

One-Ton Press Capabilities

Punching:

- The FADT Press can punch round holes up to 1/4" diameter in any thermoplastic material up to 1/4" thick.
- See the chart for larger hole-punching capabilities.
- Recommend air pressure is 70 PSI for all holes.

Hole Diameter	Maximum Material Thickness		
	Polypropylene	Co-Poly	Polyethylene
1/4" or Less	1/4"	1/4"	1/4"
3/8"	3/16"		
1/2"	5/32"	3/16"	

Riveting:

- For a flat rivet finish, use the SM211 set bit on the **PUNCH** and/or **DIE ADAPTORS. (Speedy Rivets)**
- If the combined thickness of materials to be riveted is thin (less than 3/16",) use the 3/8" **SPACER** (provided) under the **DIE ADAPTOR**.
- See the chart for the suggested set-ups for forming round rivets heads.

Rivet	Pressure	Upper Set #	Lower Buck #
3/16" Steel	90 PSI*	SM291-4704	SM200-4558
#8 Cu/Al	80 PSI		SM200-4556
#10 Cu/Al	70 PSI		SM200-4555
#12 Cu/Al	65 PSI		
Speedy	60 PSI	SM211	SM211

* Do NOT exceed 90 PSI under any circumstance!

Warnings

- ⚠ Do not use the pneumatic option with the pull handle in place. The cylinder rod attachment does require the handle to be removed.
- ⚠ Keep hands and face away from the swing bracket assembly during operation.
- ⚠ When not using the pneumatic option, TURN OFF AIR SUPPLY to the cylinder. Rotate the cylinder to face backwards and out of the way.
- ⚠ Do not hang from or jerk on the pull handle.
- ⚠ Do not exceed 90 psi air pressure to the punch.

TERMS, CONDITIONS AND WARRANTY

Credit- Tamarack reserves the right to approve the credit worthiness of the purchaser and to require acceptable security or assurance of payment of the purchase price. The acceptance of any order shall not be binding until Tamarack has given its approval of the purchaser's credit.

Delivery- All deliveries are F.O.B, shipping point St Paul, MN. Tamarack will have no liability for shipping delays for any contingency whatsoever.

Defects- The Customer shall fully inspect all parts and products upon delivery for manufacturing/ordering errors. Failure to notify Tamarack within ten (10) days of receipt will constitute acceptance of product. The sole obligation of Tamarack, at its option, will be to repair or replace free of charge, any parts or products which prove to be missing or defective.

Operation- The use of any loose blocks, shims, or other unsecured material on top of the punch heads is strictly prohibited. The Customer shall assume all responsibility in protecting the machine operator, including but not limited to personal protective equipment.

Warranty- The Tamarack FADT Punch is guaranteed to be free of defects in material and workmanship under normal use and condition for a period of five (5) years from the date of purchase, with the following exceptions:

- Stripper Springs are guaranteed for one (1) year.
- Punch and die sets, and other consumables such as oil, lubricants or mufflers are not covered for normal wear.
- All parts not manufactured by Tamarack, such as bearings and pneumatic components, are limited to the manufacturer's warranty.
- This warranty does not cover any improper use or maintenance, accident, spoilage, alteration, or damage caused by exceeding rated capacity of the punch.



Tamarack
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"Design is the Difference"

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Free-Arm Deep-Throat Press

One-Ton "Punching and Riveting" Press

CHECK OUT THESE GREAT FEATURES!

- Change hole sizes in under 10 seconds.
- Punch cleaner holes both faster and safer, 30 holes a minute with the pneumatic foot actuator.
- 15" throat depth and thin free arm allows you to punch holes in hard-to-reach locations.
- Punch holes in foam or leather covered materials.
- Locating pins and two-stage foot actuator allow pre-punch verification of hole location.
- Both manual and pneumatic available, no additional press needed.

Setting up your Free-Arm Deep-Throat Punch

PUNCH PRESS INSTALLATION:

1. If you are using the floor stand, it should be anchored to the floor with 2" cement anchors
2. Secure the punch to the floor stand or a secure bench top using four 1/4" x 20 bolts and lock washers.

INSTALLING PUNCHES & DIES:

3. Lift the QUICK RELEASE LEVER, push the SWING BRACKET back, and insert one of the STRIPPER SPRINGS. Place the SPRING WASHER over the top of the spring and insert a HOLE PUNCH. Place the matching die in the hole located on the bottom free arm of the punch.
4. Pull the SWING BRACKET back to its upright position, with the CAM BEARING directly over the punch.
5. **FOR MANUAL MODELS:** Insert the manual handle into the top hole on the cam cast assembly. The punch is ready to go!

⚠ DO NOT HANG FROM OR JERK THE HANDLE.

FOR PNEUMATIC MODELS: Follow steps 1–4 regarding mounting and swing bracket assembly. Then proceed with the additional steps below:

6. Attach the AIR CYLINDER assembly to the casting with the 3 pins as shown. (6a, 6b, & 6c)
7. Lock the assembly into place with the appropriate pins and clips.
8. Connect the supplied hose from the push fitting on the AUTO SHUT-OFF VALVE, to the OUT port on the FOOT ACTUATOR
9. Attach an air supply, filtered and regulated^A to 70 PSI^B, to the IN port on the back of the FOOT ACTUATOR.

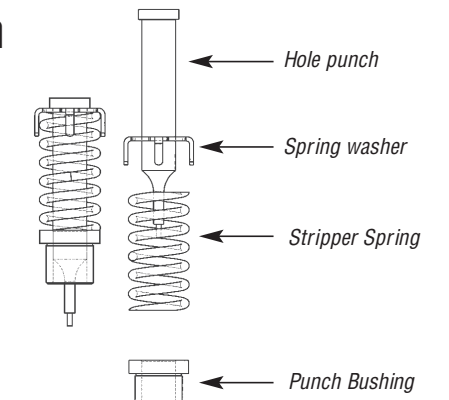
A. A regulator and ball valve are included for mounting to the casting base, or to a nearby wall.

B. The recommended air pressure is 70 PSI, which supplies enough pressure for most applications.

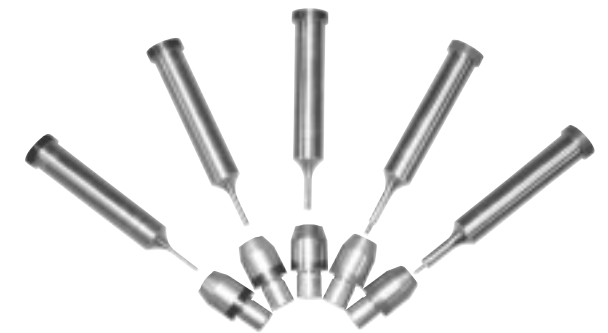
⚠ DO NOT EXCEED 90 PSI UNDER ANY CIRCUMSTANCE.

⚠ WARNING: KEEP HANDS AND BODY AWAY FROM THE SWING BRACKET ASSEMBLY, PUNCH, AND STRIPPER ARMS DURING OPERATION. FINGERS MAY BE PINCHED, CUT, OR CRUSHED IF CAUGHT BY THE SPRING OR THE PUNCH. THE CAM MOTION CAN BE FAST, AND MAY STRIKE AND SEVERELY INJURE PERSONS OR OBJECTS DIRECTLY IN FRONT OF IT.

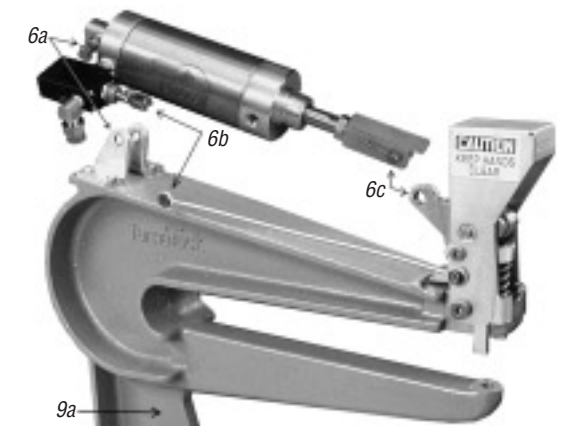
The foot actuator has two stages: Halfway down is a low pressure (~8 psi) stage which will bring the punch down to the material surface. This allows you to make sure the punch is in the proper location. Once you are sure of the hole location, pressing the pedal to the floor will open the line pressure and punch the hole.



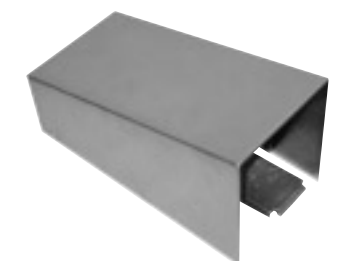
The punch and die assembly is designed to make setups and changeovers fast and easy.



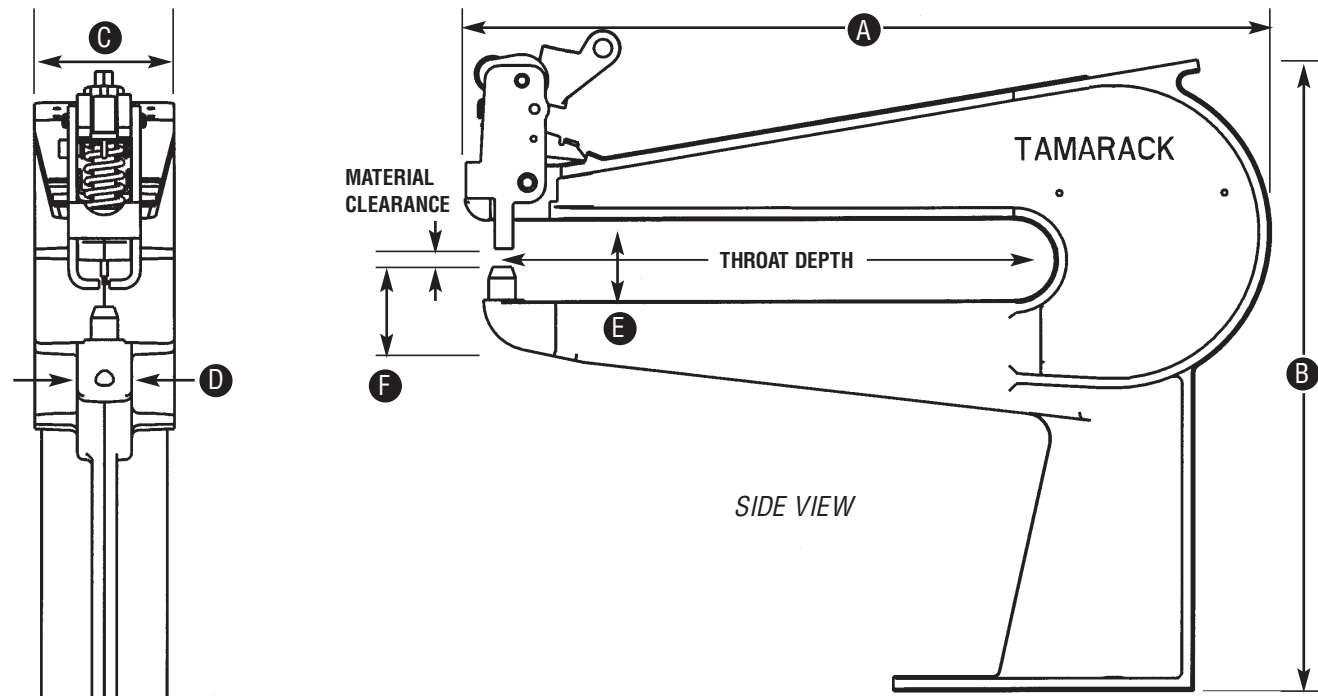
Each punch and die set is matched with color-coded rings.



Tamarack's pneumatic FADT punch press allows rapid, hands-free punching.



The two-stage foot actuator (pneumatic only) allows for the safe, accurate positioning of the workpiece before punching.



SPECIFICATIONS

REFERENCE	MODEL	MANUAL	PNEUMATIC
A	Length	22.5"	22.5"
B	Height	18"	21"
	Height w/floor stand	52"	55"
C	Width	4"	11"
D	Arm Width	1.5"	1.5"
E	Throat Clearance	2.3"	2.3"
	Throat Depth	15"	15"
F	Arm Thickness	2.5"	2.5"
	Material Clearance	1/2"	1/2"
	Weight	65 lbs.	80 lbs.
	Pneumatics	N/A	90 psi MAX.

PARTS REFERENCE LIST

REF. #	DESCRIPTION	P/N
1	FADT Punch Casting	T057
2	Die Button Holder	T005
3	Swing Bracket	T048
4	Stripper Spring	T022
5	Spring Washer	T001
6	Hole Punch	T021
	0.0938 3/32"	T021-01
	0.1250 1/8"	T021-02
	0.1563 5/32"	T021-03
	0.1875 3/16"	T021-04
	0.2500 1/4"	T021-05
7	Cam Bearing YR-1	T019
8	Cam Swing Casting	T017
9	Cam Pivot Shaft	T025
10	Quick Release Lever	T002
11	(2) 1/2" x 3/8" Shoulder Screws	SSBRCKMNT

