



WXK SERIES HYDRAULIC HOLE DIGGER

Operation Instruction



Fivestar Tools Co.,Ltd

◆ Survey

WXK series hydraulic hole digger is an advanced manual hydraulic tool to tap a hole on a metal plate with the thickness of below 3 mm, which is impossible for ordinary punching machine to do so. It has the characteristics of easy and convenient operation, high speed, even and tidy processed surface, good quality, safety, reliability and without the limit of location and site. It's of portable structure. Artistic and is easy to carry. It's can be used to hole for installing and repairing wire pipe line, signal lamp and instrument in metallurgy, petrol, chemical industry, electronics, electrical appliance, ship and machinery, etc.

Especially, it's suitable for holing on formed face plate, base plate and walls of switch box and distribution box.

◆ Technical Parameters

Model No.	WXK-8	WXK-8B	WXK-8D	WXK-15
Output tonnage (T)	8	8	8	12
Thickness Stainless steel/iron(mm)	1.6/3.2	1.6/3.2	1.6/3.2	2/4
Holing range(mm ²)	16-60	16-60	16-60	16-114
Allocated mould	Φ22Φ27Φ34 Φ43Φ49Φ60	Φ22Φ27Φ34 Φ43Φ49Φ60	Φ22Φ27Φ34 Φ43Φ49Φ60	Φ63Φ76Φ80 Φ89Φ100Φ114

◆ Specification of holing mould

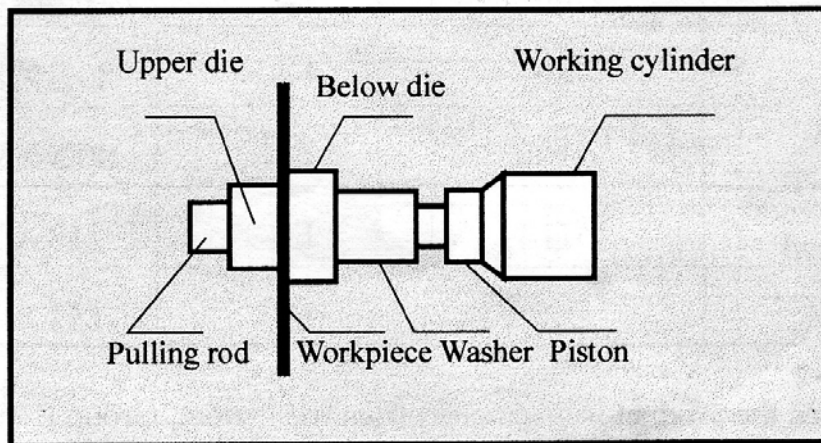
NO.	Holing size	No.	Holing size
Group A mould		Group B mould	
A1	Φ16	B1	Φ22
A2	Φ20	B2	Φ27.5
A3	Φ26.2	B3	Φ34
A4	Φ32.5	B4	Φ43
A5	Φ39	B5	Φ49
A6	Φ51	B6	Φ60
Group C mould		Group F mould	
C1	Φ63	F1	32*32
C2	Φ76	F2	46.5*46.5
C3	Φ80	F3	76.5*76.5
C4	Φ89	F4	80.5*80.5
C5	Φ100	F5	90.5*90.5
C6	Φ114	F6	113*113
		F7	151*151

Note:

When the product is dispatched from the factory, Group B mould is accompanied with Model NO.8; a pair of square hole mould 32*32 and a pair of $\Phi 22$ mould are accompanied with Model NO.15, Other specifications are available too, but they need to order.

◆ Operation Method

1. Before holing on a piece of work piece, make a 11.5mm guide hole by hand electrical driller first.
2. Turn the pulling rod of piston into the screw thread of piston cylinder, then cover washer on piston pulling rod, then put it in cavity die. Stretch the piston pulling-rod into the guide hole, at last, twist cavity die in to make blade of cavity die and the surface to be processed close tightly. At the moment, convex die, work piece and cavity die has been fixed firmly.
3. Switch off spill valve clockwise, then press step-up handle repeatedly to make plunger pump begin working, thus, oil pressure goes up, the shearing force between convex and cavity dies increases, and the mould is holing on the work piece till it shear through the work piece.
4. Loosen spill valve anti-clockwise to unload oil pressure. After operation according to above-mentioned four procedures, holing is finished.
5. Dismount convex die, clear waste plate in cavity die, then wipe the mould clean.



No-load pressing without installing die is prohibited.