

INSTRUCTION MANUAL

PORTABLE ELECTRIC POWERED HYDRAULIC PUNCHER

READ ALL INSTRUCTIONS BEFORE OPERATING THIS MACHINE TOOL
HANDY SELFER **PROFESSIONAL TOOL**

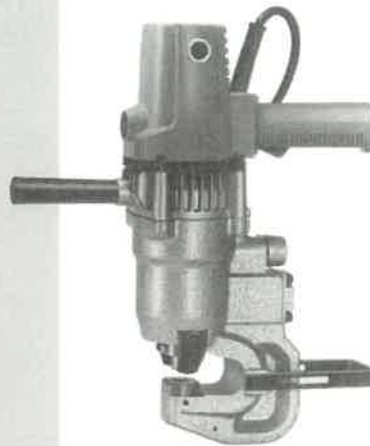


Model E25-0615

Specifications

Model		E25-0615
Power source		AC220V-240V
Punching capacity	Maximum diameter	15mm
	Maximum thickness	6mm
Maximum depth		25mm
※1 punching time(one way)		4sec
Maximum output force		114kN(11.6tf)
Mass (Weight)		7kg
Motor	Rated power consumption	305w
	Rated current	3.2A
	Length of power cord	2.4m

※1 Punching time is for 15 mm in SS400 material 6mm thick and will vary according to ambient temperature and continuous usage conditions.



Model E55-0619

Specifications

Model		E55-0619	
Power source		AC220V-240V	AC110V-120V
Punching capacity	Maximum diameter	19mm	19mm
	Maximum thickness	6mm	6mm
Maximum depth		55mm	55mm
※1 punching time (one way)		2sec	2sec
Maximum output force		147kN (15tf)	147kN (15tf)
Mass (Weight)		14kg	14kg
Motor	Rated power consumption	670w	670w
	Rated current	3A	6A
	Length of power cord	2.4m	2.4m

※1 Punching time is for 19 mm in SS400 material 6mm thick and will vary according to ambient temperature and continuous usage conditions

These specifications and the profile may be changed for improvement without prior notice.



HAJO TOOL

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SAVE THESE INSTRUCTIONS

Thank you for purchasing Nitto Kohki product.

Before using this tool, please read this manual carefully to ensure proper, efficient operation.

This instruction manual should be kept close at hand.

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PICTOGRAM



Warning: It might be dangerous to operate the power tool if the instructions supplied are not followed.

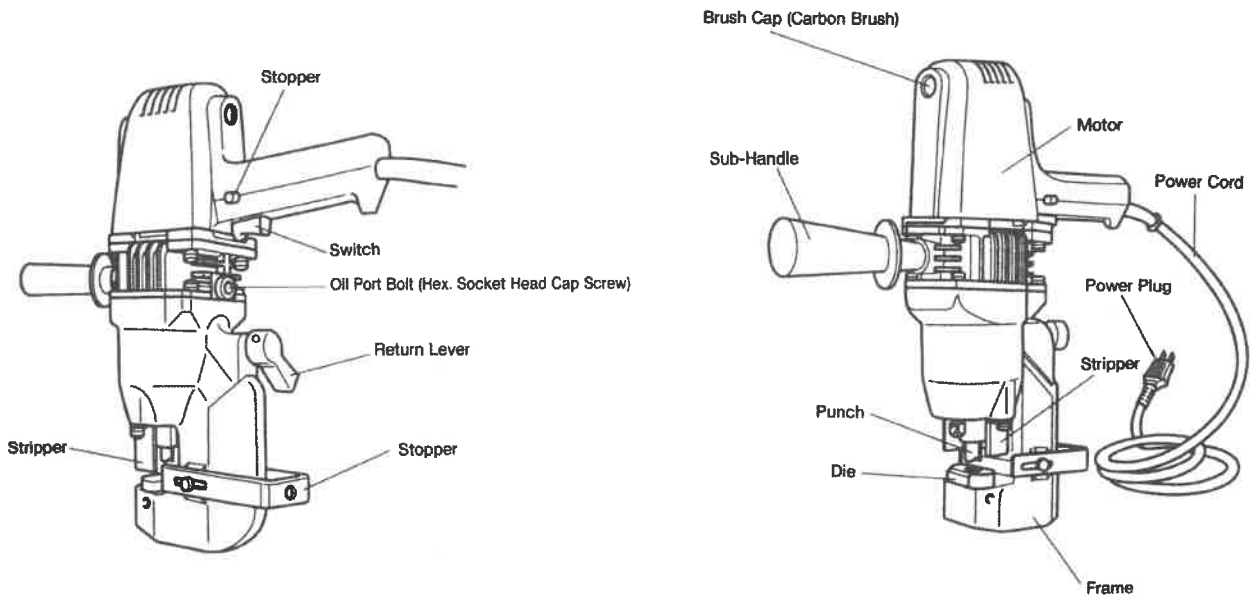


Before operating the tool, read and understand all instructions supplied. Keep for future reference.



Personal protective equipment as eye and ear protection and protective gloves must always be used when operating the tool.

Names of Parts



(Fig. 1)

⚠ WARNING

IMPORTANT SAFETY INSTRUCTIONS FOR ALL ELECTRIC POWER TOOLS

When using electric power tools, basic safety precautions should always be followed to reduce the risk of personal injury, including the followings.

Check the power supply

(1) Voltage check

Make sure the power supply voltage is within $\pm 10\%$ of the voltage shown on the identification plate attached to the main unit.

(2) Ensure earth leakage breaker.

Check to make sure that an earth leakage breaker is fitted with the power supply.

Always earth (ground) the tool even with an earth leakage breaker.

(3) Supply voltage drops

Beware of excessively long power cord (especially long thin wire wound on a drum) as they cause a voltage drop which prevents proper performance.

If an extension cable is used, choose one with appropriate diameter for the length of the cable. Avoid sharing the extension cord with other electric tools.

(4) Grounding instructions

Cord-connected tools:

In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be inserted to a matching outlet that is properly installed and grounded in accordance with all local codes and ordinance.

Do not modify the plug provided. If it will not fit the outlet, have the proper outlet installed by a qualified electrician.

Improper connection of the equipment-grounding conductor can result in a risk of electric shock. The conductor with green insulation, with or without yellow stripes, is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.

Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.

Repair or replace damaged or worn cord immediately.

Operators

Operators assigned to use the tools should be instructed in the safe use of the tool.

No person should use this tool without first having read and understood this instruction manual.

(1) Dress properly. Do not wear loose clothing or jewelry. They can be caught in moving parts. Non-skid footwear is recommended when working outdoor. Wear protective hair covering to contain long hair.

(2) Always wear eye protection. Everyday eyeglasses only have impact resistant lenses. They do NOT protect eyes. Also use face or dust mask, if operations create dust.

(3) Do not overreach. Keep proper footing and balance at all times.

(4) Stay alert. Watch what you are doing. Use common sense. Do not operate tool when you are tired.

(5) Some tools generate substantial vibrations. If discomfort or pain is encountered during use, you should cease operations and check with your physician prior to further use.

(6) Be sure to keep hands clear of moving parts.

Work-place

(1) Keep work area clean. Cluttered work areas and benches invite injuries.

(2) Consider work area environment. Do not expose power tools to rain. Do not use electric tools in damp or wet locations. Keep work area well lit.

(3) Do not operate near flammable liquids or in gaseous or explosive atmospheres.

(4) Keep children away. All visitors should be kept away from work area. Do not let visitors contact the tool or connecting cords.

(5) Some tools generate high noise levels. Check to be sure that the use of this tool conforms to all local noise regulations.

Before Work

(1) Be sure all external screws, nuts and bolts are tightly secured prior to each use.

(2) Do not use damaged, frayed or deteriorated cord and plug.

(3) Remove adjusting keys and wrenches. Form habit of checking to see that adjusting keys and wrenches are removed from tool before turning it on.

(4) Use right tool. Do not force a small tool or attachment to do the job of a heavy-duty tool. Do not use tool for a purpose not intended.

(5) Do not force tool. It will do the job better and safer at the rate for which it was designed.

(6) Secure work. Use clamps or a vise to hold work whenever possible. It is safer than using your hand and it frees both hands to operate tool.

Handling

(1) Store idle tools. When not in use, tools should be stored in dry, and locked-up places out of reach of children.

(2) Avoid unintentional starting. Do not carry connected tool with finger on the switch. When carrying tool, be sure the connecting cord to the power supply is disconnected.

(3) Reduce the risk of unintentional starting. Make sure switch is in off position before connecting cord to tool.

(4) Do not abuse cord. Never carry tool with connecting cord or yank on cord to disconnect.

(5) Never leave tool running unattended. Always turn off the power supply and disconnect the power supply cord. Do not leave tool unattended until it comes to a complete stop.

Maintenance

(1) Do not reconstruct or modify.

(2) Check damaged parts. Before further use of the tool, an accessory or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended functions. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. An accessory or other part that is damaged or inoperable should be properly repaired or replaced.

(3) Repairs by authorized personnel. Any repairs on the tool or installation of replacement parts should be performed only by the sales agent from whom you purchased the tool or the manufacturer. Use only genuine replacement parts. Failure to utilize the expertise of an authorized sales agent from whom you purchased the tool or the manufacturer or, failure to use genuine replacement parts, may result in an increased risk of injury to the user and may invalidate your warranty.

(4) Use recommended accessories. Consult this manual or the sales agent from whom you purchased the tool or the manufacturer for recommended accessories. The use of improper accessories may cause risk of injury to persons.

(5) Always turn off the power supply and disconnect the power supply cord before installing, removing or adjusting any accessory on the tool or before performing any maintenance on the tool.

(6) Do not remove any label placed on the tool. If the labels become damaged, or begin to peel away, contact the sales agent from whom you purchased the tool or the manufacturer for their immediate replacement.

IMPORTANT INSTRUCTIONS FOR HANDY SELFER

⚠ WARNING

(1) **Do not try to punch out holes outside the range of capacity.** Punching bigger holes on thicker plates than rated by the manufacturer will not only cause malfunctions but breakage of Punch and Die, that may lead to personal injury.

(2) **Use Punch and Die of the same size.** A combination of different sizes will cause breakage that, again, may lead to personal injury.

(3) **Correct setting of Punch and Die is quite important.** Improper positioning or unstable setting will cause breakage that, again, may lead to personal injury.

(4) **Make sure that no one or nothing inappropriate are in the direction of slug ejection.** The slug may be ejected with unexpected power. This is especially so when you punch out holes on hardmetals such as stainless steel. Be aware of the danger and avoid a person or a thing staying in the area of slug ejection.

⚠ CAUTION

(1) **Avoid operation when the tool is heated up.** Continuous operation will lead to heat up of the motor body. The performance of the tool will drop down when the surface temperature go over 70°C. Stop the operation for a while to cool it down.

(2) **Need idling before the operation in cold climate.** In cold regions or in winter, you may find stalls at the start-up. It is quite necessary to warm up the hydraulic oil inside by no-load operation for a few minutes after loosen the Return Lever.

1. USAGE

This tool is portable punching unit with built-in hydraulic pump which makes holes in steels.

2. BEFORE USING

After unpacking the HANDY SELFER, please verify the contents of the carton and check whether the product has been damaged in transit or with leaking oil, etc.

If there should be anything missing or damages, please contact the sales agent from whom you purchased the equipment without delay.

Contents of package, accessories of E25-0615

Package Contents, Accessories	Q'ty	Check
HANDY SELFER Main Unit	1	
Tool Box	1	
Sub-Handle	1	
Auxiliary Oil (40cc in container)	1	
E Punch 15 (attached to Main Unit)	1	
E Die 15A	1	
E Die 15B (attached to Main Unit)	1	
Spanner 10×12	1	
Allen Key 2.5	1	
Allen Key 4	1	
Instruction Manual (This Manual)	1	

Contents of package, accessories of E55-0619

Package Contents, Accessories	Q'ty	Check
HANDY SELFER Main Unit	1	
Stand	1	
Tool Box	1	
Sub-Handle	1	
Auxiliary Oil (40cc in container)	1	
EL Punch 18 (attached to Main Unit)	1	
EL Die 18A	1	
EL Die 18B (attached to Main Unit)	1	
Spanner 10×12	1	
Allen Key 3	1	
Allen Key 4	1	
Allen Key 5	1	
Instruction Manual (This Manual)	1	

3. PUNCHING CAPACITY

⚠ WARNING

Do not try to punch out holes outside the range of capacity.

3-1 Maximum punching capacity

The capacity is suggested with materials of mild steel SS400 or the equivalent. For other materials, make sure that the tool is used below its maximum output by calculating the required punching force kN from the formula below;

E25-0615;

$W=114$ kN

E55-0619;

$W=147$ kN

$$W = \frac{\pi \times D \times t \times \sigma \times 0.8}{1000}$$

W : punching force (kN) π : 3.14

D : hole diameter (mm) t : plate thickness (mm)

σ : tensile strength of the material (N/mm²)

(SS400; 400~510, SUS304; 640)

3-2 Maximum plate thickness

The restriction of plate thickness in relation to punching hole diameter is as follows;

SS400; $t_{max}=0.8D$ SUS304; $t_{max}=0.5D$

Do not try to punch holes exceeding the values. Check with the manufacturer before punching on other materials.

3-3 Minimum hole pitch

The minimum pitch for punched holes can be calculated from the following equation. It is not possible to make accurate holes if the pitch is too small.

$$P=1.5 \times t + D$$

P : pitch (mm) t : thickness (mm)

D : hole diameter (mm)

3-4 The dimensional allowance of punched holes

Punched holes are not so quite accurate due to the tool's mechanical design. Use our ATRA ACE hole cutting machines for precision cutting with annular cutters.

3-5 Lubricate the punch

Applying a little oil to the Punch will make it easier to pull out and extend its life. Use spindle oil, machine oil, or turbine oil, etc.

4. PREPARATION

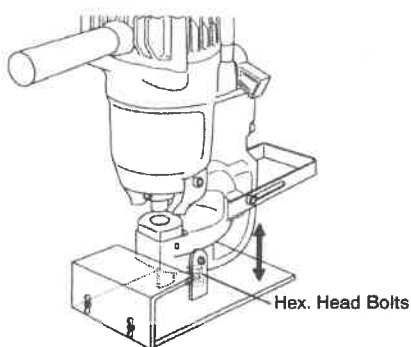
4-1 Stand installation

This accessory is not included in the standard package of E25-0615, and sold as option.

WARNING

Be sure to keep the punched slugs cleared away from under the Die. If work continues without clearing away the slugs, the internal parts in the main unit will be damaged and the Ram will not return.

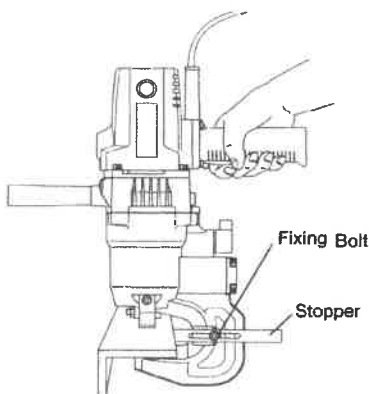
A convenient stand is provided for using the equipment in a stationary position. Use the Hex. Head Bolts to set the main unit at an angle which is convenient for the work. (Fig. 2)



(Fig. 2)

4-2 Constant throat Stopper

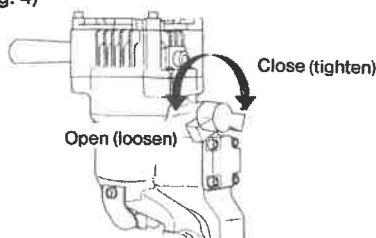
For repeated punching, use constant Stopper for throat depth setting. Loosen the Fixing Bolts to adjust the depth. (Fig. 3)



(Fig. 3)

4-3 Check the Return Lever position before operation

Return lever is to release the hydraulic pressure built up in the body and to let the Punch come back to the original position. Loosened Return Lever will not allow the Punch to go down. Make sure the Return Lever is tightened (at closed position) before start up. (Fig. 4)



(Fig. 4)

5. PUNCH & DIE REPLACEMENT

WARNING

Always turn off the power supply and disconnected the power supply cords.

Use the same size Punch and Die.

Correct setting of Punch and Die is quite important.

CAUTION

Put in the Punch, then the Die in that order.

5-1 Punch & Die replacement

Mounting (Fig. 5)

(1) Insert the punch into the ram with its large end up and the flat facing to the front.

Use the accessory Allen Key to tighten the Hex. Socket Set Screw which holds the Punch and fasten it with the Hex. Nut so that it will not move.

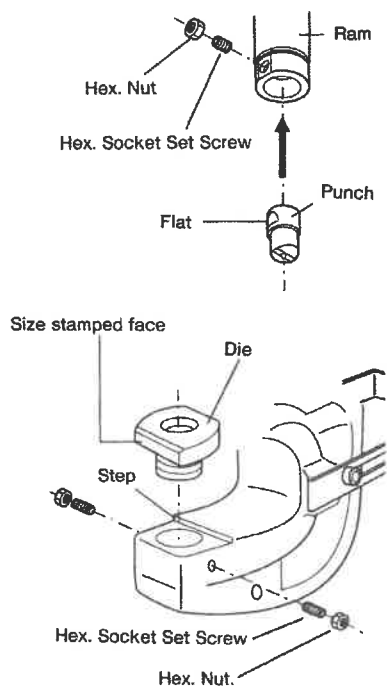
* In case of the oblong hole punch, a pin is attached to the head of the Punch. Please ensure that this pin is set to enter the pin hole in the ram.

(2) Insert the Die in the frame so that the face with the size stamp can be seen in the front of the main unit. At this time, make sure that the Die does not sit up on the step which prevents the Die from rotating in the Frame.

Use the accessory Allen Key to tighten the two Hex. Socket Set Screws securely and fasten them with the Hex. Nuts so that they will not move.

Removal

Remove the Die, then the Punch in that order.



(Fig. 5)

5-2 Die selection

Make sure the sizes of Punch and Die match. Three Dies are provided, stamped A for thin sheets, B for intermediate sheets and C for thick sheets. The die to be used depends on the thickness of the material to be cut. If a wrong Die is used, it may be difficult to withdraw the punch, and burrs and lips may be formed on the work.

Die selection chart for E25-0615

Die	Stamp	Sheet thickness	
		SS400	SUS304
Thin sheet	A	2~3.2	3
Intermediate sheet	B	4~6	4

Die selection chart for E55-0619

Die	Stamp	Sheet thickness	
		SS400	SUS304
Thin sheet	A	2~3.2	3
Intermediate sheet	B	4~6	4~5
Thick sheet	C	7~8	

6. START AND STOP

⚠ WARNING

Make sure switch is in off position before connecting the power plug.

The Punch and Die should not be touched while they are working.

⚠ CAUTION

Turn right the Return Lever and check that the Return Valve is closed.

Start (Fig. 6)

Depress the Trigger Switch. Motor will start and Punch will go down.

Depress the Trigger Switch again. Motor will stop immediately and the Punch will remain in the middle of the stroke.

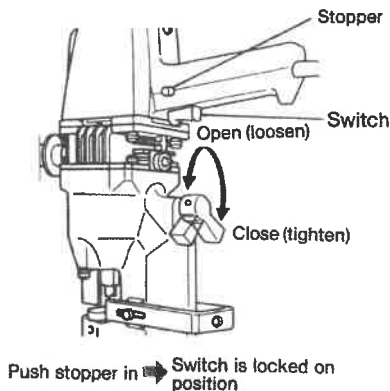
Loosen the Return Lever in order to pull back the Punch to the original position.

Stop

Switch off the motor by depressing the Trigger Switch when the Punch goes all the way down to the lowest position (and it will automatically return to the top position after finished punching.)

Hold the trigger switch

Push the Stopper (a small side projection) while the Trigger Switch is depressed, and then the switch is locked on. Depress the Trigger Switch again, which will release the Stopper.



(Fig. 6)

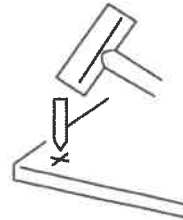
7. PUNCHING PROCEDURE

⚠ WARNING

Turn the switch off immediately after the punching to avoid possible danger. If the Trigger Switch is held depressed, the Punch will return to the top position and, again it will come down on to the Die.

(1) Mark the punch center

Use a larger hand punch chisel to mark the position of the hole center on the material. (Fig. 7)



(Fig. 7)

(2) Alignment

Align the projection at the bottom of Punch with the punched mark.

(3) Punching

Turn on the switch and start punching.

After finished punching the hole, turn off the switch and stop the motor. The Punch will automatically return to the top position.

8. MAINTENANCE & INSPECTION

⚠ WARNING

Always turn off the power supply and disconnect the power supply cords.

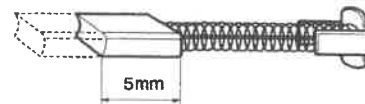
8-1 Carbon Brush replacement

Wears on the Carbon Brushes need to be checked regularly. When they have worn down to about 5mm (Fig. 8), the commutation deteriorates and may cause trouble, so they should be replaced. (Fig. 9)

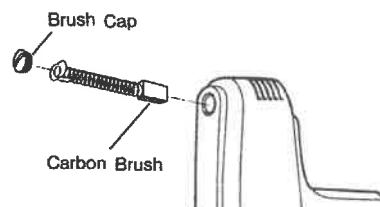
(1) Remove the Brush Cap using a screwdriver.

(2) Remove the worn Carbon Brush and replace it with a new one. Tighten the Brush Cap using a screwdriver.

(3) After replacement, run in the new Carbon brushes for at least ten minutes under no load with the Return Lever loosened.



(Fig. 8)



(Fig. 9)

8-2 Keep the Ram clean

Black scale is released from the work material during punching. It may cause oil leaks when dirt such as this black scale is attached to the Ram. So it is advisable to keep the Ram clean at all times. The Power Plug should be disconnected from the power outlet during cleaning.

9. FILLING AND REPLACING THE OIL

⚠ WARNING

Those who do not fully understand the manual, or who are not good at the maintenance inspection should not execute the procedure stated herein. Ask your service agent or the manufacturer.

⚠ CAUTION

Make sure the Return Lever is tightened (at closed position) before start up. The Oil Port Bolt has a packing (o-ring) with it. Do not misplace or leave in dirty places where it may pick up dusts causing leakage.

9-1 Refilling hydraulic oil.

The HANDY SELFER uses oil pressure as its source of power. Normal power can not be obtained if the hydraulic oil is not enough or mixed with air. If the oil is low, replenish it from the refill tank supplied.

If another brand of oil is used, use Anti-wear ISO VG32 grade.

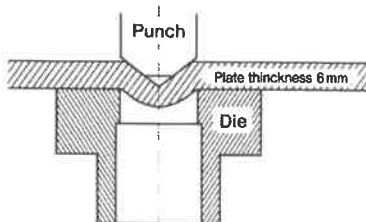
(1) Increase the hydraulic pressure inside the tool. AS shown in Fig. 10, insert a thicker (max. 6mm) plate and switch on the motor to pull down the Punch until it contacts the plate. The Punch must be depressed on to the plate half way of the thickness. This is to avoid the Punch going back abruptly. If you have made a through hole by mistake, do it all over again until the plate is fixed steady in between the Punch and Die.

(2) Lie the unit down so that the oil port facing above. Make sure the plate caught in between the Punch and Die will not come off.

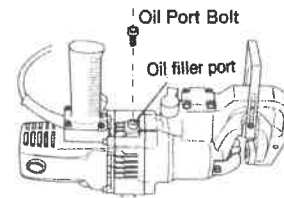
(3) Refill the hydraulic oil. Unscrew the Oil Port Bolt (Hex. Socket Head Cap Screw). See the oil level is far down and pour, refill oil up to the oil port. Then put back the bolt and tighten it. (Fig. 11)

(4) Return the punch to its original position. Pull the unit back to upright position and release the Return Lever, then you can easily take out the plate caught up. Repeat the procedure (1)~(4) until you see no oil level down.

(5) Tighten the Return Lever and repeat the following step a few times. Switch on the motor and then off the power when the Punch comes to the bottom of the stroke. The Punch shall return to the top automatically. Check no oil leakage from any part of the unit.



(Fig. 10)



(Fig. 11)

9-2 Changing hydraulic oil

The oil in a new unit should be changed after first 50 hours of operation. Then the oil should be changed at 500 hours each interval.

(1) Unscrew the Oil Port Bolt (Hex. Socket Head Cap Screw) from the oil port and drain the hydraulic oil.

(2) Remove the Oil Bag and drain the hydraulic oil. E25-0615; Unscrew the oil bag screw and remove the Oil Bag. (Fig. 12)

E55-0619; Unscrew the Hex. Socket Head Cap Screw and remove the Oil Bag. (Fig. 13).

(3) Wipe dirt off from the Oil Bag well and put it back it. Change the Oil Bag if there is any hole or crack on them.

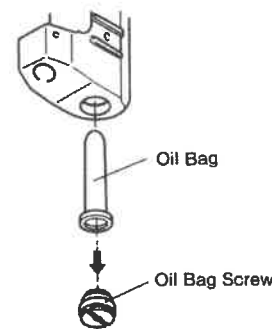
(4) Pour new hydraulic oil up to the oil port, put back the Oil Port Bolt and tighten it.

(5) Tighten the Return Lever, run in the motor for about 10 seconds.

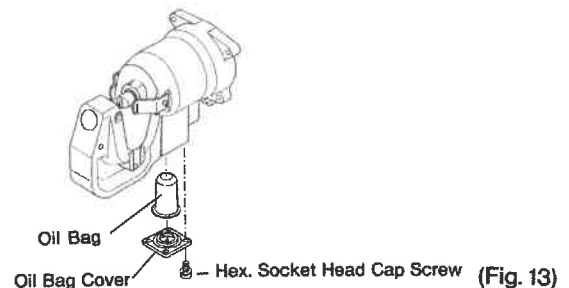
(6) Release the Return Lever and pull back the punch to the top position.

(7) Again unscrew the Oil Port Bolt from the oil port and repeat steps (4) to (6).

(8) Follow the procedure in 9-1. Refill hydraulic oil until the reservoir is full.



(Fig. 12)



10. OPTION

10-1 Stand

Part No.	Part Name
TB00800	Stand Ass'y



10-2 Punch and Die
Round Holes

Reference Table of E25-0615

Part No.	Part Name	Part No.	Part Name	Part No.	Part Name
TK00100	E Punch 4	TK00101	E Die 4A		
TK00102	E Punch 5	TK00103	E Die 5A	TK00104	E Die 5B
TK00143	E Punch 5.5	TK00144	E Die 5.5A	TK00145	E Die 5.5B
TK00105	E Punch 6	TK00106	E Die 6A	TK00107	E Die 6B
TK00146	E Punch 6.5	TK00147	E Die 6.5A	TK00148	E Die 6.5B
TK00111	E Punch 8	TK00112	E Die 8A	TK00113	E Die 8B
TK00149	E Punch 8.5	TK00150	E Die 8.5A	TK00151	E Die 8.5B
TK00117	E Punch 10	TK00118	E Die 10A	TK00119	E Die 10B
TK00120	E Punch 11	TK00121	E Die 11A	TK00122	E Die 11B
TK00123	E Punch 12	TK00124	E Die 12A	TK00125	E Die 12B
TK00097	E Punch 13	TK00098	E Die 13A	TK00099	E Die 13B
TK00167	E Punch 14	TK00168	E Die 14A	TK00169	E Die 14B
TK00428	E Punch 15	TK00288	E Die 15A	TK00429	E Die 15B

Oblong Holes

Part No.	Part Name	Part No.	Part Name	Part No.	Part Name
TK00126	E Punch 10×5	TK00127	E Die 10×5A	TK00128	E Die 10×5B
TK00158	E Punch 10×6.5	TK00159	E Die 10×6.5A	TK00160	E Die 10×6.5B
TK00129	E Punch 12×6	TK00130	E Die 12×6A	TK00131	E Die 12×6B
TK00152	E Punch 13×6.5	TK00153	E Die 13×6.5A	TK00154	E Die 13×6.5B
TK00155	E Punch 13×8.5	TK00156	E Die 13×8.5A	TK00157	E Die 13×8.5B

10-3 Punch and Die
Round Holes

Reference Table of E55-0619

Part No.	Part Name	Part No.	Part Name	Part No.	Part Name	Part No.	Part Name
TK00193	EL Punch 6	TK00208	EL Die 6A	TK00222	EL Die 6B	TK00235	EL Die 10C
TK00194	EL Punch 6.5	TK00209	EL Die 6.5A	TK00223	EL Die 6.5B	TK00236	EL Die 11C
TK00195	EL Punch 8	TK00210	EL Die 8A	TK00224	EL Die 8B	TK00237	EL Die 12C
TK00196	EL Punch 8.5	TK00211	EL Die 8.5A	TK00225	EL Die 8.5B	TK00238	EL Die 13C
TK00197	EL Punch 10	TK00212	EL Die 10A	TK00226	EL Die 10B	TK00239	EL Die 14C
TK00198	EL Punch 11	TK00213	EL Die 11A	TK00227	EL Die 11B	TK00240	EL Die 15C
TK00199	EL Punch 12	TK00214	EL Die 12A	TK00228	EL Die 12B	TK00241	EL Die 16C
TK00200	EL Punch 13	TK00215	EL Die 13A	TK00229	EL Die 13B		
TK00201	EL Punch 14	TK00216	EL Die 14A	TK00230	EL Die 14B		
TK00202	EL Punch 15	TK00217	EL Die 15A	TK00231	EL Die 15B		
TK00203	EL Punch 16	TK00218	EL Die 16A	TK00232	EL Die 16B		
TK00204	EL Punch 17	TK00219	EL Die 17A	TK00233	EL Die 17B		
TK00205	EL Punch 18	TK00220	EL Die 18A	TK00234	EL Die 18B		
TK00276	EL Punch 18.5	TK00279	EL Die 18.5A	TK00280	EL Die 18.5B		
TK00180	EL Punch 19	TK00181	EL Die 19A	TK00182	EL Die 19B		

Oblong Holes

Part No.	Part Name	Part No.	Part Name	Part No.	Part Name
TK00242	EL Punch 10×6.5	TK00254	EL Die 10×6.5A	TK00266	EL Die 10×6.5B
TK00243	EL Punch 13×6.5	TK00255	EL Die 13×6.5A	TK00267	EL Die 13×6.5B
TK00244	EL Punch 13×8.5	TK00256	EL Die 13×8.5A	TK00268	EL Die 13×8.5B
TK00245	EL Punch 13.5×9	TK00257	EL Die 13.5×9A	TK00269	EL Die 13.5×9B
TK00246	EL Punch 15×10	TK00258	EL Die 15×10A	TK00270	EL Die 15×10B
TK00247	EL Punch 16.5×11	TK00259	EL Die 16.5×11A	TK00271	EL Die 16.5×11B
TK00248	EL Punch 17×8.5	TK00260	EL Die 17×8.5A	TK00272	EL Die 17×8.5B
TK00249	EL Punch 18×9	TK00261	EL Die 18×9A	TK00273	EL Die 18×9B
TK00250	EL Punch 18×12	TK00262	EL Die 18×12A	TK00274	EL Die 18×12B
TK00251	EL Punch 19.5×13	TK00263	EL Die 19.5×13A	TK00275	EL Die 19.5×13B
TK00252	EL Punch 20×10	TK00264	EL Die 20×10A	TK00276	EL Die 20×10B
TK00253	EL Punch 21×14	TK00265	EL Die 21×14A	TK00277	EL Die 21×14B

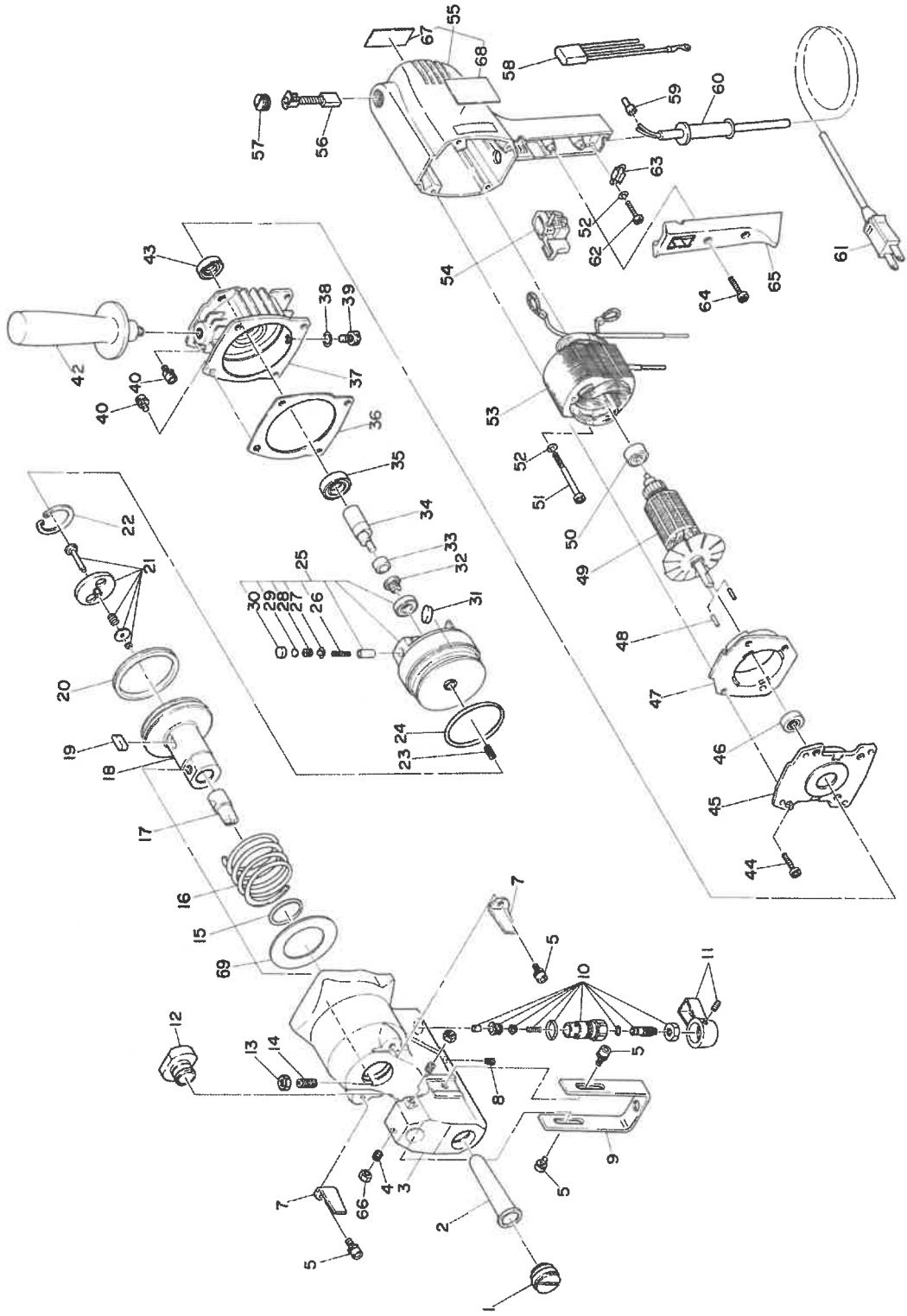
11. ORDERING SERVICE PARTS

In ordering parts and components, give each part number, part name and quantity required.

12. E25-0615 Assembly

⚠ CAUTION

The illustration is for information only. Users should never disassemble parts. Contact the sales agent from whom you purchased the tool or the manufacturer, should the tool need service, repair or replacement of parts.



13. E25-0615 Parts List

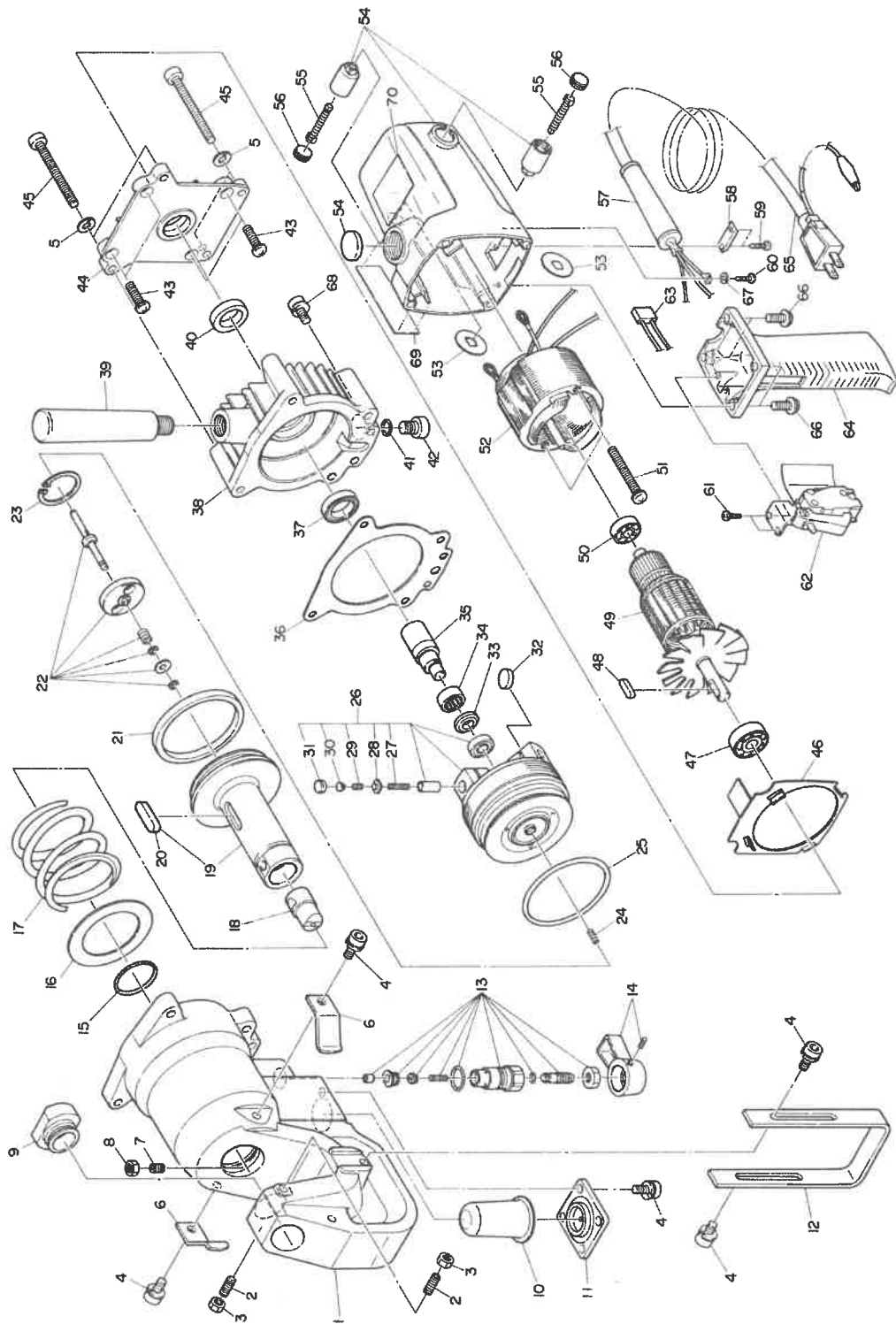
The parts numbers with () are included in the Ass'y parts written above them. © Consumable items * Locally available items

No.	Part No.	Part Name	Q'ty	No.	Part No.	Part Name	Q'ty
1	TQ01015	Oil Bag Screw	1	* 38	TP05872	O-Ring P-10	1
2	TQ01014	Oil Bag	1	* 39	TP03247	Hex. Socket Head Cap Screw 10 x 15	1
3	TQ01009	Frame	1	* 40	TQ04549	Hex. Socket Head Cap Screw 6 x 14 With Spring Washer	8
* 4	TQ02613	Hex. Socket Set Screw with Flat Point 5 x 16	2	42	TQ01051	Sub-Handle	1
* 5	TQ03327	Hex. Socket Head Cap Screw 5 x 10 With Spring Washer	4	© * 43	TQ01034	Oil Seal S15257	1
7	TQ01049	Stripper	2	44	TQ01058	⊕ YPF Self-Tapping Screw 5 x 20	4
* 8	TP15640	Hex. Socket Set Screw NPT 1/16	1	45	TQ01013	Motor Flange	1
9	TQ01048	Stopper	1	* 46	TP00468	Ball Bearing 608ZZ	1
10	TB00967	Return Valve Ass'y	1set	47	TQ00994	Fan Guide	1
11	TB00969	Return Lever Ass'y	1set	* 48	TP12618	Needle Roller 3 x 11.8	2
© 12	TK00429	E Die 15B	1	49	TB00991	Armature Ass'y	1set
* 13	TQ01050	Small Hex. Nut Type 3M8	1	* 50	TP15408	Ball Bearing 626ZZ	1
* 14	TP12382	Hex. Socket Set Screw with Cup Point 8 x 12	1	51	TQ00985	⊕ High-Low Screw 4 x 51	2
© * 15	CP07415	O-Ring P-30	1	* 52	TP04234	Spring Washer M4	4
16	TQ01036	Spring 5.5 x 50 x 57.5	1	53	TB00992	Stator Ass'y	1set
© 17	TK00428	E Punch 15	1	54	TQ00996	Switch	1
18	TB01089	Ram Sub Ass'y	1set	55	TB02251	Motor Case Ass'y	1set
* 19	(TQ01022)	Sunken Key 6 x 6 x 16 round ends	1	67	(TQ02698)	Name Plate	1
© * 20	TQ01021	Y Type Packing OSI 56 x 66 x 6	1	68	(TQ02487)	Warning Label	1
© 21	TB01090	Limit Valve Ass'y	1set	© 56	TB00993	Carbon Brush Ass'y	1set
* 22	TQ01068	Circlip JO-34	1	57	TP16323	Brush Cap	2
23	TQ01033	Spring 0.5 x 5.3 x 13-14	1	* 59	TP13769	Insulated Closed End Connector 2-SD JST	1
© * 24	TQ01032	O-Ring P-56	1	60	TP16265	Stopper	1
© 25	TB01179	Spare Pump Body Ass'y	1set	61	TQ01431	Cabtyre Code	1
26	(TQ01040)	Spring 0.6 x 3.2 x 18.4	1	* 62	TP16208	⊕ Cross Recessed Pan Head Tapping Screw 4 x 16	2
© 27	(TQ01041)	Check Valve	1	63	TQ01001	Cord Clamp	1
28	(TQ01042)	Spring 0.8 x 4.8 x 6.5	1	* 64	TQ01002	⊕ Cross Recessed Pan Head Tapping Screw 4 x 20	2
29	(TQ01364)	Spring Seat	1	65	TQ01003	Handle Cover	1
© 30	(TQ01365)	Check Valve Cap	1	* 66	LP11858	Hex. Not Type 1 M5	2
31	TQ01045	Magnet 18 x 6.3	1	69	TQ11031	Washer 42.5 X 57.5 X 1	1
32	TQ01031	Distance Collar	1				
* 33	TQ01038	Needle Bearing RNAF 101710	1				
34	TQ01037	Cam Spindle	1				
* 35	TQ01035	Ball Bearing 6902ZZ	1				
36	TQ01046	Gasket	1				
37	TQ01012	Oil Case	1				

14. E55-0619 Assembly

CAUTION

The illustration is for information only. Users should never disassemble parts. Contact the sales agent from whom you purchased the tool or the manufacturer, should the tool need service, repair or replacement of parts.



15. E55-0619 Parts List

The parts numbers with () are included in the Ass'y parts written above them.

☉ Consumable items * Locally available items

No.	Part No.	Part Name	Q'ty	No.	Part No.	Part Name	Q'ty
1	TQ01337	Frame	1	38	TQ01340	Oil Case	1
* 2	TQ01374	Hex. Socket Set Screw with Cup Point 6 x 16	2	39	TA90586	Side-Handle Ass'y	1set
* 3	TP00667	Hex. Nut Type 1 M6	2	* 40	TQ01357	Oil Seal SC20328	1
* 4	TQ04549	Hex. Socket Head Cap Screw 6 x 14 With Spring Washer	8	* 41	TP14604	O-Ring S-10	1
* 5	TP00629	Spring Washer M6	4	* 42	TP03247	Hex. socket head Cap Screw 10 x 15	1
6	TQ01371	Stripper	2	* 43	TQ01369	Cross Recessed Pan Head Tapping Screw 5 x 12 with Spring Washer	4
* 7	TP12382	Hex. Socket Set Screw with Cup Point 8 x 12	1	44	TQ01368	Motor Flange	1
* 8	TQ01050	Small Hex. Nut Type 3 M8	1	* 45	TQ01373	Hex. Socket Head Cap Screw 6 x 70	4
☉ 9	TK00234	EL Die 18B	1	* 46	TQ01476	Fan Guide	1
10	TQ01341	Oil Bag	1	* 47	TP17438	Ball Bearing 6200Z	1
11	TQ01342	Oil Bag Cover	1	48	TQ01370	Sunken Key 4 x 4 x 18 Round Ends	1
12	TQ01372	Stopper	1	49	TB02024	Armature Ass'y (220-240V)	1set
13	TB00967	Return Valve Ass'y	1set	TB04263	Armature Ass'y (110-120V)	1set	
14	TB00969	Return Lever Ass'y	1set	* 50	TP00468	Ball Bearing 608ZZ	1
☉ * 15	TP12005	O-Ring P-43	1	* 51	TQ01477	Cross Recessed Pan Head Tapping Screw 5 x 50 with Spring Washer	2
16	TQ01356	Washer 50.5 x 67.5 x 1	1	52	TB02026	Stator Ass'y (220-240V)	1set
17	TQ01355	Spring 7 x 59 x 60.7	1	TB04264	Stator Ass'y (110-120V)	1set	
18	TK00205	EL Punch 18	1	TQ00869	Insulating Washer	2	
19	TB01088	Ram Sub Ass'y	1set	54	TB01032	Motor Case Ass'y	1set
* 20	(TQ01349)	Sunken key 8 x 7 x 30 round ends	1	(TQ02488)	Name Plate (220-240V)	1	
☉ * 21	TQ01348	Y Type Packing OSI 65 x 75 x 6	1	(TQ05460)	Name Plate (110-120V)	1	
☉ 22	TB00973	Limit Valve Ass'y	1set	(TQ02487)	Warning Label	1	
* 23	TQ01068	Circlip JO-34	1	☉ 55	TB00598	Carbon Brush Ass'y	1set
24	TQ01351	Spring 0.6 x 5.2 x 9	1	56	TQ00867	Brush Cap	2
☉ * 25	TP05149	O-Ring P-65	1	TQ01478	Cord Armour	1	
☉ 26	TB01034	Spare Pump Body Ass'y	1set	58	TP13362	Cable Clamp	1
27	(TQ01040)	Spring 0.6 x 3.2 x 18.4	3	* 59	TQ01479	Cross Recessed Pan Head Tapping Screw 4 x 16 with Spring Washer	2
☉ 28	(TQ01041)	Check Valve	3	* 60	TP00831	Cross Recessed Pan Head Tapping Screw 4 x 6	1
29	(TQ01042)	Spring 0.8 x 4.8 x 6.5	3	* 61	TP11245	Cross Recessed Pan Head Tapping Screw 4 x 10 with Spring Washer	2
30	(TQ01364)	Spring Seat	3	62	TQ01480	Trigger Switch	1
☉ 31	(TQ01365)	Check Valve Cap	3	* 63	TP16481	Capacitor	1
* 32	TQ01045	Magnet 18 x 8.3	2	64	TQ01481	Switch Case	1
33	TQ01350	Washer 10 x 19 x 3.5	1	65	TB02025	Cabtyre Cord Ass'y (220-240V)	1
* 34	TQ01360	Needle Bearing RNAF 14223	1	TB04265	Cabtyre Cord Ass'y (110-120V)	1set	
35	TQ01359	Cam Spindle	1	TQ01482	Cross Recessed Pan Head Tapping Screw 5 x 20 With Spring Washer	4	
36	TQ01366	Gasket	1	TP04234	Spring Washer M4	1	
* 37	TQ01358	Ball Bearing 6804ZZ	1	TQ03338	Hex. Socket Head Cap Screw 6 x 18 With Spring Washer	2	



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INSTRUCTION MANUAL

**PORTABLE ELECTRIC POWERED HYDRAULIC PUNCHER
HANDY SELFER Model E25-0615 E55-0619**

READ ALL INSTRUCTIONS BEFORE OPERATING THIS MACHINE TOOL