



1



3



5



7



2



4



6



8

PARTS LIST

ITEM NUMBER	QUANTITY	PART NUMBER	DESCRIPTION
1	1	090550	12 VOLT AC/DC WALL ADAPTER
2	1	090551	DC BARREL SWITCH
3	2	090540	6 LED BULB STRIP (4 IN.)
4	1	090505	2-WAY SPLITTER
5	1	158203	3/16 X 5/8 X 3/16 GROMMET
6	3 IN.	013167	3M VELCRO
7	10 IN.	090530	HEAT SHRINK TUBING
8	2	660505	BLACK NYLON CABLE TIE

BASIC CONSIDERATIONS

- Intended for all machines, past and present.
- Please read the instructions **FULLY** before attempting to install the product.
- Make sure to unplug the machine from it's electrical source and perform any necessary lockout/tagout procedures.
- **NOTE:** The 3M VHB Tape is a pressure activated adhesive. If **LIGHTLY APPLIED** to a surface, it may be possible to pull off and reapply. If **FIRMLY ATTACHED**, it will be near impossible to move.
- The strips are regarded as a one – time application product. Therefore, care must be taken when applying the strips.
- In the event of a strip that has fallen off or been pulled off, it may be possible to reapply either the whole strip or a portion with the application of cyanoacrylate adhesives (i.e. Super Glue).
- It is **NOT** a guarantee that a cyanoacrylate product will work, but depending on surface preparation and adhesion on the strip, there is a chance that it may.

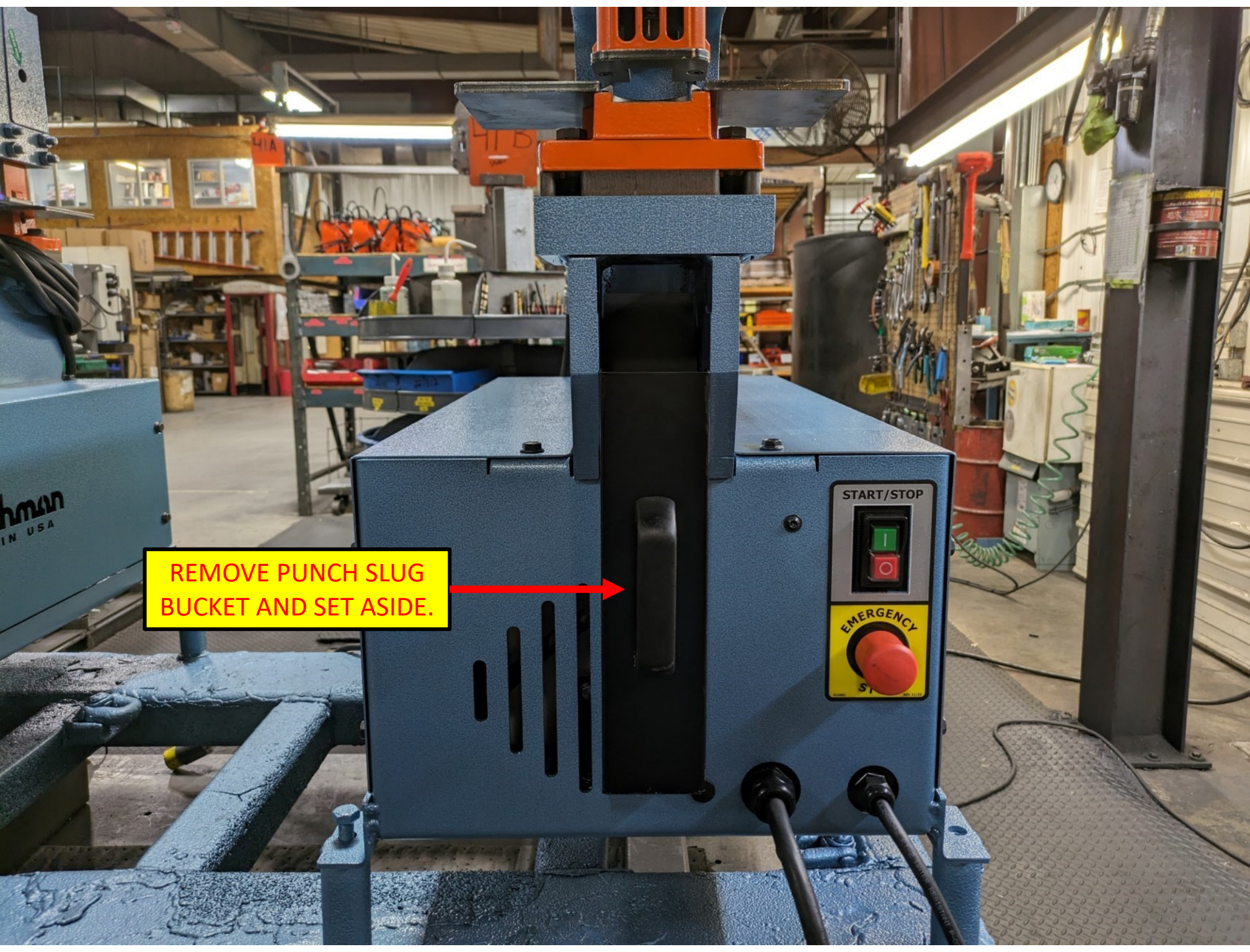
SURFACE PREPARATION

- Scotchman Industries' machines ship with an oil – based rust preventative coating on exposed, unpainted surfaces. Due to application, certain areas where the LED strips will be installed may be coated with protectant.
- To prep the surface for the LED strips, it is recommended to use a 50:50 mixture of isopropyl alcohol (IPA) and water to clean the surface.
- For areas with heavy oil, grease, oxidation, or dust, a degreaser and/or abrasion may be necessary before the alcohol mixture to prep the surface.
- Click this [link](#) for an in – depth article about surface preparation for 3M™ VHB™ Tape Applications.
- You can also use this QR Code:



- Back to Punch ([Page 13](#))

REMOVE PUNCH SLUG
BUCKET AND SET ASIDE.



A blue industrial machine, possibly a punch press, is shown in a workshop setting. The machine has a blue painted metal body with a perforated front panel. On the right side of the front panel, there is a control panel with a green and red 'START/STOP' switch and a red 'EMERGENCY' stop button. A red arrow points from a yellow text box to a bolt on the front panel. The background shows a typical workshop with shelves, tools, and equipment.

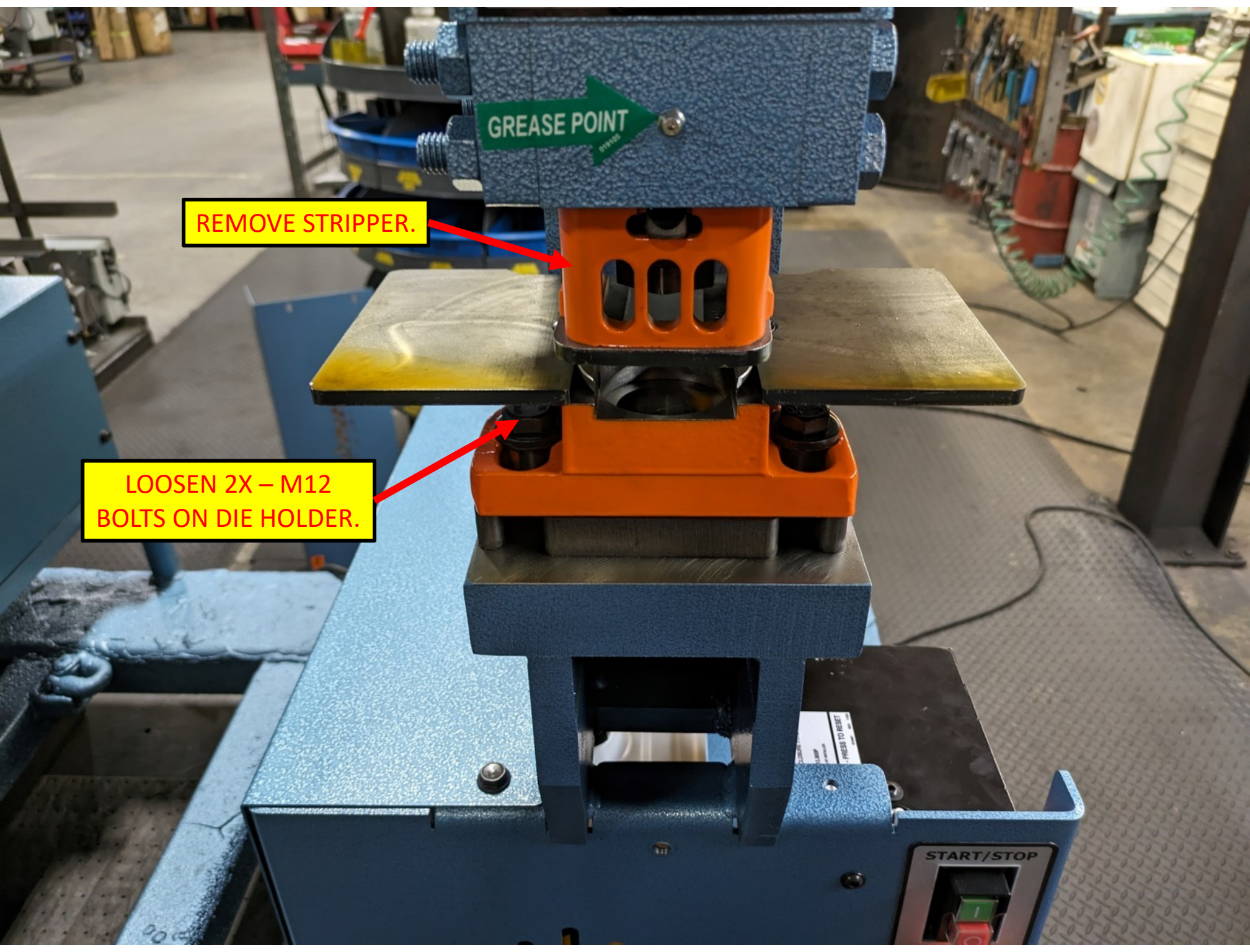
REMOVE 3X – M10 WASHERS AND
1X – M10 WHIZ LOCK BOLT. THEN
REMOVE PUNCH SLUG CHUTE.

GREASE POINT

REMOVE STRIPPER.

LOOSEN 2X – M12
BOLTS ON DIE HOLDER.

START/STOP



Ø38 THRU 10MM
PUNCH STROKE
1.0" - 25MM
THROAT DEPTH
4 1/4" - 108MM
#012372

FLAT SHEAR
BLADE LENGTH 6" - 150MM
1/2"X4" - 3/8"X6"
12X100MM - 10X150MM

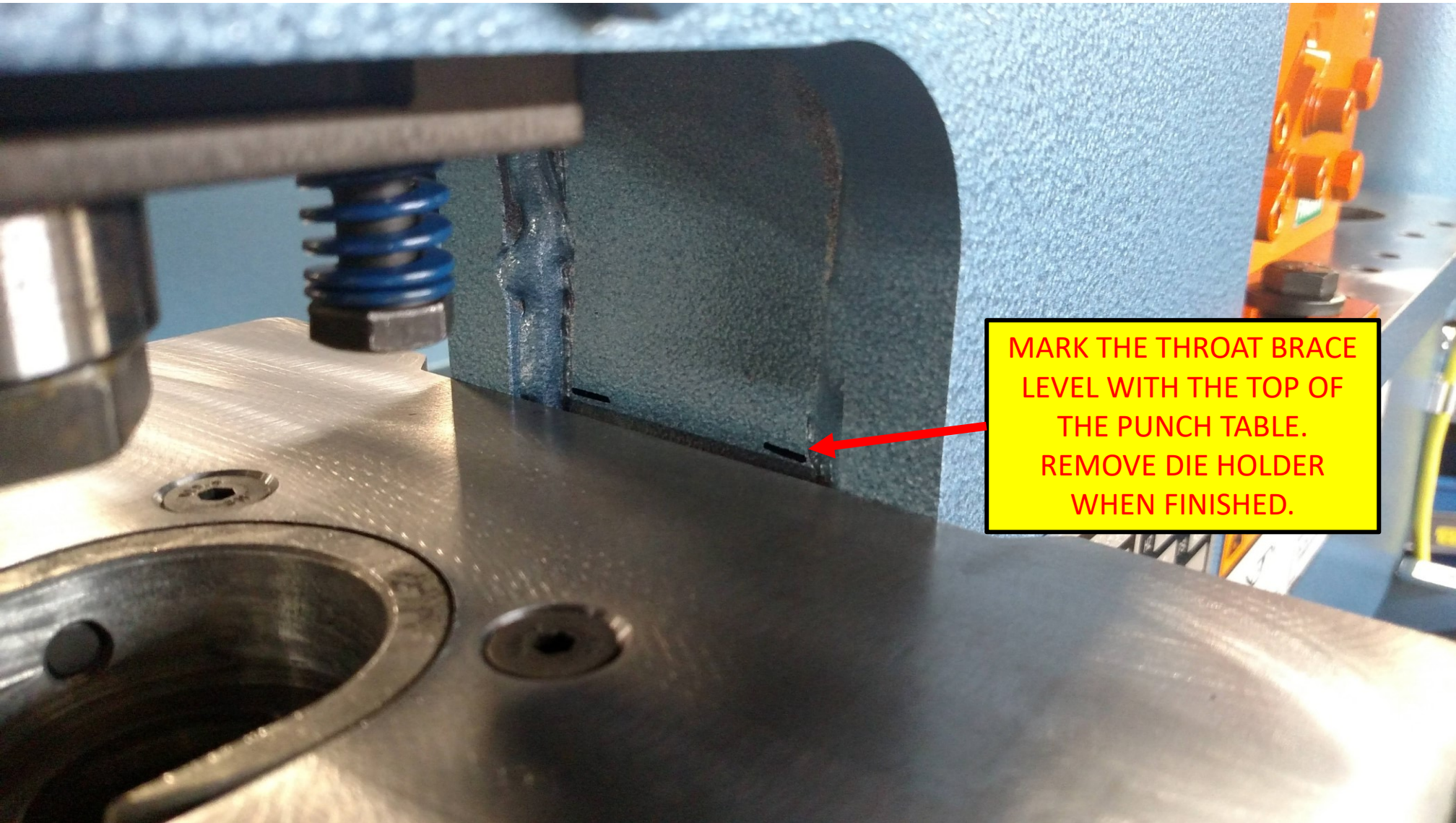
ROD SHEAR
Ø3/4" ROUND Ø18MM
5.03

**PUSH DIE HOLDER BACK,
WITH PUNCH TABLE
TOUCHING THE THROAT.**

PHILIP, SOUTH DAKOTA, U.S.A.
PH. 605-859-2542
MADE IN U.S.A.

H.P. VOLT
HZ FLA
PH PSI
BLADE LENGTH

WARNING
SAFETY GLASSES REQUIRED WHEN
OPERATING OR OBSERVING THIS MACHINE



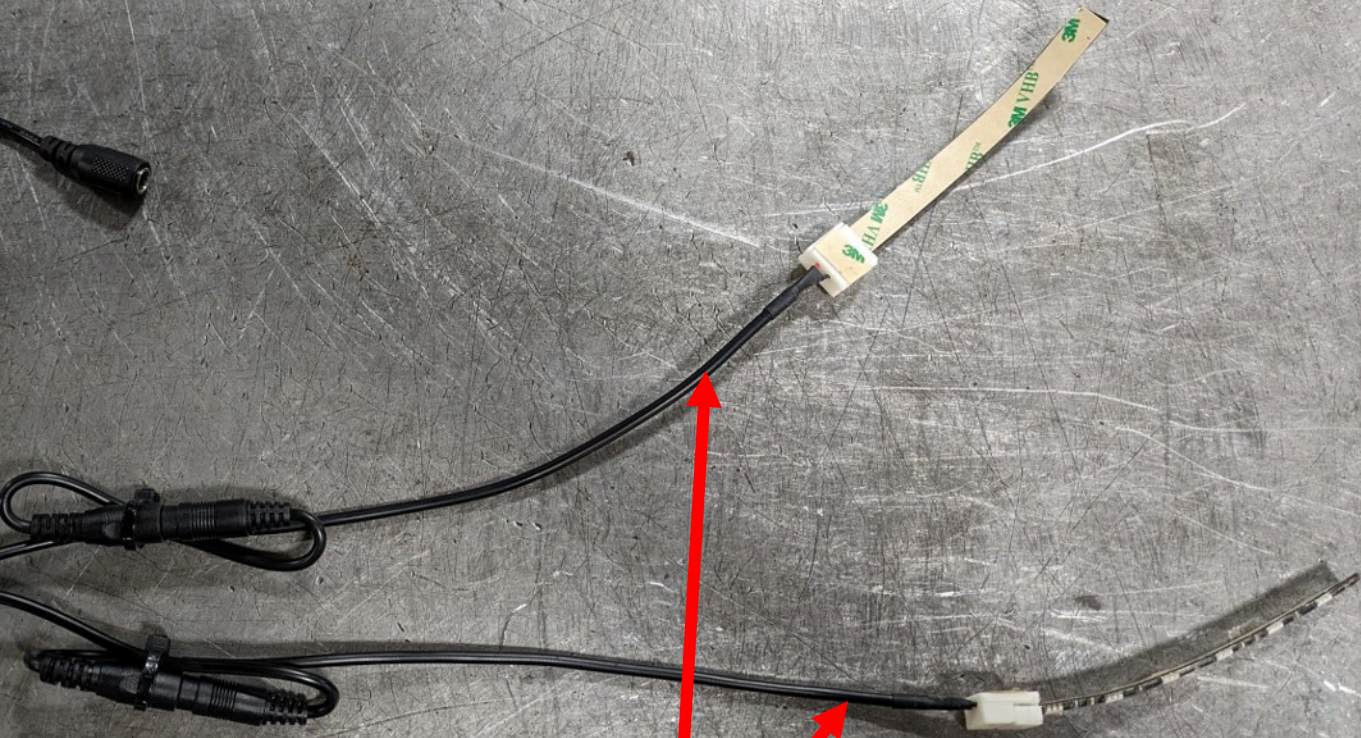
MARK THE THROAT BRACE
LEVEL WITH THE TOP OF
THE PUNCH TABLE.
REMOVE DIE HOLDER
WHEN FINISHED.

ZIP TIE ALL CONNECTIONS

P/N 090505 – 2-WAY SPLITTER



P/N 090540 – 6 LED BULB STRIP (4 IN.)



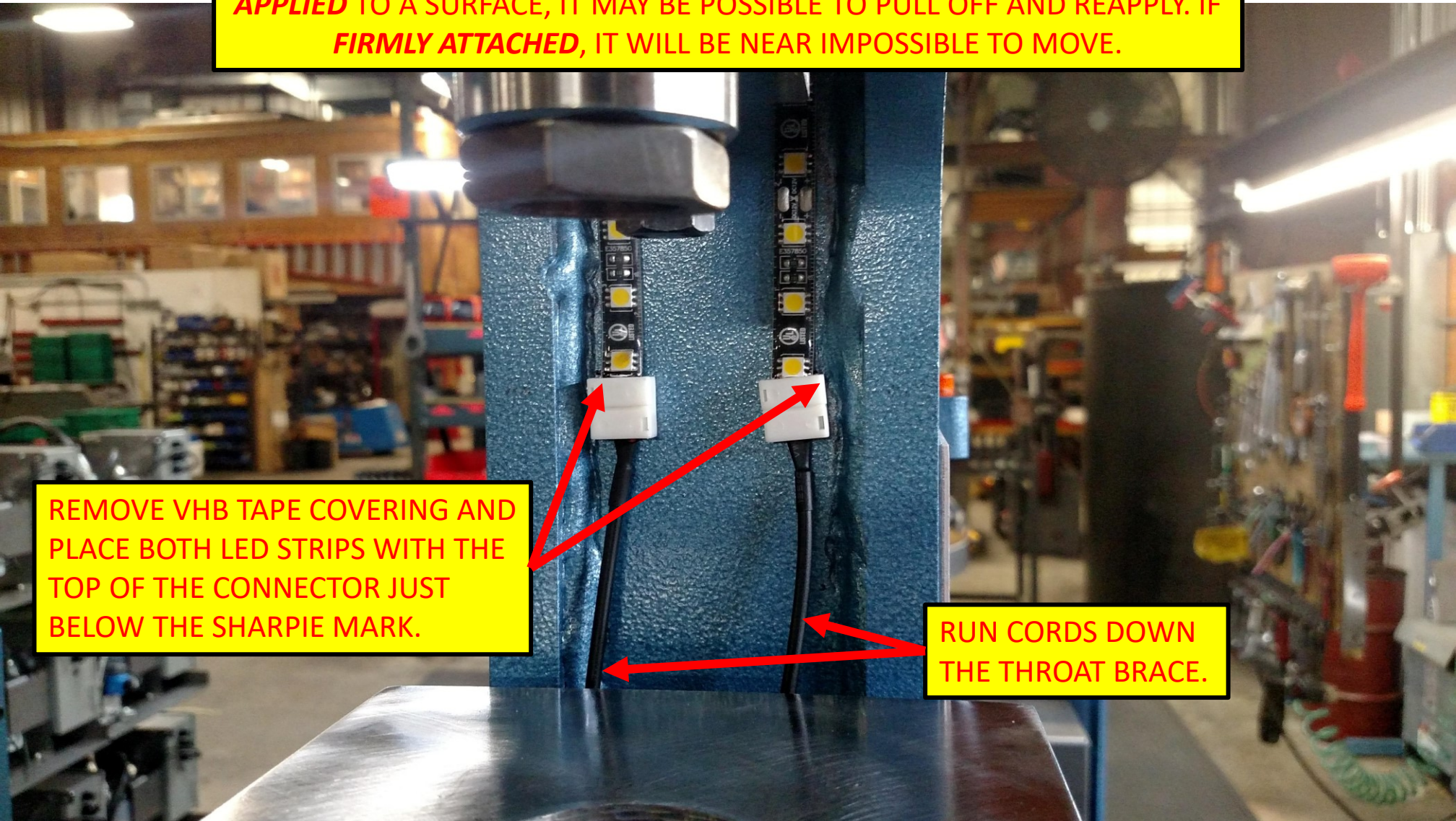


NOTE: BEFORE APPLYING THE LED STRIP, IT IS VERY IMPORTANT TO CLEAN THE SURFACE AS DETAILED [HERE](#).

NOTE: THE 3M VHB TAPE IS A PRESSURE ACTIVATED ADHESIVE. IF *LIGHTLY APPLIED* TO A SURFACE, IT MAY BE POSSIBLE TO PULL OFF AND REAPPLY. IF *FIRMLY ATTACHED*, IT WILL BE NEAR IMPOSSIBLE TO MOVE.

REMOVE VHB TAPE COVERING AND PLACE BOTH LED STRIPS WITH THE TOP OF THE CONNECTOR JUST BELOW THE SHARPIE MARK.

RUN CORDS DOWN THE THROAT BRACE.





MAKE SURE CONNECTIONS
STAY TIGHT AS YOU FEED.

RUN 2-WAY SPLITTER CORD
STRAIGHT DOWN BETWEEN
FRAMES INTO THE BASE.



LET 2-WAY SPLITTER CORD
HANG FREE UNTIL OTHER
STEPS ARE FINISHED.



CUT THE VELCRO IN
HALF AND SANDWICH
TOGETHER.



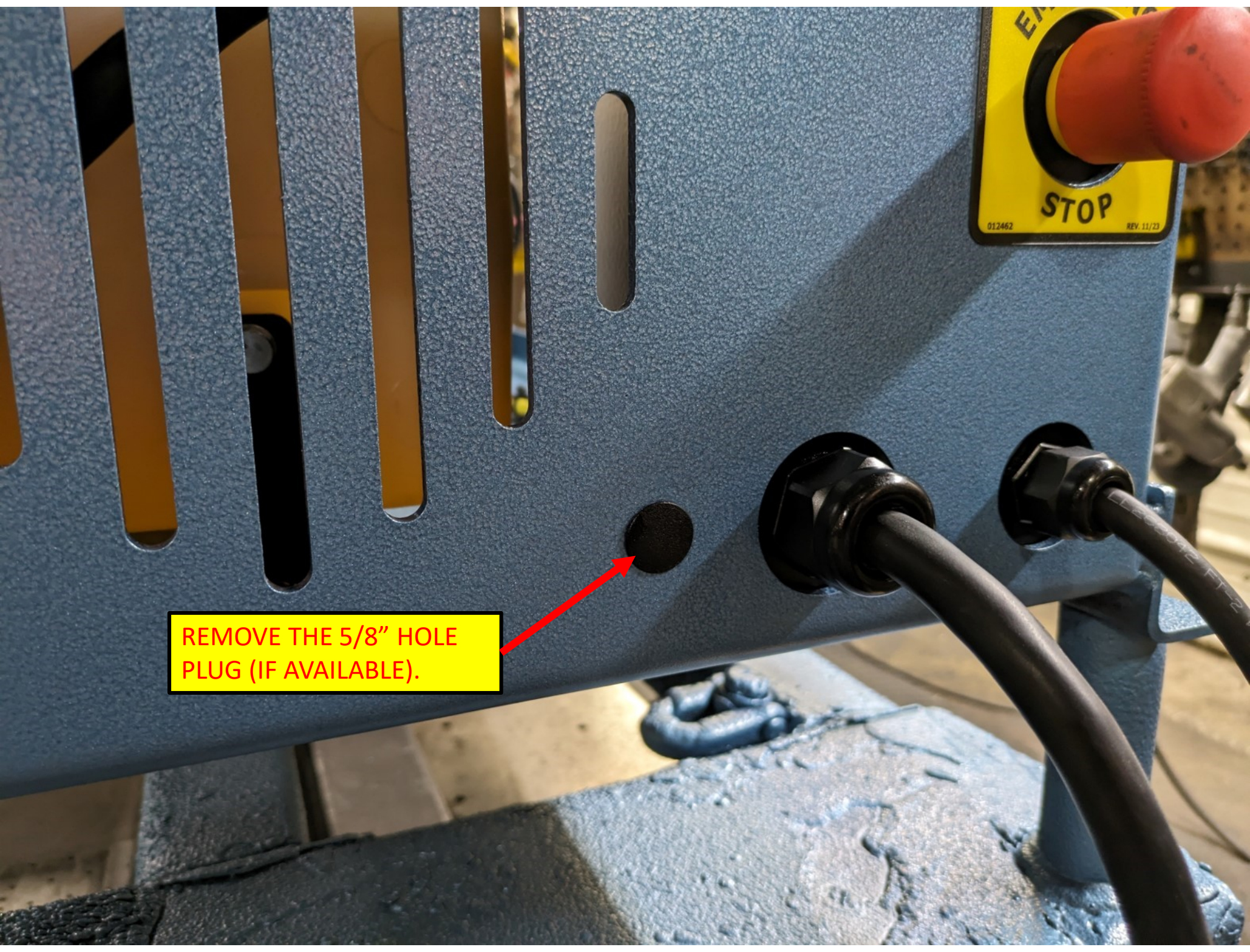
ADHERE ONE SIDE OF
THE VELCRO TO THE
POWER SWITCH.



MAKE A SLICE IN THE
GROMMET AS SHOWN.

SLIDE THE GROMMET
ONTO THE MALE CORD
OF THE POWER SWITCH.





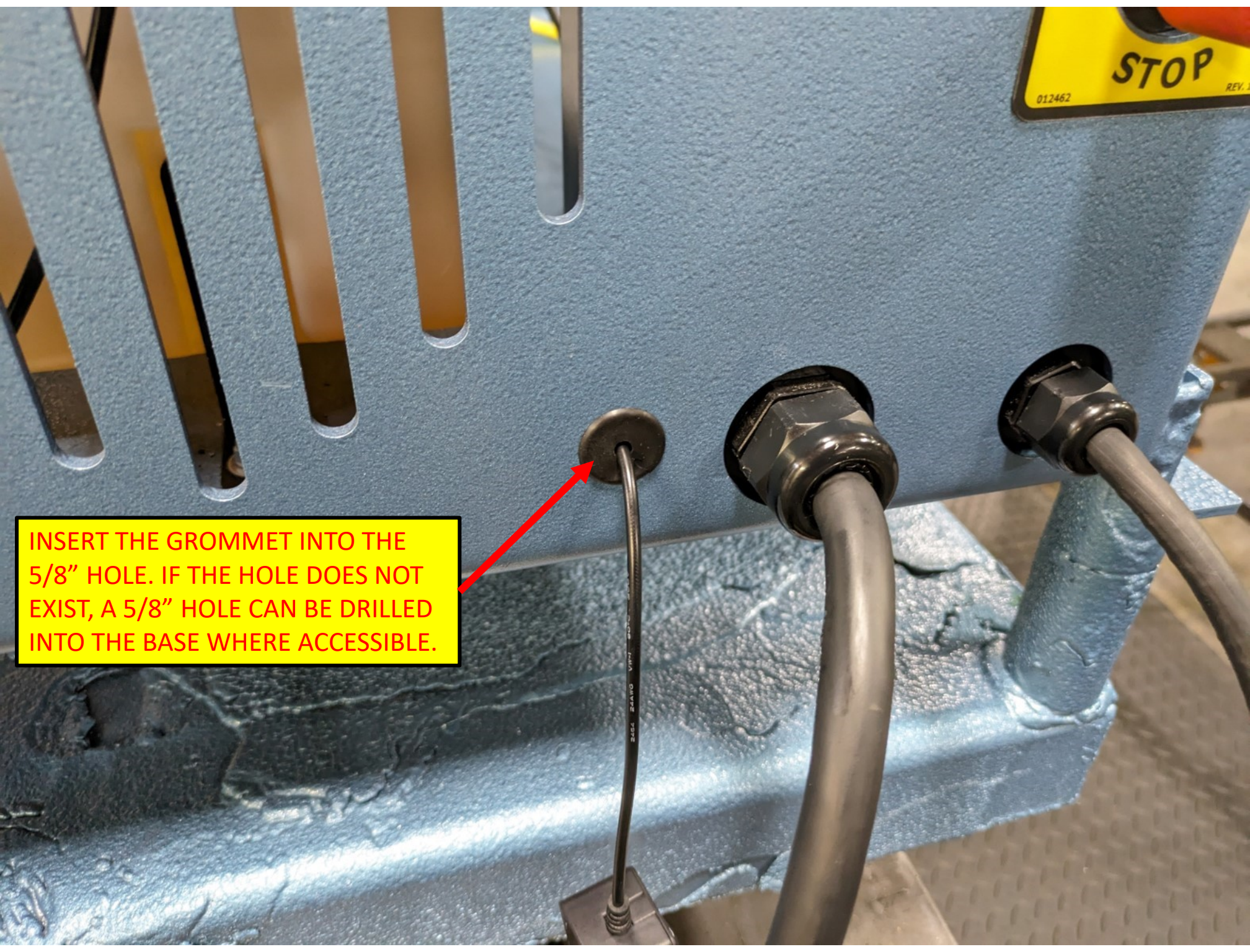
REMOVE THE 5/8" HOLE
PLUG (IF AVAILABLE).

STOP

012462

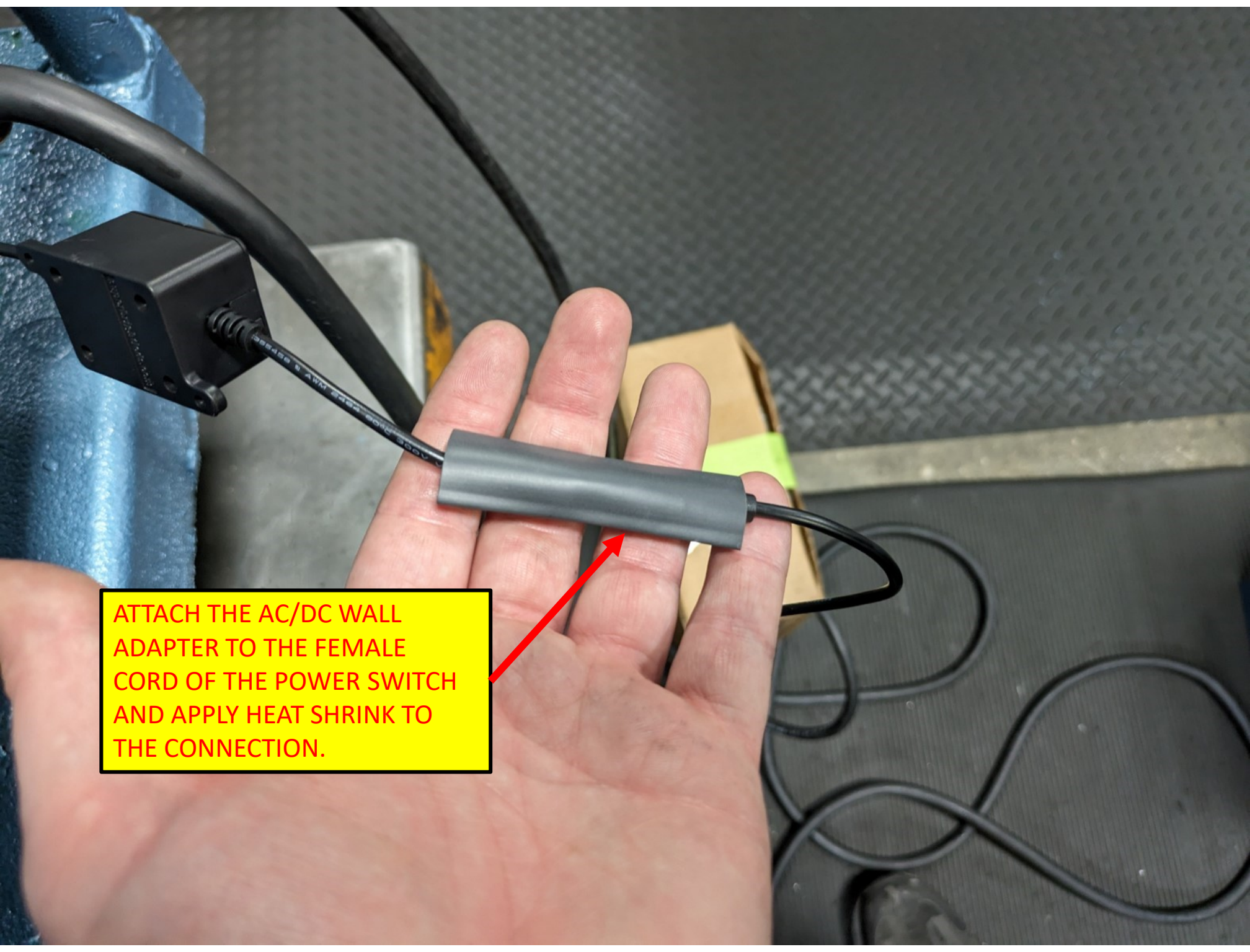
REV. 1

INSERT THE GROMMET INTO THE 5/8" HOLE. IF THE HOLE DOES NOT EXIST, A 5/8" HOLE CAN BE DRILLED INTO THE BASE WHERE ACCESSIBLE.





ATTACH THE POWER SWITCH MALE CORD END TO THE 2-WAY SPLITTER FEMALE END. APPLY HEAT SHRINK TO THE CONNECTION.



ATTACH THE AC/DC WALL ADAPTER TO THE FEMALE CORD OF THE POWER SWITCH AND APPLY HEAT SHRINK TO THE CONNECTION.

FIND A SUITABLE LOCATION ON THE BASE OF THE MACHINE AND APPLY THE VELCRO OF THE POWER SWITCH.

START/STOP



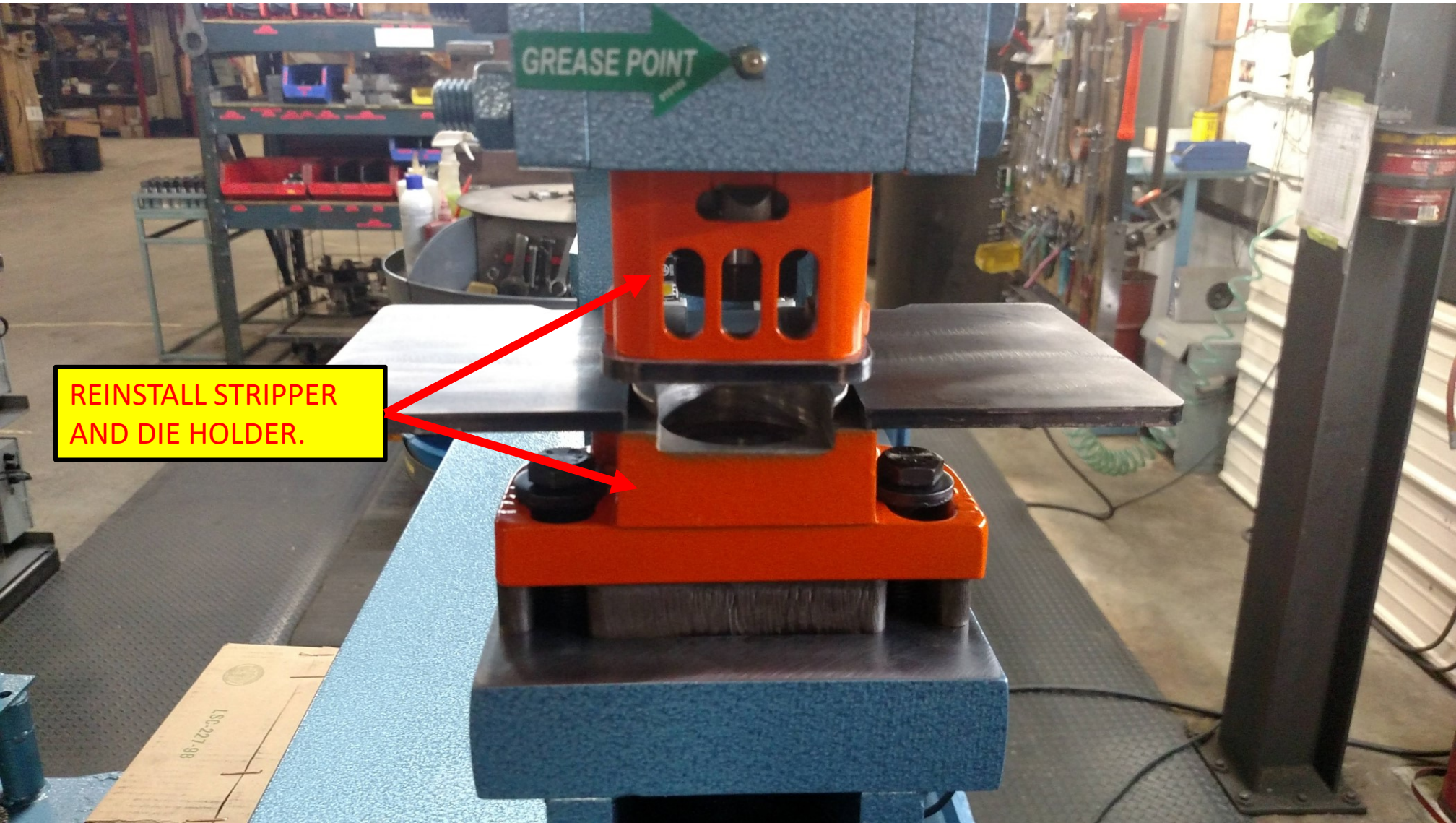
EMERGENCY
STOP

012462



GREASE POINT

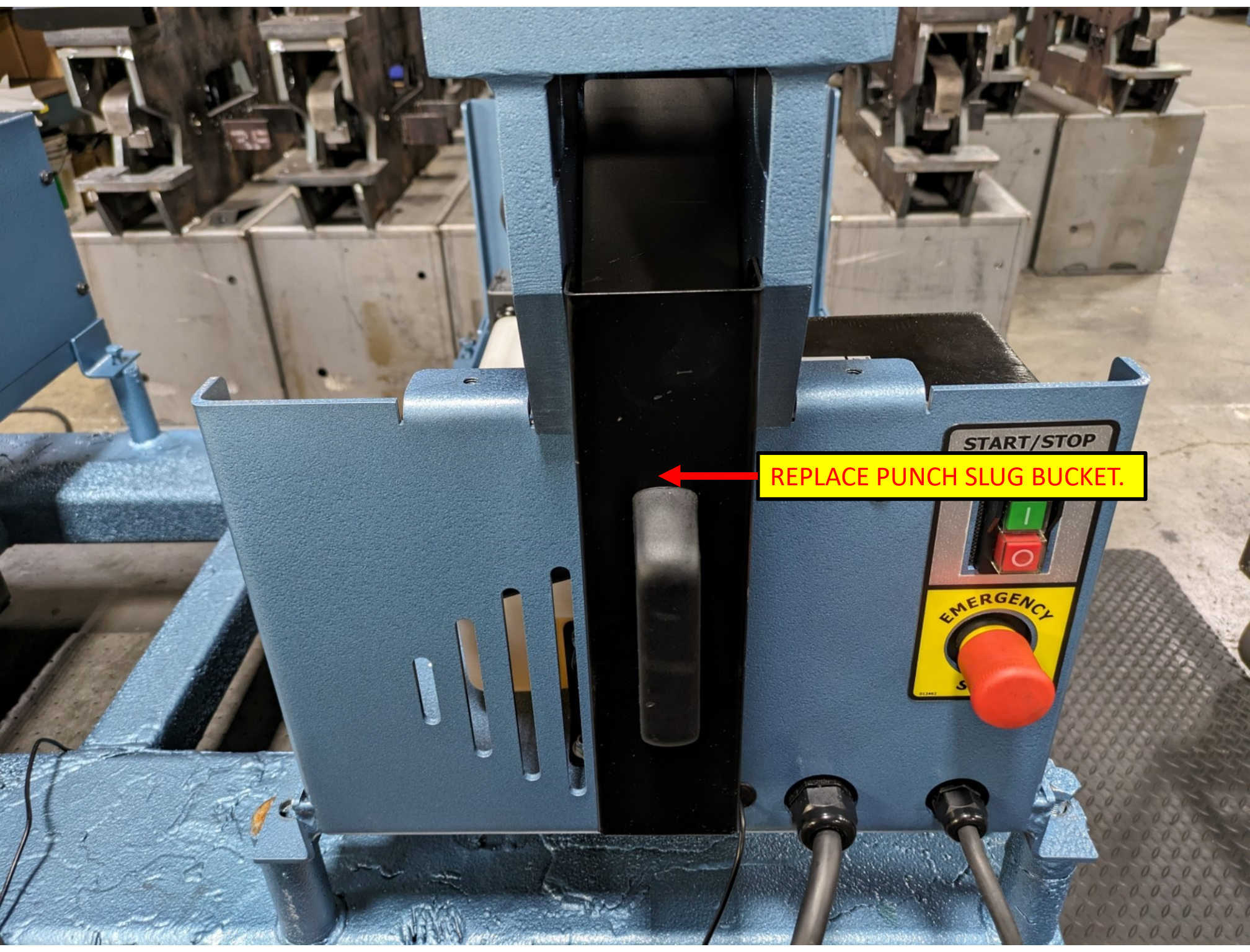
REINSTALL STRIPPER
AND DIE HOLDER.



REPLACE PUNCH SLUG CHUTE,
3X – M10 WASHERS, AND 1X –
M10 WHIZ LOCK BOLT.

START/STOP

EMERGENCY



REPLACE PUNCH SLUG BUCKET.

START/STOP

EMERGENCY



Scotchman®



PORTA-FAB 45
MACHINE CAPACITIES

PLATE	ANGLE SHEAR
1/2" X 12"	1/2" X 12" X 120"
3/4" X 12"	3/4" X 12" X 120"
1" X 12"	1" X 12" X 120"
1 1/2" X 12"	1 1/2" X 12" X 120"
2" X 12"	2" X 12" X 120"
2 1/2" X 12"	2 1/2" X 12" X 120"
3" X 12"	3" X 12" X 120"
3 1/2" X 12"	3 1/2" X 12" X 120"
4" X 12"	4" X 12" X 120"
4 1/2" X 12"	4 1/2" X 12" X 120"
5" X 12"	5" X 12" X 120"
5 1/2" X 12"	5 1/2" X 12" X 120"
6" X 12"	6" X 12" X 120"
6 1/2" X 12"	6 1/2" X 12" X 120"
7" X 12"	7" X 12" X 120"
7 1/2" X 12"	7 1/2" X 12" X 120"
8" X 12"	8" X 12" X 120"
8 1/2" X 12"	8 1/2" X 12" X 120"
9" X 12"	9" X 12" X 120"
9 1/2" X 12"	9 1/2" X 12" X 120"
10" X 12"	10" X 12" X 120"
10 1/2" X 12"	10 1/2" X 12" X 120"
11" X 12"	11" X 12" X 120"
11 1/2" X 12"	11 1/2" X 12" X 120"
12" X 12"	12" X 12" X 120"



SCOTCHMAN INDUSTRIES, INC.
P.O. BOX 1000
SOUTH GASTON, S.C. 29088
PH: 803-681-5500

**REPLACE FRONT SHROUD
AND 6X – M8 WHIZ-LOCK
BOLTS.**

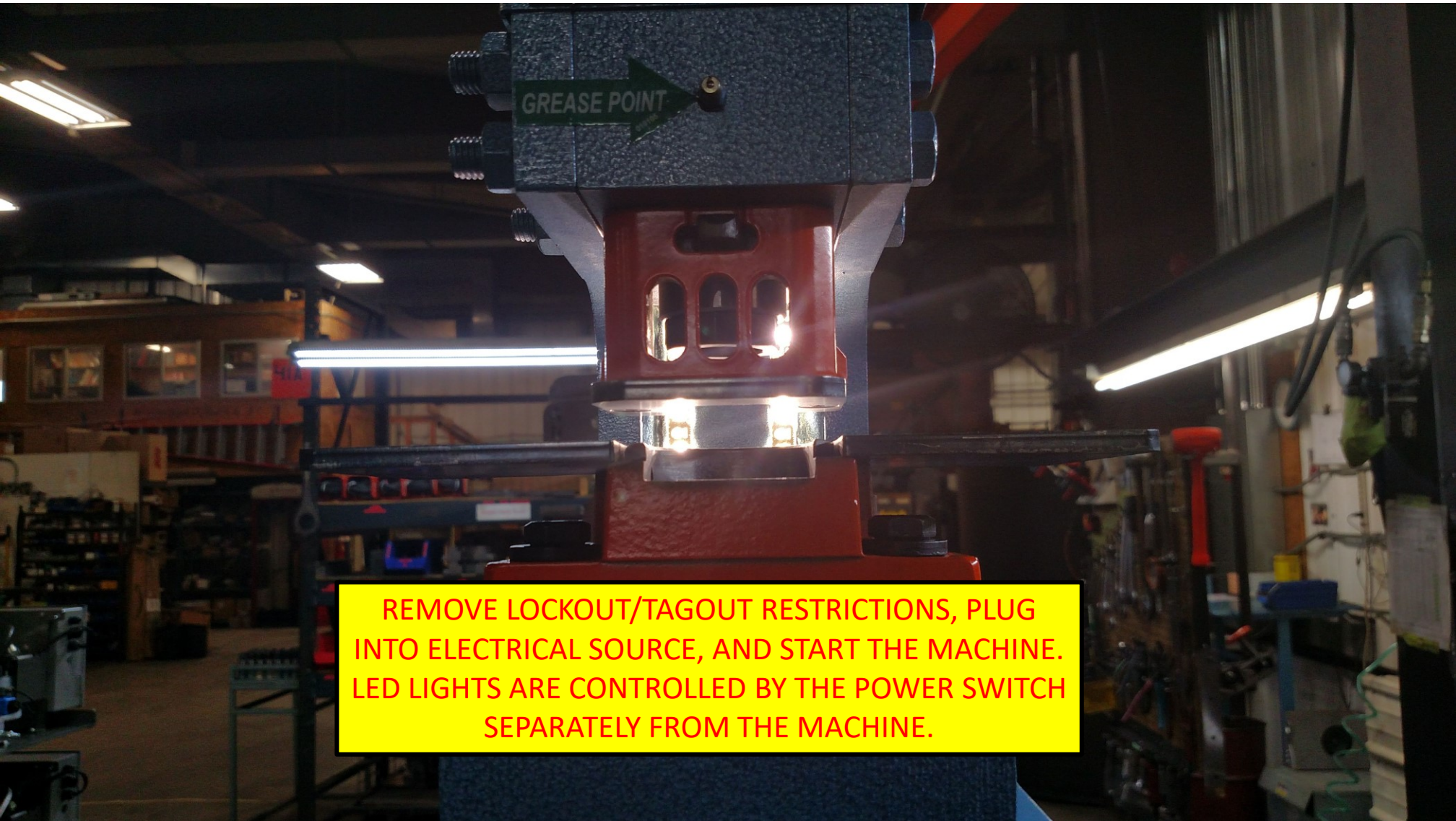
110 VOLTS

Scotchman
MADE IN USA



**CONNECT WALL ADAPTER
TO A (US) STANDARD 120
VAC POWER SOURCE.**





REMOVE LOCKOUT/TAGOUT RESTRICTIONS, PLUG INTO ELECTRICAL SOURCE, AND START THE MACHINE. LED LIGHTS ARE CONTROLLED BY THE POWER SWITCH SEPARATELY FROM THE MACHINE.