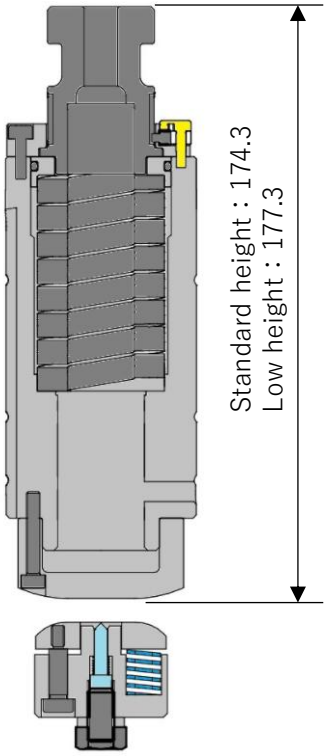
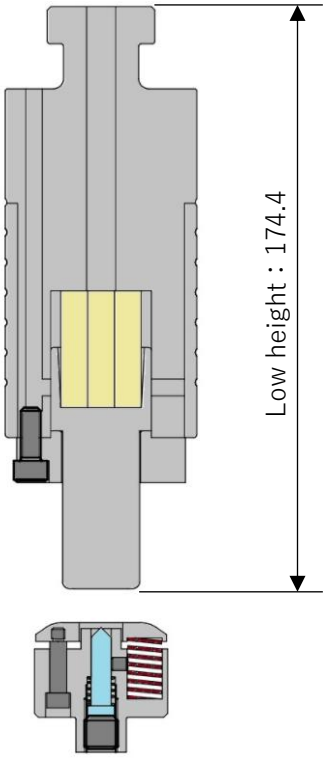
Center Punch (Bottom marking) Instruction Manual

There are three types of center punch on the bottom, and each has different handling instructions.

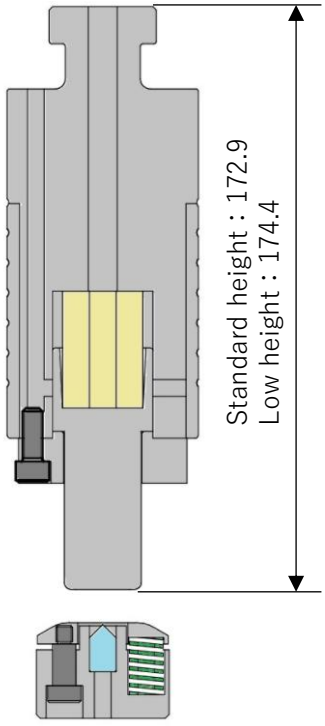
Adjustable Punch Projection Type
1 Vulcan II Air Adjustable Center Punch
2 Vulcan II Adjustable Center Punch



Adjustable Punch Projection Type
3 114 Adjustable Center Punch



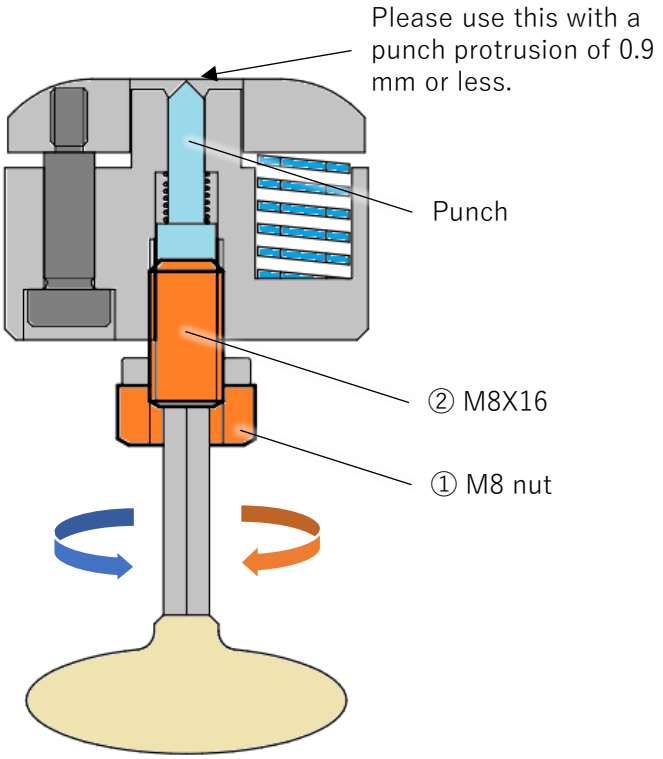
Fixed Punch Type
4 114 Center Punch



Punch Projection Adjustment Method(※4 1 1 4 Center Punch does not allow for adjustment of the punch protrusion.)

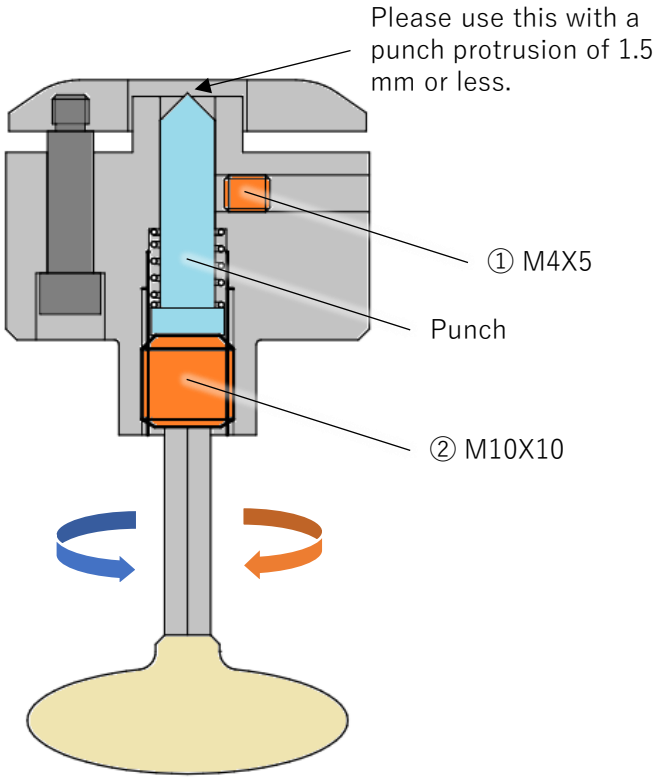
1 Vulcan II Air Adjustable Center Punch
2 Vulcan II Adjustable Center Punch

1 . Loosen ① M8 nut.
2 . Use a hex wrench to turn the screw ② and adjust the punch protrusion.
3 .Tighten ① M8 nut to secure it.

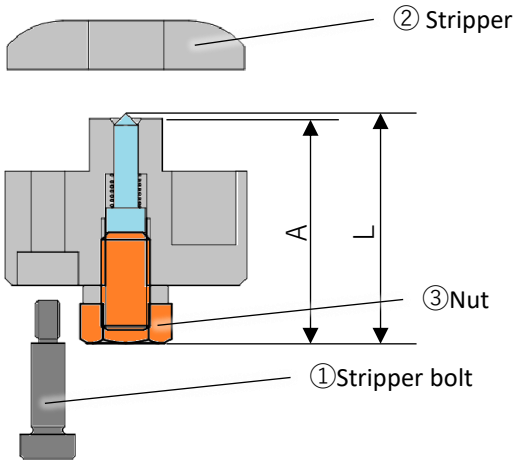


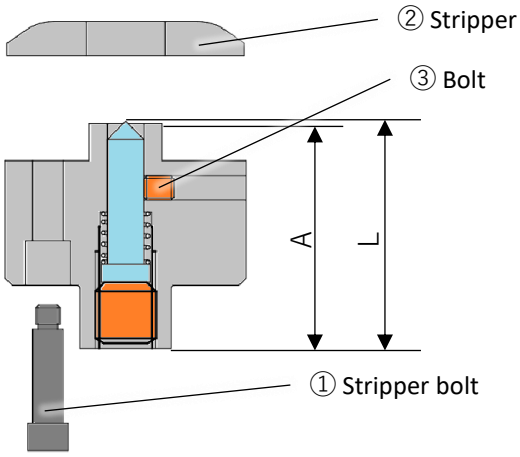
3 114 Adjustable Center Punch

1 . Loosen the set screw ① M4×5.
2 . Use a hex wrench to turn the screw ② and adjust the punch protrusion.
3 .Tighten the set screw ① M4×5 to secure it.



To fine-tune the punch projection, ① loosen the stripper bolt, ② remove the stripper, and then measure the projection. ③ Tighten the bolt and nut to a preliminary torque setting before taking the measurement. (Punch projection = L – A)





Tool Lubrication

Please apply lubricant to the outer circumference of the punch holder (Right figure– – – – –part) before installing the die in the machine.

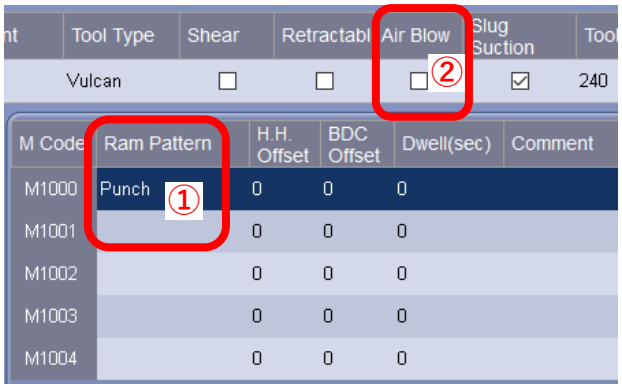
Punch holder	Recommended lubricant
Vulcan II Air	Mori Oil Spray F100、Yushiron Former FL91 (Air blow oil)
Vulcan II、114	Grease or lubricating oil, depending on your model



Tool Registration and Adjustment Methods (Machine-Side Operations)

※ The screen and input methods may vary depending on the model you are using.

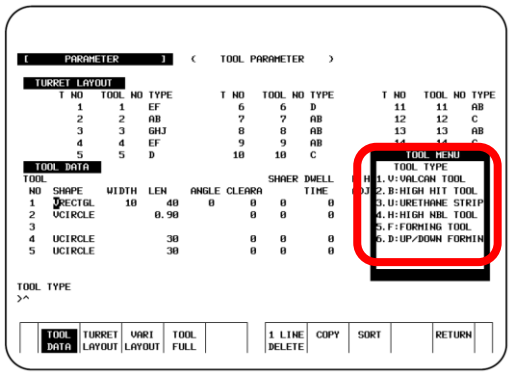
If the machine control panel screen is a touch panel



In the “Tool” section, under “Conditions,” set
①the Ram pattern to:
1Vulcan II Air, 2Vulcan II **【Punch】**
3 4114 **【Forming or Marking】**
1If using Air Blow, check ② **【✓】**
Register lower edge correction as **【0】**

1 For the Vulcan II Air and 2 Vulcan II low-height type (overall length of the upper unit is 177.3mm), ③please set the standby correction to [+3.0].

If the machine control panel screen is a button



In “TOOL PARAMETER” set the tool type for
2 Vulcan II to **【1.V: Vulcan Tool】**
and register 3 4114 as **【5.F: Forming Tool】**

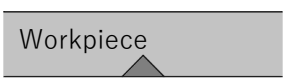
Register lower edge correction as **【0】**

Precautions during processing

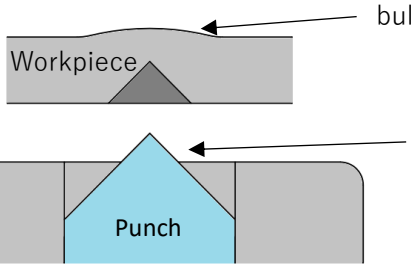
No dry running. Doing so will damage the mold.

Machined shape

Proper shape



The back of the workpiece bulges



You're punching too deep into the workpiece.
Please reduce the punch depth to less than half the board thickness.

Tool maintenance

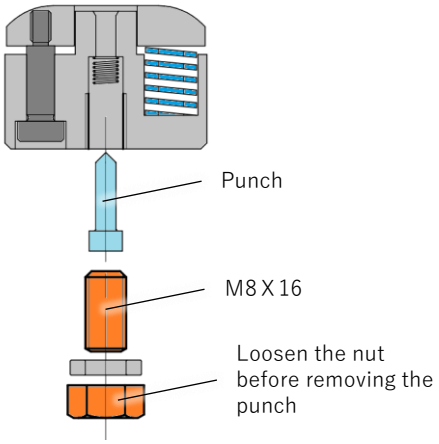
Replacement guideline： If the imprint becomes faint, please check the condition of the punch or the urethane (built-in only on model 114).

Punch ： If you can see that the tip of the punch is worn down, it's time to replace it.

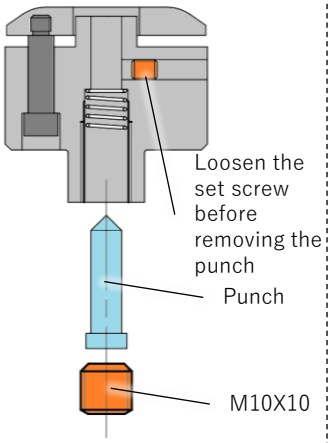
Urethane：Replace it if cracks or hydrolysis (whitish discoloration, crumbling) occur.
We recommend replacing it if you have been using it for more than a year.

How to Replace the Punch and Urethane

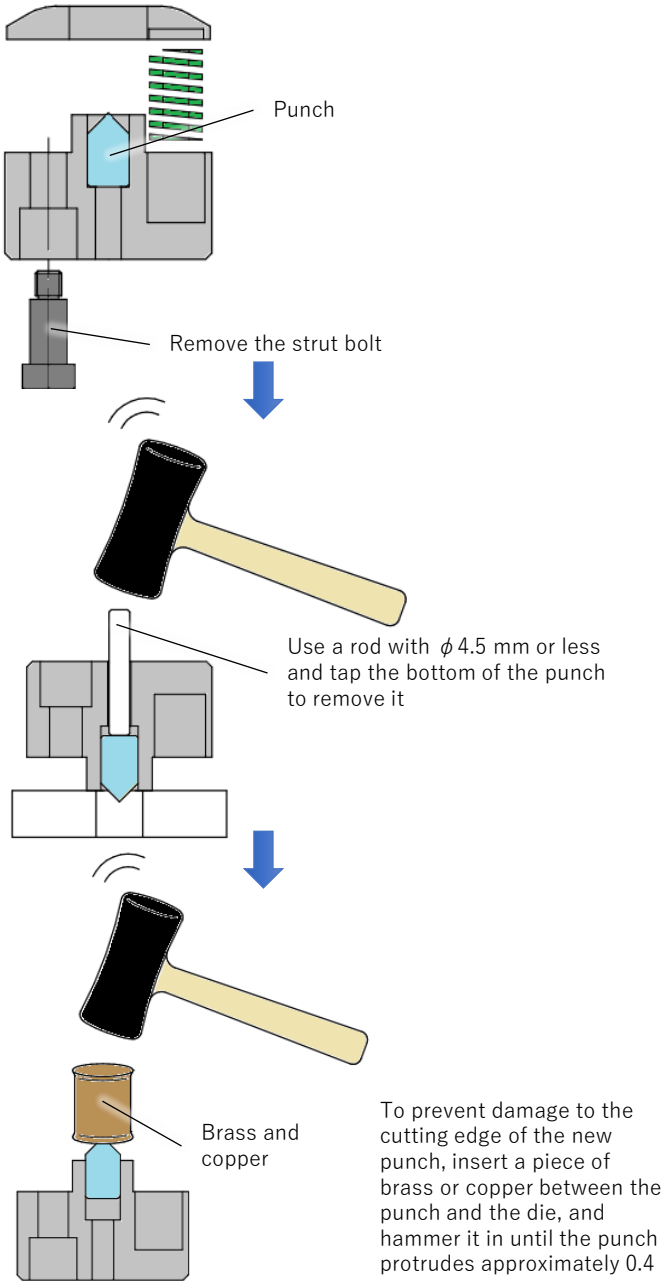
1 Vulcan II Air Adjustable
2 Vulcan II Adjustable



3 114 Adjustable



4 114 Center Punch



To prevent damage to the cutting edge of the new punch, insert a piece of brass or copper between the punch and the die, and hammer it in until the punch protrudes approximately 0.4 mm.

