

Louvering

Use the centre block.

The standard tool produce louvres with openings of 4 mm, 6 mm and 9 mm.

This operation is carried out in two stages.

1) Cutting the louvre.

The lateral distance between the cutting edge of the punch and that of the die is adjusted in the same way as for the cutting tool.

Start the motor, set the control lever to position A and adjust the feed screw so that the distance between the upper and lower tools is equal to the thickness of the plate which is to be louvered. Feed in the material after the lever has been returned to position E. The control lever is then set to the position B or C (6 or 9 mm size of louvre). Cut the entire length of louvre. To avoid cracks at the corner of the louvre, extend the cutting length at each end by approximately 2 mm more than the actual required length of the louvre. Do not commence forming louvres too near the end of the louvre.

2) Forming the louvre.

The control lever is set to position A, and the punch pressed down.

Feed the plate the entire length of the louvre, forming each end by moving the handle on the tool to the right or left as required.

After the louvre has been formed, it can be planished by making a further run with a short stroke at high speed.

Use either straight or circle cutting attachment for guiding the plate.

