



**Clinching Presses
GEN II H600 series
Spare parts**

AZIMUTH MACHINERY

Punch presses manufacturer since 1975

CUSTOM MACHINE FOR YOUR UNIQUE APPLICATION

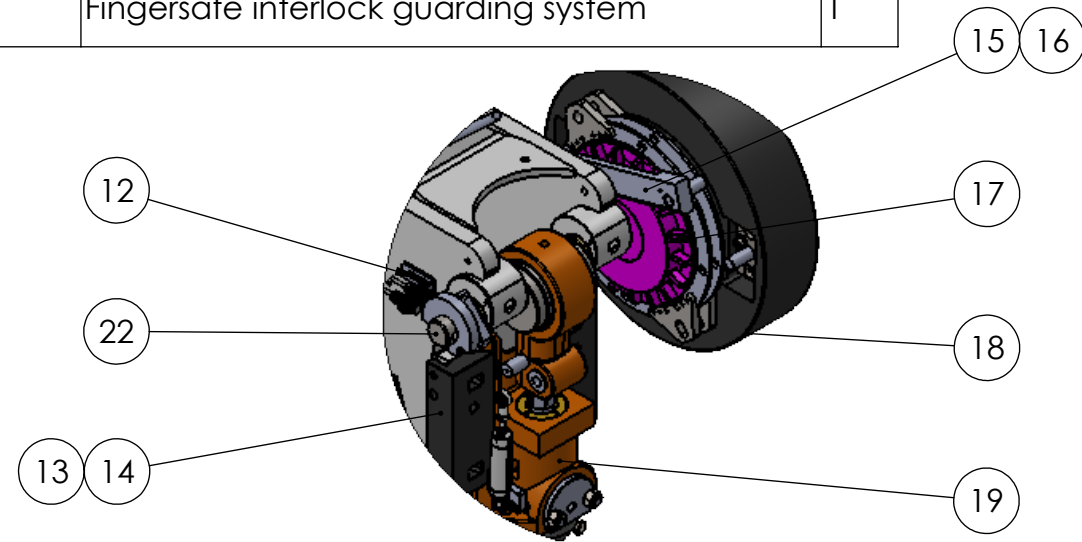
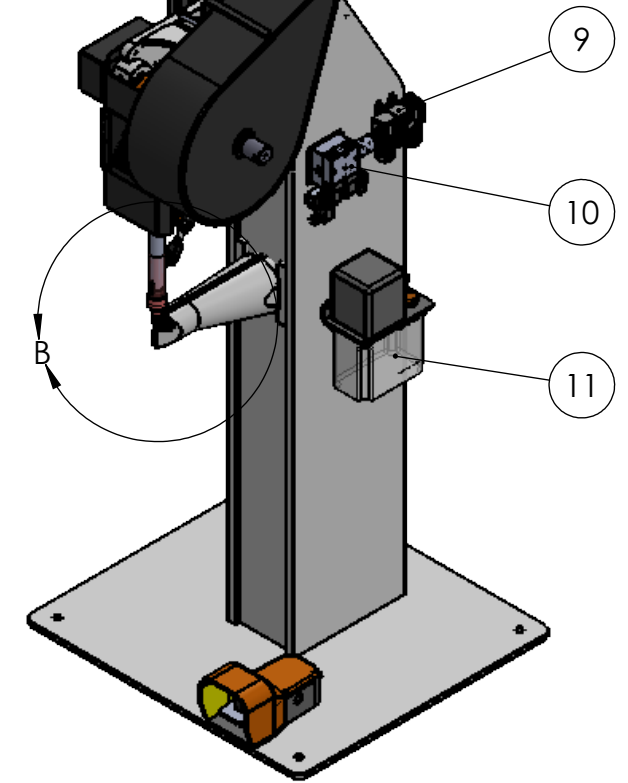
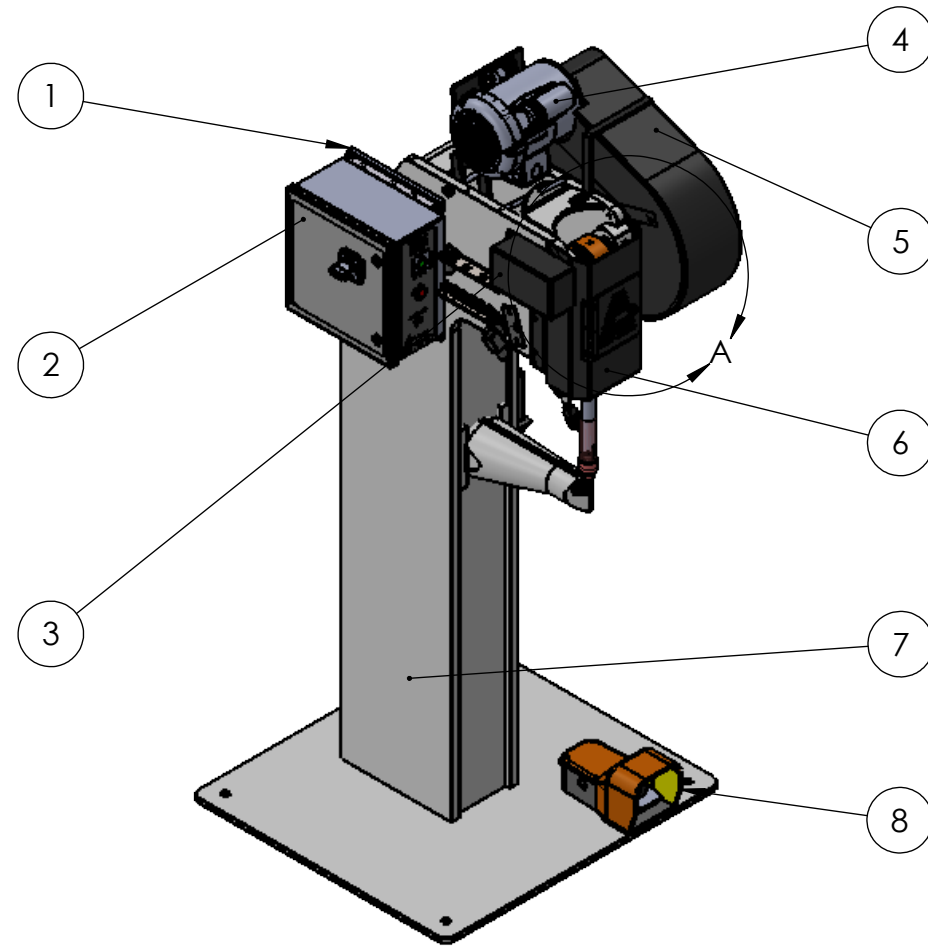


*Upon your request, Azimuth
customize your machine, the
way you need it !*



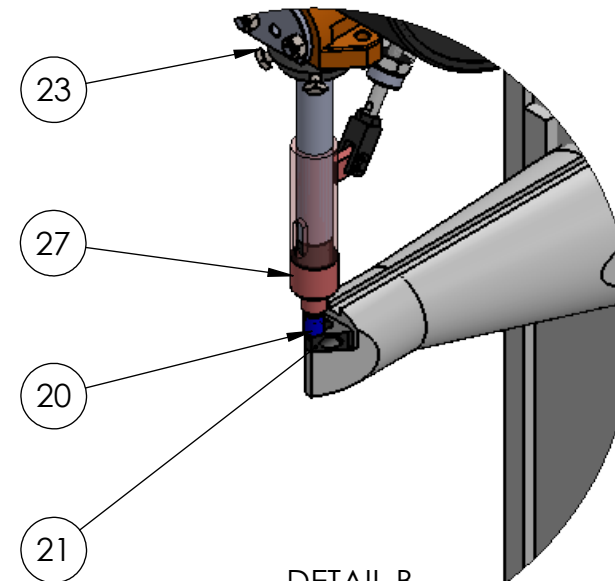
*Send us your sample today for a
free evaluation & recommendation
for your application*

ITEM NO.	PART NO	DESCRIPTION	QTY.
1	4-263	ACZ CONTROL PANEL BRACKET	2
2	4-503	ACZ CONTROL PANEL	1
3	6-227	CAM GUARD	1
4	6-369AS	MOTOR ASSEMBLY	1
5	6-327AS	FLYWHEEL GUARD ASSEMBLY	1
6	6-326	FRONT GUARD	1
7	H612-001	FRAME	1
8	1005-025	ELECTRIC FOOT PEDAL	1
9	1310-020	MODULAR FRL 1/4NPT	1
10	4-205	SAFETY DUAL VALVE 1/4NPT	1
11	1300-041	AUTOMATIC OILER	1
12	4-259AS	PROXIMITY SWITCHES ASSEMBLY	1
13	6-022.1	6T GIB, RIGHT	1
14	6-022	6T GIB, LEFT	1
15	4-202AS	UPPER BRACKET	1
16	4-202.1AS	LOWER BRACKET	1
17	4-200AS	AIR CLUTCH ASSEMBLY	1
18	6-341.1AS	CLINCHING AIR CLUTCH FLYWHEEL ASSEMBLY	1
19	6-023AS	6T RAM ASSEMBLY	1
20	20032AS	DIE ASSEMBLY	1
21	6-306	DIE BLOCK	1
22	6-233.1AS	6T ACZ CRANKSHAFT ASSEMBLY	1
23	6-302.1AS	NARROW PUNCH HOLDER ASSEMBLY	1
24	6-311	PUNCH MOUNTING BRACKET	1
25	6-311.1	DIE MOUNTING BRACKET	1
26	6-315	LASER ALIGNMENT TOOL	1
27	6-370AS	Fingersafe interlock guarding system	1



DETAIL A
SCALE 1 : 8

*6-327AS (AIR CLUTCH FLYWHEEL GUARD ASSEMBLY),
6-326AS (CLINCHING AIR CLUTCH FRONT GUARD)
AND 6-227 (6T CAM GUARD)
ARE HIDDEN IN THIS VIEW



DETAIL B
SCALE 1 : 6

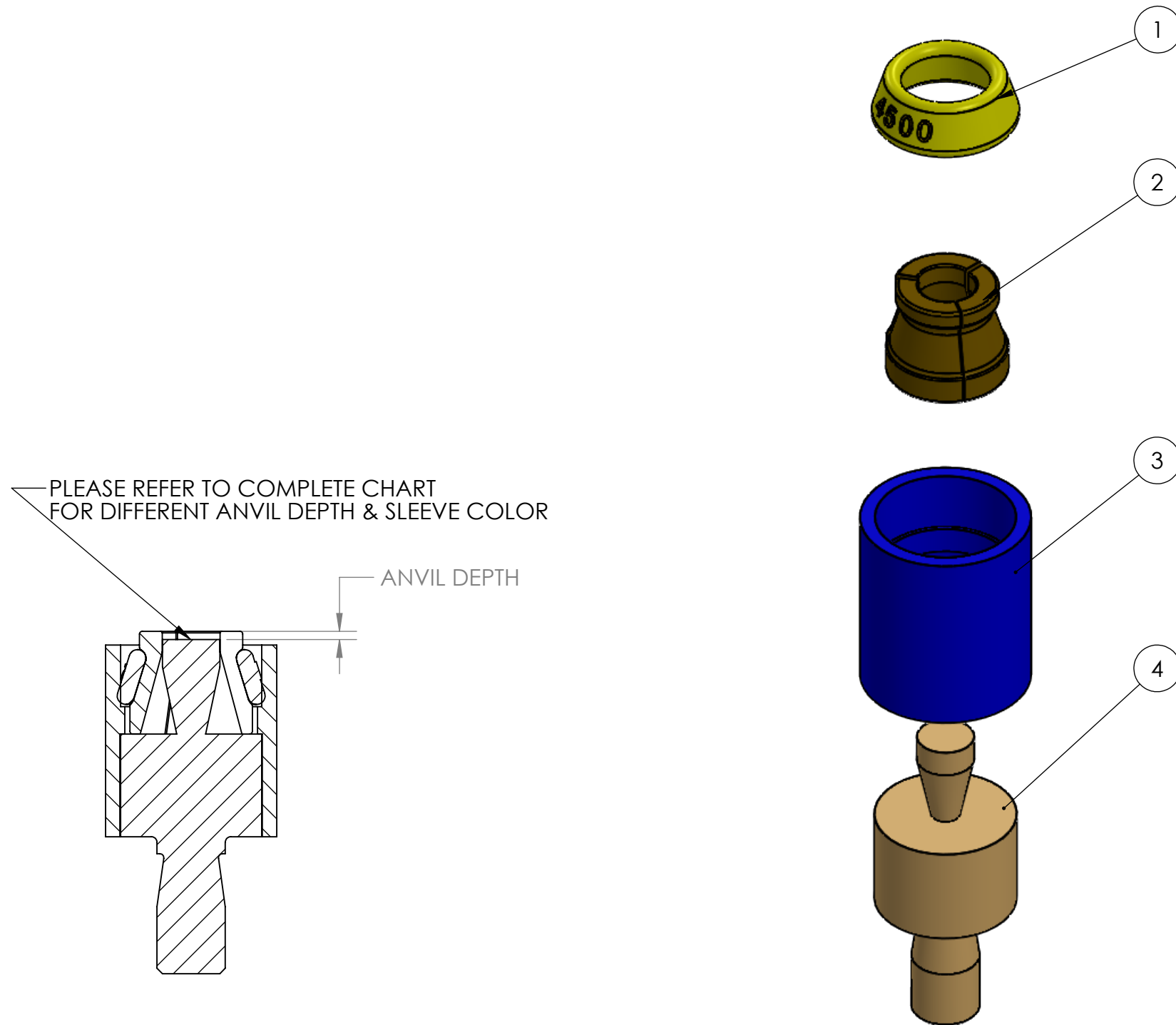


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DESCRIPTION	
H612 GEN II	
CUSTOMER	
DRAWN BY	DATE
AZIMUTH MACHINERY	2020-01-09
ISSUED FOR	DWG. #
	H612-AC-AS
COMMENTS :	

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NO	PartNo	DESCRIPTION	QTE
1	20262	ELASTOMER MEDIUM	1
2	20254	BLADES	3
3	6-304.1	BLUE Sleeve	1
4	20032	Clinching die body 0.180, 24-29G	1




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DESCRIPTION
DIE ASSEMBLY

DESCRIPTION
STANDARD PARTS

DRAWN BY JOEY TRUDEAU	DATE 2019-04-15
ISSUED FOR CUSTOMER APPROVAL	DWG. # 20032AS

COMMENTS :

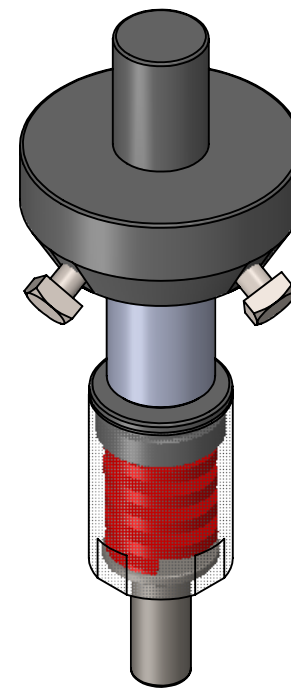
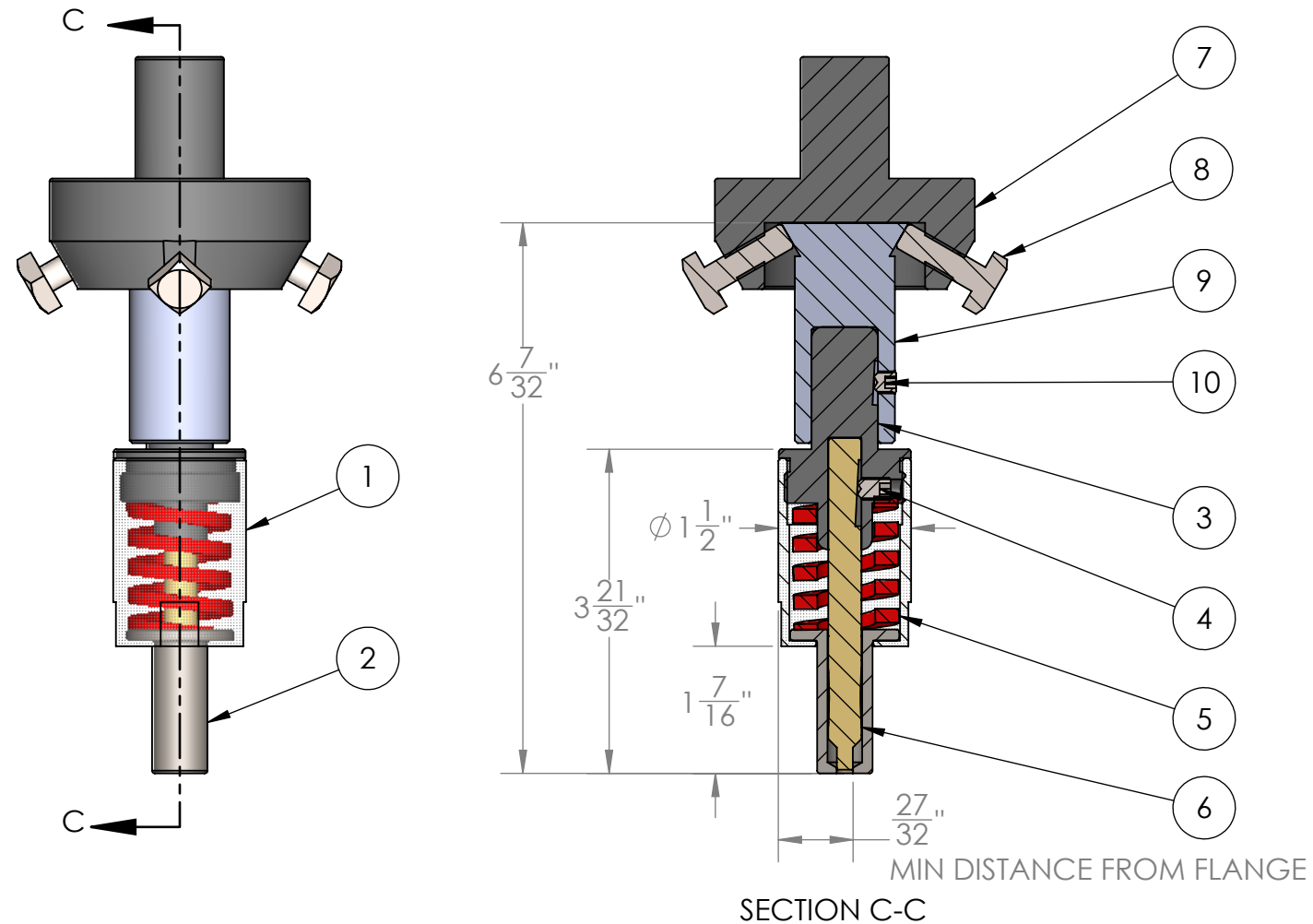
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FOR ROUND TOOLING (GALVANIZED, ALUMINUM, MILD STEEL, PRE-PAINTED)

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	6-310	Spring holder	1
2	6-305	Stripper	1
3	6-303	Punch holder	1
4	4000-007	Setscrew 1/4-28 x 3/8" LG.	1
5	REFER TO CHART	Spring	1
6	20886	Clinching punch 0.180 12-26G, 3.75"	1

NOT INCLUDED IN THE ASSEMBLY

ITEM NO.	PART NO.	DESCRIPTION	QTY.
7	4-301	H412 Tooling adapter	1
8	22052	Square head bolt, 5/16-18 x 1" LG.	4
9	4-302	Shank	1
10	4000-012	1/4-28 x 1/4" LG.	1



FOR DIFFERENT SIZE PRESSES, CHANGE THE FIRST DIGIT OF SHANK AND TOOLING ADAPTER PART NO. EX. H612 IS A 6-301 TOOLING ADAPTER

GAUGE	SPRING COLOR	PART NO
16	GOLD	32068
17	GOLD	32068
18	GOLD	32068
19	GOLD	32068
20	GOLD	32068
21	GOLD	32068
22	RED	32066
23	RED	32066
24	RED	32066
25	RED	32066
26	RED	32066
27	RED	32066
28	RED	32066
29	RED	32066
30	RED	32066

UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES
 TOLERANCES :
 FRACTIONAL ± 1/64
 TWO PLACE DECIMAL ± .01
 THREE PLACE DECIMAL ± .005

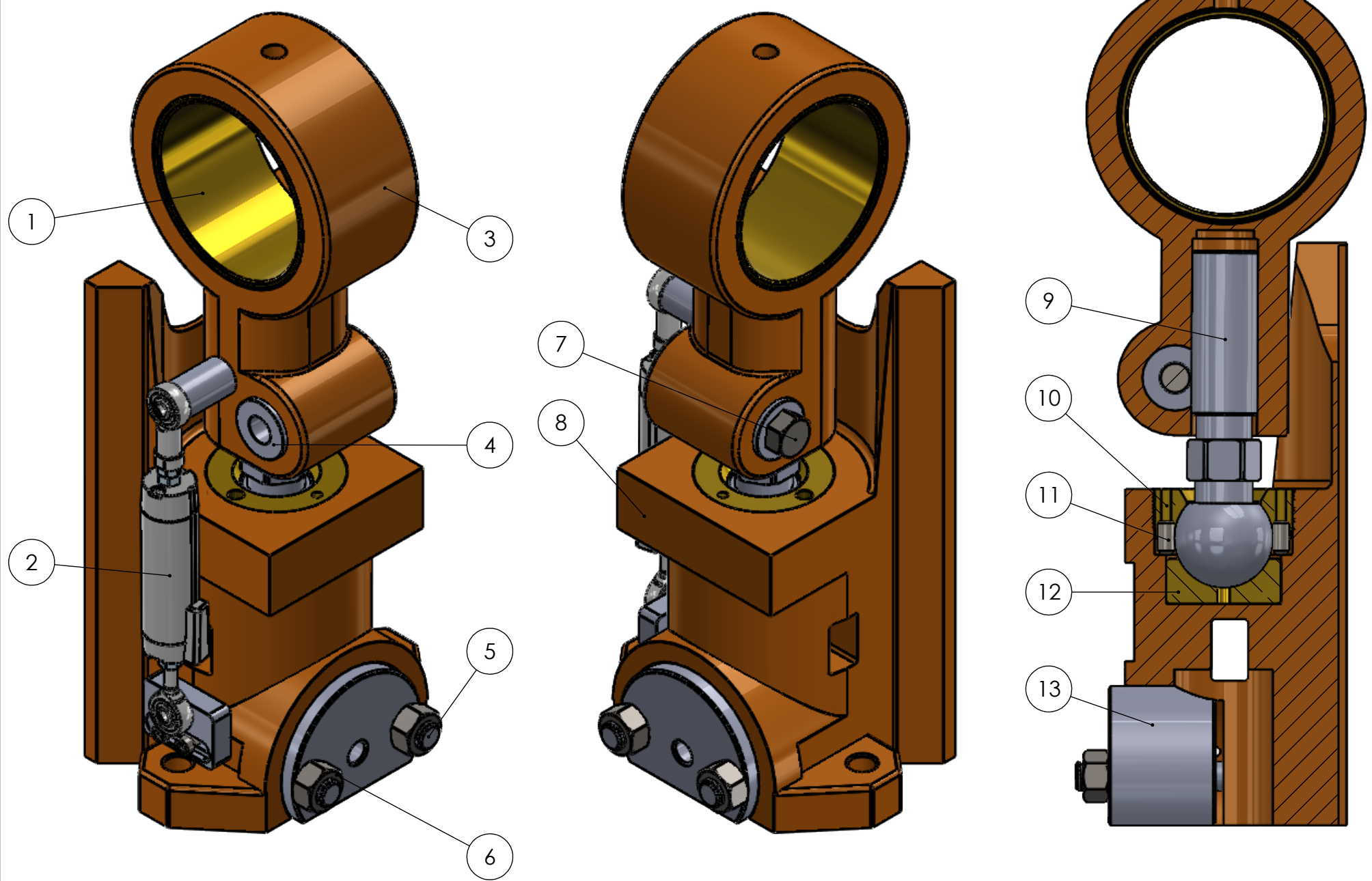


DESCRIPTION PUNCH ASSEMBLY - STYLE A	
PART NO 20886AS	
DRAWN BY JOEY TRUDEAU	SCALE 2:3
DRAWING # 20886-AS	
COMMENTS :	

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NOTE	DESCRIPTION
1	MAKE SURE TO ALWAYS TIGHTEN SET SCREWS #11 AFTER REPLACING PART #10 (6-026). TO READJUST CUP-BALL, LOOSEN UP SCREW #11, THEN ROTATE CW THE CUP-BALL UNTIL IT IS TIGHT. ONCE TIGHT, LOOSEN UP THE CUP-BALL ADJUSTMENT (6-026) OF APPROXIMATELY 1/16 OF A TURN CCW TO GIVE A SMALL LOOSE TO THE BALL-SCREW
2	LOOSEN BOLT #7 TO ADJUST SHUT HEIGHT. MAKE SURE TO ALWAYS RETIGHTEN BOLT AFTER ADJUSTMENT

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	6-136	BRONZE BUSHING PITMAN	1
2	6-403AS	SHUT HEIGHT INDICATOR ASSEMBLY (OPTIONAL) 0-1"	1
3	6-029	PITMAN (CON, ROD)	1
4	6-028	CLAMP BLOCK, PITMAN	1
5	6-090	CLAMP BLOCK	2
6			2
7		HEX BOLT 7/16-14X1-1/4 LG.	1
8	6-023	RAM	1
9	6-027	BALL SCREW, PITMAN	1
10	6-026	CUP, BALL ADJUSTMENT	1
11		SET SCREW 1/4-28X1/2 LG.	2
12	6-025	BALL SEAT, RAM	1
13	6-024	CLAMP BLOCK, RAM	1



SECTION VIEW



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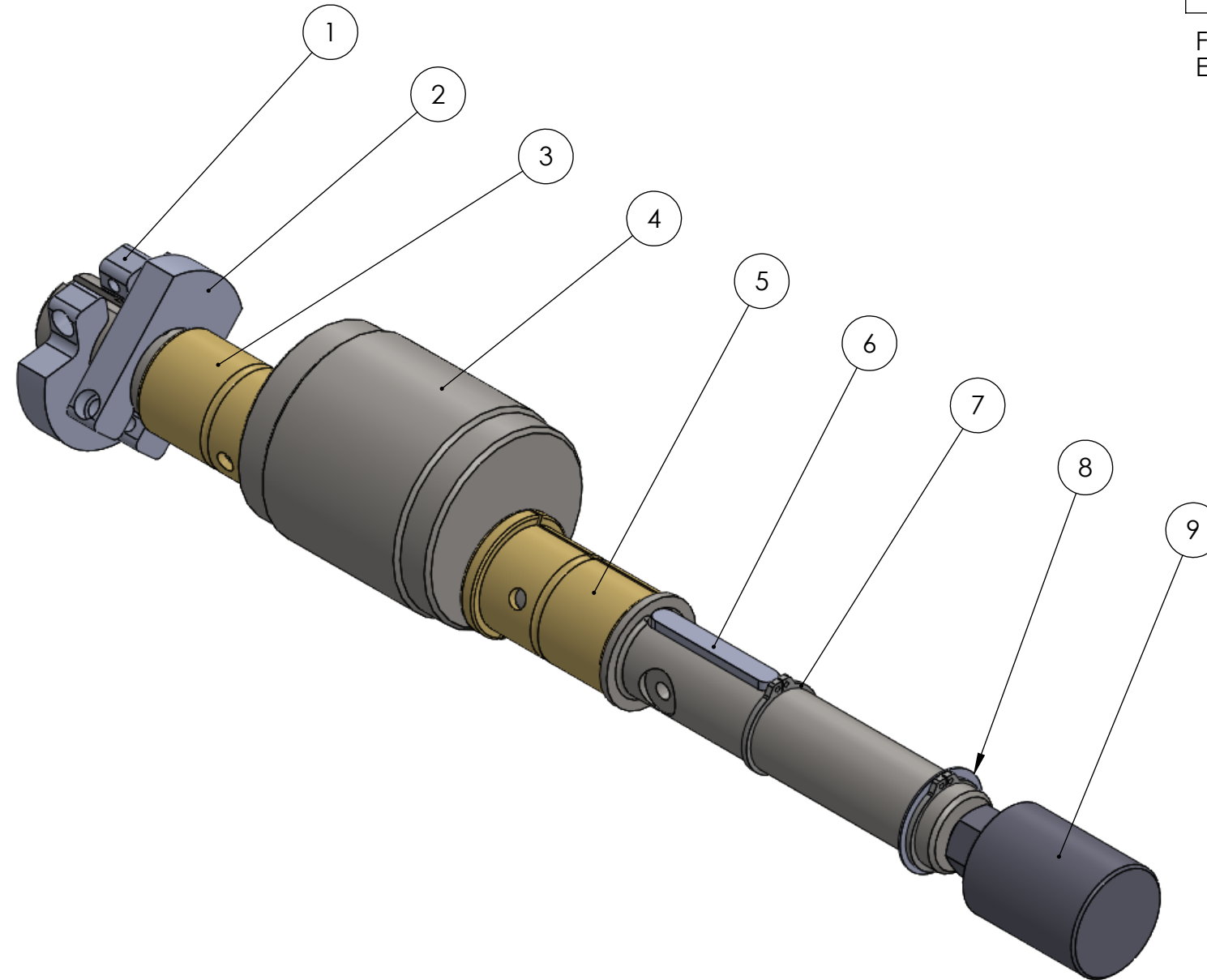
DESCRIPTION	
6T RAM ASSEMBLY	
CUSTOMER	
DRAWN BY	DATE
AZIMUTH MACHINERY	2019-06-20
ISSUED FOR	DWG. #
	6-023AS

COMMENTS :

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ITEM NO.	PART NO	DESCRIPTION	QTY.
1	6-251	6T TOP-STOP CAM	1
2	6-251.1	6T BRAKE CAM	1
3	6-034SO	6T BRONZE BUSHING, SOLID	1
4	6-233	6T AIR CLUTCH CRANKSHAFT 1.25" STROKE	1
5	6-034SP	6T BRONZE BUSHING, SPLIT	1
6	4-236	4 & 6T AIR CLUTCH KEY	1
7	6-101	6T CRANKSHAFT RETAINING RING	2
8	6-237	SHIM AC CRANKSHAFT	1
9	4-201	4 & 6T ROTARY UNION 1/4NPT	1

FOR DIFFERENT SIZE PRESSES, CHANGE THE FIRST DIGIT
EX : 6-233 IS A 6T CRANKSHAFT
10-233 IS A 10T CRANKSHAFT



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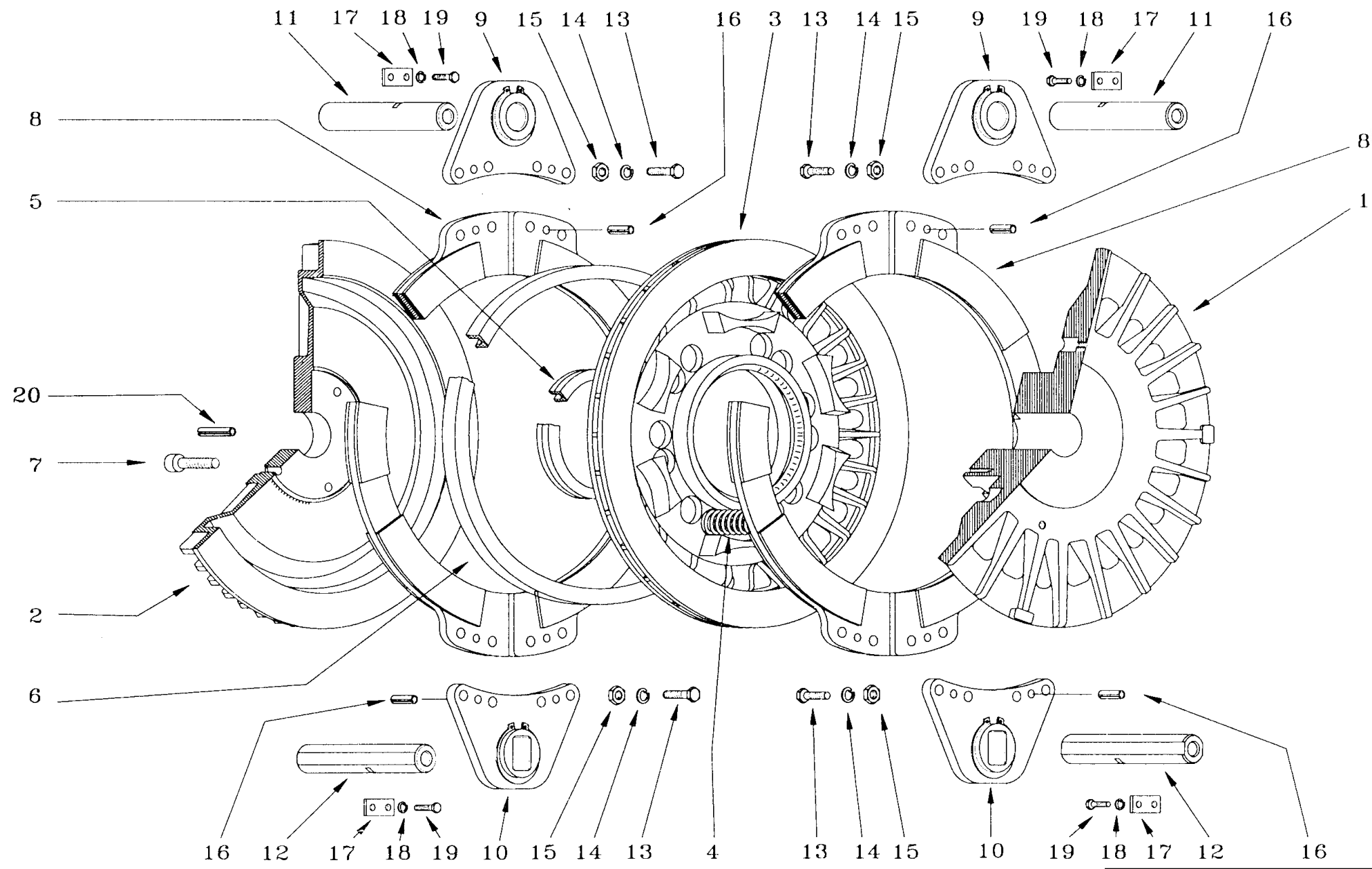
DESCRIPTION
6T ACZ CRANKSHAFT ASSEMBLY
MODEL NO

DRAWN BY AZIMUTH MACHINERY	SCALE
DRAWING # 6-233.1	REV

COMMENTS :

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Part no. 4-200

4-200.1	Clutch plate & Integral Hub
4-200.2	Brake cover
4-200.3	Piston
4-200.4	Brake Springs
4-200.5	Inner piston Seal
4-200.6	Outer piston seal
4-200.7	Socket head cap screw- Hub
4-200.8	Clutch or brake Lining (One each side)
4-200.9	Mouting ears - Round
4-200.10	Mouting ears - Square
4-200.11	Reaction Pin - Round
4-200.12	Reaction Pin - Square
4-200.13	Hex head bolt – Lug
4-200.14	Lock washer - Lug
4-200.15	Lock nut - Lug
4-200.16	Spring pin – Mounting Lug
4-200.17	Retaining Plate – Reaction Pin
4-200.18	Lock washer – Retaining plate
4-200.19	Hex head bolt – Retaining plate
4-200.20	Dowel pin – Hub

ITEM NO.	PartNo	DESCRIPTION	QTY.
1		EXTERNAL RETAINING RING FOR 3/8 OD	1
2		3/8-16 HEX NUT	2
3		3/8-16 FLAT WASHER	2
4	6-070	STD MOTOR BRACKET STUD	1
5	4-053	3/8 SHAFT COLLAR	2
6		STEEL ROD 3/8X8-3/4 LG.	1
7	6-069	MOTOR BRACKET	1
8		HEX BOLT 5/16-18X1 LG.	4
9		5/16 HEX NUT	4
10		5/16 SPRING LOCK WASHER	4
11		5/16 FLAT WASHER	8
12	6-126.2	motor 3/4-1800rpm-110v (clinching)	1
13	6-123.1	Pulley MOTOR, CLINCHING	1

THIS ASSEMBLY INCLUDES :
2X 4-124 Belt, motor



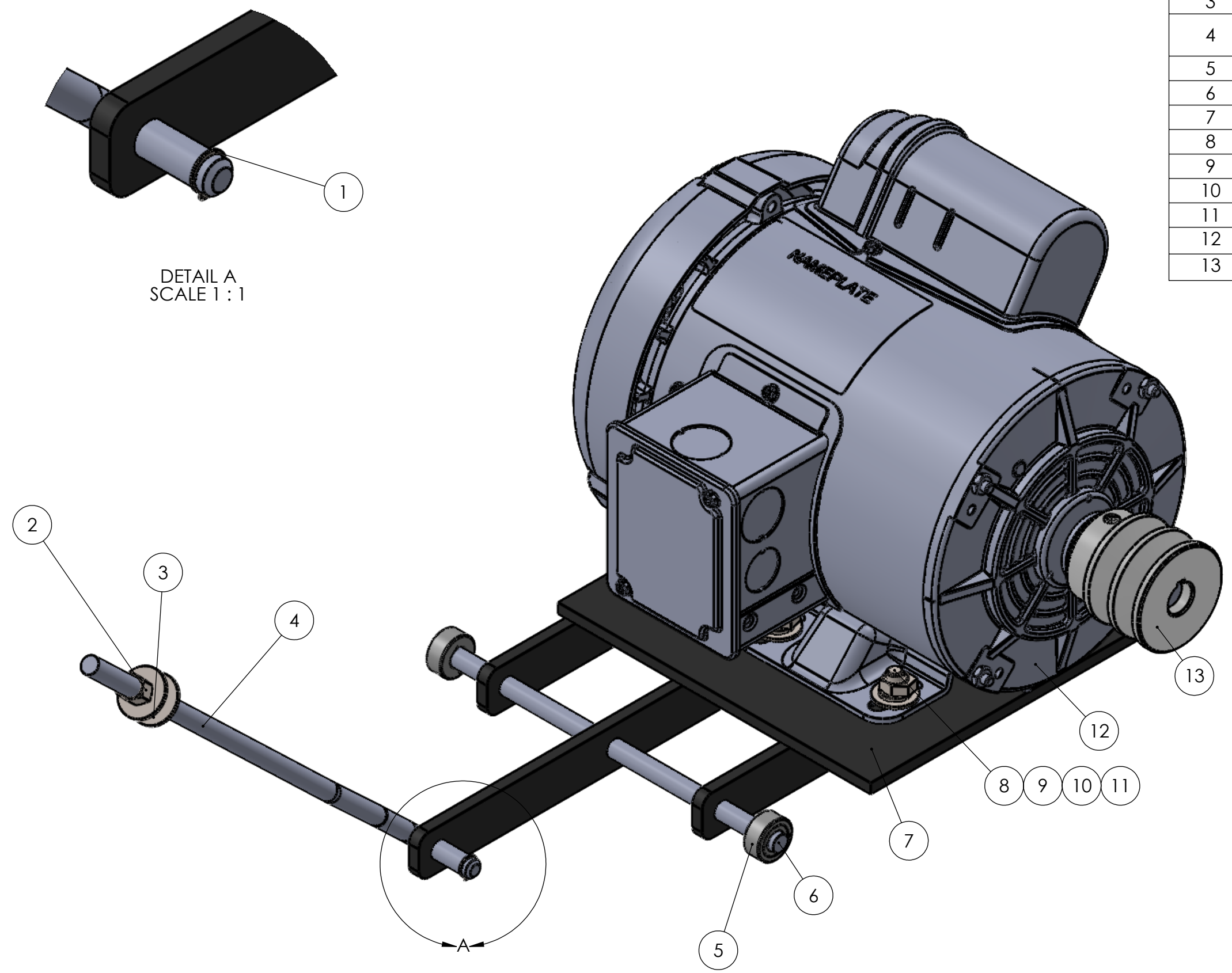
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DESCRIPTION
6T CLINCHING ELECTRIC MOTOR ASSEMBLY
CUSTOMER

DRAWN BY AZIMUTH MACHINERY	DATE 2018-07-05
ISSUED FOR	DWG. # 6-369-AS

COMMENTS :

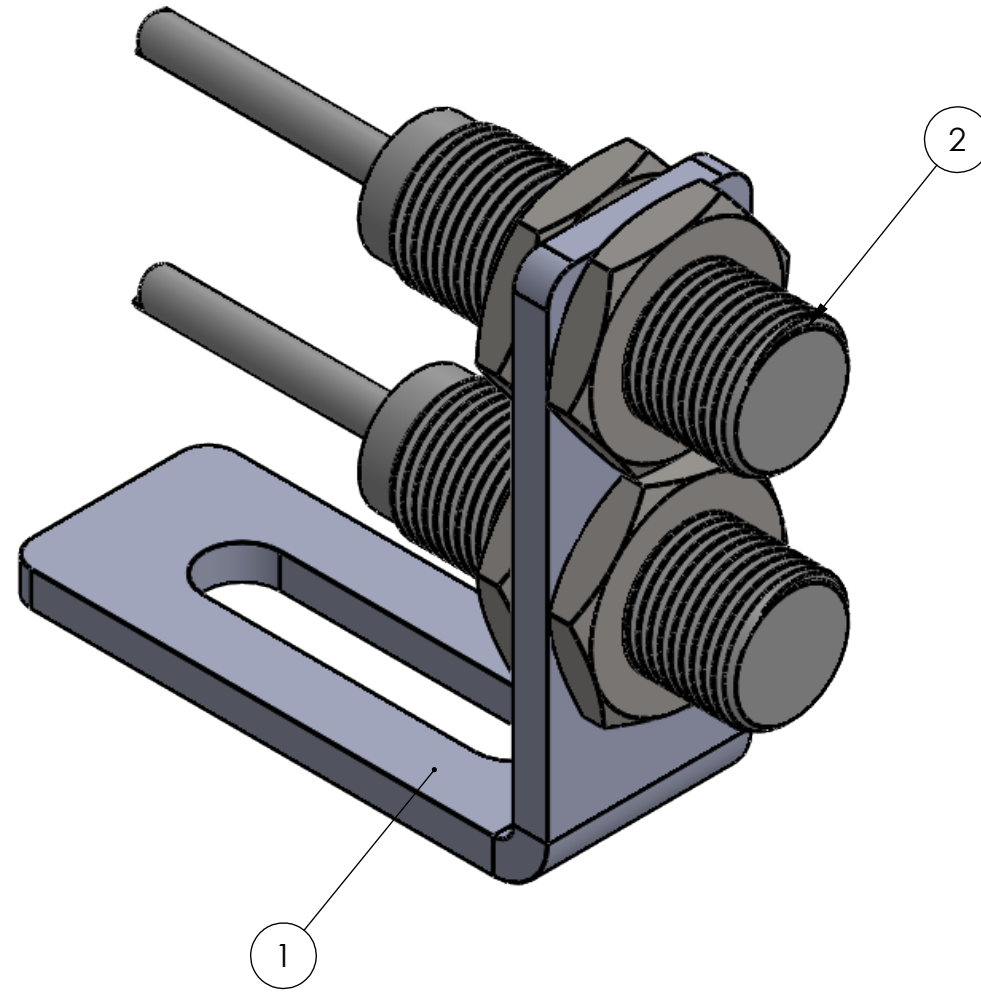
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DETAIL A
SCALE 1 : 1

ITEM NO.	PartNo	DESCRIPTION	QTY.
1	4-259	Bracket - Proximity Switch	1
2	1005-051	Proximity switch Inductive	2

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED

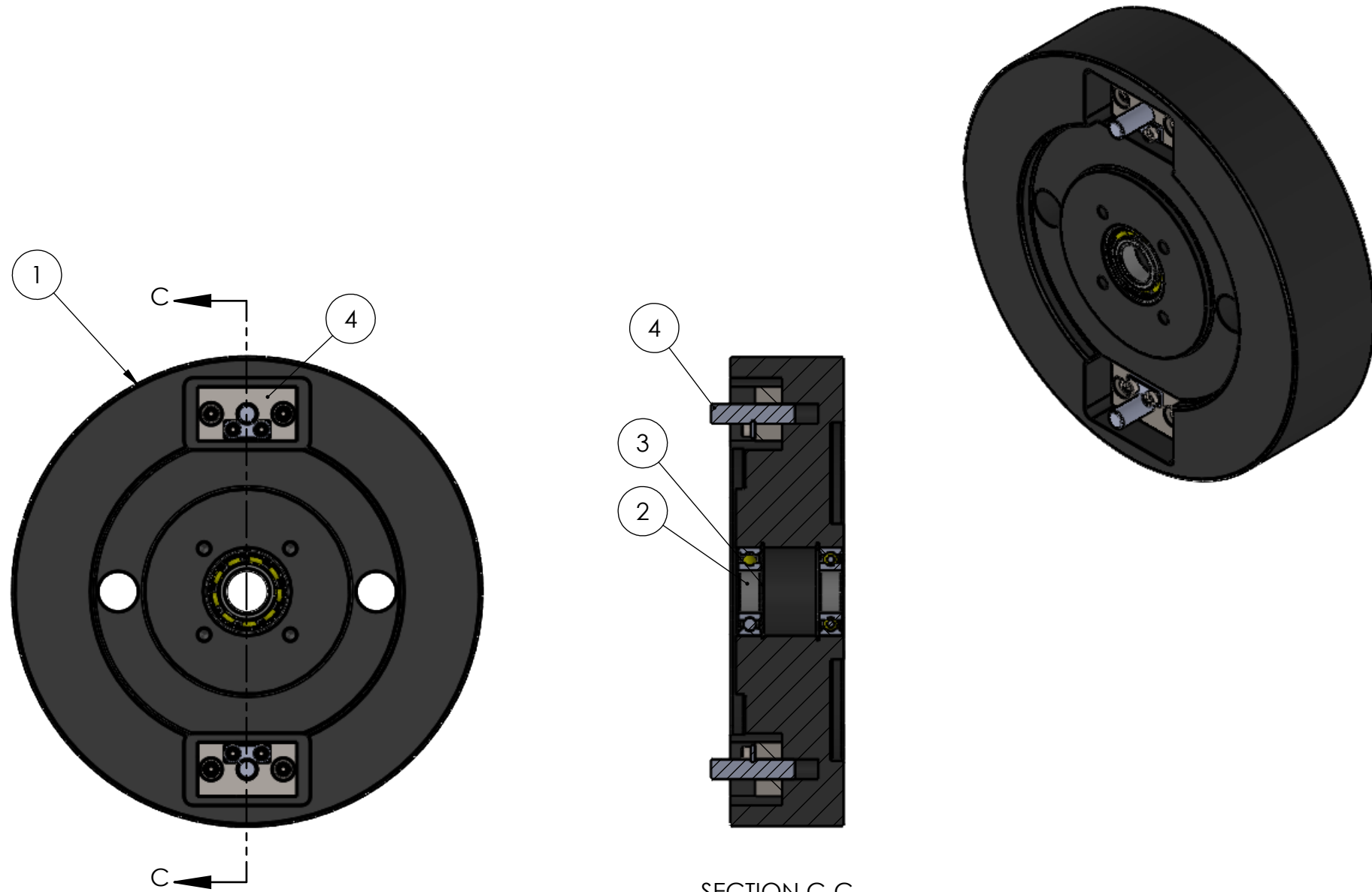



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DESCRIPTION	
PROXIMITY SWITCHES ASSEMBLY	
MODEL NO	
4-259AS	
DRAWN BY	SCALE
JOEY TRUDEAU	1:1
DRAWING #	REV
COMMENTS :	
<p align="center">PROPRIETARY AND CONFIDENTIAL</p> <p>THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF AZIMUTH MACHINERY. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF AZIMUTH MACHINERY IS PROHIBITED.</p>	

ITEM NO.	PartNo	DESCRIPTION	QTY.
1	6-341.1	FLYWHEEL, 6 TONS CLINCHING AC	1
2	6-122	6T FLYWHEEL BEARING	2
3	6-109	6T FLYWHEEL RETAINING RING	2
4	4-202.2AS	FLYWHEEL BRACKET ASSY.	2

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED




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DESCRIPTION	
CLINCHING AIR CLUTCH FLYWHEEL ASSEMBLY	
MODEL NO	
6-341.1AS	
DRAWN BY	SCALE
JOEY TRUDEAU	1:4
DRAWING #	REV
COMMENTS :	

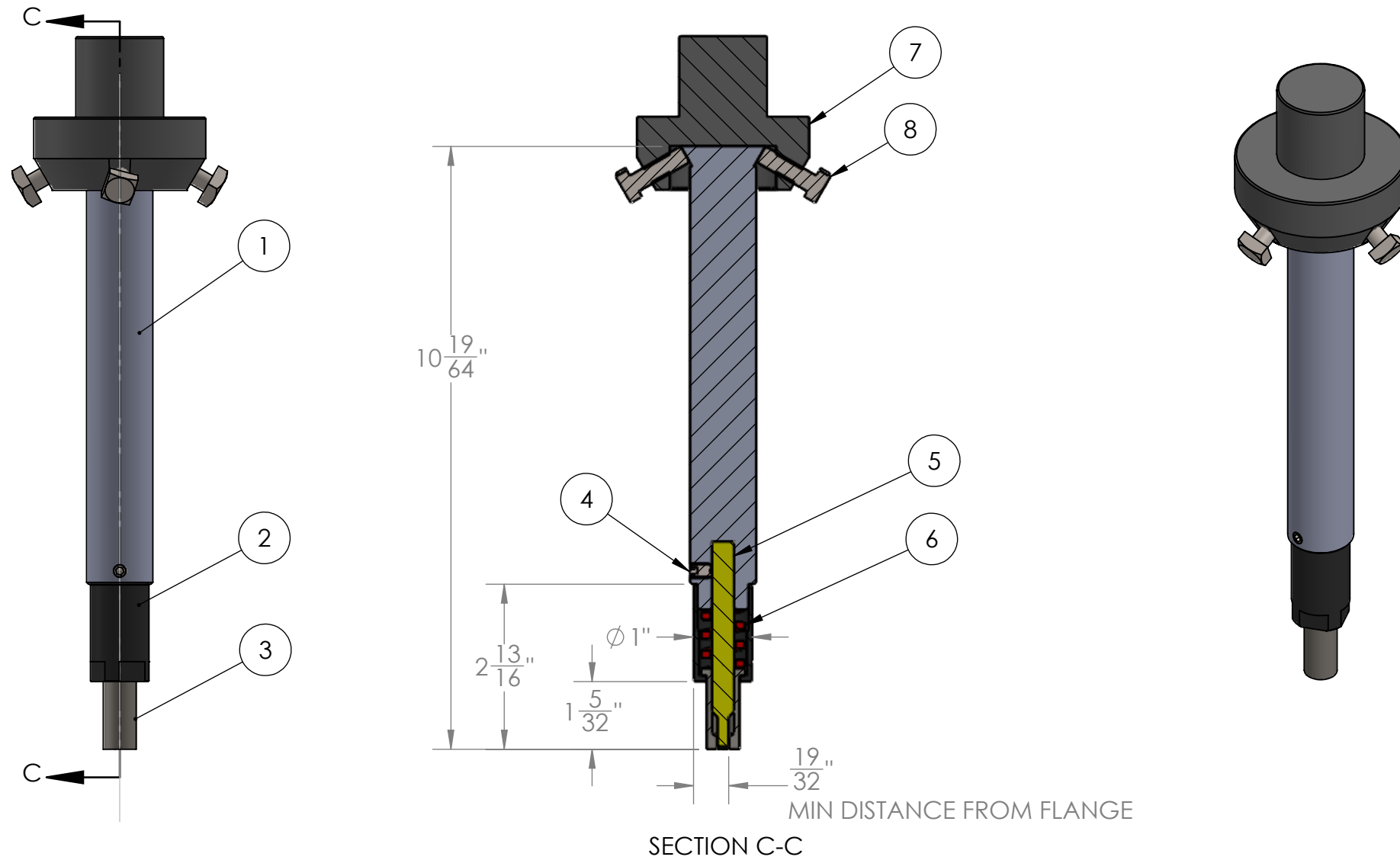
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ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	6-302.1	Shank (H612) Taloc	1
2	6-310.1	Spring holder	1
3	6-305.1	Stripper, Narrow punch holder	1
4	4000-007	Setscrew, 1/4-28, 0.375" LG.	1
5	20618	Clinching punch 3.5" 22G	1
6	Refer to shart	Spring	1

NOT INCLUDED IN THIS ASSEMBLY

ITEM NO.	PART NO.	DESCRIPTION	QTY.
7	6-301	H600 Tooling adapter	1
8	22052	Square head bolt, 5/16-18 x 1" LG.	4

GAUGE	SPRING COLOR	PART NO
14	GREEN	22064
15	GREEN	22064
16	GREEN	22064
17	GREEN	22064
18	GREEN	22064
19	GREEN	22064
20	GOLD	22068
21	GOLD	22068
22	GOLD	22068
23	GOLD	22068
24	GOLD	22068
25	GOLD	22068



UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES
TOLERANCES :
FRACTIONAL ± 1/64
TWO PLACE DECIMAL ± .01
THREE PLACE DECIMAL ± .005



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DESCRIPTION
NARROW PUNCH HOLDER ASSEMBLY

PART NO
6-302.1AS

DRAWN BY JOEY TRUDEAU SCALE 2:5
DRAWING #

COMMENTS :
TO BE USED WITH PUNCH 018274

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