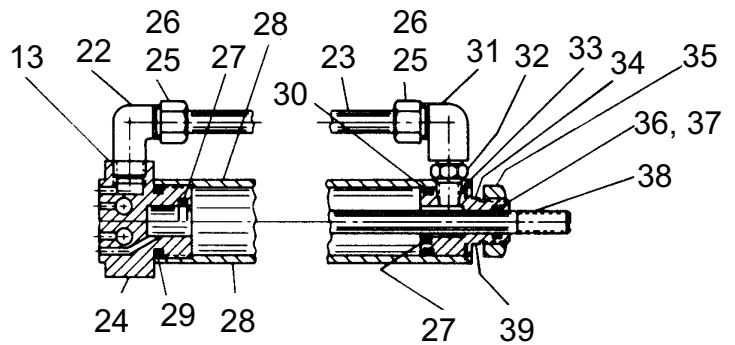
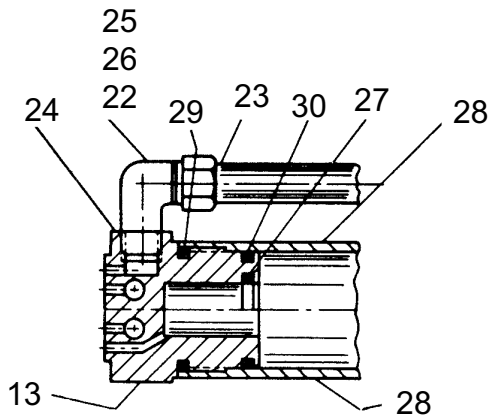
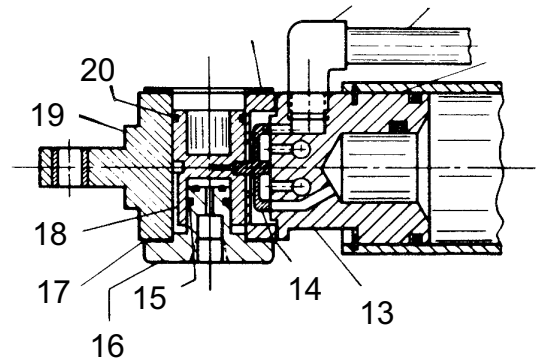
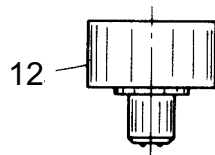
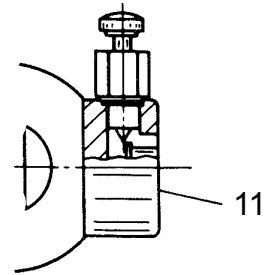
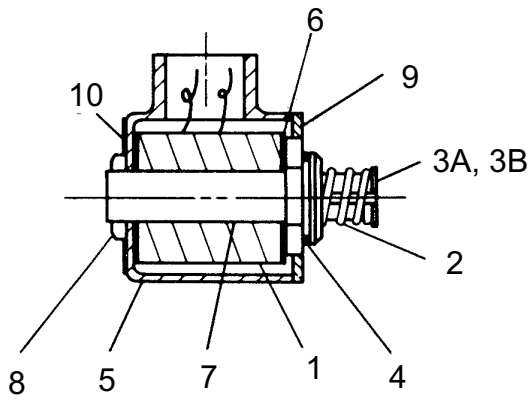
Di-Acro 18E Stylus (Part 5 of 5)  
Figure 8

Item No.	Part No.	Description	Qty.
54	3102011	Seal	8
55	3102010	Ball Bearing	6
56	3103016	Cam Follower Bearing	2
57	066-1113111	Clamp Mount Bar	1
58	4901110	Washer	2
59	066-1113102	Carriage Support	1
60	066-1113101	Carriage	1
61	066-4701143	Clamp Screw	1
62	066-1113123	Carriage Clamp	1
63	066-1113115	Support Bar	1

### CLUTCH COUPLING



Item No.	Description	Part No.
1	Armature hub assebly	5104-541-006
2	Armature	5125-111-001
3	Bearing mounted field and rotor assembly	5104-452-022
4	Terminal accessory	5103-101-002



### Allenair Assembly - Part Identification List

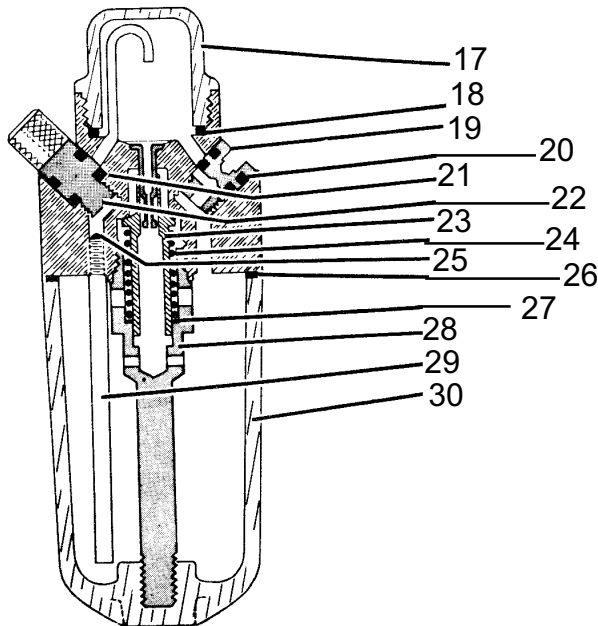
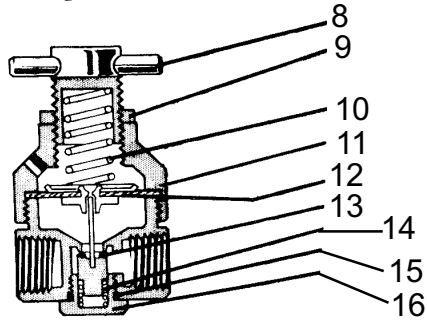
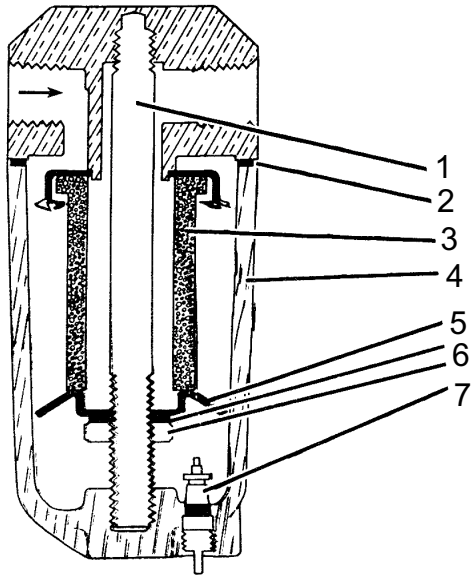
Item No.	Description	Part No.
1	Coil	243-1-SV-PK
2	Spring	243-2-SV-PK
3	Plunger	243-3-SV-PK
3A	Over-ride Plunger	243-3A-SV-PK
4	"0" Ring	243-4-SV-PK
5	Cover	243-5-SV-PK
6	Fibre Washer	243-6-SV-PK
7	Plunger Housing	243-8-SV-PK
8	Plunger Housing Nut	243-9-SV-PK
9	Steel Washer	243-10-SV-PK
10	Name Plate	243-13-SV-PK
11	Over-ride Button	AV-249-SV-OR-LH
12	Allenair Spool Cap	AV-249-SV

### Air Valve Assemblies

Item No.	Description	SVS-R-PK Part No.	SVS-E-OR-PK Part No.
13	Rear Head	AV-103-SV	AV-1503-SV
14	Slider	AV-235-SV	AV-235-SV
15	Spool Cap "U" Cup	AV-262-AP	AV-262-AP
16	Spool Cap	AV-249-APSR	AV-249-APSR
17	Spool Cap Gasket	AV-251-SV	AV-251-SV
18	Valve Spool	AV-246-APSR	AV-246-APSR
19	Top Valve Body	AV-234-SV	AV-234-SV
20	Spool "0" Ring	AV-261-AP	AV-261-AP
21	Spool Cap Gasket	AV-251-SV	AV-251-SV
22	Elbow (Rear)	AV-262-SV	AV-262-SV
23	Copper Tubing	AV-161-SV	AV-1561-SV
24	Rear Head (Cushion)	AV-103-SV-C	AV-1503-SV-C
25	Compression Ring	AV-261-A-SV	AV-261-1-SV
26	Compression Nut	AV-261-2-SV	AV-261-2-SV
27	Head Cushion Seal	A-115	A-1515
28	Cylinder Tube	AV-101-SV	AV-1501-SV
29	Rear Head "0" Ring Seal	AV-118-SV	AV-1518-SV
30	Heads "0" Ring Seal	A-118	A-1518
31	Elbow (Front)	AV-162-SV	AV-162-SV
32	Nipple	AV-165-SV	AV-1565-SV
33	Snap Rings	A-112	A-1512
34	Front Head	A-102	A-1502
35	Head Nut	A-114	A-214
36	Front Head Rod "0" Ring	A-110	A-1510
37	Front Head Back-up Ring	A-127	A-1527
38	Piston Rod	A-104	A-1504
39	Front Head Cushion	A-102-C	A-1502-C
40	Piston Lock Nut		A-1506
41	Boss		A-1507
42	Piston Rod "0" Ring Seal		A-1517
43	Piston**	A-105	A-1505
44	Piston Packing	A-116	A-1516
45	Front Head Bearing		A-1511

\*\* Include on Rod

Foot Mount Flange for SVS-E-OR-PK ... Part No. 232



Item No.	Description	Part No.
1	Retaining Rod	49
2	Bowl Gasket	101
3	Filter Cone	77
4	Bowl	3
5	Baffle	76
6	Baffle Gasket (not shown)	102
7	Nut	51
8	Drain Valve Assy	SA7
9	Adjusting Screw	SA53
10	Check Nut	51
11	Adjusting Spring	52C
12	Diaphragm Gasket	102
13	Diaphragm Assy	SA20R
14	Disc	SA37
15	Bottom Spring	105
16	Bottom Plug Gasket	103
17	Bottom Plug	2
18	Sight Glass	103
19	Sight Glass Gasket	43
20	Adjusting Screw	37
21	"O" Rings (3 req'd)	41
22	"O" Rings	42
23	Filler Plug	4
24	By-pass Disc	137
25	By-pass Spring	52
26	Ball Check	106
27	Bowl Gasket	101
28	Felt Seal	105
29	Retaining Rod	49
30	Dip Tube	74
31	Bowl	3