

## **What is the difference between the traditional punch & die set and the TruPunch® set?**

With the traditional punch and die set you must scribe center guidelines on your material and eyeball the alignment of the I.D. and O.D. holes. The TruPunch® sets eliminate the need for scribing lines because these sets offer pilots which fit into the ends of the O.D. punches to ensure a centered hole. The TruPunch® process is so unique that it has been patented and is only available from Precision Brand Products, Inc. To watch how the TruPunch® works click [here](#).

## **Why is the "initial adjustment" necessary?**

All punch & die sets with a plastic top (not "The Big" TruPunch®) will need an initial adjustment because the plexi-glass plastic top contracts and expands with the change in temperature and during the manufacturing phase. It is because of this that we've purposely manufactured the plastic top punch holes slightly smaller to ensure whatever climate you are in, the set will hold close tolerances.

### **Before using always let your set adjust to room temperature.**

If the punches are difficult to insert through the plastic top and cannot be moved by firm hand pressure, you need to perform the initial adjustment on the die.

**Initial Adjustment:** Turn over the die and lightly tap each punch through the appropriate die hole from the tool steel plate towards the plexi-glass top. **Always insert the punches with the cutting edge first.**

**The hammerhead should always squarely strike the punches on top of the beveled end. NEVER strike the cutting edge end of the punch with a hammer.** Excess material will be shaved from the holes allowing the punches to move smoothly through the die. Repeat this procedure several times until the fit becomes workable. Insertion of the punches will become easier after continued use. You may view this initial adjustment procedure in our TruPunch® video.

## **Can I increase the gap between the top and bottom plates?**

No, the TruPunch® is only engineered to punch materials no thicker than .025"/.635mm. Raising the top plate would cause it to be unsupported or not parallel to the bottom plate thus creating a stress, which may crack the top plate or result in damage to the die.

## **Are special size punch & die sets available on special order?**

No, production of a single punch & die configured for special, non-standard sizes would be cost prohibitive.

## **Is a square punch & die available?**

No, production of a single punch & die configured for special shapes would be cost prohibitive.

### **My plastic top cracked, can I get a replacement?**

We do not have replacement plastic tops available for our traditional set (#40105), the TruPunch® set (#40110), or the “Metric 10” TruPunch® (#40300).

Replacement punches, pins and pilots are available as a complete set to purchase from a Precision Brand® distributor for all the TruPunch® sets. Use the following part numbers when ordering: Traditional style punch & die (#40105) replacement punches parts is #40100, TruPunch® (#40110) replacement components parts is #40115, “The Big” TruPunch® (#40200) replacement components parts is #40215, “Metric 10” TruPunch® (#40300) replacement component parts is #40315.

### **What can I do if the pilots in my TruPunch® keep falling?**

The pilots are designed with a split pin end so that tension can be adjusted. If the pilot is falling out too easily, simply split the pin legs apart slightly to increase tension when inserted to the punch.