

# Marathon Plus™ Punch Draw Bolt Torque Fixture INSTALLATION AND USE INSTRUCTIONS

## Fixture Installation Instructions

### SETUP

1. Determine if the fixture will be machine or vise mounted.
2. Set the vise block to the desired angle using a 5mm hex wrench. (Figure 2)

### MACHINE INSTALLATION

1. Loosen the vise block to allow clearance for the plate thickness of the machine. (Figure 3)
2. Hold the fixture by the support plate.
3. Slide the fixture onto the machine, positioning the vise block into the slot on the machine plate. (Figure 4)
4. Tighten the vise block to secure the fixture to the machine using a 5 mm hex wrench to 159 inch lbs(18.0 Nm).

### WISE MOUNT INSTALLATION

1. Tighten the vise block to the base plate using a 5mm hex wrench to 159 inch lbs(18.0 Nm).
2. Clamp the vise block into the vise.

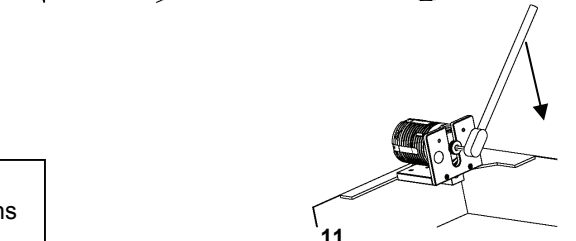
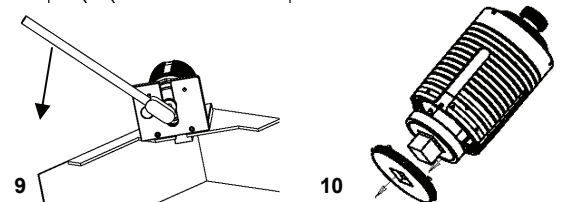
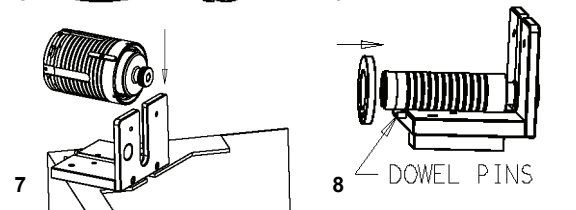
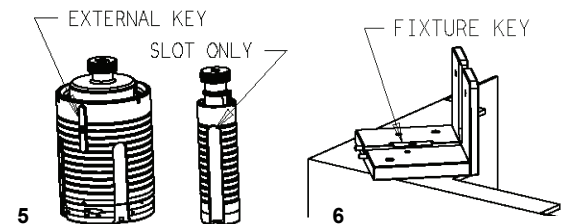
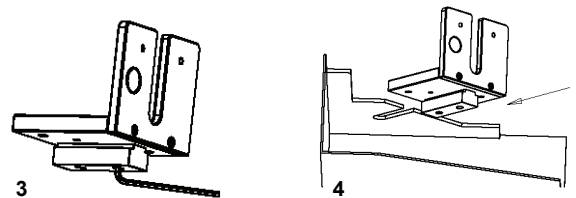
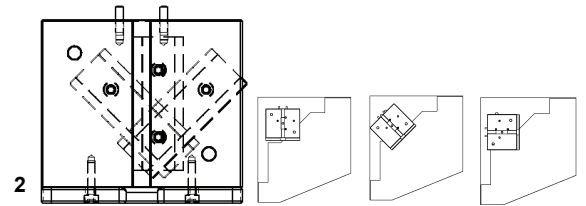
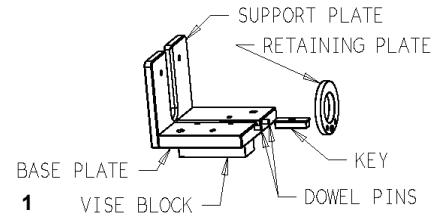
## Fixture Use Instructions

1. If punch holder body has an external key; (Figure 5)
  - Lift punch holder body over the support plate while inserting the tang into the vertical slot on the support plate. (Figure 7)
  - Lower punch holder body to bottom of vertical slot.
  - Position external key in base plate slot.
2. If punch holder body does not have an external key; (Figure 5)
  - Place fixture key into base plate slot. (Figure 6)
  - Lift punch holder body over the support plate while inserting tang into the vertical slot on the support plate. (Figure 7)
  - Lower punch holder body to bottom of vertical slot.
  - Rotate body until fixture key rests in punch holder body slot.
  - For XB station only: Slide retaining plate over punch holder body and onto dowel pins for added support. (Figure 8)

### Once the punch holder has been secured in the fixture:

1. Loosen punch draw bolt to release punch using torque wrench. (Figure 9)
2. Rotate stripper lock ring counter-clockwise to release stripper.
3. Remove stripper and punch. (Figure 10)
4. Place new punch and stripper in punch holder body and press down on the stripper to lock in place.
5. Tighten punch draw bolt with the designated torque using torque wrench. (Figure 11)
  - 300 inch lbs(34.0 Nm) for XB and B stations
  - 900 inch lbs(102.0 Nm) for larger stations
6. Lift punch holder body vertically to remove from maintenance fixture.
7. Adjust punch length to achieve proper stripper lead by using external length adjustment button.

For installing and removing punch and stripper, see LIT00573, Marathon Plus™ Fully Guided Punching System Installation Instructions





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