

F. MARATHON PUNCHING TIPS

The precision Marathon punching system will perform efficiently for many years. To insure its longevity the following points should always be kept in mind:

- A. Depth of penetration should be kept around .018” of penetration to get the most life out of the punches and dies (see Section 4).*
- B. Punch ring alignment and seating procedure should always be performed whenever the punch and die rings are moved (See Section 5).*
- C. Shaft condition is important. The punch and die shafts should always be kept free from nicks and burrs. The punch and die rings should always slide freely on their shafts.
- D. Severe web wrap-ups should be avoided through the use of matrix break and web break detectors (See Section 1).*
- E. Seat the individual punches in the punch ring. It is extremely important that the individual punches are all properly seated and are at the same precise height in the punch ring (See Section 10). *
- F. When replacing dies it is best to replace punches as well. This procedure will keep the old, worn punch from damaging the new die.
- G. Disengage punches when not in use.
- H. When reengaging punches always align the mating punch and die marked “X” for longest punch life.
- I. Do not peen punches.

* Please refer to the T&P instruction manual for a thorough explanation of these items.