



AZIMUTH

Clinching Presses
GEN I H400 series
Spare parts

AZIMUTH MACHINERY

Punch presses manufacturer since 1975

CUSTOM MACHINE FOR YOUR UNIQUE APPLICATION

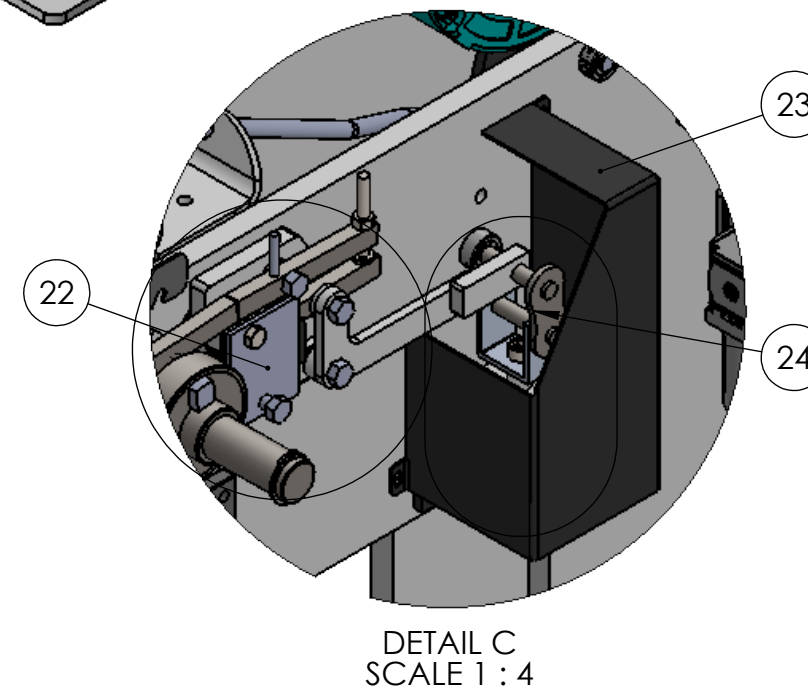
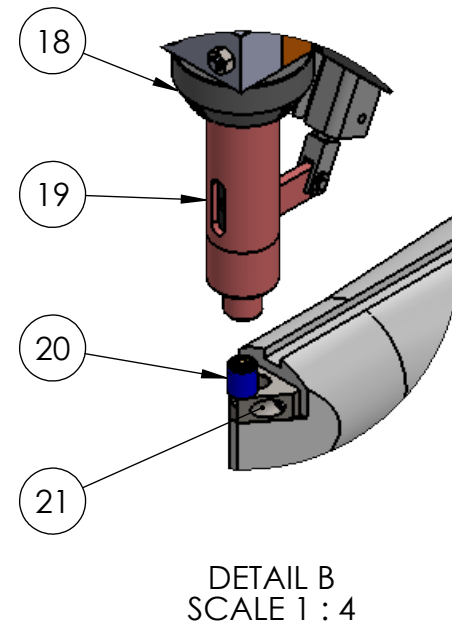
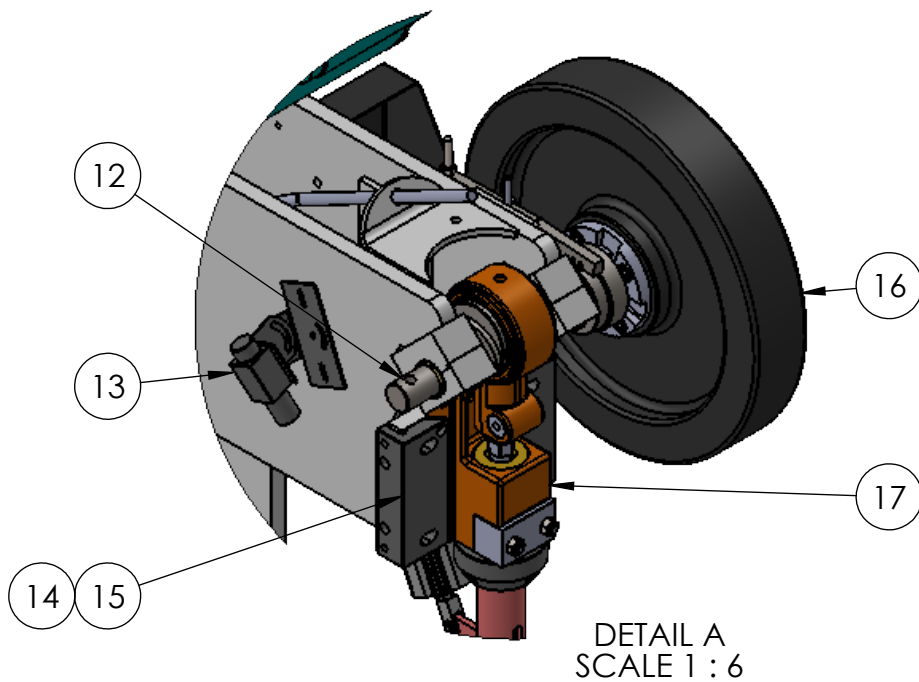
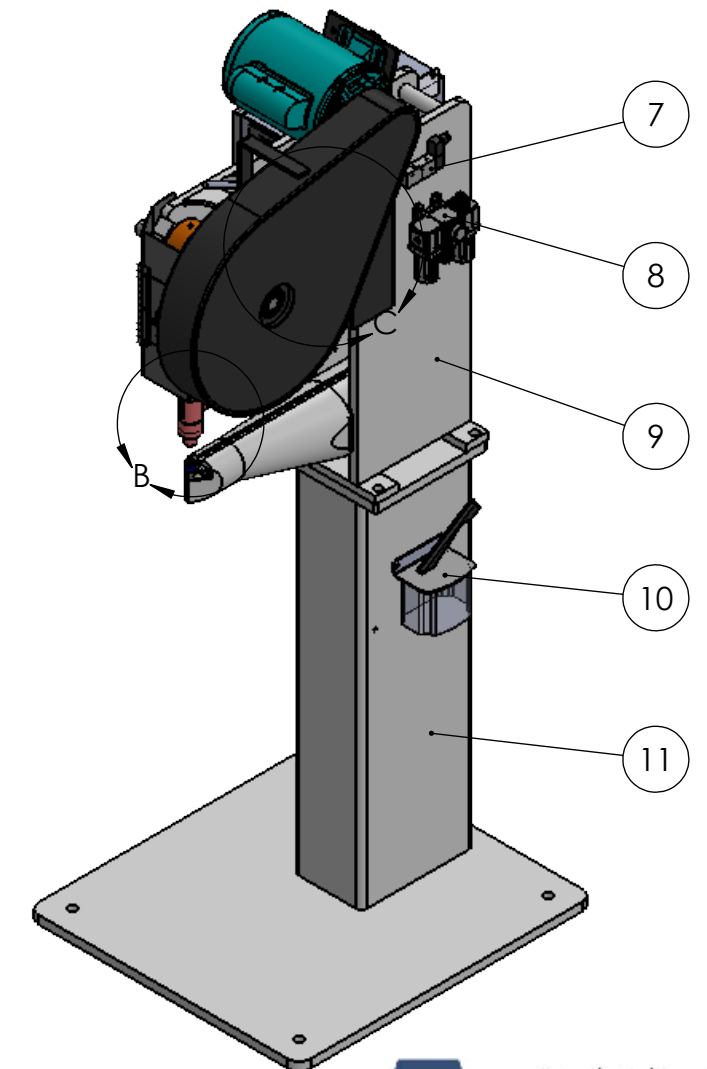
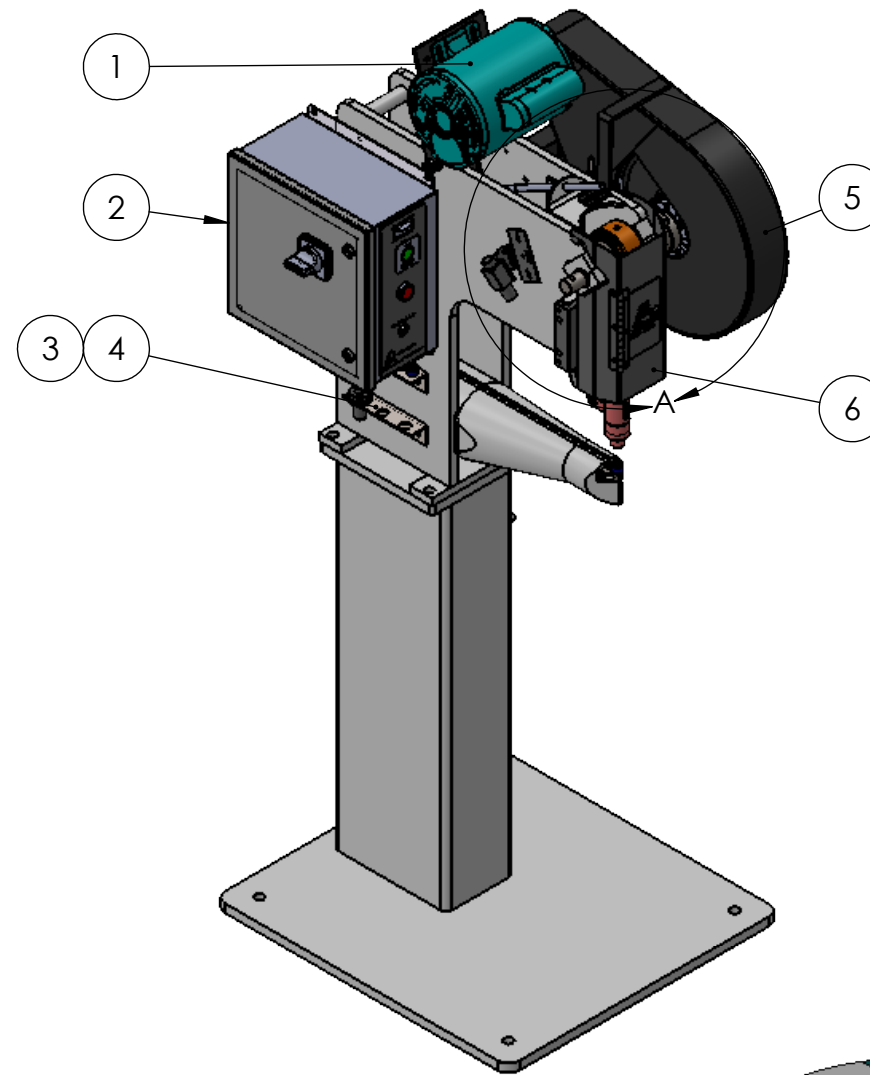


*Upon your request, Azimuth
customize your machine, the
way you need it !*



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

ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	4-069AS	MOTOR ASSEMBLY	1
2	4-503	ACZ CONTROL PANEL	1
3	6-311.1	DIE MOUNTING BRACKET	1
4	6-311	PUNCH MOUNTING BRACKET	1
5	4-325AS	4T CLINCHING FLYWHEEL GUARD ASSEMBLY	1
6	4-326AS	4T CLINCHING FRONT GUARD	1
7	4-151	SOLENOID VALVE 3/2-110VAC	1
8	1310-020	MODULAR FRL 1/4NPT	1
9	H412-001	FRAME	1
10	1300-018	MANUAL OILER	1
11	4-002.1	H412 BENCH	1
12	4-033AS	4T CRANKSHAFT ASSEMBLY	1
13	6-315	LASER ALIGNMENT TOOL	1
14	4-022.1	4T GIB, RIGHT	1
15	4-022	GIB, LEFT	1
16	4-041AS	4T FLYWHEEL ASSEMBLY	1
17	4-023AS	RAM ASSEMBLY	1
18	4-302.1AS	NARROW PUNCH HOLDER	1
19	4-328AS	FINGERSAFE INTERLOCK GUARDING	1
20	20032AS	CLINCHING DIE SET 24-29G BLUE	1
21	6-306	DIE BLOCK	1
22	4-049.1AS	4T MECHANICAL CLUTCH ASSEMBLY	1
23	4-228	H412 ACTUATOR GUARD	1
24	4-149AS	4T AIR ACTIVATED SYSTEM	1



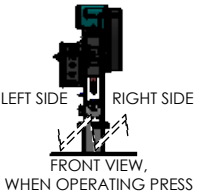
* 4-325AS (FLYWHEEL GUARD ASSEMBLY)
* 4-326AS (FRONT GUARD)
ARE HIDDEN IN THIS VIEW

* 4-326AS (FRONT GUARD)
IS HIDDEN IN THIS VIEW

* 4-325AS (FLYWHEEL GUARD ASSEMBLY)
IS HIDDEN IN THIS VIEW



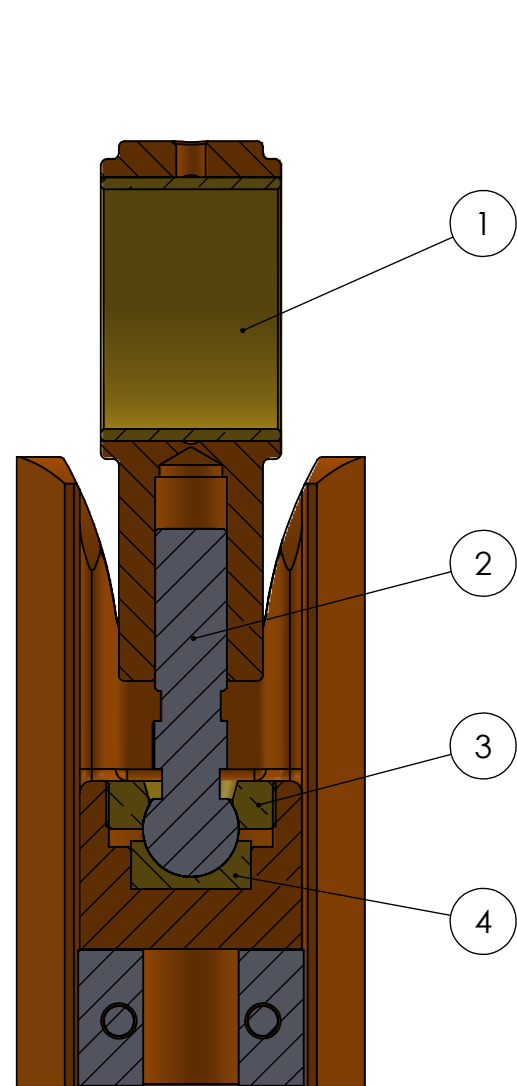
Azimuth Machinery Ltd
T 450 632 8080
F 450 632 8081
www.azimuthpress.com
6040 Rte. 132, Ste Catherine
QC, Canada, J5C 1B6

DESCRIPTION H412	
CUSTOMER	
DRAWN BY AZIMUTH MACHINERY	DATE 2020-02-14
ISSUED FOR	DWG. #
COMMENTS :	
 <p>LEFT SIDE RIGHT SIDE FRONT VIEW, WHEN OPERATING PRESS</p>	

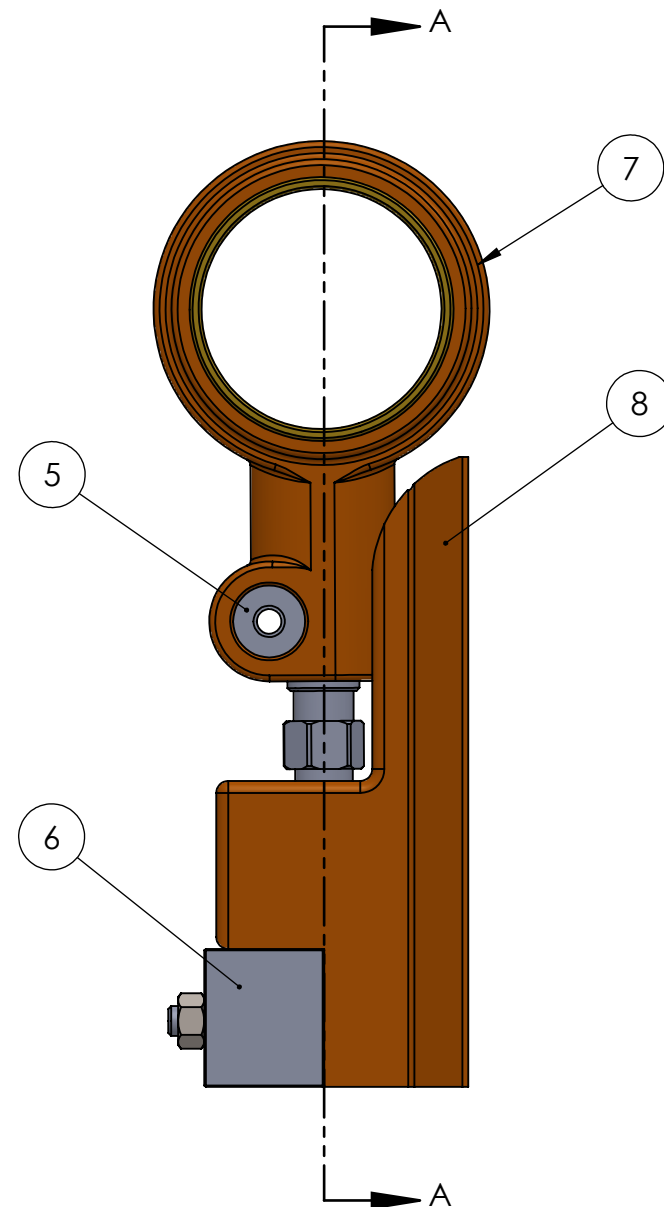
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ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	4-136	PITMAN BRONZE BUSHING	1
2	4-027	BALL SCREW, PITMAN	1
3	4-026	BALL ADJUSTMENT, CUP	1
4	4-025	RAM BALL SEAT	1
5	4-028	PITMAN CLAMPING BLOCK	1
6	4-024	RAM CLAMPING BLOCK	1
7	4-029	PITMAN CONNECTING ROD	1
8	4-023	RAM	1

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED



SECTION A-A



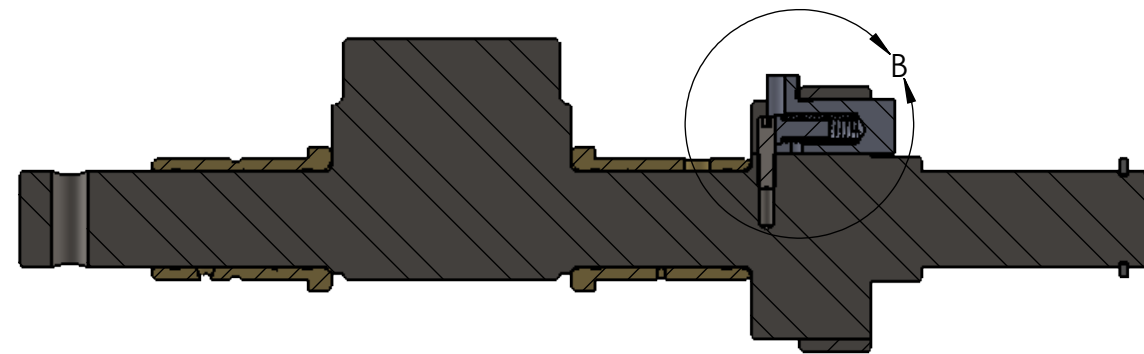
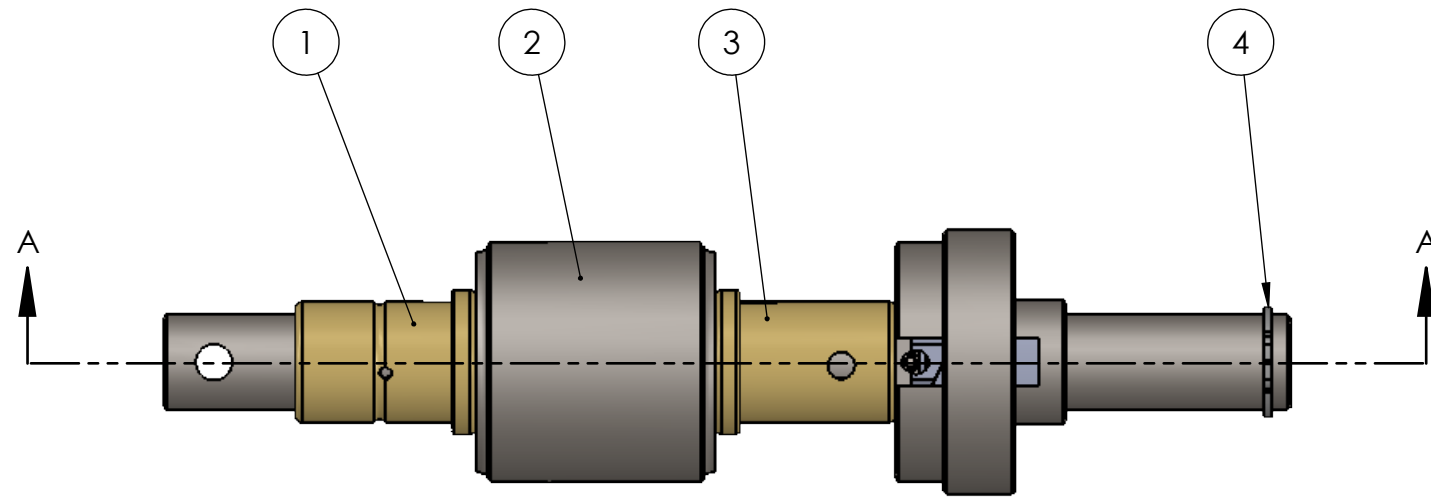

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DESCRIPTION	
RAM ASSEMBLY	
MODEL NO	
4-023AS	
DRAWN BY	SCALE
JOEY TRUDEAU	1:2
DRAWING #	REV
COMMENTS :	

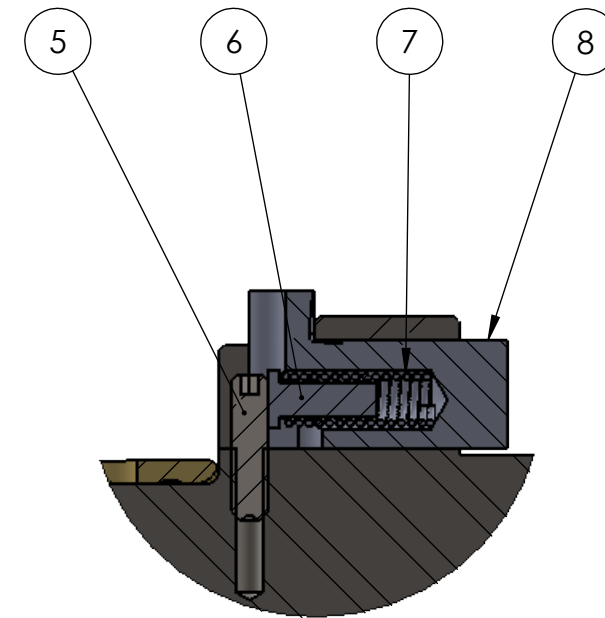
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ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	4-034	BRONZE BUSHING SOLID, GROOVED	1
2	4-033	CRANKSHAFT, 1.25 STROKE	1
3	4-034	BRONZE BUSHING. SPLIT	1
4	4-101	EXTERNAL RETAINING RING, SHAFT Ø 1.00	1
5	4-086	SOCKET SET SCREW, CUP POINT, 10-24 UNC X 3/4 LG.	1
6	4-104.1	PUSHER, LATCH SPRING	1
7	4-043	SLIDING KEY SPRING, Ø 0.281 X 1.25 LG.	1
8	4-042	SLIDING KEY, CLUTCH DOG	1

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED



SECTION A-A



DETAIL B
SCALE 1 : 1



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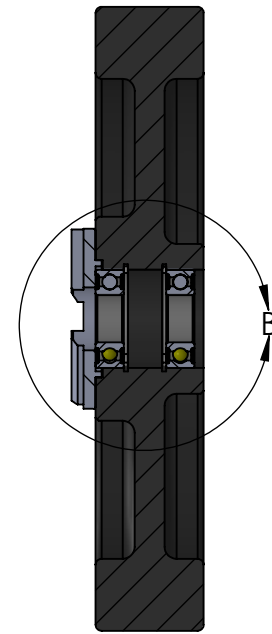
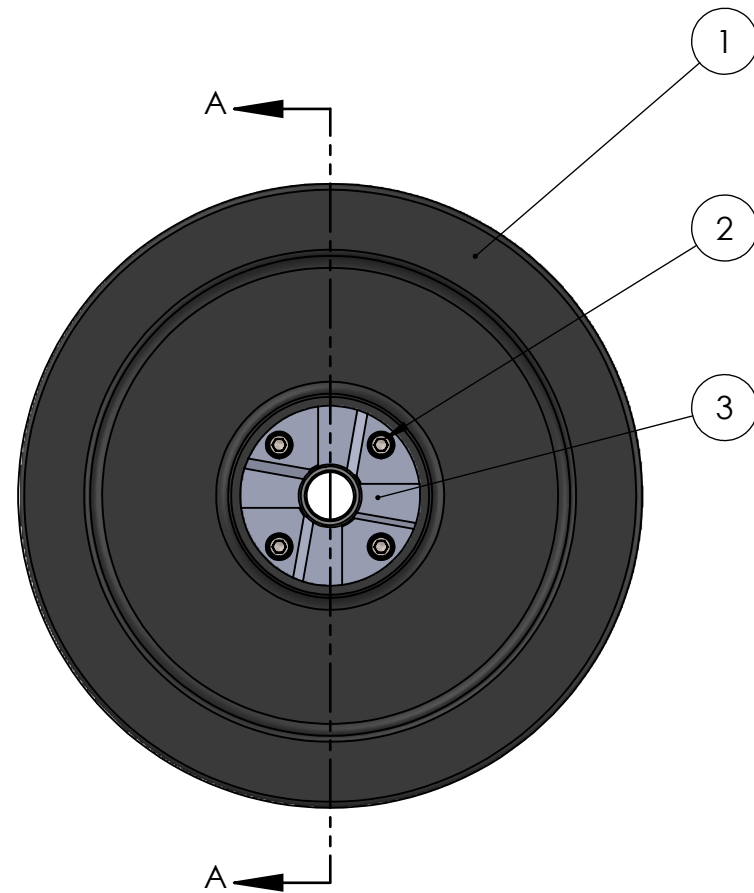
DESCRIPTION	
4T CRANKSHAFT ASSEMBLY	
MODEL NO	
4-033AS	
DRAWN BY	SCALE
JOEY TRUDEAU	1:2
DRAWING #	REV

COMMENTS :

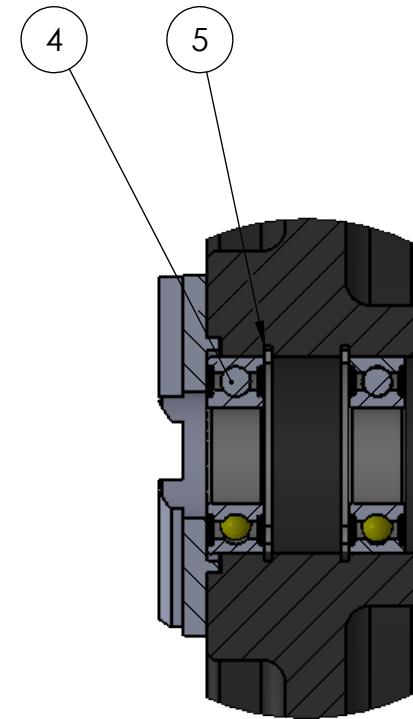
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ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	4-041	FLYWHEEL	1
2	4-085	SHCS, 5/16- 18 UNC, 3/4 LG.	4
3	4-038	CLUTCH PLATE	1
4	4-122	SEALED BALL BEARING, 6205-2RSL	2
5	4-109	INTERNAL RETAINING RING, FOR Ø 2.0625	2

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED



SECTION A-A



DETAIL B
SCALE 1 : 2

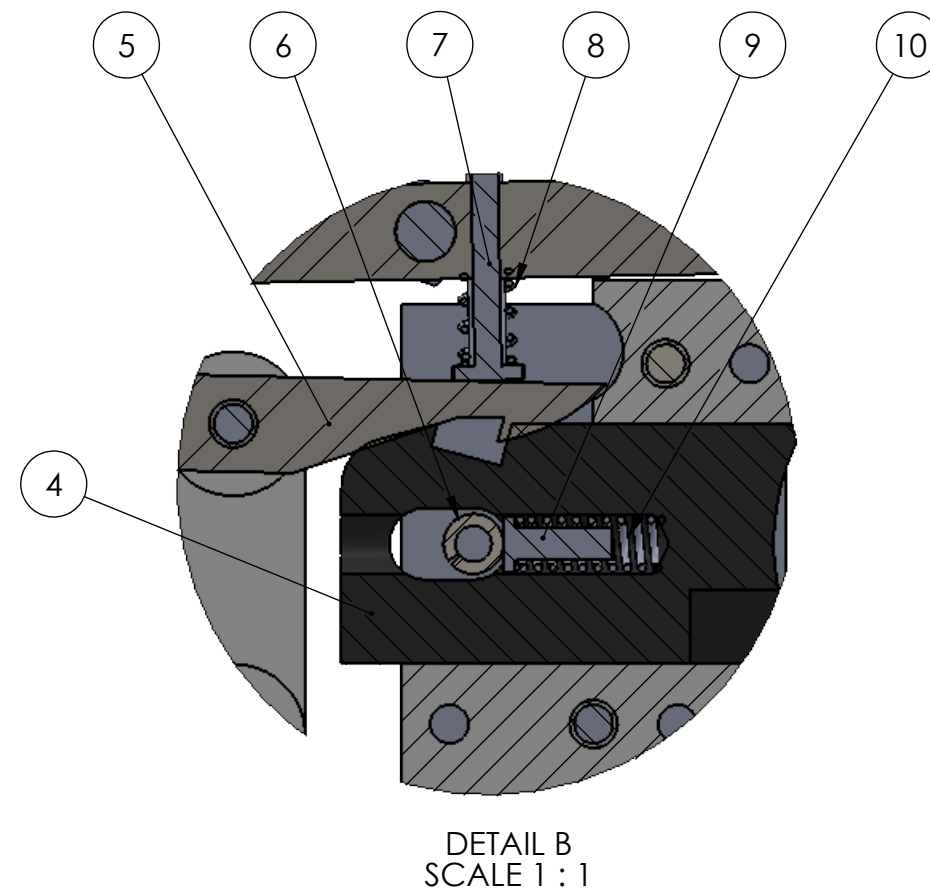
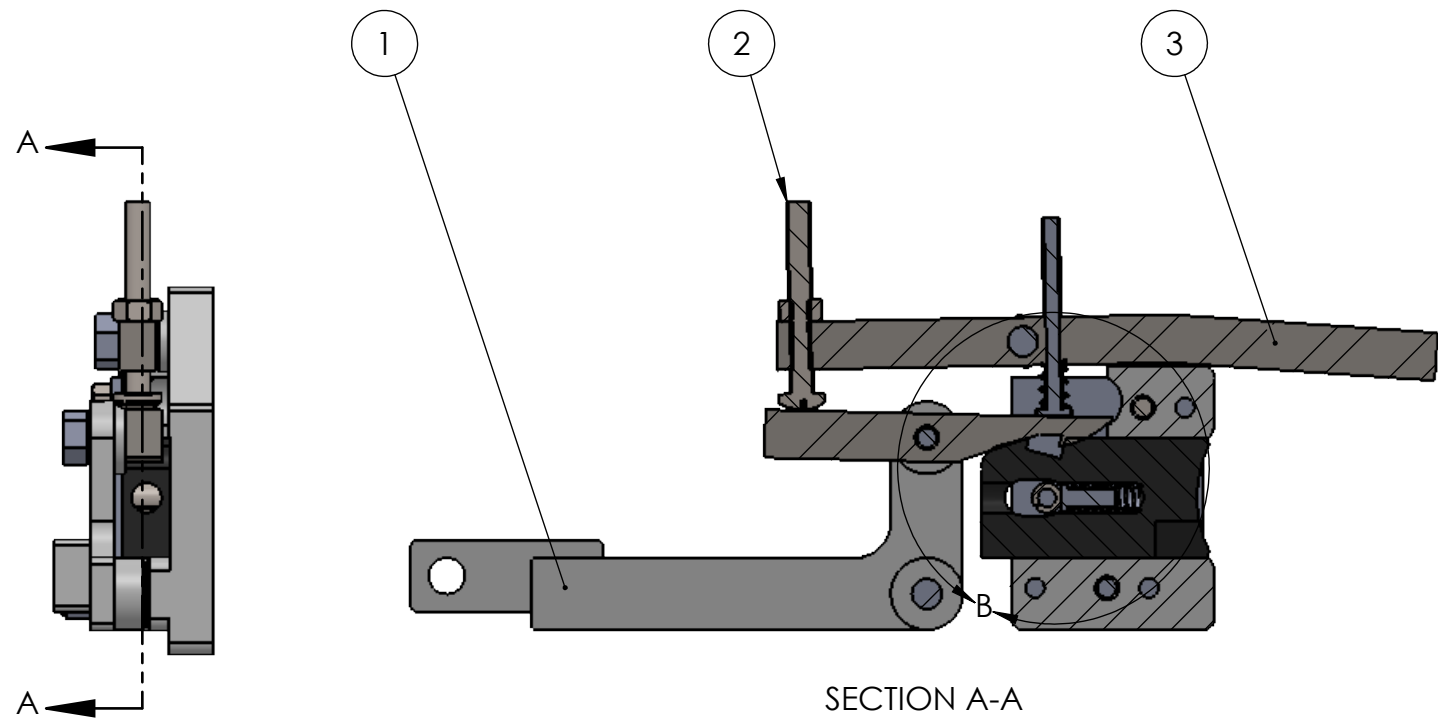
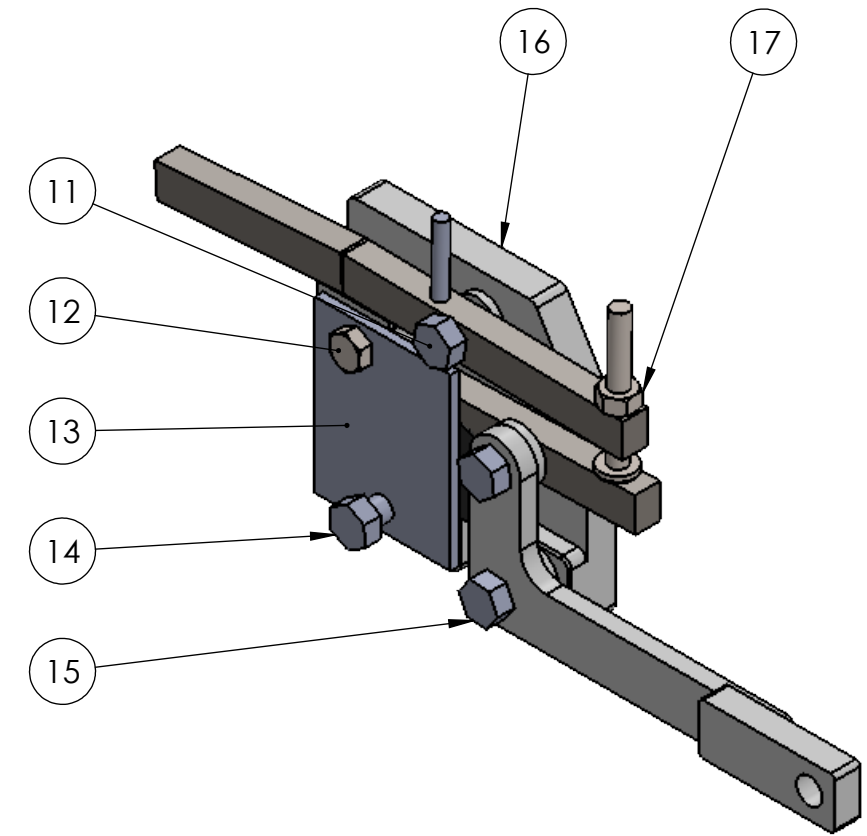


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DESCRIPTION	
4T FLYWHEEL ASSEMBLY	
MODEL NO	
4-041AS	
DRAWN BY	SCALE
JOEY TRUDEAU	1:4
DRAWING #	REV
COMMENTS :	

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ITEM NO.	PART NO	DESCRIPTION	QTY.
1	4-055.1	LATCH HOOK LEVER, LONG	1
2	4-098	PAN HEAD SCREW 1/4-20 UNC, 2 LG.	1
3	4-047	CLUTCH RELEASE LEVER	1
4	4-045	CLUTCH DISENGAGING LATCH	1
5	4-046	DISENGAGING LATCH HOOK	1
6	MCM_98296A939	SLOTTED SPRING PIN, Ø 5/16 X 15/16 LG.	1
7	4-048	SPRING PIN, RELEASE LEVER	1
8	4-106	HOOK SPRING, Ø 0.3 X 0.5 LG.	1
9	4-104.1	PUSHER, LATCH SPRING	1
10	4-104	DISENGAGING LATCH SPRING, Ø 0.3 X 1 LG.	1
11	4-074	SHOUDLER SCREW, CLUTCH LINKAGE	2
12	MCM_92620A537	HEX HEAD SCREW, 1/4-20 UNC, 1/2 LG.	1
13	4-050	CLUTCH BRACKET COVER	1
14	4-073	SHOUDLER SCREW, CLUTCH BRACKET	1
15	4-076	SHOUDLER SCREW, LINKAGE PIVOT	1
16	4-049	CLUTCH BRACKET	1
17	MCM_94895A029	HEX BOLT, 1/4-20 UNC	1

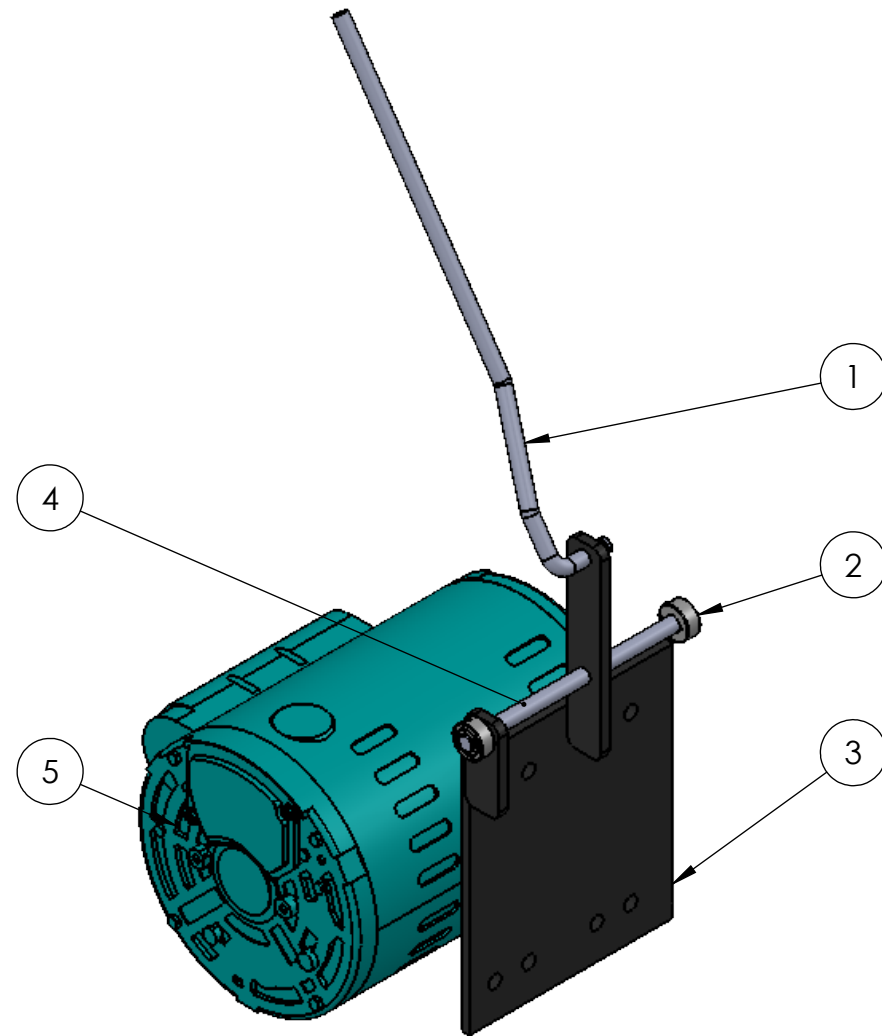


DESCRIPTION	
4T MECHANICAL CLUTCH ASSEMBLY	
MODEL NO	
4-049.1AS	
DRAWN BY	SCALE
JOEY TRUDEAU	1:2
DRAWING #	REV
COMMENTS :	
PROPRIETARY AND CONFIDENTIAL	
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ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	4-070	MOTOR BRACKET ADJUSTMENT ROD	1
2	4-053	3/8 SHAFT COLLAR	2
3	4-069	MOTOR BRACKET	1
4	4-071	SHAFT, MOTOR BRACKET	1
5	4-126	MOTOR 1/3 HP, 1800RPM-110V	1

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED

NOT INCLUDED IN THIS ASSEMBLY		
PART NO.	DESCRIPTION	QTY.
4-123	MOTOR PULLEY	1
4-124	MOTOR V-BELT	1



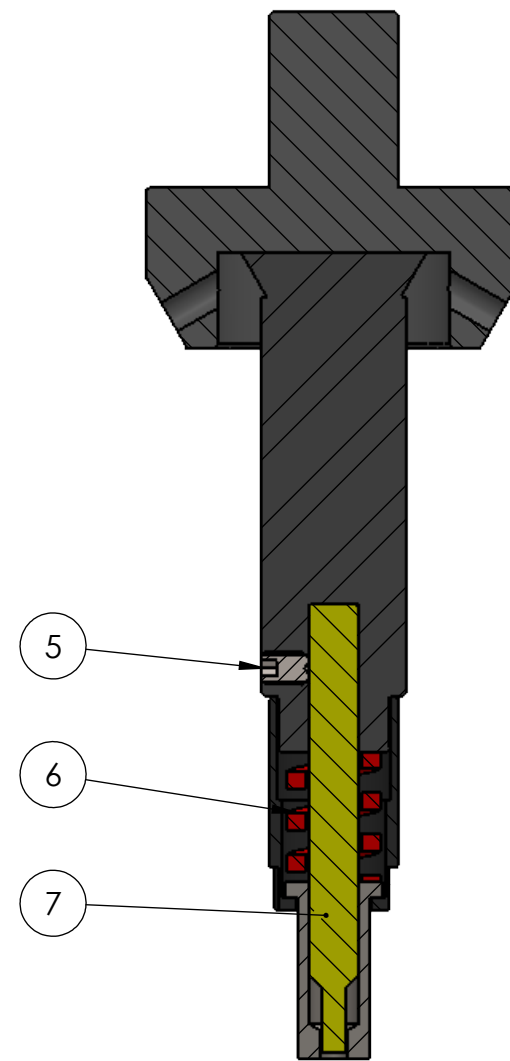
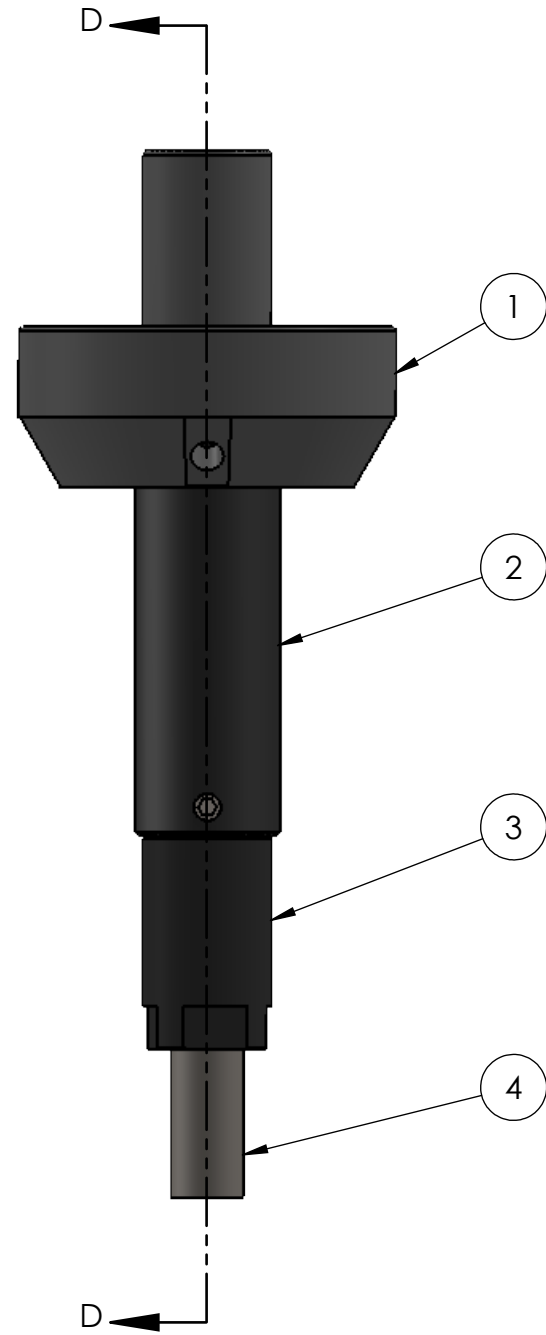

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DESCRIPTION	
MOTOR ASSEMBLY	
MODEL NO	
4-069AS	
DRAWN BY	SCALE
JOEY TRUDEAU	1:2
DRAWING #	REV
COMMENTS :	

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ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	4-301	TOOLING ADAPTER	1
2	4-302.1	SHANK 1-1/2".	1
3	6-310.1	SPRING HOLDER	1
4	6-305.1	CROWN STRIPPER, Ø 3/4	1
5	4000-007	SHSS, 1/4-28 x 3/8" LG.	1
6	22068	SPRING 3/4" X 3/8" X 1", GOLD (T)	1
7	20618	CLINCHING PUNCH, 3.5" LG.	1

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED



SECTION D-D



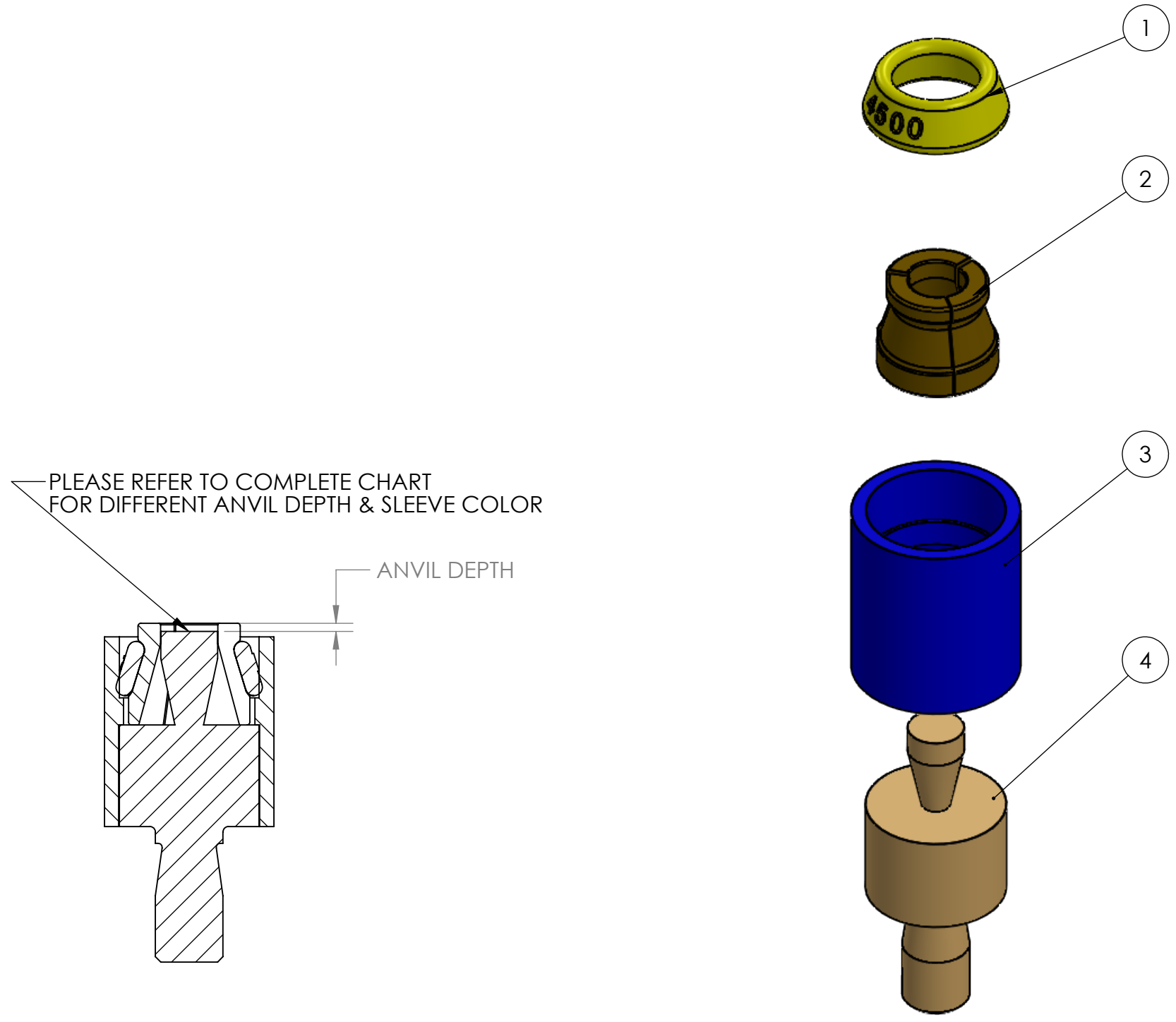
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DESCRIPTION	
NARROW PUNCH HOLDER	
MODEL NO	
4-302.1AS	
DRAWN BY	SCALE
JOEY TRUDEAU	2:3
DRAWING #	REV

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 :

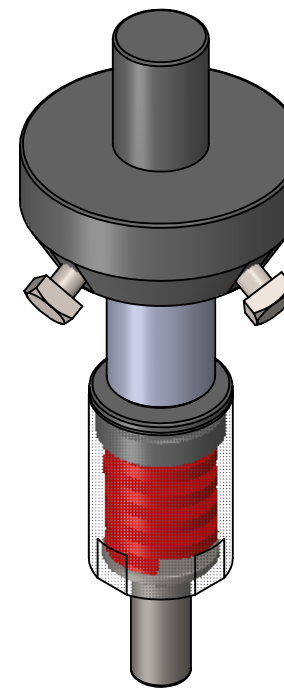
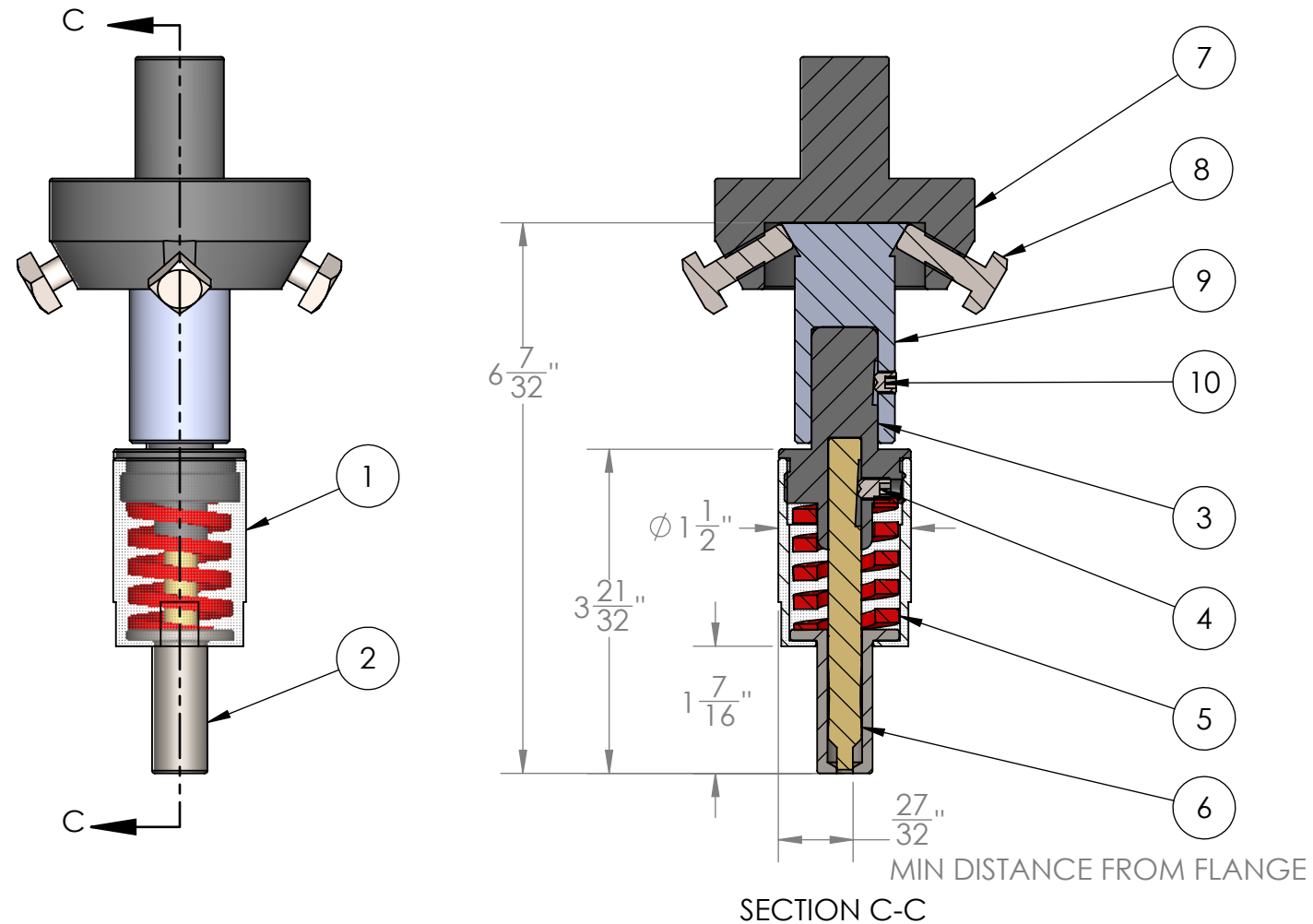
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FOR ROUND TOOLING (GALVANIZED, ALUMINUM, MILD STEEL, PRE-PAINTED)

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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