

## IRONWORKER MODEL NUMBER P65

For Serial Numbers P65-3001 to Current Models  
Call us: 800-338-5471

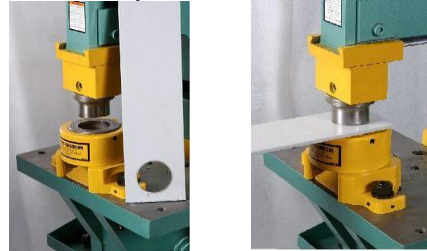
Publication Date: May 3, 2022

## Piranha Optional Tooling and Attachments

Enhance your Ironworker's Versatility

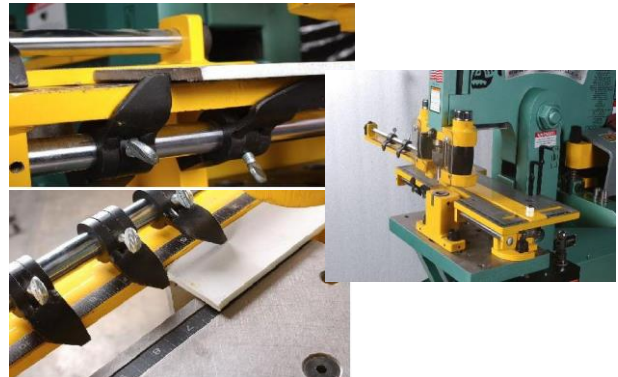
### Oversize Punch Attachments

- Expand punching capacity up to 5"



### Quickset Gauging Table

- Allows you to quickly set-up your punch end for multiple holes.
- Includes an angle gauge bar to index off the heel of your angle and a plate gauge bar, which indexes off the end of your plate.
- Extensions are available in left- and right-hand styles in 5' and 10' lengths.



### Backgauge

- Allows you to quickly set-up your machine to repeat your shearing length by adding a mechanical backstop.
- Backstop can be positioned in either the angle, flat bar, or round bar section of the machine.
- Available in lengths of 3', 6', 9', or 12'.
- An electronic version is also available, which cycles the machine automatically when material makes contact with the backgauge probe.



### Pipe Notching Attachment

- Allows you to single notch Schedule 40 Pipe.
- A must have for handrail jobs.
- Attaches to the punch end of the machine.
- Notching dies available for 3/4", 1", 1-1/4", 1-1/2", and 2" Schedule 40 Pipe.



### Oversize Bending Attachments

- Expand your bending capacity to 24" on most models.
- Includes a 4-way die block for different thicknesses of material.



\*\*\*Additional Options Shown on Inside of Back Cover\*\*\*



## **Ironworker Manual Model P65**

Be sure to register your model and serial number to receive Piranha Service and Product Updates.

### **Support**

Please have the serial number or model ready when calling.

For technical support:

Via Phone: 815.490.0473

Via Email: [service@piranhafab.com](mailto:service@piranhafab.com)

For ordering parts and consumables:

Via Phone: 800.338.5471

Via Email: [tooling@piranhafab.com](mailto:tooling@piranhafab.com)

Piranha  
650 Race St. • P.O. Box 1206  
Rockford IL 61105, USA  
[www.piranhafab.com](http://www.piranhafab.com)

## Table of Contents

---

Refer to second section of this manual for information on repair parts breakdown and ordering repair parts.

Table of Contents.....	4
Foreword.....	5
Warranty .....	5
Introduction .....	6
Safety Precautions.....	7
Machine Specifications .....	8
Functional Diagram.....	9
Dimensional Data.....	10
Standards Compliance.....	11
Installation.....	12
Operating Instructions.....	13
Lubrication .....	21
Maintenance .....	22
Troubleshooting .....	23
Tonnage Required for Punching Holes in Mild Steel .....	27
Maintenance Tools List .....	28
Ordering Repair Parts .....	29
Service Record Chart.....	51
Piranha Optional Tooling and Attachments .....	53

## Foreword

---

This manual has been prepared for those persons who will operate and maintain the Piranha Ironworker. It is important that all persons responsible for the care and operation of this equipment read and understand the information presented in this publication.

The illustrations and instructions on the following pages were the most recent available at the time of publication and selection of this material was made based on a standard machine arrangement. Differences between the machine you received, and the views contained in this manual are the result of design improvement and / or the addition of optional accessories specified on your order.

## Warranty

---

Piranha / MegaFab will replace (F.O.B. our factory) or refund the purchase price for any goods which are defective in materials and workmanship within 12 months of date of purchase. The buyer must return the warranty registration card within thirty-(30) days of the purchase date, and at the seller's option, return the defective materials freight and delivery prepaid to the seller, which shall be the buyer's sole remedy for defective materials. Seller shall not be liable to purchaser or any other person for consequential or incidental damages. Hydraulic and electrical components are subject to their respective manufacturer's warranties. This warranty does not apply to machines and / or components, which have been altered in any way, or subjected to abusive or abnormal use, inadequate maintenance, and lubrication, or to use beyond seller's recommended capacities and specifications. Seller shall not be liable under any circumstances for labor costs expended on such goods or consequential damages. Seller shall not be liable to purchaser or any other person for loss or damage directly or indirectly arising from the use of the goods, or from any other cause. No employee, agent, officer, or seller is authorized to make oral representations or warranty of fitness or to waive any of the foregoing terms of sale and none shall be binding on the seller.

## Introduction

---

The Piranha Ironworker is a compact hydraulically powered machine that shears, punches, bends, notches, and copes, all in a low silhouette, efficiently designed unit, resulting in minimal floor space requirements. The integral lifting lug provides instant portability and the unit arrives fully assembled, requiring only the addition of hydraulic oil and electrical power to become fully operational. A quick-change mounting assembly, utilizing a split dovetail, allows setup from punching to bending in less than one minute. The large platen has seventeen 5/8-11 tapped holes giving a wide base for increased flexibility of attachment sizes. The shearing operation features an adjustable automatic hold-down allowing the operator to clamp the work piece with a slight initial adjustment. All workstations are located approximately 44" off the floor for ease of operation.

The first part of this manual provides operations and maintenance instructions, including a section on troubleshooting various problems that may occur. The second part of this manual provides repair parts information and a complete parts list with their respective part numbers.

Proper understanding and application of the information and procedures given in this manual will aid in establishing a preventative maintenance program and, provide assistance for correcting malfunctions that may occur in the machine. The repair parts list provides information for parts procurement as well as assembly breakdowns to aid in disassembly and reassembly for repair part installation.

## About Piranha

Piranha is a subsidiary of MegaFab, based in Rockford Illinois. MegaFab is a manufacturer of metal fabrication machinery, including laser cutting machines, plasma cutting machines, ironworkers, press brakes, bending rolls, combination punching and cutting machines, and structural steel punching equipment. Equipment is sold under the Piranha, Whitney, and Bertsch brands.

## Safety Precautions

---

The operator of this machine should view the operational video provided with the machine, and thoroughly understand this manual before starting any operation.

This machine was designed for use by a single operator only.

Wear eye protection at all times.

Use the proper voltage outlet for the machine.

Make sure that all guards and cover shields are down before starting machine.

**CAUTION:** *Do not remove guards.*

Keep hands off working tables and out of the path of moving parts during operation. Remove all material from the tables except for the work piece.

Remove all tooling from the punch end before starting shearing or coping operations.

Make sure that all tooling is properly held in position before starting any operation.

The area around the machine should be well lit, dry, and free from obstructions.

All maintenance and repair work should be performed by a person familiar with this publication.

At the end of the working day, power off the machine.

Adjust limit switches when punching or bending to allow 1/4" maximum clearance between bottom of the stripper foot or bending punch and the top of the material. Contact the factory for limit switch adjustments on special tooling.

Turn selector switch to the "OFF" position when changing tooling or performing maintenance work. Reference Page Error! Bookmark not defined., Figure "B").

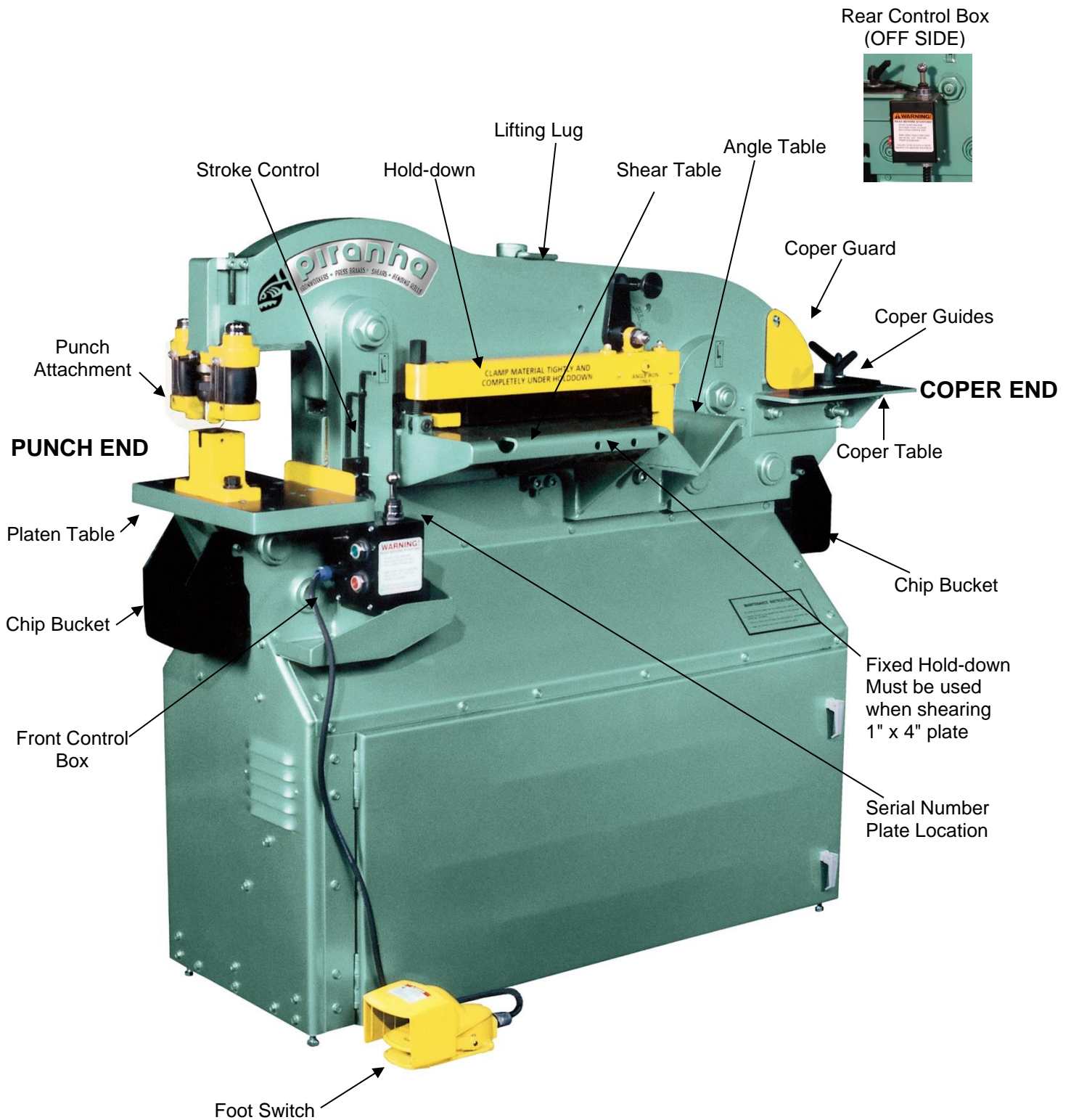
## Machine Specifications

---

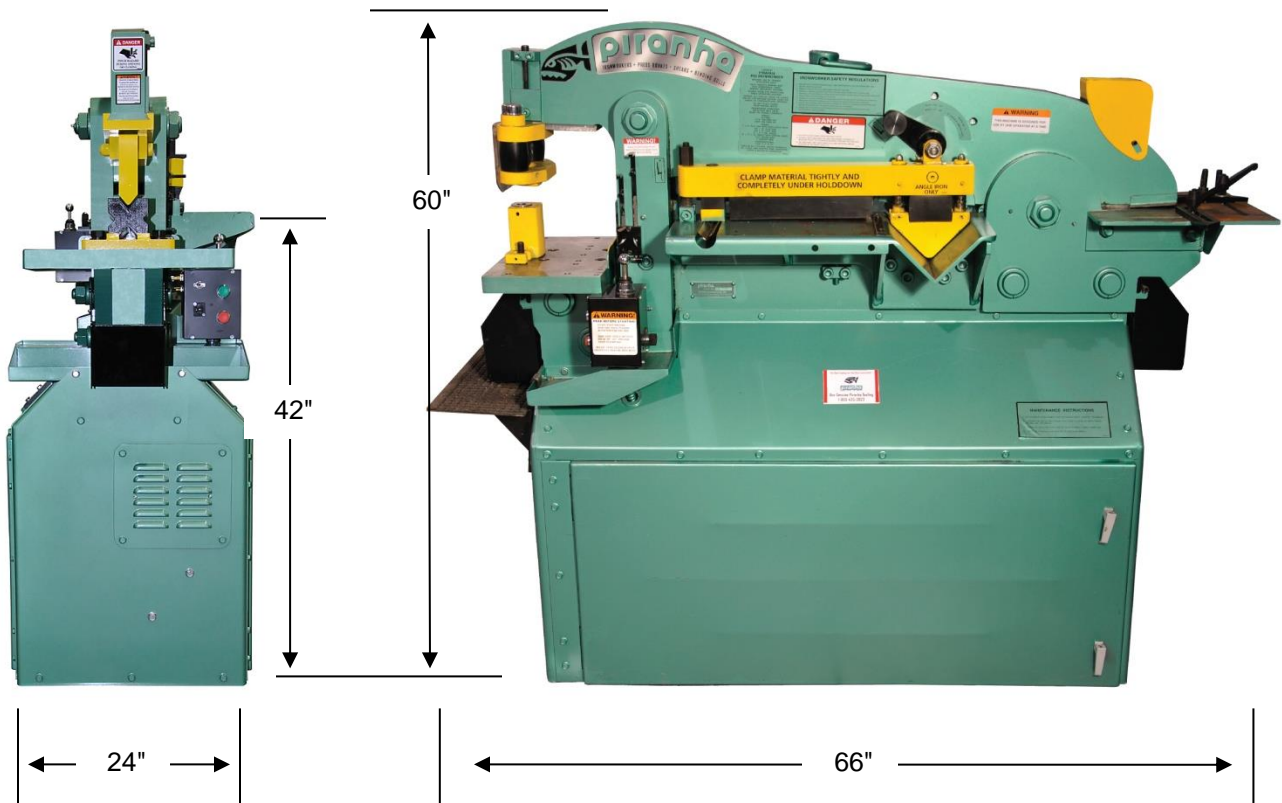
<b>HYDRAULIC SYSTEM</b>	
Drive Motor	7.5HP 230 / 460 Volt / 3 Phase
Hydraulic Tank Capacity	18 Gallons
Hydraulic Tank - Initial Fill	13.5 Gallons
Hydraulic Oil	AW-32 or Equivalent (ISO Grade 32) Consult your local distributor for a cross reference
<b>WORKING SURFACE</b>	
Platen Table	10" x 17"
Coper Table	15" x 15"
<b>CAPACITIES</b>	
Punch	Maximum 1-1/16" Thru 3/4" thick material or 65 Tons
Bending	Maximum 65 Tons
Punch End	Maximum 65 Tons
Bar	1-1/2" Round or 1" Square
Plate	1" x 4" w / Fixed Hold-down, 3/4" x 10", or 5/8" x 15"
Angle	5" x 5" x 3/8" or 4" x 4" x 1/2" with Optional Knife
Coper-Notcher	2-3/4" x 4" x 1/4"
<b>WEIGHT</b>	
Shipping Weight	2,600 Pounds



## Functional Diagram



# Dimensional Data



## Standards Compliance

---

### **Electrical System Design/Manufacture:**

The machines manufactured in Rockford, Illinois, USA are furnished with electrical / electronic products that are UL (Underwriter's Laboratory) approved. These components have the UL numbers printed or stamped on them and can be easily traced to the point of manufacture. In addition, all of the machines meet the current "Ontario Hydro" electrical code for proper manufacture of the electrical circuits.

### **Hydraulic System Design/Manufacture:**

Hydraulic components used in Piranha machines are approved by NFPA (National Fluid Power Association), and those approval numbers can be traced through the manufacturer's part numbers.

### **ANSI/OSHA Compliance:**

Piranha meets the current ANSI construction standards for manufacturing of ironworkers, press brakes, and shears:

**ANSI B11.5 - Ironworkers, Construction, Care, and Use**

**ANSI B11.3 - Power press brakes, Construction, Care, and Use**

**ANSI B11.4 - Shears, Construction, Care, and Use**

The ANSI B11 standards were developed to establish levels of responsibility for manufacturing safe products, and for installing, training, and using these products. The levels of responsibility are fairly evenly distributed between the manufacturer, the owner/end-user of the equipment, and the operator. Specific guarding requirements are, in general, assigned to the owner/end-user of the equipment.

With specific reference to Ironworkers, OSHA (Occupational Safety and Health Administration) made a ruling on March 4, 1991 - under their standard number 1910.212, specific to the OSHA Machine Guarding Standard 29 CFR 1910.212(a)(1). This ruling is stated verbatim below:

"If an employer provides an iron worker machine (at his or her workplace), which is manufactured in compliance with the safety requirements specified in ANSI B 11.5-1988, and the guarding is maintained as required; then that employer meets OSHA's machine guarding requirements for that machine."

Please understand that this ruling places the primary burden of responsibility for maintenance of guarding on the owner/end-user of the equipment. Inherent in this requirement is the responsibility of the owners/end-users of the equipment to develop and maintain guarding specific to their application for the equipment. These ANSI safety requirements may be acquired from:

**American National Standard Institute**

**1430 Broadway**

**New York, New York 10018**

**Telephone (212) 354-3300**

<https://www.ansi.org/>

## Installation

---

### Location

For the best overall performance, install the Piranha in a location that is clean and well lighted. Provide sufficient space in all directions to allow for the material lengths of the work pieces to be processed by the Piranha.

### Foundation

To maintain the accurate alignment built into the Piranha, and to prevent undue stress on the moving parts under a load, the Piranha should be placed on a stable base or floor adequately constructed to withstand the unit weight. **NOTE: Use the leveling bolts provided with the machine.**

### Wiring

The Piranha is shipped totally wired through the electrical enclosure box. It has been left to the owner's discretion whether to wire direct to an electrical disconnect, or to install a cord and plug for mobility of the Piranha.

**CAUTION:** Compare machine wiring to input voltage *prior* to connecting power. Only connect the specified voltage to the machine.

### Lifting

The lifting lug on the Piranha is an integral part of the machine. Use a device with adequate lifting capacity to handle the Piranha.

**CAUTION:** The unit is exceptionally **top heavy**! Lifting from the underside of the machine may cause damage to the cabinet structure.

### Assembly

The Piranha is pre-assembled at the factory. The only requirements are the addition of hydraulic oil and electrical power.

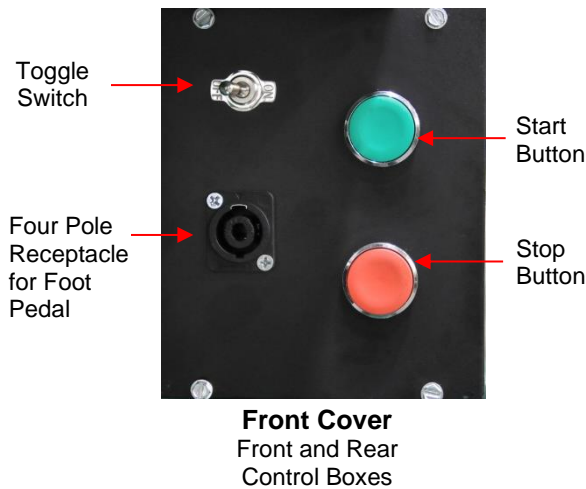
## Operating Instructions

The Piranha Ironworker comes pre-assembled and pre-wired, requiring only the addition of hydraulic fluid in the reservoir to the mark on the fill cap dipstick and a power source from a disconnect to the electrical enclosure box located inside the cabinet.

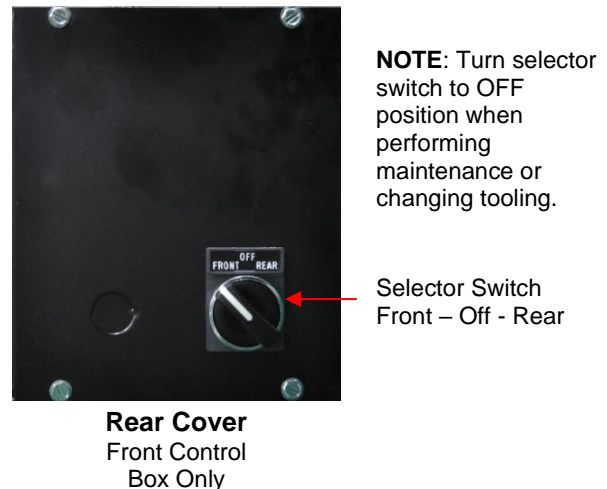
The unit can be started and stopped by the push button operators located on the front cover of the control boxes on each end of the unit. See figure A below. For the Control Box locations, reference the next page, figure E.

The electrical controls have a selector switch to determine which control box controls the unit. This safety feature is located on the rear cover of the front control box only. See figure B. The legend plate on the selector switch is printed "Front-Off-Rear". "Front" allows electrical control to the Front Box only. "Off" disconnects electrical control to both control boxes. "Rear" allows electrical control to the Rear Box only. The selector switch should be in the "OFF" position when the machine is not being used, such as, changing tooling, maintenance work, etc. The machine can only be started from the control box selected via the selector switch. It can be stopped using either "stop" button.

**FIGURE A**



**FIGURE B**



## Joystick Operation

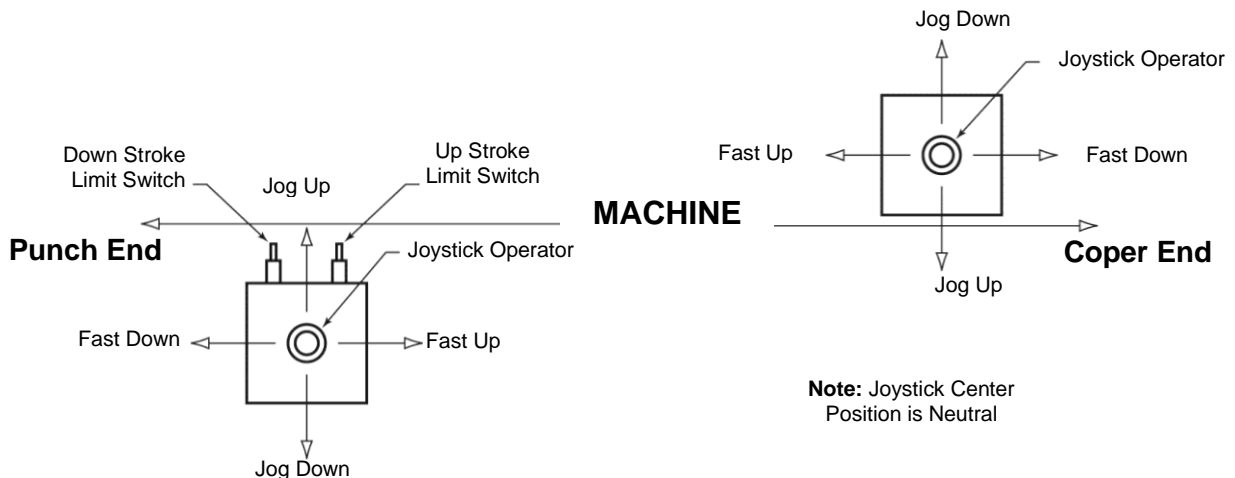
The ironworker is hand controlled by a five-position momentary joystick operator. When the joystick is released from any of the four positions, it will return to the neutral (center) position stopping machine movement instantly. The joysticks are located on top of the control box at each end of the machine. See figure E below.

The four controlling positions of the joystick are:

1. Fast Down (pulling the handle forward).
2. Fast Up (pushing the handle away).
3. Jog Down (pushing the handle to the right).
4. Jog Up (pushing the handle to the left). See figures C and D.

All directions in figures C and D are determined by standing at either end and facing the machine. The jog speed in both positions is a slow speed for alignment of center punch marks and scribe lines for shearing. The fast cycle should be used for the work cycle.

**FIGURE E**  
Control Box Locations



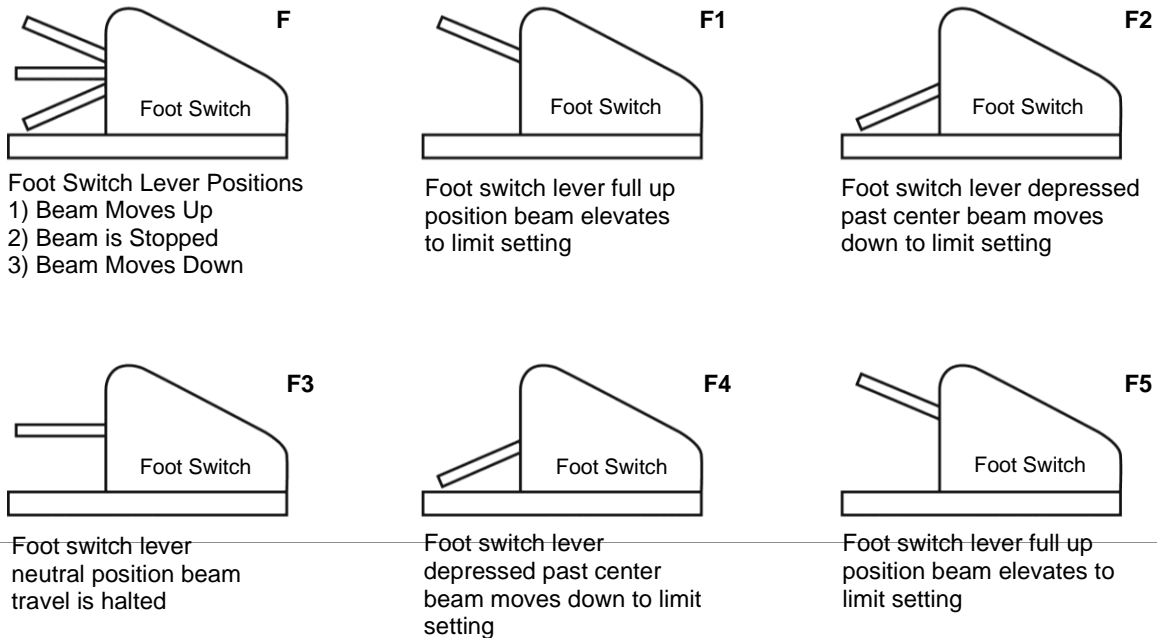
**FIGURE C**  
Front Control Box

**FIGURE D**  
Rear Control Box



## Footswitch Operation

The ironworker can also be controlled by a footswitch. See figure below. The footswitch is used by plugging the 4-pole twist lock cap into the 4-pole twist lock receptacle located in the front cover of either control box (reference figure A), and switching the toggle switch (reference figure A) from the "OFF" position to the "ON" position.



The footswitch is a three-(3) position switch allowing hands-free operation.

- By fully depressing the footswitch lever, machine movement is downward to limit setting (F2).
- By allowing the footswitch lever to elevate to the center position, machine movement stops (F3).
- Completion of downward cycle is accomplished by depressing footswitch lever again. Machine movement is down until limit setting is met (reference Figure F4).
- Removing foot pressure from the switch entirely allows machine movement upward to limit setting, completing upstroke cycle (reference Figure F5).

### Footswitch Limit Switches

The footswitch is used in conjunction with the upstroke and downstroke limit switches located on the machine side off the front control box only, see figure C.

- The front limit switch (closest to the punch end and the lower switch of the two switches) controls the downstroke limit.
- The back switch (furthest from the punch end and the higher of the two switches) controls the upstroke limit.
- The limit switches are activated by the limit switch arms: Item number 60, shown on page number [31](#).

To set the stroke using the limit switch arms, use the following procedure:

1. Plug in footswitch.
2. Turn toggle switch to "ON" position.
3. Loosen thumbscrew on down stroke limit-switch arm.
4. Fully depress footswitch lever allowing beam to move downward.
5. Slide limit switch arm until contact with the down stroke switch stops beam movement at the desired lower limit.
6. Tighten thumbscrew to hold limit switch arm firmly in place.
7. Loosen thumbscrew on upstroke limit-switch arm.
8. Allow footswitch lever to elevate allowing beam to rise.
9. Slide limit switch arm until contact with the upstroke switch stops beam movement at the desired upper limit.
10. Tighten thumbscrew to hold limit switch arm firmly in place.

**NOTE:** When punching or using the bending attachment, set upper and lower limits to allow for 1/4" maximum clearance between the bottom of the punch and the top of the work material. The setting will change when the work material thickness changes.

**NOTE:** The downstroke limit switch on the punch end controls the upstroke limit on the coper end. The upstroke limit is the only switch controlled from the rear control box footswitch control. The operator controls the downstroke limit by allowing the footswitch lever to fully elevate after the upper coper knife passes through the material.



## **Punch/Stripper Attachment Alignment**

The alignment of the punch and die should be accomplished in the following manner. (Reference page [31](#) and page [37](#)).

1. Slide the punch stripper assembly on the dovetail-mounting shoe.
2. Tighten the locking shoe by turning the cap screw clockwise (requires 3/8" Allen wrench). This locks the stripper assembly firmly in place.
3. Remove the coupling nut from the punch stem using the coupling wrench.
4. Insert the punch in the coupling nut and tighten on the punch stem using the coupling wrench.
5. Insert the female die in the die block.
6. Tighten the setscrew against the female die (requires 3/16" Allen wrench).
7. Slide the die block around the setscrews on the platen table. Do not tighten the flanged nuts.
8. Switch the front control box toggle switch (reference Figure "A") to the "OFF" position. Disconnect the foot switch from the receptacle.
9. Start the machine. Use the front control box joystick in the jog down mode (reference Figure "C"), to move the beam downward. Stop beam movement when the bottom of the stripper foot is approximately 1/8" above the die block.
10. Align the punch and die visually and by hand movement of the die block. Jog down again slightly and align. Continue this procedure until the punch has passed through into the die.
11. Using the wrench supplied with the machine, tighten the flanged nuts on the setscrews to hold the die block firmly to the platen table.
12. Set the limit switches to control the length of stroke. Reference previous page.
13. Start operation.
14. Remove all tooling from the punch end before starting shearing or coping operations.

## Stripper Assembly Adjustment

**NOTE:** The selector switch should be in the "OFF" position until all tooling changes are complete. Reference page [13](#), figure B.

The adjustment of the stripper assembly to compensate for varying punch lengths should be accomplished in the following manner. (Reference page [37](#) for a visual reference).

**NOTE:** The correct adjustment should have the tip of the punch 1/16" below the bottom of the stripper footplate and the stripper footplate level.

1. Install the stripper assembly on the upper beam (reference instructions previously listed).
2. Insert punch in the stripper assembly (reference instructions previously listed).
3. Measure the length of the punch relative to the bottom of the stripper foot.
4. If the tip of the punch extends more than 1/16" below the bottom of the stripper foot, adjustment is required.
5. Turn the two (2) guide pin adjusting caps counterclockwise until the tip of the punch extends 1/16" below the bottom of the stripper footplate. The stripper footplate **MUST** remain level or parallel to the work material. The punch tip should be able to line up on a center punch mark before the stripper footplate engages the material.
6. If the tip of the punch does not extend 1/16" below the bottom of the stripper foot, or if the stripper footplate is not parallel with the work material, adjustment is required.
7. Turn the two (2) guide pin adjusting caps clockwise until the tip of the punch extends 1/16" below the bottom of the stripper footplate. The stripper footplate **MUST** remain level or parallel to the work material. The punch tip should be able to line up on a center punch mark before the stripper footplate engages the material.

## **Bending Attachment Alignment**

The alignment of the bending punch and bending die should be accomplished by the following manner. (Reference page [31](#) and page [39](#)).

1. Slide the bending punch assembly on the dovetail-mounting shoe. The front edge of the bending dovetail slide should be even with the mounting shoe
2. Tighten the locking shoe by turning the cap screw clockwise (requires 3/8" Allen wrench). This locks the bending punch assembly firmly in place.
3. Place the bending base holders on the platen table over the setscrews. Do not tighten flanged nuts.
4. Place the four-way bending die into the bending base holder with the proper width die opening on the top.
5. Switch the front control box toggle switch (Reference Figure "A") to the "OFF" position and disconnect the foot switch from the receptacle.
6. Start the machine. Using the front control box joystick in the jog down mode (Reference Figure "C"), move the beam downward.
7. When contact between the bending punch and the bending die block opening is made, the bending die block will center itself.
8. Using the wrench supplied with the machine, tighten flanged nuts on the setscrews to hold the base assembly firmly to the platen.
9. Set the limit switches to control the length of stroke (reference procedures previously listed).
10. Start operation.

## Shear Hold-Down Assembly Adjustment

The adjustment on the hold-down assembly should be accomplished by the following manner. (Reference page [35](#)).

1. Raise the upper beam to its full upstroke limit.
2. Adjust the three-position hold-down locator per the following instructions:
  - Locator hole nearest punch end - Plate = 1/4" thick and less, Angle = 3/16" thick and less.
  - Locator hole center position - Plate = 5/16" to 1/2" thick, Angle = 1/4" to 5/16" thick.
  - Locator hole nearest the copier end - Plate = 5/8" to 1" thick, Angle = 3/8" to 1/2" thick\*

**\*NOTE: Shearing 1/2" thick angle requires the optional 1/2" upper angle knife not provided with the standard machine.**

3. Loosen the long hex head nut without removing it from the swing bolt, raising the hold-down assembly.
4. Assure the hold-down bar has risen until it is directly under the long nut.
5. Insert material to be sheared under the hold-down assembly.
6. Tighten the long hex head nut to allow for approximately 1/8" clearance between the bottom of the shear urethane and the top of the material to be sheared. The material should move freely and not be held by the hold-down assembly at this point.
7. Lower the beam using the front control box joystick in the jog mode (reference Figure "C") until the hold-down assembly firmly clamps the material.

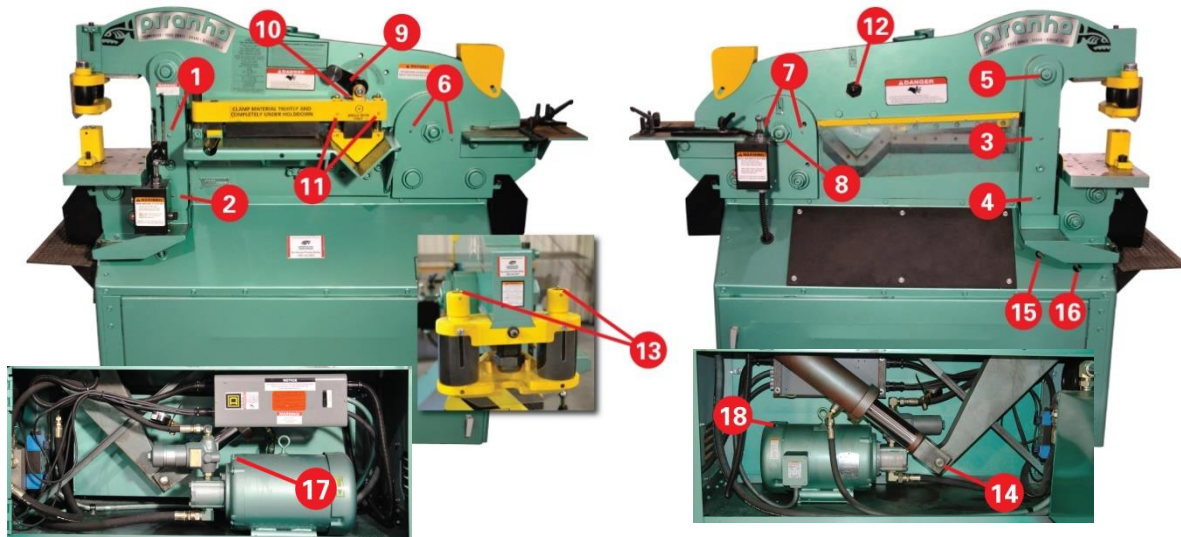
**NOTE:** The hold-down assembly must firmly clamp the material before the shear knives engage the material surface.

8. If the foot switch is to be used during the operation, adjust the limit switches to control the length of stroke (reference procedures previously listed).

**NOTE: Do not attempt to shear any material that will not be held by the Hold-down Assembly. When shearing up to 1" X 4" flat bar, install the Fixed Flat Bar Hold-down, Part Number 0330129 to the front of the shear table. Make sure the material is held properly at the urethane and that the material extends into the fixed flat bar hold-down area as well. The Fixed Flat Bar Hold-down acts as a bumper bar assisting the Urethane Hold-down in its normal function.**

## Lubrication

The importance of correct lubrication cannot be over emphasized. Under no circumstances should the machine be operated without complying with the lubrication requirements set forth in this publication.



### LUBRICATION CHART

Station	Part Lubricated	Frequency	Instructions	Lubrication Type
1	Upper Pull Arm On Side	Every 40 hours or weekly with normal use	Apply with Grease Gun Until Grease Appears Around Edge of Parts	Mobile MP Or Any Multi-Purpose Grease
2	Lower Pull Arm On Side			
2	Upper Pull Arm Off Side			
4	Lower Pull Arm Off Side			
5	Upper Pull Arm Hinge Pin			
6	Coper Side Plate On Side (2 Places)			
7	Coper Side Plate Off Side (2 Places)			
8	Rear Hinge Pin			
9	Angle Knife Bushing			
10	Hold-down Link			
11	Hold-down Bar (2 Places)			
12	Hold-down Pin			
13	Stripper Assembly (2 Places)			
14	Clevis Pin			
15	Lower Pull Arm Hinge Pin			
16	Crank Arm Hinge Pin			
17	Drive Motor	One Shot Per Year	One Shot from Grease Gun	Multi-Purpose Grease
18	Drive Motor			

## Maintenance

---

**NOTE:** The Selector Switch should be in the "OFF" position while maintenance checks are being performed. Reference page [Error! Bookmark not defined.](#), Figure B.

### Hydraulic Filter Element

The hydraulic oil filter is a vital component of the hydraulic system as it filters impurities and foreign particles to avoid hydraulic component malfunctions.

**CAUTION:** When the filter element is plugged, hydraulic fluid will by-pass the element, allowing contamination to enter the hydraulic system. It is recommended that the filter element be changed every three-(3) months, depending on workload and environmental conditions. One extra element is furnished with the basic unit. This element should be installed after the first 40 hours of use. The filter housing is mounted inside the access door on the machine. Reference: Repair Parts List for reordering instructions and the item number 7, page [46](#).

### Fasteners and Connections

The efficiency and accuracy of the Piranha is dependent upon proper alignment of all parts. Alignment can only be achieved by keeping the fasteners tight. Check all bolts and nuts for tightness every 40 hours of operation, or when lubricating the machine. Unless specified in parts illustrations, torque socket head bolts and hinge pin jam nuts to the specifications in the table on page [28](#).

Check all hydraulic hose and fitting connections for tightness when lubricating the machine. It is recommended to use Loctite hydraulic sealant or an equivalent product on all connectors.

Check to ensure the hydraulic cylinder clevis is screwed tight on the piston rod each time machine is lubricated.

### Hydraulic Oil Level

The Piranha ironworker is equipped with a dipstick indicator on the fill cap located inside the access door. The dipstick is marked to help maintain proper fluid level. This should be checked as part of your normal maintenance cycle.

**NOTE:** Implement a weekly maintenance program to inspect and lubricate your Piranha. For convenience, a service record chart has been provided on page [51](#).

## Troubleshooting

---

Many of these problems can be solved by following a step-by-step procedure for isolating the issue. Take notes on the steps tried, and the outcomes. This way if you are not able to fix the issue, you can pass on what has been done and tried already to the Piranha technician.

### Potential Problems and Solutions

#### P1 - Machine Will Not Start

1. Check that selector switch is turned to the control box you are starting the machine from.
2. Check fuses at disconnect.
3. Check voltage to motor starter.
4. Transformer control voltage (Output - 120 V). If not, check:
  - A. Transformer fuse. If blown, inspect circuit for a ground short.
  - B. Incoming voltage to input side of transformer is correct and the jumper bars are in the correct location. Reference page [41](#).
  - C. All wire and fuse holder connections are tight.
  - D. Possible faulty transformer.
5. Control circuit from transformer to front and rear control boxes to motor starter coil. (Reference Wiring Diagram page [42](#)).

## **P2 - Machine Starts but Will Not Operate**

Determine if the problem is electrical or hydraulic by using the manual override buttons located on the directional valve top and bottom sides. (Refer to page [45](#), Item 11).

If the machine operates, the problem is electrical. Follow the procedure below:

1. Determine if problem exists in the front control box only, the rear control box only, or in both control boxes.
  - A. If problem is isolated to one box only, check the internal wiring and wiring harness with disconnect plug for loose connection.
  - B. If the problem exists in both boxes, follow the remaining procedures.
2. Check wiring connections in the electrical enclosure.
3. Check the valve body wiring harness, including the disconnect plugs, for loose connections.
4. Check coils in the directional control valve.

**If the machine does not operate on manual override, the problem is hydraulic.**

1. Check to determine if the pump is developing flow. If not:
  - A. See if motor rotation is correct.
  - B. Check motor / pump coupling (in models prior to S/N P3-5893) for tightness on both shafts; and also check that insert is not damaged.
  - C. Check hydraulic suction line for tightness.
  - D. Check Oil level.
  - E. If the above checks out okay, the pump may be defective
2. Check to determine if the spool in the directional control valve is stuck in the center position. If the valve is stuck, remove the end caps of the control valve and free the spool. Inspect for contamination.



### **P3 - Machine Overheats**

1. Check if fluid level in reservoir is low.
2. Check for low line voltage to transformer, causing low control voltage to directional valve solenoid coils.
3. Determine if limit switches are set improperly when using footswitch, allowing cylinder to bottom out at retraction and extension. This may cause hydraulic fluid to by-pass over relief valve, creating heat buildup.
4. If jog mode is used during production, hydraulic fluid may pass over the NC valve and create heat buildup.
5. Check for restrictions in the hydraulic system. Example: Contaminated cartridge valve, restricted or kinked hose, etc.

### **P4 - Reset On Motor Starter Kicks Out**

1. Internal overheating. Refer to P3, above, for troubleshooting procedure.
2. Insure proper sized heater coils are being used. Reference the wiring diagram on page [42](#).
3. Check for proper line voltage.
4. Check for loose connections on motor cable at starter or motor.

### **P5 - Edges On Knife Blade Chipped By Material**

1. Check knife clearance - .007" to .010". If not:
  - A. Combo table bolts may have become loose, allowing scale and contamination between table and beam. Remove table and clean.
  - B. Combo table bolts may have stretched the threads in the beam. Remove table and sand beam surface flat.
  - C. Knives may have been ground. Shim to recommended clearance.
2. Knives may be dull and are creating a pulling effect on the shearing edge.
3. Material may be too hard.
4. Material may be thicker than rated capacities.

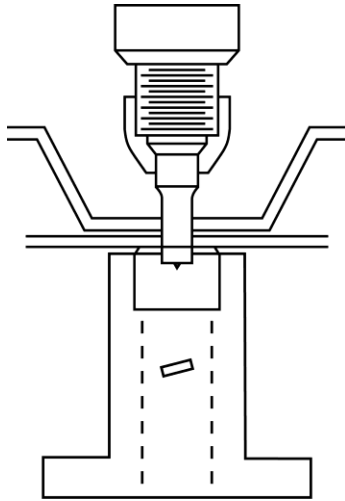
**P6 - Machine Leaves Burr When Shearing**

1. Knife clearance: .007" to .010". If not, follow procedure in P-5.
2. Check shear knives for sharpness
3. Check that the automatic hold-down is adjusted to clamp the material securely.

**P7 - Bent or Broken Shear Hold-Down Swing Bolt**

1. Check that the alignment of the angle hold-down block with the angle table is square with table.
2. Check to see if the spiral pins holding the guide pins to the angle block are sheared.
3. Check that hold-down link moves freely in the hold-down bar.
4. Check that wing bolt moves freely in the hold-down bar.
5. Check that the three-position hold-down is in proper location for material being sheared. (Reference the hold-down assembly adjustment on page [42](#).)

## Tonnage Required for Punching Holes in Mild Steel



This table shows the tons of force required for punching round holes in mild steel derived by the formula:

Force = hole diameter x material thickness x constant 80. All figures shown are in U.S. tons.

For holes larger than 1 inch, the punching force can be calculated per the following example:

*What pressure is required to punch a 2-1/4" round hole in 7/8" thick material?*

*Since a 1" round hole in 7/8" thick material requires 70 tons of pressure, multiply this 70 tons x 2.25 = 157.50 tons.*

**NOTE:** Do not punch a hole with a smaller diameter than the thickness of the material.

Material Thickness	Punch Size														
	1/8	5/16	1/4	5/16	3/8	7/16	1/2	9/16	5/8	11/16	3/4	13/16	7/8	15/16	1
3/32	1	1	2	2	3	3	4	4	5	5	5	6	7	7	8
1/8	1	2	3	3	4	4	5	6	6	7	8	8	9	9	10
3/16		3	4	5	6	7	8	9	9	10	11	12	13	14	15
1/4			5	6	8	9	10	11	13	14	15	16	18	19	20
5/16				8	9	11	13	14	16	17	19	20	22	23	25
3/8					11	13	15	17	19	21	23	24	26	28	30
7/16						15	18	20	22	24	26	28	30	33	35
1/2							20	23	25	28	30	33	35	38	40
9/16								26	28	30	34	36	40	42	45
5/8									31	34	38	41	44	47	50
11/16										38	41	44	48	51	55
3/4											45	49	53	56	60
13/16												53	57	61	65
7/8													61	66	70
15/16														71	75
1															80

## Maintenance Tools List

---

The following tools are required for performing maintenance and to assist you in troubleshooting your machine:

1. Grease gun with a flexible connection
2. Open end wrenches - 3/4" thru 1-1/4"
3. Adjustable wrench – 1-1/2" thru 2-1/4" opening
4. Allen wrenches - 3/16" thru 5/8"
5. Screwdrivers - miscellaneous sizes
6. Voltmeter

### Recommended Fastener Torque Specifications (Unless Otherwise Specified)

Bolt Size	Torque (Ft-Lbs.)
3/8-16	45
7/16-14	70
1/2-13	100
5/8-11	210
3/4-10	375
Jam Nuts	600

### Die Clearance Chart for Steel

Gauge	Decimal Thickness	Die Clearance (Add to Punch Size)
13 thru 11	0.089 – 0.125"	0.01"
10 thru 7	0.126 – 0.190"	1/64" (0.016")
Over 7 thru 1/2" Plate	0.191 – 0.500"	1/32" (0.032")

## Ordering Repair Parts

---

The following assembly parts lists are shown in four columns. In the first column are the index numbers of the parts illustrated. The second column contains the Piranha part number, followed by the description in the third column. The last column shows the quantity of parts required for the assembly.

Electrical wiring diagrams and hydraulic diagrams are shown with the Piranha part numbers. Some of these items shall be considered as an assembly and only one part number will be given, even though they are comprised of component parts.

You will receive quicker service when ordering repair parts by adhering to the following procedure.

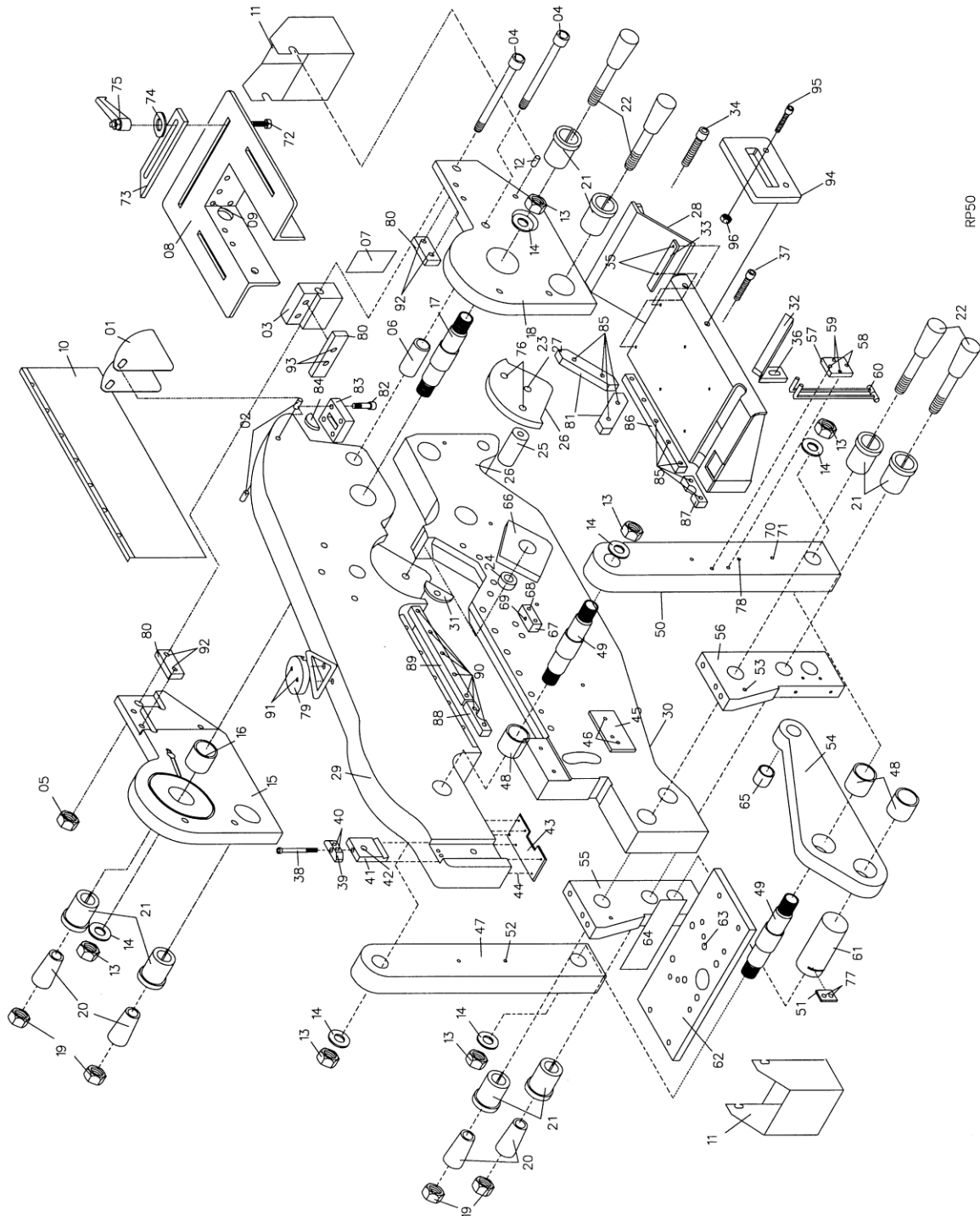
1. Provide the complete serial number of the machine. The machine serial number is stamped on the nameplate and is located on the right-hand side of the machine (when facing the punch end).
2. Provide part number, description, and the quantity of parts that you require.
3. Specify each individual piece required. Do NOT use the term "complete assembly".
4. Specify how and where to ship. Define the method of transportation desired. UPS, Old Dominion, and FedEx Freight are the most frequently used carriers at Piranha.

**ALWAYS PROVIDE THE COMPLETE SERIAL NUMBER  
FOR PARTS AND SERVICE**

## Repair Parts Table of Contents

	<b>Page No.</b>
P65 Basic Machine Illustrated .....	31
Shear Hold-Down Assembly Illustration .....	35
Punch Assembly Illustration .....	37
8" Bending Assembly (Optional) Illustration .....	39
Electrical Enclosure Assembly .....	41
Front Box Assembly .....	43
Rear Box Assembly.....	44
Valve Body Assembly Illustrated .....	45
Motor Assembly .....	46
Cylinder Assembly .....	48
Foot Switch Assembly .....	48
Knives .....	50

## P65 Basic Machine Illustrated



RP50

## Basic Machine Part Numbers

ALWAYS PROVIDE THE COMPLETE SERIAL NUMBER FOR PARTS AND SERVICE

Figure and Index No.	Part Number	Description	Qty.
1	0230142	Coper Guard	1
2	0531351	3/8" x 1" Roll Pin	2
3	0230117-1	Coper End Knife Support	1
4	0531118	3/4" x 7-1/2" HH	2
5	0531255	3/4" Nylock HN	2
6	0230155	Black Pipe Spacer	1
7	0230144	Coper Dust Cover Plate	1
8	0230124	Coper Table Assembly	1
9	0531080	1/2" x 1" SHCS	4
10	0230415	Shear Guard Assembly	1
11	0230143	Chip Bucket	2
12	0531352	1/2" x 1-1/2" Roll Pin	2
13	0531270	1-1/2" NF JN	6
14	0531303	1.535 ID x 3 OD X .255 Washer	6
15	0230116-1	Coper Side Plate-Off Side	1
16	0330170	Rear Hinge Pin Bushing	1
17	0230166	Rear Hinge Pin	1
18	0230115-1	Coper Side Plate-On Side	1
19	0531260	1 NF ND HN	4
20	0230163	Taper Pin Plug	4
21	0230161	Taper Pin Split Bushing	8
22	0230160	Taper Pin	4
23	0531250	5/8" Nylock HN	1
24	0230167	Angle Knife Bushing	1
25	0230154	Urethane Spacer	1
26	0230146	Angle Knife Cover	1
27	0531112	3/4" x 2-1/2" SB	1
28	0230121	Combo Shear Table	1
29	02301001	Upper Beam Assembly	1
30	02301011	Lower Beam Assembly	1
31	0230156	Angle Knife Block	2
32	0230141	Round Bar Guide Assembly	1
33	02301401	Plate Shear Guide	1
34	0531110	3/4" x 2-1/4" SHCS	4
35	0531000	1/4" x 1/2" SHCS	2
36	0531081	1/2" x 1-1/4" SHCS	1
37	0531092	5/8" x 2-1/4" SHCS	6



## Basic Machine Part Numbers – Continued

ALWAYS PROVIDE THE COMPLETE SERIAL NUMBER FOR PARTS AND SERVICE

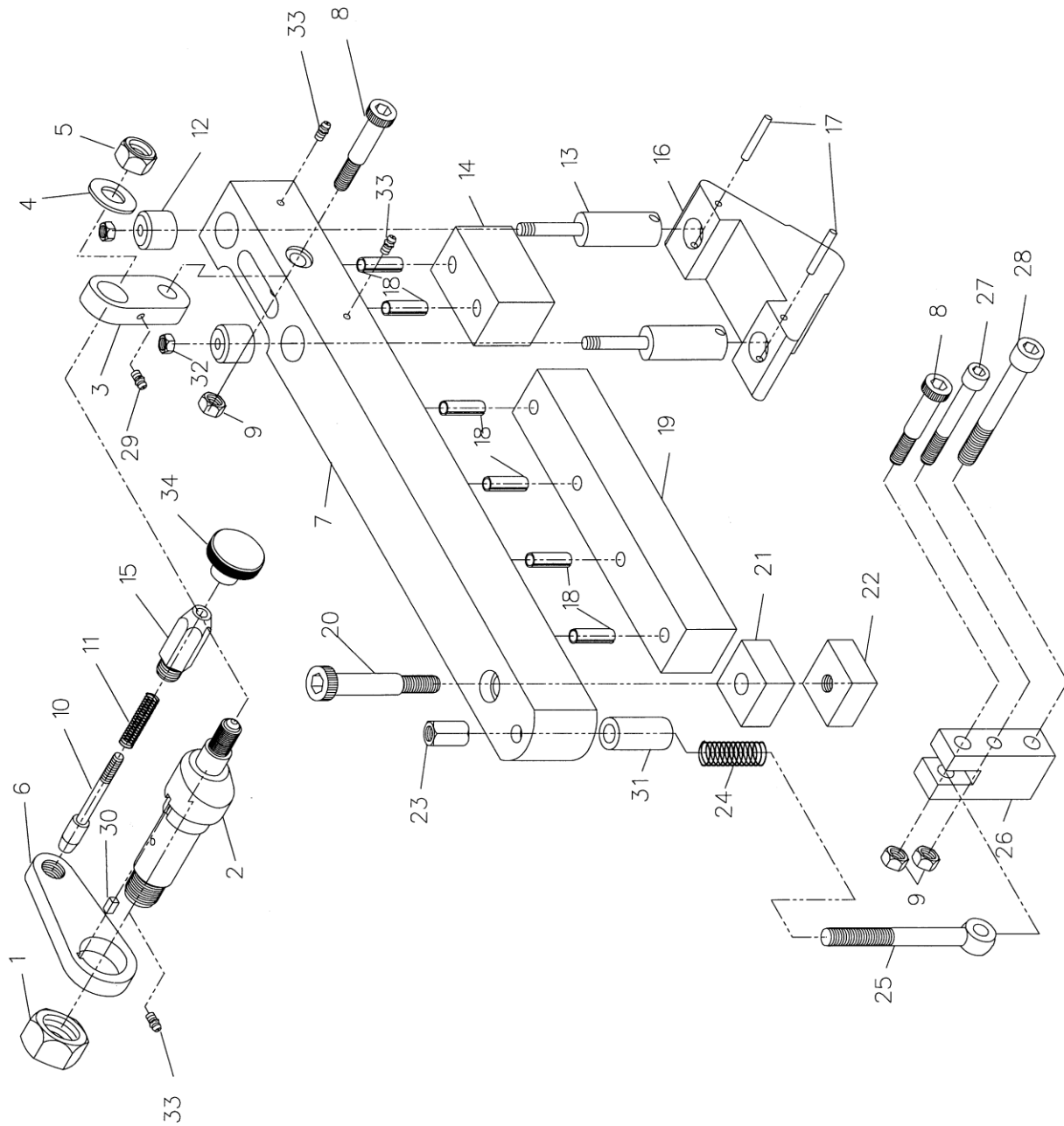
Figure and Index No.	Part Number	Description	Qty.
38	0531076	7/16" x 4" SHCS	1
39	0230130	Locking Shoe Bearing	1
40	0531051	3/8" x 1-1/4" SHCS	2
41	0230131	Locking Shoe	1
42	0330189	Locking Shoe Bolt	1
43	0230132	Mounting Foot	1
44	0531039	3/8" x 3/4" SHCS	6
45	0230145	Bronze Wear Plate	1
46	0531062	3/8" x 3/4" FHSC	2
47	0230111	Pull Arm-Off Side	1
48	0330168	Crankarm Bushing	3
49	0230165S	Pull Arm-Hinge Pin	2
50	0230110	Pull Arm-On Side	1
51	0230148	Crankarm Pin Lock Plate	1
52	0531097	5/8" x 6-1/2" SHCS	1
53	0531050	3/8" x 1" SHCS	2
54	0230112	Crankarm Assembly	1
55	0230114	Platen Support-Off Side	1
56	0230113	Platen Support-On Side	1
57	0230149	Microswitch Guide Block	1
58	0531001	1/4" x 3/4" SHCS	2
59	0531320	1/4" x 1/2" Thumbscrew	2
60	0230153	Microswitch Arm Assembly	2
61	0230164S	Crankarm Hinge Pin	1
62	0230120	Platen Table	1
63	0531090	5/8" x 1-3/4" SHCS	4
64	0230150	Pull Arm Guard	1
65	0330167	Clevis Pin Bushing	1
66	0230273	Upper Angle Knife	2
67	0230147	Shear Table Adjust Block	1
68	0531090	5/8" x 1-3/4" SHCS	2
69	0531087	1/2" x 2" SSS	1
70	0531005	1/4" x 1/2" Button Head Cap Screw	1
71	0581140	1/4" HN	1
72	0531088	1/2" x 1-1/2" Carriage Bolt	3
73	0330128	Coper Table Guide	3
74	0531307	1/2" Flat Plated Washer	3
75	0531715	KP79 (1/2-13) Plastic Handle	3
76	0531094	5/8" x 2-1/2" HHCS	2

## Basic Machine Part Numbers – Continued

ALWAYS PROVIDE THE COMPLETE SERIAL NUMBER FOR PARTS AND SERVICE

Figure and Index No.	Part Number	Description	Qty.
77	0531060	3/8" x 3/4" HCS GR8	2
78	0531253	5/8" JN	1
79	0531400	Lifting Lug	1
80	0230276	Coper Knife- Lower Side and End	1
81	0276274	Angle Knife - Lower	2
82	0531050	3/8" X 1" SHCS - Upper Coper	4
83	0230277	Coper Knife - Upper	1
84	0531330	Woodruff Key - Upper Coper Knife	1
85	0531071	7/16" x 2" SHCS - Lower Shear, Lower Rd Bar, Lower Angle	11
86	02302501	Flat Shear Knife x 12.125"	1
87	0230262	Round Bar Knife	1
88	0230262	Round Bar Knife	1
89	02302501	Flat Shear Knife x 12.125"	1
90	0531070	7/16" x 1-3/4" SHCS - Upper Shear, Upper Rd Bar	7
91	0531086	1/2" x 1-3/4" SHCS - Lift Lug	2
92	0531069	7/16" x 1-1/2" SHCS	4
93	0531072	7/16" x 2-1/4" SHCS	2
94	0330129	Flat Bar Hold-down	1
95	0531086	1/2" x 1-3/4" SHCS	2
96	0531216	1/2" Nylock HN	2

## Shear Hold-Down Assembly Illustration



## Shear Hold-Down Assembly Part Numbers

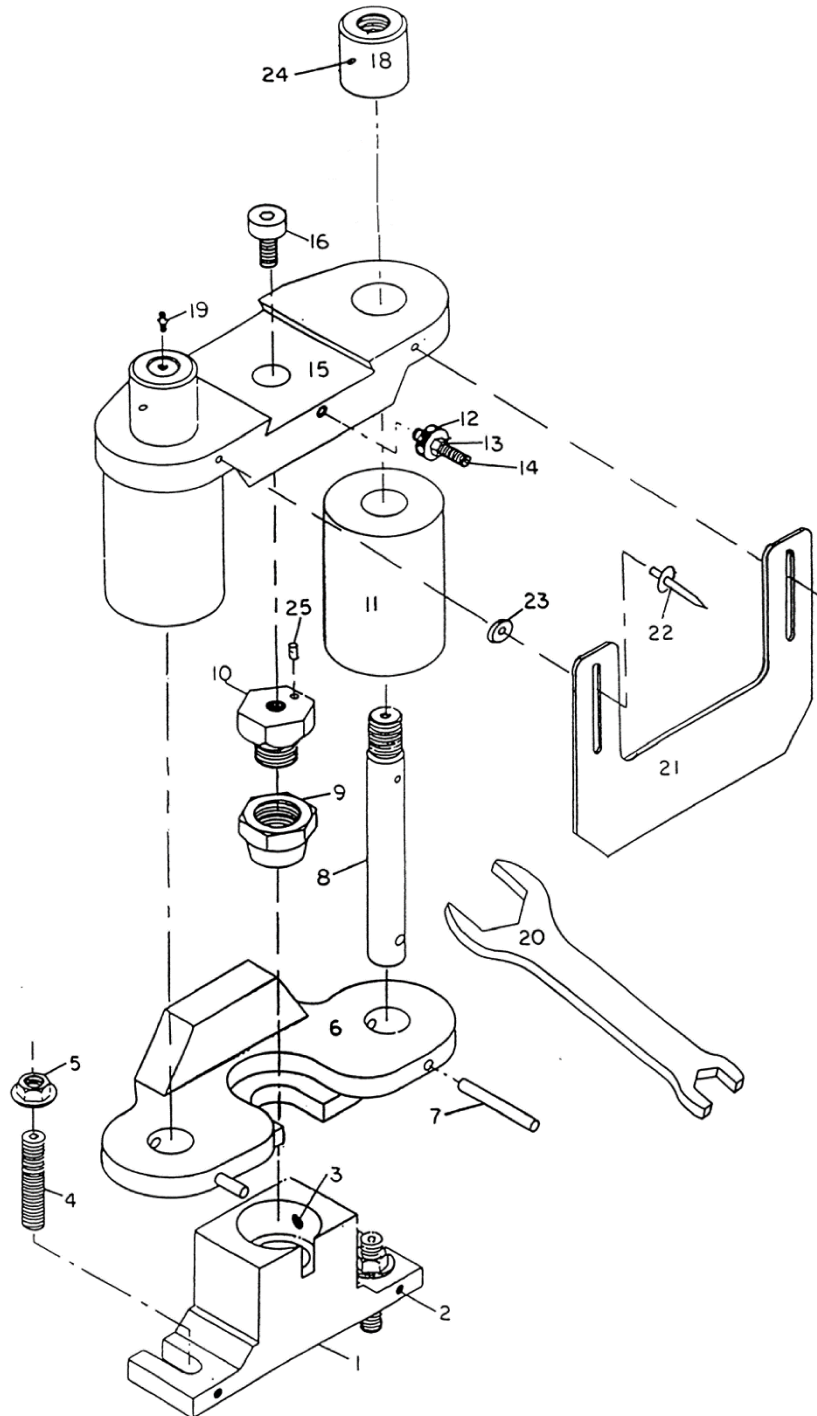
Part Number 02302001

ALWAYS PROVIDE THE COMPLETE SERIAL NUMBER FOR PARTS AND SERVICE

Figure and Index No.	Part Number	Description	Qty.
1	0531271	1-1/4-12 JN	1
2	02302011	Hold-down Pin	1
3	0330202	Hold-down Link	1
4	0531300	3/4" Hard Black Fit. Washer	1
5	0531255	3/4" Nylock HN	1
6	0330214	Locator Plate	1
7	03302001	Hold-down Bar	1
8	0531104	5/8" x 2" SB	2
9	0531216	1/2" Nylock HN	3
10	0340212	Locator Pin	1
11	0340216	Locator Pin Spring	1
12	0376221	Angle Guide Pin Sleeve	2
13	0376223	Angle Guide Pin	2
14	03302081	Angle Urethane	1
15	0340213	Locator Pin Housing	2
16	0376224	Angle Block	1
17	0541062	5/16" x 2-1/2" Spiral Pin	2
18	0531352	1/2" x 1-1/2" Roll Pin	4
19	0330207	Shear Urethane	1
20	0531114	3/4" x 3" SB	1
21	0330209	Round Bar Urethane	1
22	0330205	Round Bar Block	1
23	0531252	Swingbolt Coupling Nut CL-3-CN	1
24	0330211	Hold-down Spring	1
25	0531108	5/8" x 6" Swingbolt CL-63-EB	1
26	0230206	Swingbolt Block	1
27	0531084	1/2" x 4" SHCS	1
28	0531095	5/8" x 4-1/2" SHCS	1
29	0531363	45 Degree Zerk	1
30	0330215	Hold-down Pin Key	1
31	0330216	Hold-down Bar Bushing	1
32	0531212	3/8" Nylock Nut	2
33	0531362	Straight Zerk	3
34	0541393	Locator Pin Knob	1
35	0550170	Decal - Material Thickness	1

**NOTE:** Hold-down Assembly, Part Number 02302001- Includes Index Numbers 3 - 5, 7 - 9, 12 - 14, 16 - 22, and 31.

## Punch Assembly Illustration



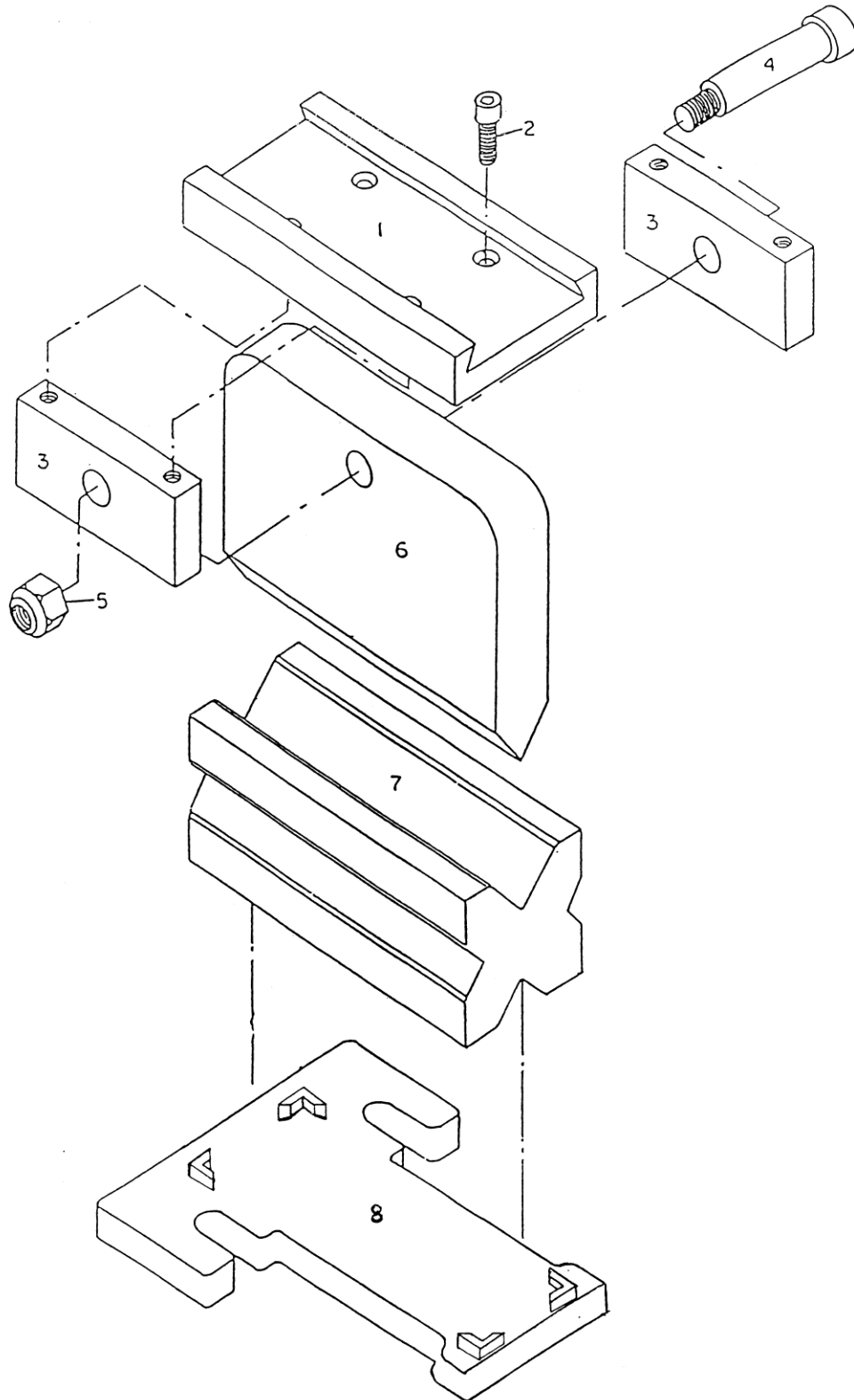
## Punch Assembly Part Numbers

Part Number 02304011

Figure and Index No.	Part Number	Description	Qty.
1	02304001	1-13/16" Die Block Cast	1
2	0531002	1/4" x 3/4" SSS	3
3	0531055	3/8" x 1/2" SSS	1
4	0531100	5/8" x 3" SSS	2
5	0531251	5/8" CL-4 FLDG Nut	2
6	03304011	Stripper Foot Cast	1
7	0531356	3/8" x 2-1/2" Spiral Pin	2
8	03304021	Stripper Guide Pin	2
9	0330406	C-56 Coupling Nut	1
10	0330407	Figure 16 - Punch Stem	1
11	0330403	Stripper Block	2
12	0531211	3/8" CL-1 Knurled Nut	1
13	0531210	3/8" HN	1
14	0531058	3/8" x 2" SSS	1
15	03304041	Punch Dovetail Slide Cast	1
16	0531106	5/8" x 1-1/2" FHCS	1
17	N/A	N/A	N/A
18	0340408	Stripper Guide Pin Adjust Cap	2
19	0531360	1610 Zerk	2
20	0231410	2" Coupling Wrench	1
21	0330400	Punch Guard	1
22	0531012	Punch Guard Rivet	2
23	0531013	Punch Guard Spacer	2
24	0541045	W-17N Ball Plunger 1/4-20	2
25	0531350	1/4" x 3/4" Roll Pin	1

**NOTE:** Punch Assembly, Part Number 02304011- Includes Index Numbers 6 - 19 and 21 - 25.

## 8" Bending Assembly (Optional) Illustration



## 8" Bending Assembly (Optional) Part Numbers

Part Number 4431648

Figure and Index No.	Part Number	Description	Qty.
1	0330500	Bending Dovetail Slide	1
2	0531039	3/8" x 3/4" SHCS	4
3	0330501	Bending Punch Slide Plate	2
4	0531114	3/4" x 3" SB	1
5	0531250	5/8" Nylock HN	1
6	0330502	8" Bending Punch	1
7	0330503	8" 4 way Bending Die	1
8	0330504	8" Bending Die Base	1

**NOTE:** 8" Bending Punch Assembly, Part Number 0230500 - Includes Index Numbers 1 - 6.

## BENDING DIE CAPACITIES

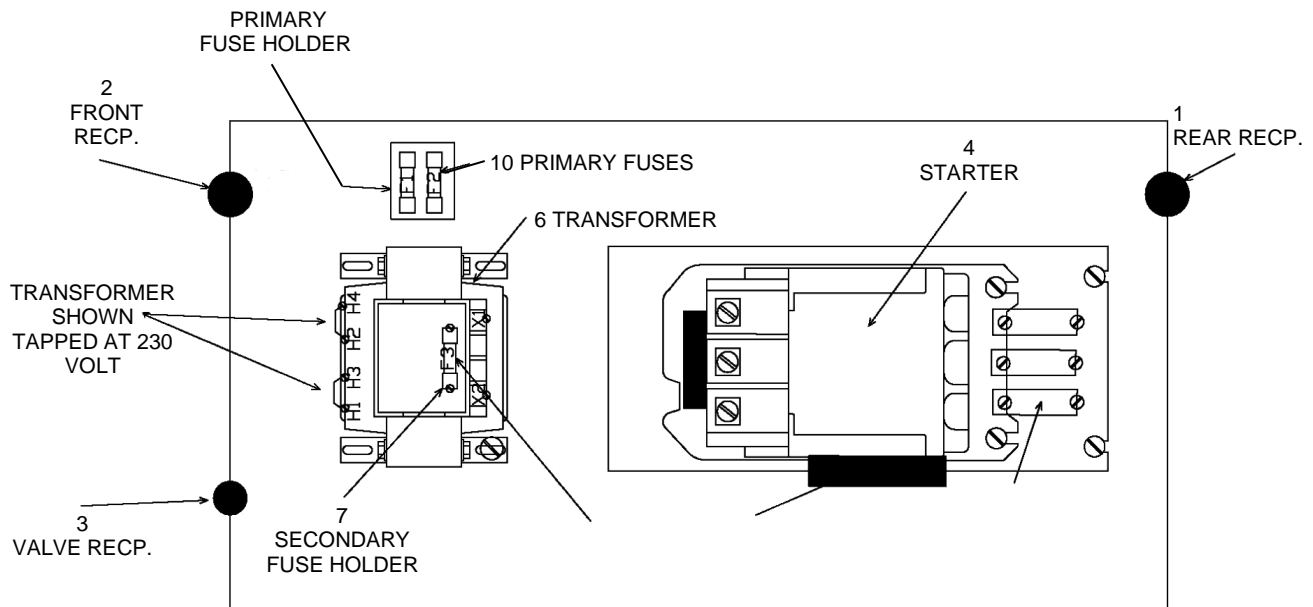
"V" WIDTH	MAXIMUM MATERIAL
2"	1/4"
1-1/2"	3/16"
1-1/8"	10 Gauge
7/8"	12 Gauge

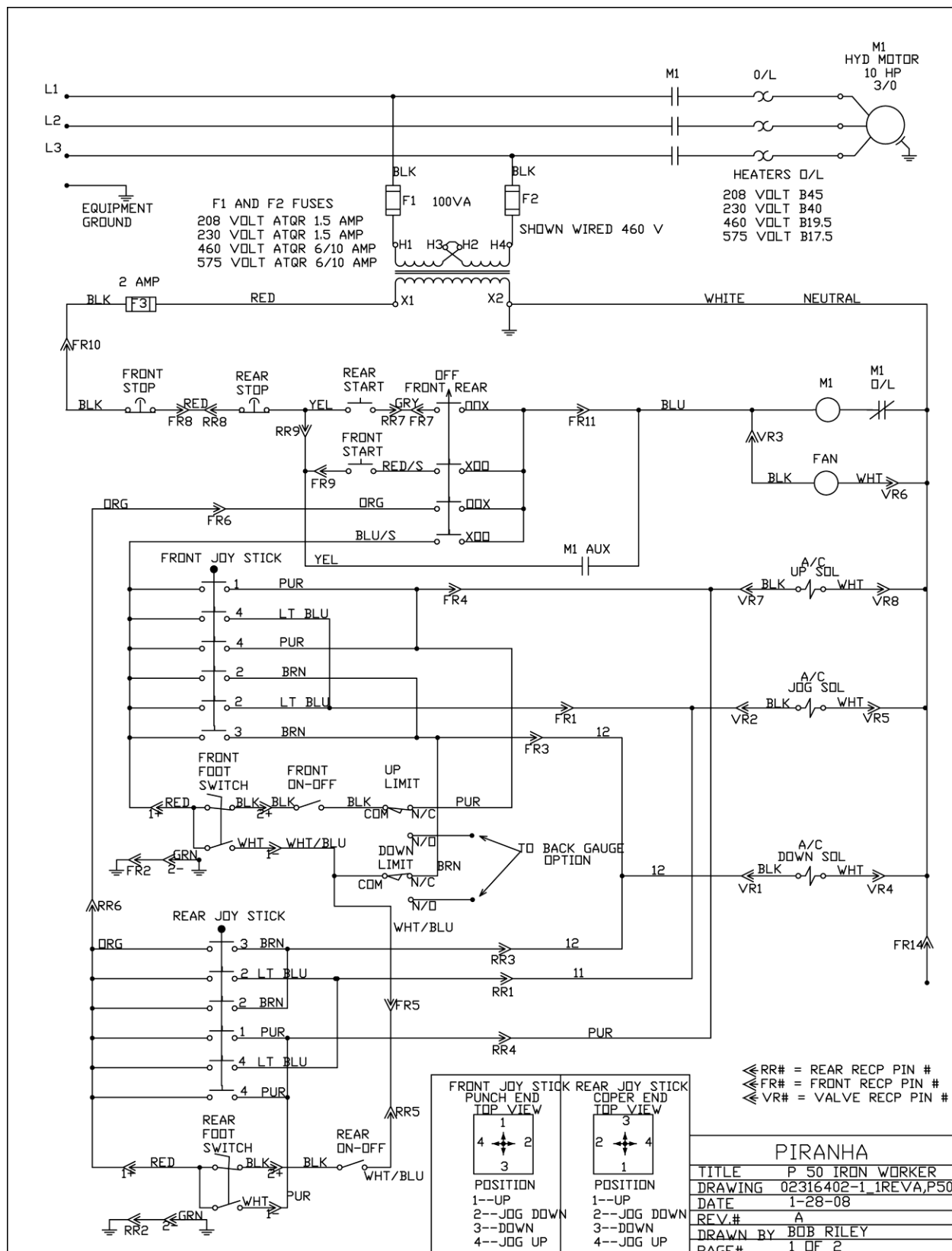


## Electrical Enclosure Assembly

Part Number 02316402-1

Figure and Index No.	Part Number	Description	Qty.
1	0521634	Rear Wiring Harness Receptacle	1
2	0521634	Front Wiring Harness Receptacle	1
3	0521636	Valve Body Harness Receptacle	1
4	0531641	Starter	1
5	T2253	Auxiliary Contact	1
6	05316261	220 / 440 Volt Transformer	1
- or -	05316271	575 Volt Transformer	1
- or -	05316281	208 Volt Transformer	1
7	05316221	Fuse Block	1
8	0531606	MDX3 Fuse	1
9		220 Volt Heater Coil B-36 for Standard 7.5HP	
- or -	0531639	220 Volt Heater Coil B-40 for Speedup 10HP	3
- or -		440 Volt Heater Coil B17.5 for Standard 7.5HP	3
- or -	0531634	440 Volt Heater Coil B-19.5 for Speedup 10HP	3
- or -		575 Volt Heater Coil B12.8 for Standard 7.5HP	3
- or -	0531635	575 Volt Heater Coil B-17.5 for Speedup 10HP	3
10	T0771	208/230 Volt Fuse ATQR 1.5	2
- or -	T0794	440/575 Volt Fuse ATQR 6/10	2
Not Shown	03316512-1	Valve Body Wiring Harness	1



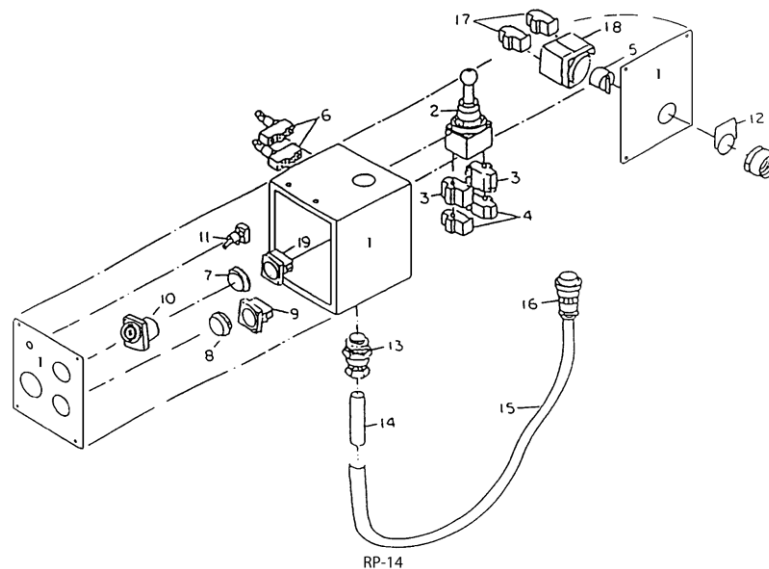


## Front Box Assembly

Part Number 02316292-1

Figure and Index No.	Part Number	Description	Qty.
1	05316291	Front Control Box - With Covers	1
2	0531608-1	Joystick 9001 K35 – With Contact Blocks	1
3	0531609	KA-1 Contact Block	2
4	0531644	KA-2 Contact Block	2
5	05316451-1	Selector Switch ZB4BD3	1
6	0531616	Microswitch	2
7	05316101-1	Start Button ZB4BA3	1
8	05316111-1	Stop Button ZB4BL4	1
9	05316121-1	Contact Block w / base N.C. ZB4BZ102 (Contact Number ZB4BE102)	1
10	0531618	4 Pole Receptacle	1
11	0531619	Toggle Switch	1
12	05316461	Legend Plate, Front-Off-Rear, ZB2BY2002	1
13	0531654	Liquid Tight Connector, 3/8"	1
14	0531657	JIC Grey Conduit	1
15		Flexguard	1
16		Quick Disconnect Plug	1
17	05316781-1	Contact Block ZB4BE101	2
18	0531678-1	Mounting Base with 2 each N.O. Contacts *ZB4BZ103	1
19	0531696-1	Contact Block w/base ZB4BZ101*	1

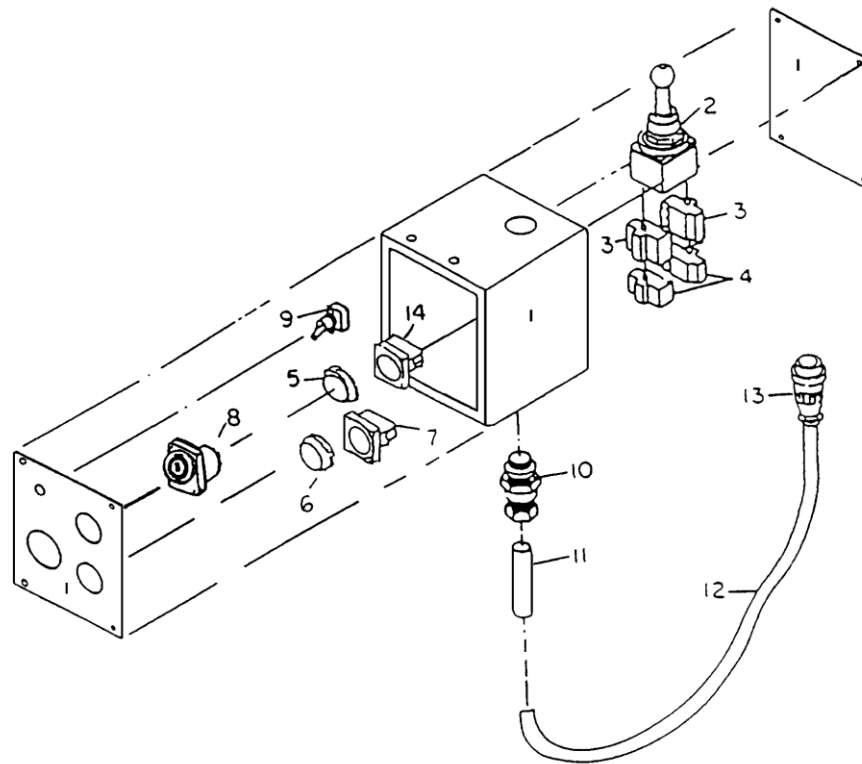
\* Replacement contacts for item Number 18 requires 2 each of part Number ZB4BE101. Item Number 19 requires 1 each.



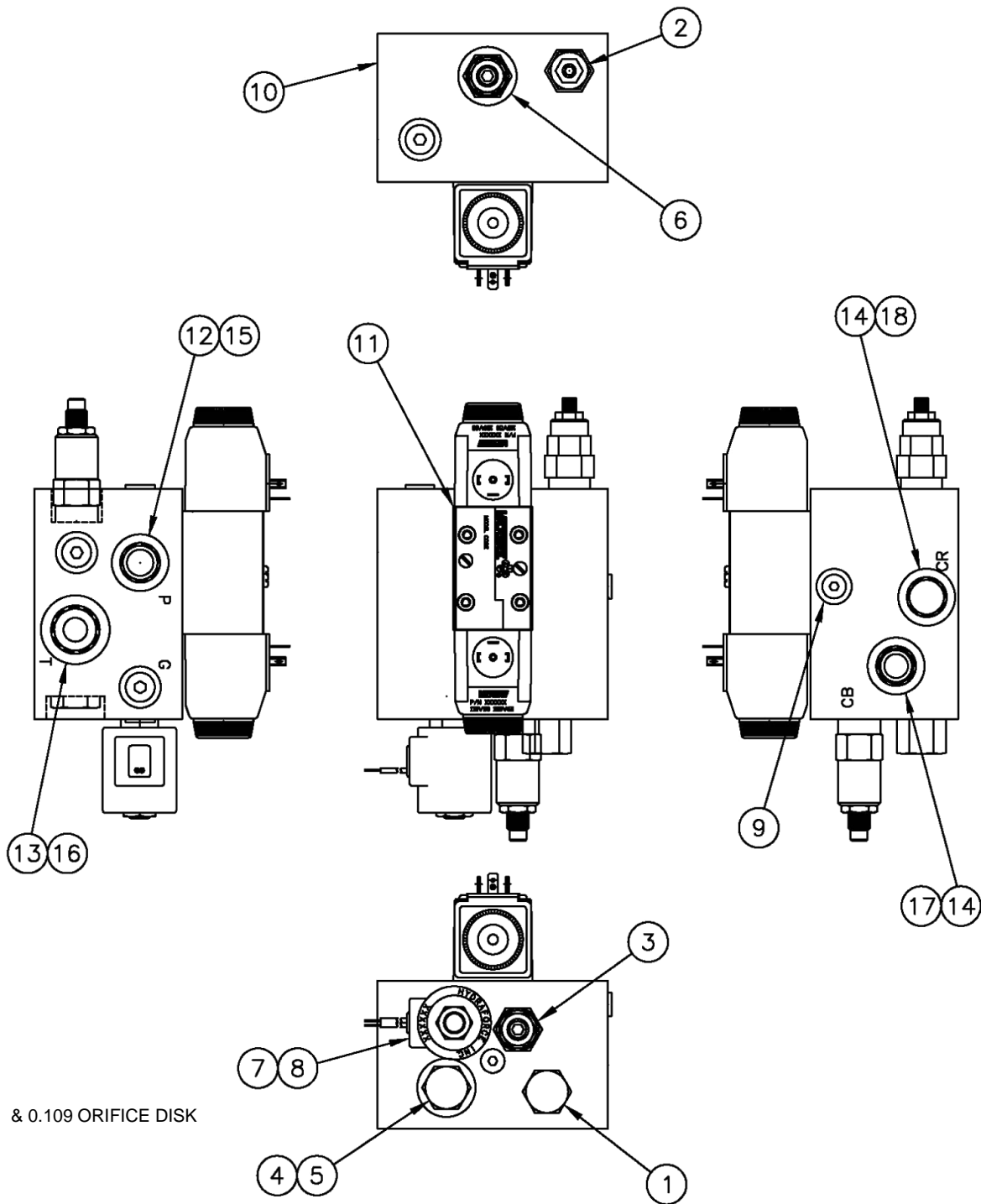
## Rear Box Assembly

Part Number 02316302-1

Figure and Index No.	Part Number	Description	Qty.
1	05316301	Rear Control Box - With Covers	1
2	0531608-1	Joystick 9001 K35 – With Contact Blocks	1
3	0531609	KA-1 Contact Block	2
4	0531644	KA-2 Contact Block	3
5	05316101-1	Start Button ZB4BA3	1
6	05316111-1	Stop Button ZB4BL4	1
7	05316121-1	Contact Block with base N.C. ZB4BZ102 (Contact Number ZB4BE102)	1
8	0531618	4 Pole Receptacle	1
9	0531619	Toggle Switch	1
10	0531654	Liquid Tight Connector 3/8"	1
11	0531657	JIC Grey Conduit	1
12		Flexguard	1
13		Quick Disconnect Plug	1
14	0531696-1	Contact Block with base ZB4BZ101 (Contact Number ZB4BE101)	1



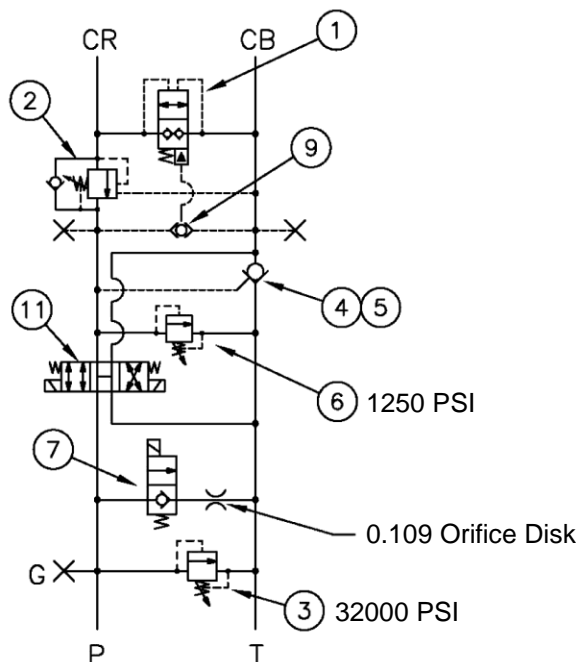
**Valve Body Assembly Illustrated**  
Part Number 0231530-2



## Valve Body Assembly

Part Number 0231530-2

Figure and Index No.	Part Number	Description	Qty.
1	T3572	Pilot Valve 2-Way	1
2	0551566-1	Counterbalance Valve	1
3	0551559-1	Pressure Relief Valve 35/26	1
4	0531567-1	Check Valve	1
5	0531566-1	Single Pilot Piston Valve	1
6	0531562-1	Pressure Relief Valve 25/12	1
7	0551561-1	Solenoid Valve (N.C.)	1
8	T3574	115V AC Solenoid Coil	2
9	0541535-1	Shuttle Valve	1
10	0531530-1	Valve Body	4
11	0531574-1	Directional Control Valve 4-way	1
12	0581503	6801-10 Fitting	1
13	0531531	6801-12 Fitting	1
14	0531509	6802-10 Fitting	2
15	0571532	32" Hose to Filter Assembly	1
16	0531543	32" Hose to Tank	1
17	0531522	75" Hose to Cylinder	1
18	0531521	50" Hose to Cylinder	1
19	03316512-2	Valve Body Wiring Harness (not shown)	1



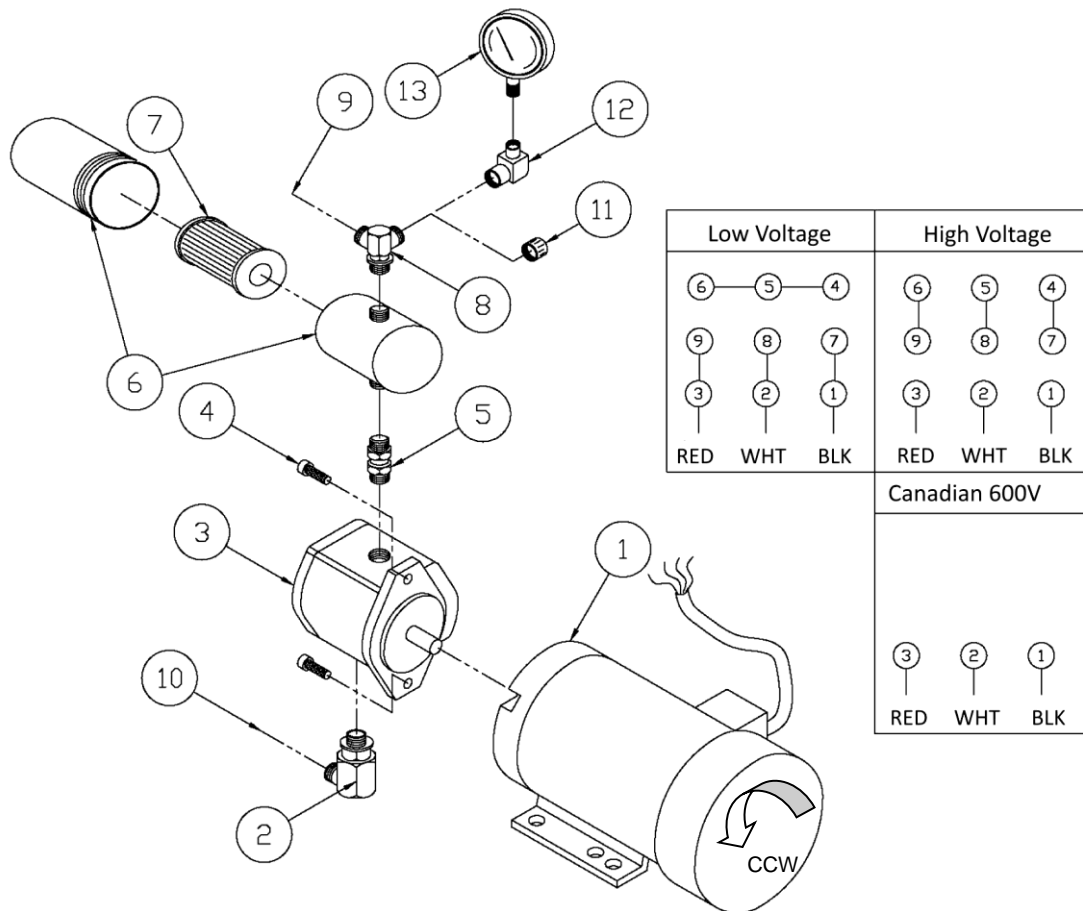
Part that Needs Seal	Seal Part Number
Pilot Valve 2-Way	0531549
Counterbalance Valve	0531598
Pressure Relief Valve 35/26	0531548
Check Valve	0531460
Pressure Relief Valve 25/12	0531460
Solenoid Valve (N.C.)	0531542
Shuttle Valve	0531733

## HYDRAULIC SCHEMATIC

## Motor Assembly

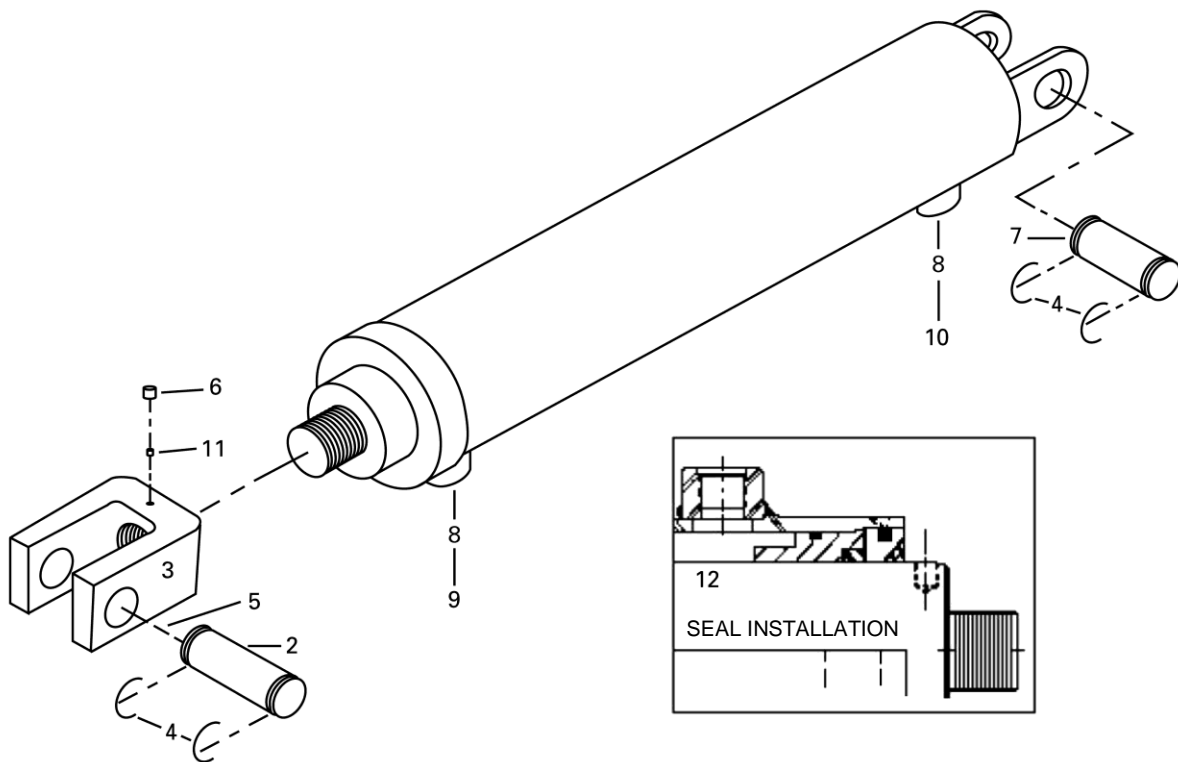
Part Number 0231600-2

Figure and Index No.	Part Number	Description	Qty.
1	05316615	7.5 HP Motor 220/440V (Hollow Shaft)	1
- or -	05316654	7.5 HP Motor 575V (Hollow Shaft)	1
- or -	05316702	10 HP Motor Single Phase (Hollow Shaft)	1
2	0533539	6801-16 Hydraulic Fitting	1
3	05215691-2	Hydraulic Pump	1
4	0531050	3/8" x 1" SHCS	2
5	0531515-1	6403-12-10-NWO	1
6	0521550-2	Filter Assembly 4" Ikron	1
7	0521551-2	Filter Element 4" Ikron	1
8	0531508	6801-10-12LP JM6 Hydraulic Fitting	1
9	0571532	32" Hose to Valve Body	1
10	0531544	48" Hose to Tank	1
11	0541531	304-C-6 Hydraulic Fitting	1
12	0531514	6503-6-4 Hydraulic Fitting	1
13	0541542	Pressure Gauge PGD-25-5000S	1



## Cylinder Assembly

Figure and Index No.	Part Number	Description	Qty.
1	0531503-3	Cylinder- Tata, 2019 models and newer (For older models, please call)	1
2	0230171S	Clevis Pin	1
3	0230152	Clevis	1
4	0531340	5103-125 Snap Ring	4
5	0531362	1652B Zerk Str 1/4-28	1
6	0531085	1/2" x 1/2" SSS	1
7	02301721S	Cylinder Pin	1
8	0531509	6802-10 Hydraulic Fitting	2
9	0531521	50" Hose to Valve Body	1
10	0531522	75" Hose to Valve Body	1
11	N/A	Nylock Plug	1
12	05315011	Green Cylinder Seal Kit, Number 44-1792SS	1



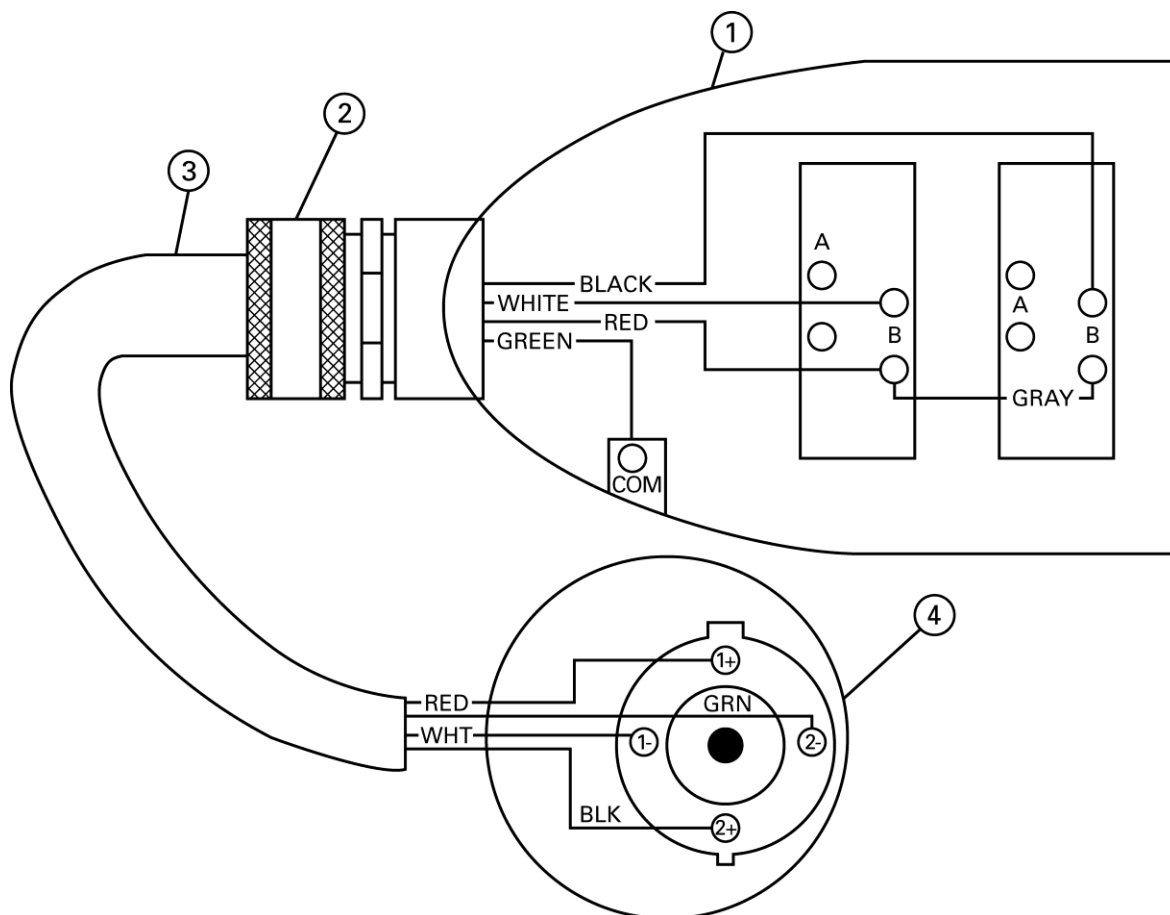


## Foot Switch Assembly

Part Number 0231628

Figure and Index No.	Part Number	Description	Qty.
1	0531655	Foot Switch	1
2	0531636	Cord Grip	1
3	0531637	16 - 4 SEO Cord (sold by the foot)	6 ft
4	0531617	4 Pole Plug	1

**NOTE:** Limit Switches in Foot Pedal are not a stock item but can be obtained.



## Knives

Index No.	Part Number	Description	Qty.
	02302501	Flat Shear Knives x 12.125"	2
	0230252	3/8" Round Bar Knife	2
	0230253	Blank Round Bar Knife	2
	0230254	1/2" Round Bar Knife	2
	0230256	5/8" Round Bar Knife	2
	0230258	3/4" Round Bar Knife	2
	0230260	7/8" Round Bar Knife	2
	0230262	1" Round Bar Knife	2
	0230264	1-1/8" Round Bar Knife	2
	0230266	1-1/4" Round Bar Knife	2
	0230268	1-3/8" Round Bar Knife	2
	0230269	1-1/2" Round Bar Knife	2
	0230270	3/4" Square Bar Knife	2
	0230272	1" Square Bar Knife	2
	0276274	Angle Knife - Lower	2
	0230273	Angle Knife - Upper	1
	0230276	Coper Knife - Lower and Sides	3
	0230277	Coper Knife - Upper	1
	0230280	1/4" Round Bar Knife	2
	0230283	1/2" Square Bar Knife	2
	0230284	5/8" Square Bar Knife	2
	0531050	3/8" x 1" SHCS -Upper Coper	4
	0531072	7/16" x 2-1/4" SHCS - Rear Coper	2
	0531069	7/16" x 1-1/2" SHCS - Side Coper	4
	0531070	7/16" x 1-3/4" SHCS - Upper Shear	4
	0531071	7/16" x 2" SHCS - Lower Shear	4
	0531070	7/16" x 1-3/4" SHCS - Upper Rd. Bar	2
	0531071	7/16" x 2" SHCS - Lower Rd. Bar	2
	0531071	7/16" x 2" SHCS - Lower Angle	4
	0531330	Woodruff Key - Upper Coper Knife	1
	0230271	1/2" Angle Knife	

## Service Record Chart

[illegible]



### Channel Shear

- Attaches to the punch end of the machine.
- Removes a 1/2" slug for each cut.
- Slug must be slid out the front of the channel shear after each cut.
- A pinned slide block is adjusted to accommodate different widths of channel.



## Piranha Optional Tooling and Attachments

---

*Enhance your Piranha's versatility!*

### Pressbrake Tooling Holders

- Allows you to use pressbrake punches and dies in your ironworker for higher precision bending.



### Roller Feed Tables

- Available in 5' lengths.
- Includes rollers for angle and flat bar sections.
- 20" wide flat rollers and 6" angles.



### Channel Die Block

- Enables you to punch into the legs of channel and other structural shapes.
- Mounts in place of your standard die block.
- Still utilizes your urethane punch attachment.
- Can be used in conjunction with offset dies to punch very near to the web of your material.



\*\*\*Additional Options Shown on Inside of Front Cover\*\*\*

