



Piece Maker™ Punches are designed to split the slug into two pieces for easy removal after punch completion

Manual Knockout Sets

Capacity - 10 gauge (.134") Mild Steel

Model 158PM – 1/2" to 1 1/4" and
Model 159PM – 1 1/2" and 2"

Instruction Sheet

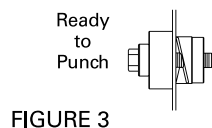
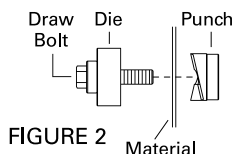
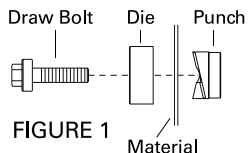
This instruction sheet is free of charge. All personnel who operate the Knockout Set should have a copy of this instruction sheet and read and understand its contents. To request a copy, call or write to the address below.

03/04 - REV. 0

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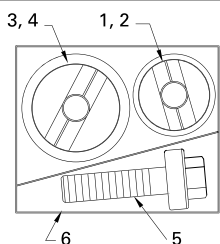
OPERATING INSTRUCTIONS

- Match the punch, die and draw bolt for the size hole to be punched.
- After marking the hole location, drill a hole approximately 1/32" to 1/16" larger than the draw bolt being used.
- Place the die on the draw bolt with the open end of the die facing the material to be punched. Insert the draw bolt through the hole drilled in Step 2. Thread the punch onto the draw bolt until snug against the material. The punch cutting edges should face the material to be punched. (See FIGURES 1, 2, and 3.)
- Place a 1" hex wrench on the head of the draw bolt and turn CLOCKWISE until the material is punched.
- When punch is completed, disassemble the set-up by holding the hex head of the draw bolt and turning the punch COUNTER-CLOCKWISE. Tip the die and the split slug should fall freely from the die.



PARTS LIST – 159PM

ITEM #	PART #	QTY	DESCRIPTION
1	1532	1	1 1/2" PIECE MAKER™ PUNCH
2	1533	1	1 1/2" DIE
3	1534	1	2" PIECE MAKER™ PUNCH
4	1535	1	2" DIE
5	1558	1	DRAW BOLT – 3/4" x 2 15/16"
6	1503	1	CASE



IMPORTANT SAFETY INFORMATION

! Read and understand this material before using the Knockout Set. Failure to understand how to safely operate this unit may result in serious injury or death.

Follow ALL safety information provided by the manufacturer.

- ! DANGER** NEVER use this Knockout Set or any of its components near live circuits.
- ! WARNING** ALWAYS thread the punch COMPLETELY onto the draw bolt to avoid thread failure. ALL punch threads must be completely engaged with the draw bolt.
- ! WARNING** Hand pressure is sufficient to complete the punching process. NEVER attempt to apply additional pressure to the wrench. Do NOT use a cheater bar. If hand pressure is not sufficient to complete the punching process, disassemble the set up and determine the cause before continuing.
- ! WARNING** NEVER attempt to exceed the punching capacity (hole diameter or material thickness) of this knockout set. Doing so may cause component failure and possibly serious injury.
- ! WARNING** NEVER use this knockout set or any of its components except for its intended purpose.
- ! WARNING** Be careful as hole punching process is completed. The punching assembly (punch, die and draw bolt) can fall as the slug breaks free from the hole.
- ! WARNING** Be careful of your footing and balance during the punching process. Make sure to have total control of your balance as the slug breaks free from the hole at the end of the punching process.
- ! CAUTION** ALWAYS inspect every component of the punch set-up including the ratchet, punch, die, and draw bolt before each use. Replace any worn or defective parts. NEVER use dull punches.
- ! CAUTION** NEVER use any component that has worn or damaged threads.
- ! CAUTION** ALWAYS check to ensure all components are properly assembled before punching.
- ! CAUTION** New punches are sharp. Be careful when handling them.
- ! CAUTION** ALWAYS wear safety glasses when punching.

PARTS LIST – 158PM

ITEM # PART # QTY DESCRIPTION

1	1557	1	DRAW BOLT – 3/8" x 1 5/8"
2	1559	1	DRAW BOLT – 3/4" x 2 1/8"
3	1524	1	1/2" PIECE MAKER™ PUNCH
4	1525	1	1/2" DIE
5	1526	1	3/4" PIECE MAKER™ PUNCH
6	1527	1	3/4" DIE
7	1528	1	1" PIECE MAKER™ PUNCH
8	1529	1	1" DIE
9	1530	1	1 1/4" PIECE MAKER™ PUNCH
10	1531	1	1 1/4" DIE
11	1502	1	CASE

