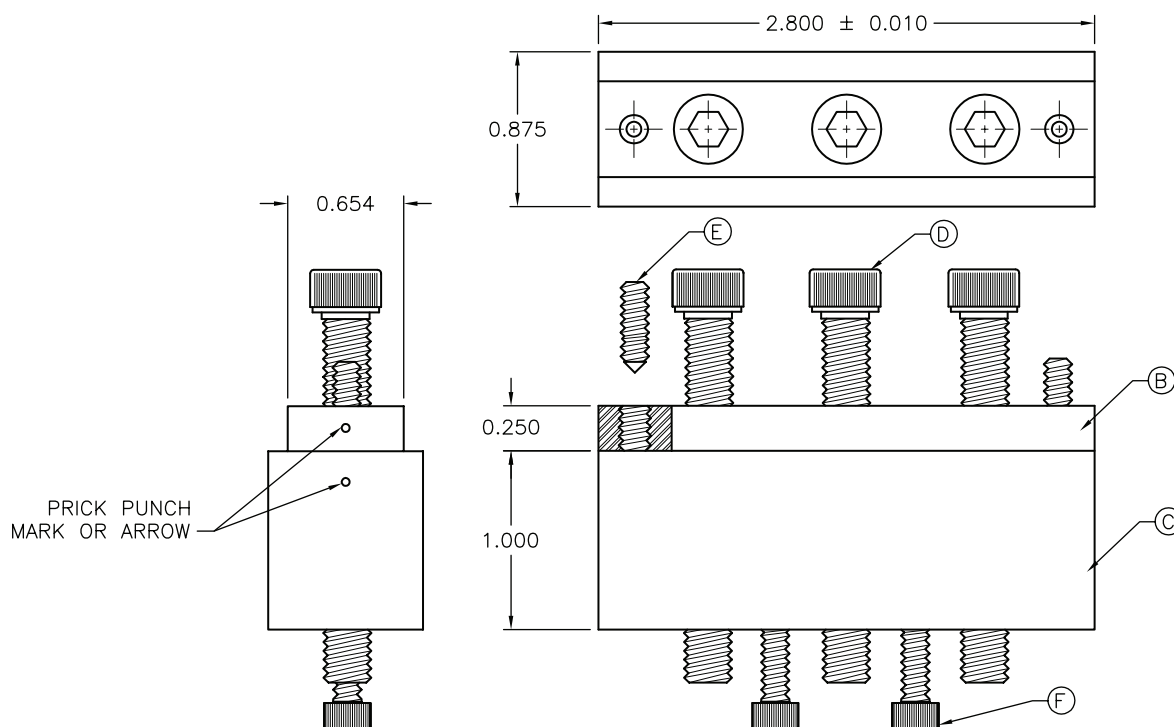




DSP-50P - For use with T&B Ansley, ITT Cannon and TRW Cinch plastic plugs and sockets as well as other plastic and metal sockets. The punch/die unit itself is machined of D-2 tool steel, hardened, and cutting edges are ground. Punch and die are drawn together by 3 bolts which are tightened in a predetermined sequence. Adhesive templates which are provided with the kit locate these three bolt holes. Before the hole is completely cut, two hard point screws are tightened to both mark and prick punch the receptacle mounting screw holes. After the operation is completed, the slug is ejected from the die by use of two cap screws. All fasteners are socket headed and allen wrenches are provided. Punches are designed for recommended thicknesses from 22 gauge to 16 gauge steel and aluminum panels.

### Dimension and Specifications (Punch, Die and Screws)



Item	Qty	Description
B	1	Punch
C	1	Die
D	3	Draw Screw; Socket Head Screw (M6 × 50mm)
E	2	Socket Set Screw, Cone Point #8-32 UNC × 0.50lg.
F	2	Socket Head Cap Screw. #8-32 UNC × 1lg.

**Notes:**

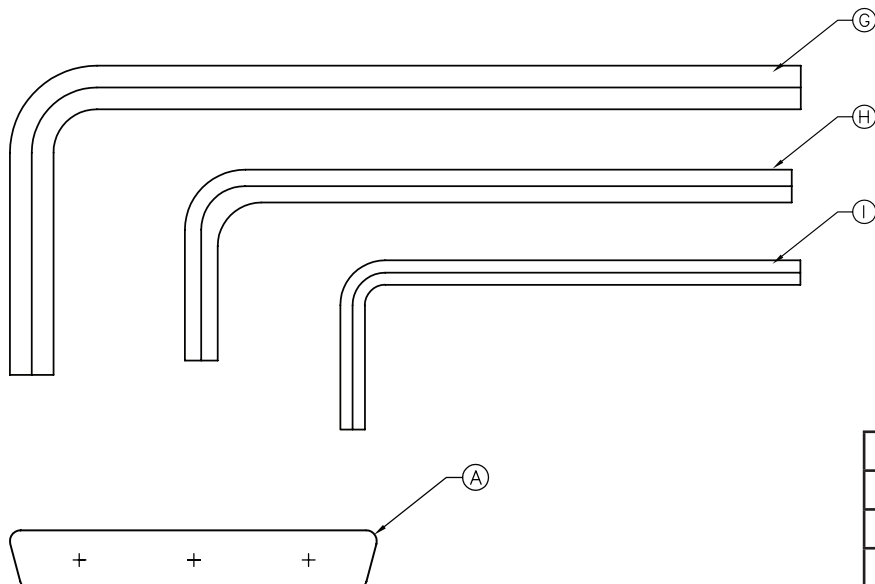
- Material: D-2 Tool Steel
- Heat-Treat: Normalized
- Finish: Black Oxide
- All Screws are Mill Run Grade 5 Steel or Less

# D-Sub Punch

## 50 Connector Pins



### Dimension and Specifications (Hex Keys and Template)

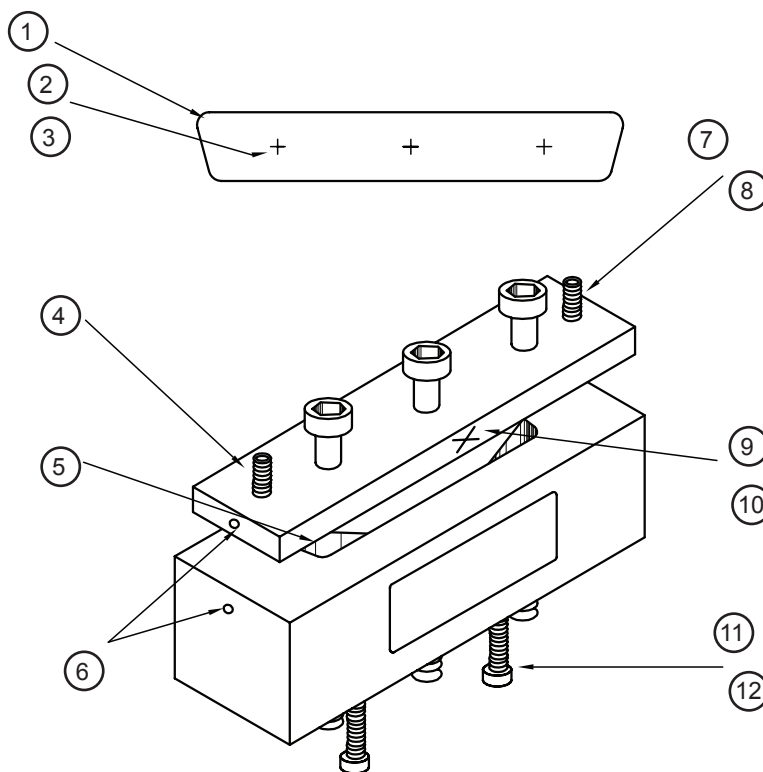


#### Notes:

- Material: Cold Rolled Steel
- Finish: Black Oxide

Item	Qty	Description
A	25	Adhesive-Backed Template
G	1	Hex Key, Short Arm (5mm)
H	1	Hex Key, (9/64)
I	1	Hex Key, (5/64)

### Instructions



# D-Sub Punch

## 50 Connector Pins



- (1) **Mount** the adhesive backed template at the location you wish to make a connector installation. CAUTION: be sure there will be sufficient clearance to use both punch & die at this spot. Surface must be clean & dry so the template will adhere.
- (2) **Center Punch** and drill three 1/4 inch holes at the points marked "+" on the template. It is wise to remove the template before the actual drilling.
- (3) **Clean and Lubricate** the area to be punched. Any oil (or even vegetable shortening) will allow the punch to work easier.
- (4) **Thread** the 2 hard point screws into their holes so the points do not project beyond the face of the punch flange. If they project beyond the flange face excessive load will cause the punch to break
- (5) **Note** the template has tapered ends; so do the punch and die. When the punch & die are installed to make the hole they must be aligned properly with each other.
- (6) **INSERT** these three Draw Screws into their holes on the punch, through the 3 holes you drilled in the panel and thread them into their tapped holes in the die. You will note there is a punch mark on the end of the punch; there is a corresponding mark on the end of the die. These marks must both be on the same and, as shown in the sketch. If you install the Punch/ Die wrong, the die will break and the punch will be distorted. There is no warranty against breakage or distortion due to such misuse.
- (7) **After** properly aligning punch to die and snugging the 3 draw screws hand light, use the large hex key to tighten the draw screws, alternately if necessary, and thus cut the hole. Most times the entire hole can be made by use of the center draw screw only and the screws on either side are used to correct any tilting of the punch as related to the die.
- (8) **After** the hole is punched and before the 3 draw screws are loosened the two hard point set screws are tightened sufficiently to mark the locations of the mounting holes for the connector. (After removal of the punch unit you can then center punch and drill the holes at these locations.) Then, Back these 2 Screws Clear (as per paragraph (4)).
- (9) **Remove** the 3 Draw screws and die.
- (10) **Remove** the punch from the panel. By gripping the punch with vise grip pliers in the center of the flange and applying slight up-and-down motion the punch should release. Do not pry the punch out with a screwdriver.
- (11) **By** threading the 2 ejector screws into the die the slug is readily removed.
- (11) **Store** the tool after applying a light oil coating.

### Part Number Table

Description	Part Number
D-Sub Punch, 50 Connector Pins	DSP-50P

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