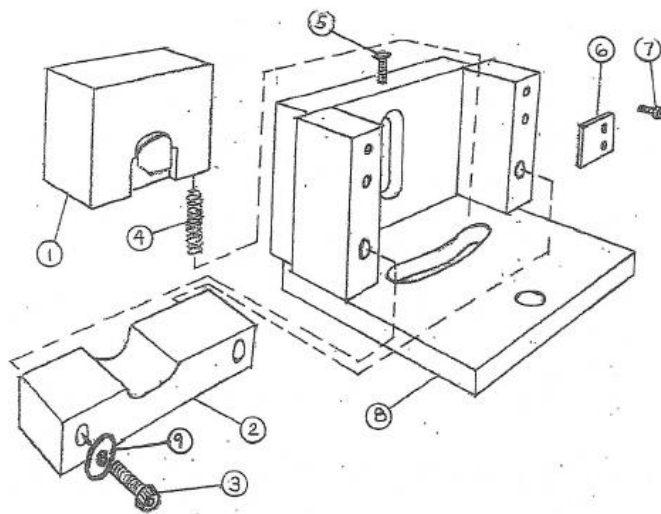


<u>Item#</u>	<u>Qty</u>	<u>Description</u>
1	1	Punch
2	1	Die
<i>Note: The above 2 items are included in the MP4151 through MP4156 Pipe Notch Die Sets.</i>		
3	2	3/8-16 x 2" Socket Head Screw (Die to Housing mount)
4	2	3/8" x 2-1/8" Punch Return Spring
5	1	1/4-20 x1-1/2" Flat Head Screw (Punch height adjustment screw)
6	2	Punch Retainer Plate
7	4	1/4-20 x 1/2" Socket Head Screw (Punch retainer plate mounting)
8	1	Pipe Notch Weldment
9	2	3/8" Flat Washer

Note: The above items, along with the 3946-push pin (not pictured) are included in the MP4150 Housing



Installation Instructions

1. Remove 4 -1/4-20 x 1/2" Socket Head Screw (7) and remove 2- Punch Retainer Plate (6).
2. Turn the Punch Height Adjustment Screw CCW so the end is retracted from the slot.
3. Slip the Punch Return Springs (4) into the holes in the bottom of the Punch (1).
4. Slide the Punch into the Pipe Notch Weldment (8).
5. Re-install the Punch Retainer Plates using the 1/4-20 x 1/2" Socket Head Screws.
6. Attach the Die (2) to the Pipe Notch Weldment using 2-3/8-16 x 2" Socket Head Screws (3) and 2-3/8" Flat Washers (9). Hand-tighten.
7. Turn the Punch Height Adjustment Screw CW pushing the Punch downward compressing the springs. Using the proper size pipe for the punch and die, continue turning the adjustment screw until the ID of the pipe, when set in the radius of the die, fits cleanly around the punch.
8. Ensuring that the die is centered relative to the punch, tighten the 3/8-16 x 2" Socket Head Screws.
9. Unscrew the Punch nut from the Ram on the Ironworker and replace with the Push Pin.
10. Replace the die holder with the Pipe Notch Assembly. *Note: Only the front bolt holds the Pipe Notch Assembly to the Ironworker Weldment.*
11. Use a small amount of cutting oil on the Punch and Die to extend the life of the cutting surfaces.

Call METALpro with any questions