

Tool Tutorial

The following was copied from the manual and is incomplete

Operation

Always check to make sure die wedges are tight. re-check wedges regularly when operating. A light coating anti-seize or grease on wedges is recommended. Regular inspection and tightening of all connections and fastening on this and any power hammer are mandatory. Open shut-off valve slowly. Always stand clear when the ram comes up! Lubricate guides before each session. This is a single blow hammer with fantastic control. As with any manually operated machine, operator skill plays a large part in the satisfactory performance of the machine. In most cases, the operator needs to anticipate the blow and let off the treadle just before the hammer strikes so that the hammer can bounce off the work. If a more holding blow is used, a lot of heat is sucked from the work and another heat may be required. When striking repeated blows, it is not necessary (or even desirable) to let the hammer return all the way to the top of its stroke. Come down on the treadle soon enough so the hammer only raises about six or eight inches off the work. We offer many standard dies for your hammer and would be happy to quote on any special dies for your requirements.

Removing Dies

Open shut-off valve slowly. Place a block of wood (2 x 4) about 12 inches long between ram and anvil cap. Close shut-off valve to lower ram. Bleed valve should remain open until ready to run the hammer! Make sure ram resting securely on block! Shut-off valve with operators secure key padlock! Drive wedge loose from the operator side. When removing top die it must be held up by hand or prop as the wedge is withdrawn. Remove wedge and die should be free to come out.

Installing Dies

With hammer blocked as described above, put die in place with center pin (locating pin) and insert proper wedge. Tighten wedge just snug (from side opposite operator). Close bleed valve and open shutoff valve slowly. When ram raises remove block, close shut-off valve and open bleed valve to lower ram. Sock wedges tight with two-pound hammer. Re-check wedges after one or two strikes of the ram. Re-check position of the dies often after changing dies.

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