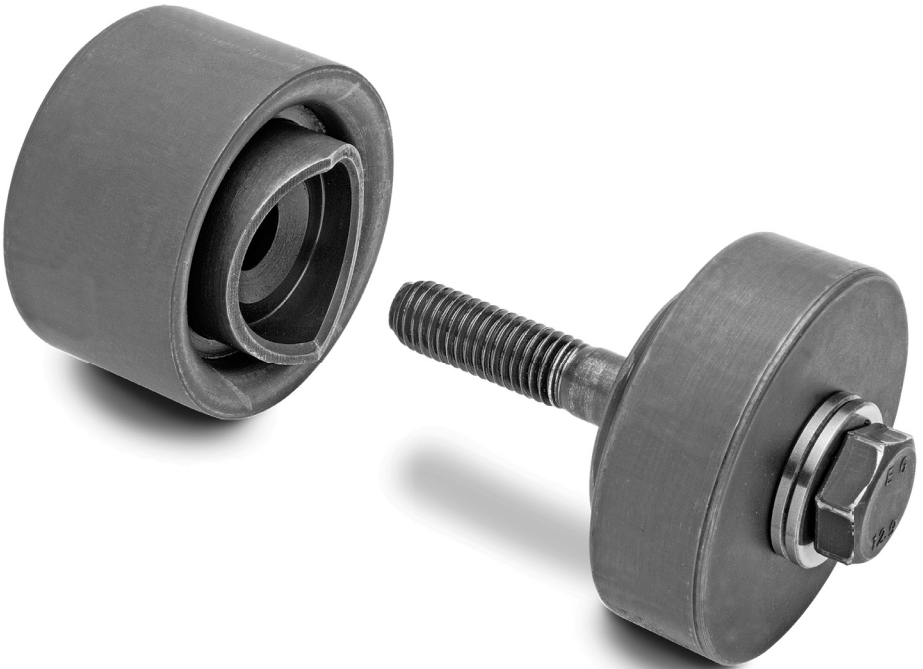


Eastwood

DO THE JOB RIGHT.

Item #20556

1", 1.5", 2", 2.5" PUNCH & FLARE DIE SETS INSTRUCTIONS



The **EASTWOOD PUNCH & FLARE DIE SETS** will punch a clean hole and produce a smoothly radiused, 45 degree flare in aluminum and mild steel in a choice of 4 sizes.

FINISHED FLARED HOLE DIMENSIONS

#20530	1" Die Set	1-1/8" I.D, Hole x 1/4" Deep Flare
#20355	1.5" Die Set	1-5/8" I.D, Hole x 1/4" Deep Flare
#20531	2" Die Set	2-1/8" I.D, Hole x 1/4" Deep Flare
#20532	2.5" Die Set	2-5/8" I.D, Hole x 1/4" Deep Flare

MAXIMUM MATERIAL THICKNESS

Aluminum	14 Ga (.064")
Mild Steel	16 Ga (.060")
Stainless Steel	19 Ga (.044")

SAFETY INFORMATION

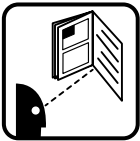
In this manual, on the labeling, and all other information provided with this product:

WARNING

WARNING indicates a hazardous situation which, if not avoided, could result in death or serious injury.

CAUTION

CAUTION used with the safety alert symbol, indicates a hazardous situation which, if not avoided, could result in minor or moderate injury.



READ INSTRUCTIONS

Read this entire manual before set up and use of this tool.
Save this instruction manual for future reference.



WARNING INJURY HAZARDS

- Do not use impact wrenches with this tool.
- Always wear ANSI rated eye protection when using this tool.
- Pinch Hazard! Keep fingers away from the moving parts when operating.
- Wear appropriate work gloves and protective clothing. Sheet metal will often have sharp edges which can cause cuts to hands and arms.



CAUTION

Never attempt to use this tool on materials thicker than those shown as serious tool damage can result.

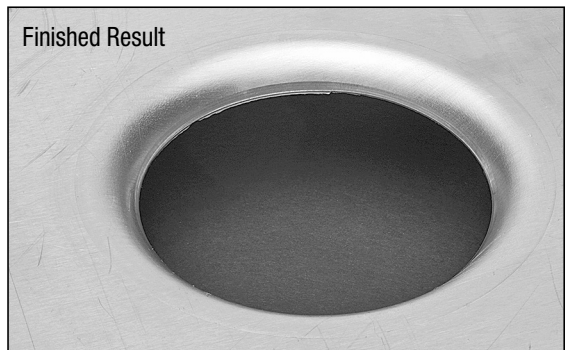
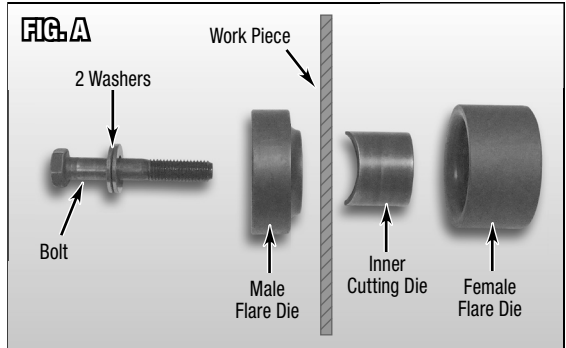
INCLUDES

(1) Bolt (2) Washers (1) Male Flare Die (1) Inner Cutting Die (1) Female Flare Die

OPERATION

PUNCH & FLARE

- Determine the position and direction of the finished flared hole.
- Drill a 1/2" hole at the center of the location.
- Firmly secure the work-piece.
- Lubricate washers.
- Assemble the tool in the order shown (Fig A) & (Fig B).
- From left to right, stack two thrust washers and Male Flare Die onto the Bolt. Insert the end of the Bolt through the hole drilled in the work-piece. On the opposite side of the work-piece, assemble the Inner Cutting Die and thread on the Female Flare Die, with the mating cavity facing the Male Flare Die and Inner Cutting Die.
- Tighten the Bolt by hand until resistance is felt.
- Using a wrench or socket, continue to turn the Bolt until the material is pierced and the feature is formed.
- Disassemble tool in reverse order.



MAINTENANCE

- Keep the die set clean. Remember to remove slugs from die after each use.
- Keep a light coating of machine oil on all surfaces to prevent rust.
- Store in a clean & dry environment when not in use.

ADDITIONAL ITEMS

- #20533** 1" Punch & Bead Die Set
- #20356** 1-1/2" Punch & Bead Die Set
- #20534** 2" Punch & Bead Die Set
- #20535** 2-1/2" Punch & Bead Die Set

If you have any questions about the use of this product, please contact
The Eastwood Technical Assistance Service Department: 800.544.5118 >> email: techhelp@eastwood.com
PDF version of this manual is available online >> eastwood.com/20556manual

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