



## NEXT™ Insert Tooling System Installation Instructions

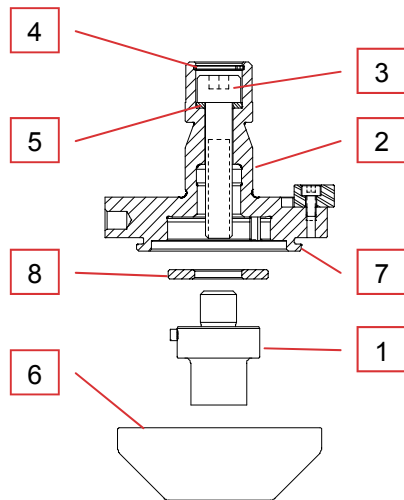
Install the NEXT™ punch insert [1] into the NEXT™ Insert Holder [2] by tightening the 8mm draw bolt [3] with a 6mm hex wrench bit and pre-set torque wrench. Recommended torque setting 288 in-lbs (33 Nm). Note: the retaining ring [4] ensures that the draw bolt [3] and washer [5] remain captive and cannot get lost.

For Size 40 holders only, install the push-on urethane stripper [6] by pressing the large opening against the mounting feature on the holder [7] until it snaps securely into place.

Regrind the punch when required and adjust the tool length in the normal way. Note: The Size 40 Urethane Stripper must be removed prior to regrinding.

Once 0.118(3.00) has been removed from the punch point, install the punch shim [8] between the punch insert [1] and the holder [2]. The punch length is now returned to its original length at no additional cost, instead of being replaced.

Retighten the draw bolt [3]. Reinstall the Size 40 urethane stripper [6] if appropriate.



Dimensions in Inches(millimeters)