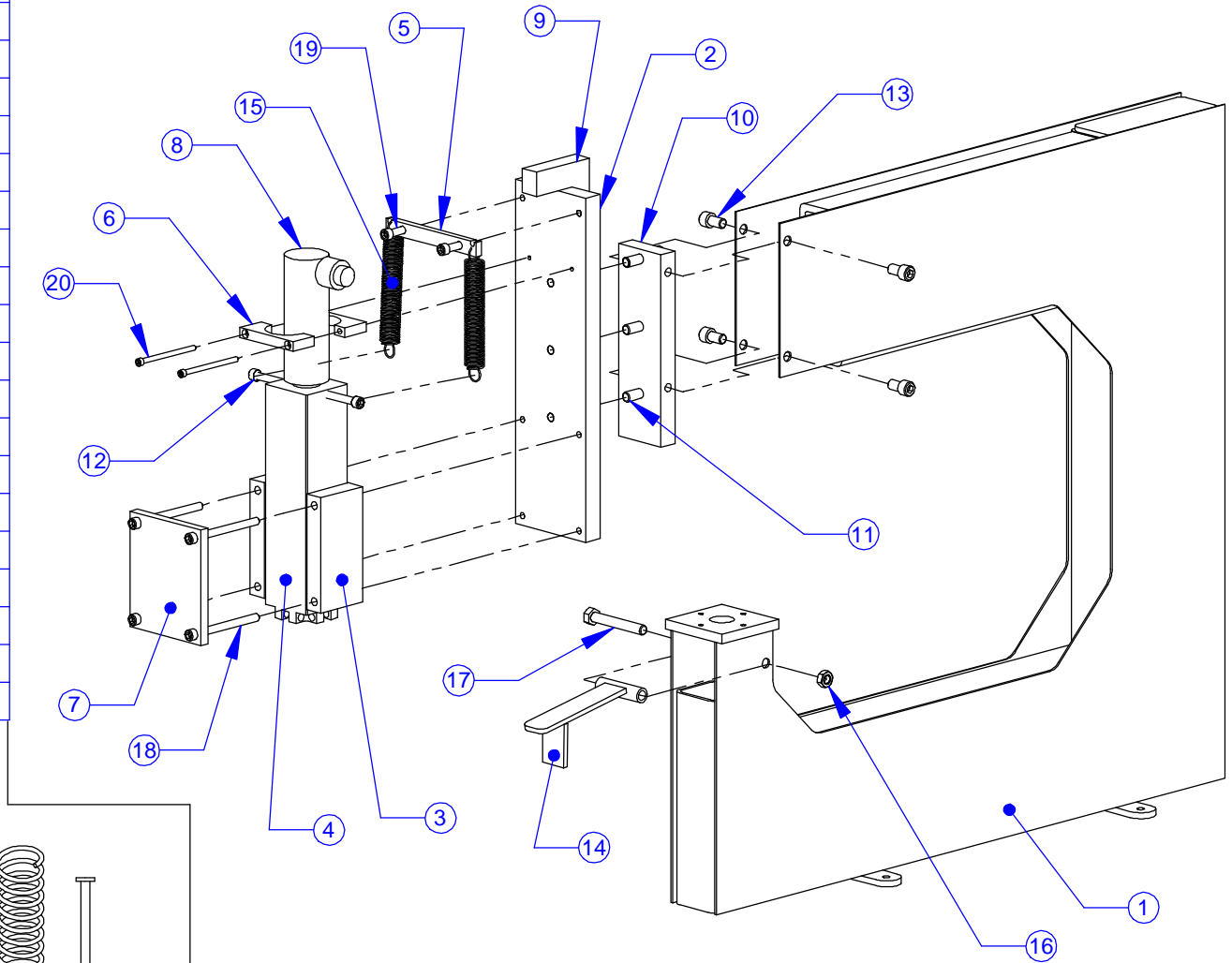
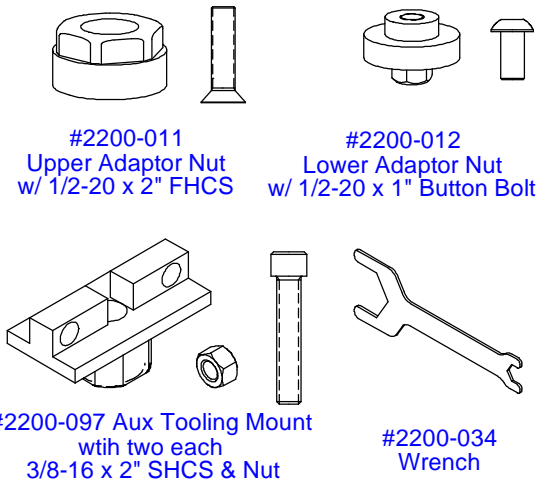


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	2210-010	Frame Assembly	1
2	2210-008	Main Mounting Plate	1
3	2210-003	Rail	2
4	2210-004	Slide	1
5	2210-009	Upper Spring Holder	1
6	500-022	Cylinder Clamp	2
7	2210-005	Cover Plate	1
8	2210-501	10 Ton Cylinder	1
9	2210-006	Cylinder Stop	1
10	2210-007	Mounting Block	1
11	HX-SHCS 0.5-13x2	SHCS	3
12	HX-SHCS 0.375-16x3.75	SHCS	2
13	HX-SHCS 0.5-13x0.875	SHCS	4
14	2200-015A	Ejector Pin Assembly	1
15	500-502	Compression Spring	2
16	HJNUT 0.5000-13	Nut	1
17	HBOLT 0.5000-13x3.5	Bolt	1
18	HX-SHCS 0.375-16x4.5	SHCS	4
19	HX-SHCS 0.375-16x1.375	SHCS	2
20	HX-SHCS 0.25-20x3.75	SHCS	2



Included



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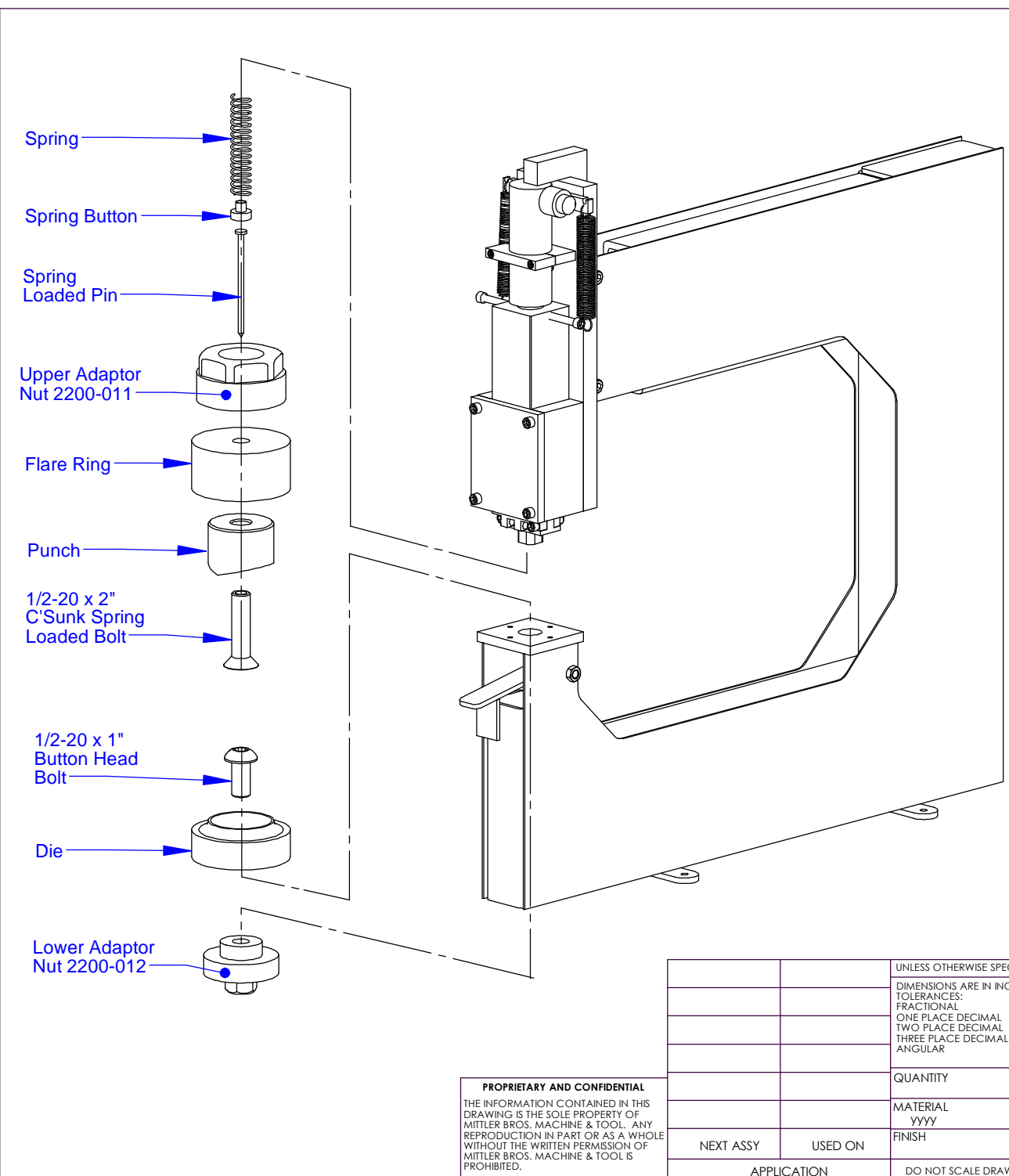
5/18/11		UNLESS OTHERWISE SPECIFIED:		NAME	DATE
6/1/11		DIMENSIONS ARE IN INCHES		DRAWN	BAB 3/9/11
		TOLERANCES:		CHECKED	
		FRACTIONAL ±.015		ENG APPR.	
		ONE PLACE DECIMAL ±.015		MFG APPR.	
		TWO PLACE DECIMAL ±.010		Q.A.	
		THREE PLACE DECIMAL ±.005		COMMENTS	
		ANGULAR ±1°			
		QUANTITY			
		MATERIAL			
		YYYY			
		FINISH			
	NEXT ASSY	USED ON			
	APPLICATION		DO NOT SCALE DRAWING		

M3 MITTLER BROS. MACHINE & TOOL
 10 Cooperative Way, Wright City, MO. 63390
 (636)745-7757 Fax (636)745-2874

TITLE:
Hydraulic 10 Ton Press

SIZE	DWG. NO.	REV
A	2210-000	

SCALE: 1:10 WEIGHT: 310.150 SHEET 1 OF 2



ASSEMBLY:

- Remove 1/2" - 20 Bolt and Bearing from Punch & Flare Tool - set bolt / bearing aside.
- Install Button Head Bolt through Female Die.
- Install Lower Adaptor Nut #2200-012 through hole in Lower Platen Tooling Plate
- Thread Button Head Bolt into Lower Adaptor Nut - **DO NOT Tighten.**
- Install Ejector Pin through Button Head Bolt - See Drawing
- Install 1/2"-20 Countersunk Bolt through Punch and Male Flare Ring.
- Install and Tighten 1/2"-20 Bolt into Upper Adaptor Nut #2200-011.
- Install Spring Load Pin through center of Bolt - See Drawing.
- Place a dab of grease on bottom of Spring Button to assist in Spring Button to Spring Loaded Pin Alignment.
- Place Spring Button on Bolt head.
- Install Spring over tab on Spring Button.
- Carefully Install Spring Loaded Assembly into Upper Ram Cavity while Threading Upper Adaptor Nut onto Ram.
- Tighten Upper Adaptor Nut using Wrench #2200-034.
- Lower Upper Ram / Punch / Male Flare Ring Assembly.
- Align Female Die with Punch by moving Female Die.
- Lower Assembly onto Lower Tooling Plate.
- Tighten Lower Adaptor Nut using Wrench #2200-034.

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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	 MB MITTLER BROS. MACHINE & TOOL 10 Cooperative Way, Wright City, MO. 63390 (636)745-7757 Fax (636)745-2874	
		DIMENSIONS ARE IN INCHES		DRAWN	BAB		6/1/11
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		FRACTIONAL ±.015		ENG APPR.			
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		THREE PLACE DECIMAL ±.005		COMMENTS			
		ANGULAR ±1°					
		QUANTITY				TITLE:	
		MATERIAL				Punch & Flare Assembly	
		yyyy				SIZE DWG. NO. REV	
NEXT ASSY	USED ON	FINISH				A 2210-000	
APPLICATION		DO NOT SCALE DRAWING				SCALE: 1:10 WEIGHT: 310.150 SHEET 2 OF 2	

5

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3

2

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