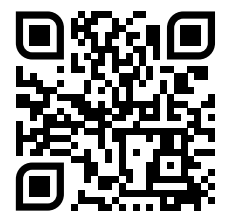
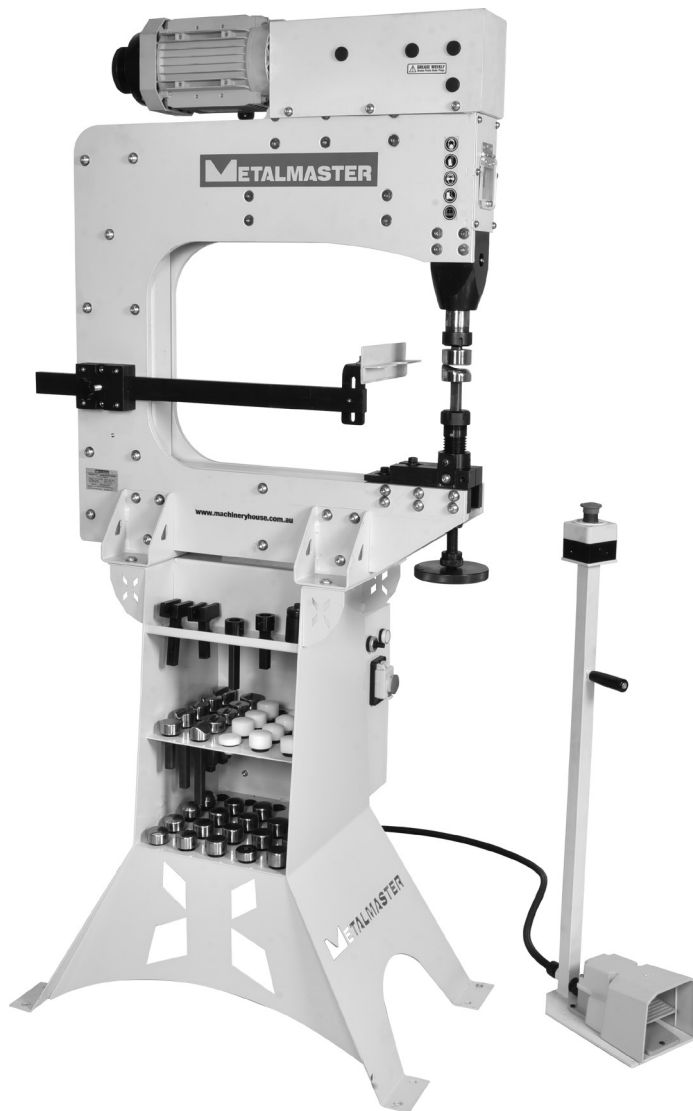


METALMASTER



Edition : 2.0
Date: (02/26)

Instruction Manual

POWER HAMMER PHM-560MK2

Order Code: (S228)

MACHINE DETAILS

MACHINE.	POWER HAMMER
MODEL NO.	PHM-560MK2
SERIAL NO.	
DATE OF MANF.	

IMPORTED BY

AUSTRALIA



www.machineryhouse.com.au

NEW ZEALAND



www.machineryhouse.co.nz

NOTE:

This manual is only for your reference. At the time of the compiling of this manual every effort to be exact with the instructions, specifications, drawings, and photographs of the machine was taken. Owing to the continuous improvement of the METALMASTER machine, changes may be made at any time without obligation or notice. Please ensure the local voltage is the same as listed on the specification plate before operating any electric machine.

SAFETY SYMBOLS:

The purpose of safety symbols is to attract your attention to possible hazardous conditions



Note:

Indicates a potentially hazardous situation causing injury or death

Indicates an alert against unsafe practices.

Used to alert the user to useful information

NOTE:

In order to see the type and model of the machine, please see the specification plate. Usually found on the back of the machine. See example (Fig.1)


	
PRODUCT SPECIFICATIONS	
Model: PHM-560	Voltage: 240V, 50Hz
Capacity: 1.5mm Mild Steel	Motor: 1.1kW / 1.5HP
Nett Weight: 170kg	Full Load Current: 3.65Amps
MFG Date:	
www.machineryhouse.com.au	Serial No: <input type="text"/>
www.machineryhouse.co.nz	Made in China

FIG.1

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1.1 SPECIFICATIONS

Order Code	S228
MODEL	PHM-560
Capacity Mild Steel (mm)	1.2
Capacity Aluminium (mm)	1.6
Throat Height Capacity (mm)	395
Throat Depth Capacity (mm)	560
Strokes (p/min)	0-960
Motor (watt)	750
Power Input	240V,50Hz,1ph
Variable Speed Via. Inverter	AC200-240V, 1ph,50/60Hz, Output 3ph, 4.5amps
Dimensions (H x W x D) (mm)	1800 x 480 x 850
Nett Weight (kg)	170
Gross Weight (kg)	195

Features

1. Suited to a multitude of metal shaping applications for Automotive, Motorcycles, Aviation and Sculpture
2. Easy for adjusting & assembly.
3. Variable speed foot pedal control.
4. Easy speed adjustment via an inverter.
5. Suited to a vast array of materials, including Steel, Aluminium, Stainless Steel, Copper, and many more.
6. Heavy duty steel fabricated frame.
7. Adjustable heavy duty single arm length stop with 1 x Round Roller and 1 x guide fence

NOTICE

**READ AND UNDERSTAND THIS
MANUAL BEFORE OPERATING
THIS EQUIPMENT**



1.2 INCLUDED ACCESSORIES

Tools
Collet Spanners,
Hex Keys &
spanner



3 x Spring Sets
Soft, Medium, Hard

Die Holders and Dies



1.3 INCLUDED DIE HOLDERS & DIES



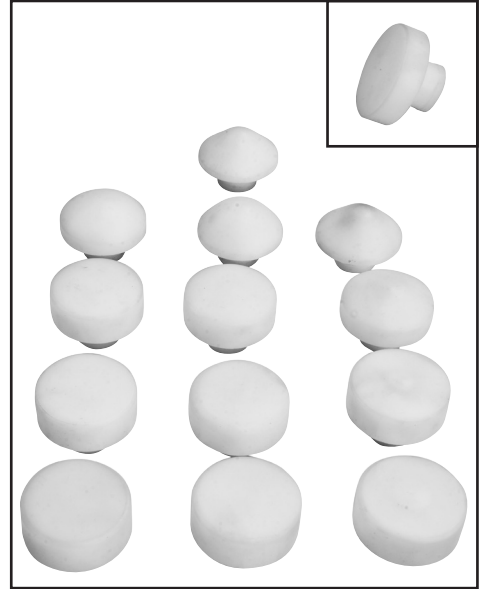
1 x Set - Round Die Holders
 Ø20 x 20mm Holder
 (16mm square shank)



1 x Set Doming Dies
3.1" Radius
 (Ø20 x 20mm round shank)



16 x Steel Lower Dies
 3/4", 1", 1-1/8", 1-1/2", 1-7/8", 2", 3", 4", 5",
 6", 8", 14-1/2", 24", 36" Radius
 (Ø20 x 20mm round shanks)



1 x Nylon Upper Die
13 x Nylon Lower Dies
 3/4", 7/8", 1-1/8", 1-1/2", 1-7/8", 4", 5",
 6" x 1/16" Radius Edge, 6" x 1/4" Radius Edge,
 8", 14-1/2", 24", 36" Radius
 (Ø20 x 20mm round shank)



Upper Hammer Die
 (16mm square shank)



Lower Linear Stretching Die
 (16mm square shank)



1 x Set Universal Die Holders
 14mm opening
 (16mm square shank)



1 x Set Thumbnail Shrinking Dies
 (16mm square shank)



1 x Set 1/4" Beading Dies
 (16mm square shank)



1 x Set 3/8" Beading Dies
 (16mm square shank)

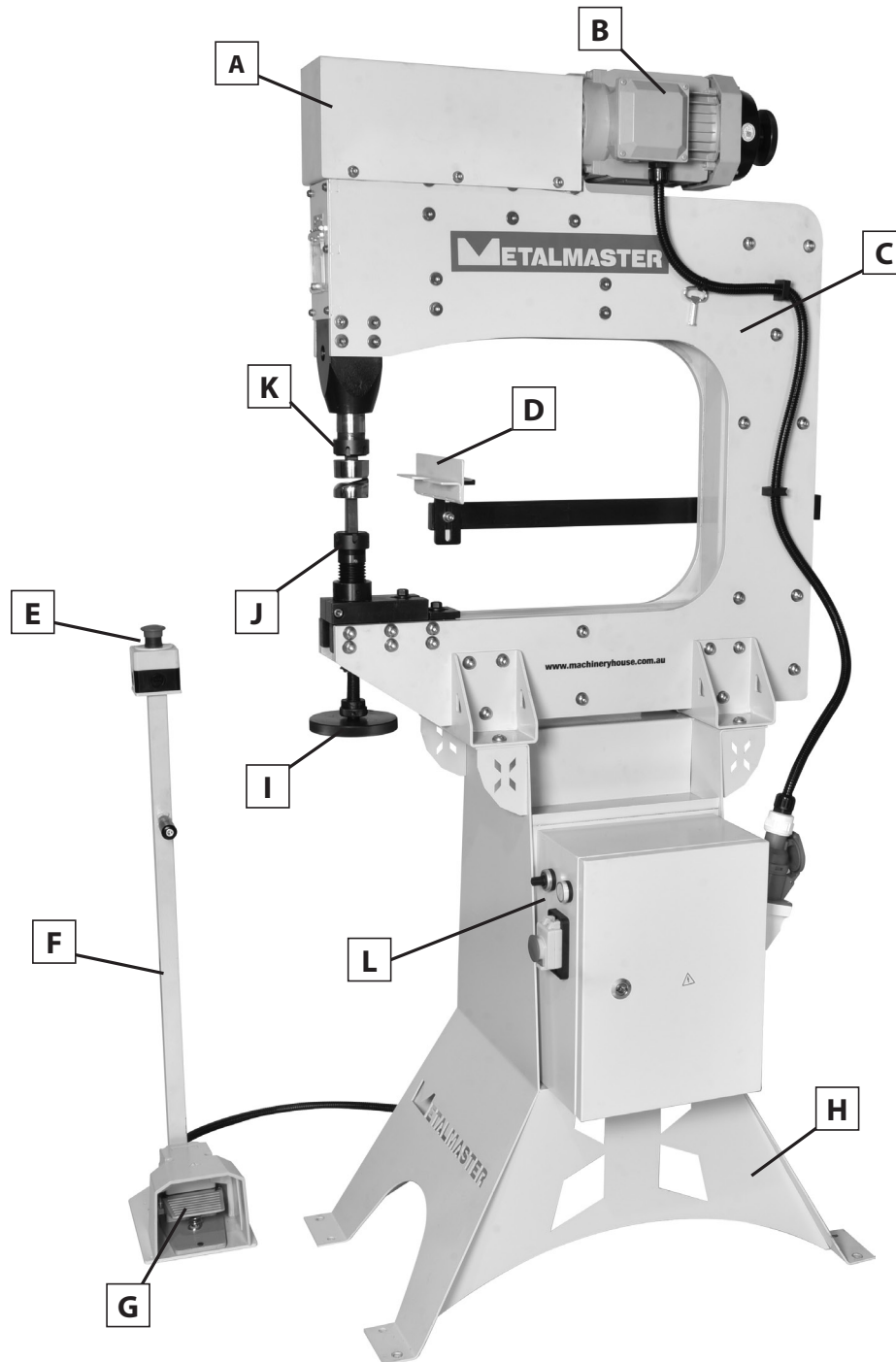


1 x Set 1/2" Beading Dies
 (16mm square shank)



1 x Set Louvre Dies
 (16mm square shank)

1.4 IDENTIFICATION



A	Drive Shaft Cover	G	Foot Pedal Control
B	Motor	H	Heavy Duty Stand
C	Main Frame	I	Lower Die Adjustment Handle
D	Fence	J	Lower Collet Chuck Die Holder
E	Emergency Stop Button	K	Upper Collet Chuck Die Holder
F	Roving Foot Pedal	L	Control Panel

1.5 CONTROLS

The purpose of this control overview is to provide the novice operator with a basic understanding of how the machine is used during operation, and the machine controls and what they do. It also helps the operator to understand if they are discussed later in this manual.

NOTE: DO NOT start the machine until all of the setup instructions have been performed. Operating a machine that is not setup may result in malfunction or unexpected results that can lead to serious injury, death or damage to the machine or property.

Control Panel

A. Speed Control: When adjusted increases or decreases the number of blows per minute of the Hammer. (Fig. 1.2)

NOTE: Numbers shown are indicated in % and do not refer to the number of blows per minute.

B. Power Lamp: This lamp is illuminated when the motor is switch ON. (Fig. 1.2)

C. ON/OFF Power Switch Cover: When the cover is lifted then access is available to the ON/OFF buttons. When the red knob on the cover is pressed the motor will stop and the cover will be latched. (Fig. 1.2)

D. ON Button: When pressed switches the motor ON (Fig. 1.2)

E. OFF Button: When pressed switches the motor OFF (Fig. 1.2)

Mobile Foot Control: (F)

G. Emergency Stop Button: When pressed switches the power to the control panel OFF. To reset the EMERGENCY STOP twist the Red button clockwise until it pops out - this resets the E-Switch and enables the ON/OFF buttons to work again. (Fig. 1.3)

H. Variable Foot Pedal: When pressed starts the hammer action begins and increases or decreases with pressure applied. (Fig. 1.3)

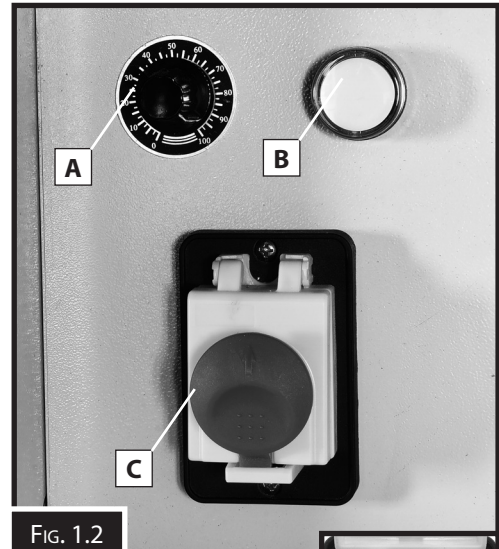


FIG. 1.2

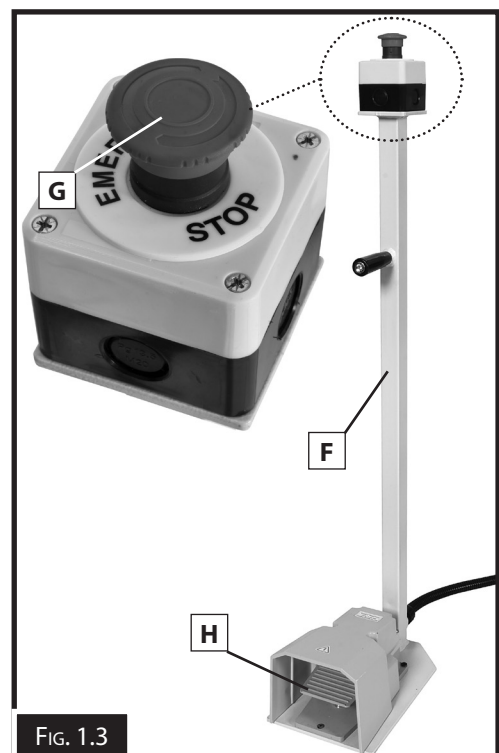
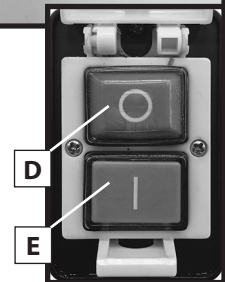


FIG. 1.3

2. SAFETY

2.1 GENERAL METALWORKING MACHINE SAFETY

DO NOT use this machine unless you have read this manual or have been instructed in the use of this machine in its safe use and operation.



WARNING

This manual provides safety instructions on the proper setup, operation, maintenance, and service of this machine. Save this manual, refer to it often, and use it to instruct other operators. Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.

The owner of this machine is solely responsible for its safe use. This responsibility includes, but is not limited to proper installation in a safe environment, personnel training and authorization to use, proper inspection and maintenance, manual availability and comprehension, of the application of the safety devices, integrity, and the use of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



- ✓ Always wear safety glasses or goggles.
- ✓ Wear appropriate safety footwear.
- ✓ Wear respiratory protection where required.
- ✓ Gloves should never be worn while operating the machine, and only worn when handling the workpiece.
- ✓ Wear hearing protection in areas > 85 dBA. If you have trouble hearing someone speak from one metre (three feet) away, the noise level from the machine may be hazardous.
- ✓ DISCONNECT THE MACHINE FROM POWER when making adjustments or servicing.
- ✓ Check and adjust all safety devices before each job.
- ✓ Ensure that guards are in position and in good working condition before operating.
- ✓ Ensure that all stationary equipment is anchored securely to the floor.
- ✓ Ensure all machines have a start/stop button within easy reach of the operator.
- ✓ Each machine should have only one operator at a time. However, everyone should know how to stop the machine in an emergency.

2.1 GENERAL SAFETY REQUIREMENTS CONT.

- ✓ Ensure that keys and adjusting wrenches have been removed from the machine before turning on the power. Appropriate storage for tooling should be provided.
- ✓ Ensure that all cutting tools and blades are clean and sharp. They should be able to cut freely without being forced.
- ✓ Stop the machine before measuring, cleaning or making any adjustments.
- ✓ Wait until the machine has stopped running to clear cuttings with a vacuum, brush or rake.
- ✓ Keep hands away from the cutting head and all moving parts.
- ✓ Avoid awkward operations and hand positions. A sudden slip could cause the hand to move into the cutting tool or blade.
- ✓ Return all portable tooling to their proper storage place after use.
- ✓ Clean all tools after use.
- ✓ Keep work area clean. Floors should be level and have a non-slip surface.
- ✓ Use good lighting so that the work piece, cutting blades, and machine controls can be seen clearly. Position any shade lighting sources so that they do not cause any glare or reflections.
- ✓ Ensure there is enough room around the machine to do the job safely.
- ✓ Obtain first aid immediately for all injuries.
- ✓ Understand that the health and fire hazards can vary from material to material. Make sure all appropriate precautions are taken.
- ✓ Clean machines and the surrounding area when the operation is finished.
- ✓ Use proper lock out procedures when servicing or cleaning the machines or power tools.

DO NOT

- × Distract an operator. Horseplay can lead to injuries and should be strictly prohibited.
- × Wear loose clothing, gloves, neckties, rings, bracelets or other jewelry that can become entangled in moving parts. Confine long hair.
- × Handle cuttings by hand because they are very sharp. Do not free a stalled cutter without turning the power off first. Do not clean hands with cutting fluids.
- × Use rags or wear gloves near moving parts of machines.
- × Use compressed air to blow debris from machines or to clean dirt from clothes.
- × Force the machine. It will do the job safer and better at the rate for which it was designed.



CAUTION !

A prepared list of safety guidelines can never be complete. Every workshop environment is different. Always consider Safety first, as it applies to your individual working conditions. Use this machine and other machinery with caution and respect. Failure to do so could result in serious Personal injury, damage to the equipment, or poor work results.

2.1 GENERAL SAFETY REQUIREMENTS CONT.

HAZARDS ASSOCIATED WITH MACHINES include, but are not limited to:

- Being struck by ejected parts of the machinery.
- Being struck by material ejected from the machinery.
- Contact or entanglement with the machinery.
- Contact or entanglement with any material in motion.

Health Hazards (other than physical injury caused by moving parts)

- Chemicals hazards that can irritate, burn, or pass through the skin.
- Airborne items that can be inhaled, such as oil mist, metal fumes, solvents, and dust.
- Heat, noise, and vibration.
- Ionizing or non-ionizing radiation. (X-ray, lasers, etc.)
- Biological contamination and waste.
- Soft tissue injuries (for example, to the hands, arms, shoulders, back, or neck) resulting from repetitive motion, awkward posture, extended lifting, and pressure grip.

Other Hazards

- Slips and falls from and around machinery during maintenance.
- Unstable equipment that is not secured against falling over.
- Safe access to/from machines. (access, egress)
- Fire or explosion.
- Pressure injection injuries from the release of fluids and gases under high pressure.
- Electrical Hazards, such as electrocution from faulty or ungrounded electrical components.
- Environment in which the machine is used. (in a machine shop, or on a work site)



WARNING

The machine is the sole responsibility of the owner for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training, proper inspection and maintenance, manual availability and comprehension. The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



WARNING!

Machines are safeguarded to protect the operator from injury or death with the placement of guards. Machines must not be operated with the guards removed or damaged.

2.2 SPECIFIC SAFETY FOR POWER HAMMERS

DO NOT use this machine unless you have been instructed in its safe use and operation and have read and understood this manual.



Safety glasses must be worn at all times in work areas.



Close fitting protective clothing or overalls are encouraged



Appropriate protective footwear with substantial uppers must be worn.



Rings and jewellery must NOT be worn in the workshop



Gloves should be worn when handling a work piece



Ear protection should be used in loud and noisy conditions

PRE-OPERATIONAL SAFETY CHECKS

1. Ensure you are familiar with the operation of the Power Hammer.
2. Check for any damage or parts missing.
3. The area around the machine must be clean and free of trip hazards.
4. Hammer dies used, must be inspected for safe use i.e. no cracks.
5. Double check/re-tighten upper locator dies & mounting posts.
6. Ensure safety glasses or goggles are available and are worn by all persons in the vicinity.
7. Any test piece, project or material (work piece) to be pressed must be of an appropriate thickness and safe to use on this equipment.
8. Faulty equipment must not be used. Immediately check suspect machinery.

OPERATIONAL SAFETY CHECKS

1. Check working height is approximately at the middle of operators chest (Standing platform may be required)
2. Place your test piece, project or material securely between the top and bottom dies.
3. Using the hand-wheel/crank, rotate the hand-wheel to check the two dies are not impacting & check clearance before turning the machine on.
4. Do not over reach. Maintain a balanced stance at all times, so that you do not fall or lean against the machine.
5. Use the Power Hammer pedal, to slowly work the material & gradually increase RPM
6. Keep hands and fingers away from the hammer dies.
7. Wear leather gloves when handling any work piece with sharp edges.
8. Use the right tool. Do not force a hammer die set to do a job that it was not designed to do.
9. Give your work undivided attention. Looking around, carrying on a conversation and “horseplay” are careless acts that can result in serious injury
10. DO NOT apply excessive force to the Power Hammer.

AFTER OPERATION COMPLETED

1. After use, clean the machine down and place any tools and equipment in the appropriate storage area.
2. Place all scrap or waste in the appropriate bin.

POTENTIAL HAZARDS

- Beware of high forces applied
- Pinch and squash
- Eye injuries – flying or shattering objects
- Laceration injuries

3. POWER SUPPLY

3.1 ELECTRICAL INSTALLATION

Place the machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure there is access to a means of disconnecting the power source. The electrical circuit must meet the requirements for 240V.

NOTE : The use of an extension cord is not recommended as it may decrease the life of the electrical components on your machine.

ELECTRICAL REQUIREMENTS

Nominal Voltage.....	240V
Cycle.....	50 Hz
Phase.....	Single Phase
Power Supply Circuit.....	15 Amps
Full Load Current.....See the Motor Plate

(Full load current rating is also on the specification plate on the motor.)

3.2 FULL-LOAD CURRENT RATING

The full-load current rating is the amperage a machine draws when running at 100% of the output power. Where machines have more than one motor, the full load current is the amperage drawn by the largest motor or a total of all the motors and electrical devices that might operate at one time during normal operations.

Full-Load Current Rating for these machine is available on the motor plate.

It should be noted that the full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating and if the machine is overloaded for a long period of time, damage, overheating, or fire may be caused to the motor and circuitry.

This is especially true if connected to an undersized circuit or a long extension lead. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the requirements.



4 SET-UP

4.1 UNPACKING

This machine was carefully packaged for safe transport. When unpacking, separate all enclosed items from packaging materials and inspect them for shipping damage. If items are damaged, please contact your distributor.

NOTE: Save all the packaging materials until you are completely satisfied with the machine and have resolved any issues with the distributor, or the shipping agent.

When unpacking, check the packing list to make sure that all parts shown are included. If any parts are missing or broken, please contact your distributor.

4.2 CLEAN - UP

The unpainted surfaces of the machine have been coated with a waxy oil to protect them from corrosion during shipment. Remove the protective coating with a solvent cleaner or a citrus based degreaser.

Optimum performance from your machine will be achieved when you clean all moving parts or sliding contact surfaces that are coated with rust preventive products.

It is advised to avoid chlorine based solvents, such as acetone or brake parts cleaner, as they will damage painted surfaces and strip metal should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.

4.3 SITE PREPARATION

When selecting the site for the machine, consider the largest size of workpiece that will be processed through the machine and provide enough space around the machine for operating the machine safely. Consideration should be given to the installation of auxiliary equipment. Leave enough space around the machine to open or remove doors/covers as required for the maintenance and service as described in this manual.

It is recommended that the machine is anchored to the floor to prevent tipping or shifting. It also reduces vibration that may occur during operation.

4.4 LIFTING INSTRUCTIONS



This machine is extremely heavy. Serious personal injury may occur if safe moving methods are not followed. To be safe, you will need assistance and power equipment when moving the shipping crate and removing the machine from the crate.



On the day that the machine arrives, make sure that a forklift or lifting device, with sufficient capacity is available to unload the machine from the vehicle. Ensure access to the chosen site is clear and that doors and ceilings are sufficiently high and wide enough to receive the machine.



Make sure that the lifting eyebolt is screwed completely in and is secured. Use only certified lifting equipment.

4.5 ANCHORING TO THE FLOOR

OPTIONS FOR MOUNTING

The machine is best mounted on a concrete slab. Masonry anchors with bolts are the best way to anchor machinery, because the anchors sit flush with the floor surface, making it easy to unbolt and move the machine later if needed. (Fig. 4.1) Other methods of mounting is the use of machine mounts which also help with the levelling of the machine and isolating vibration. (Fig. 4.4)

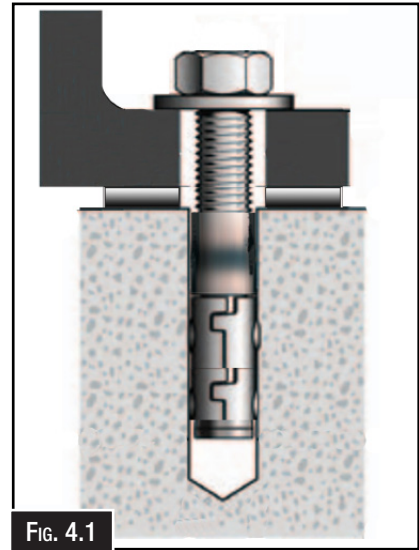


Fig. 4.1

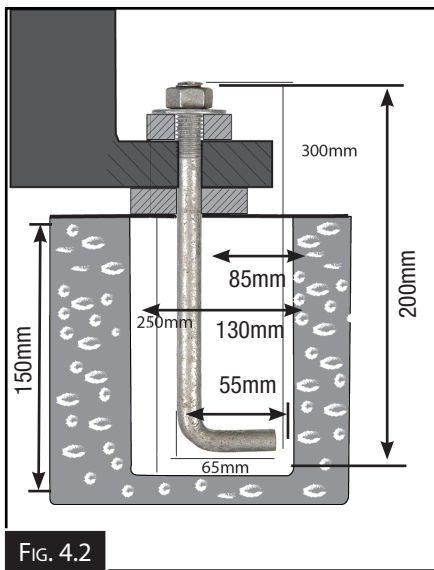


Fig. 4.2

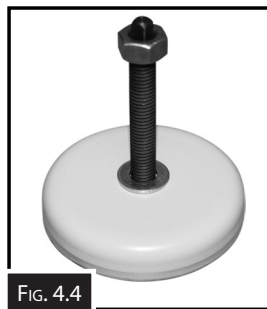


Fig. 4.4

In some cases a suitable foundation may not be available and a new one may need to be prepared.

The foundation should be concrete approximately 200mm thick with pockets left clear for the hold down bolts. The hold down bolts can be “L” shape as per the example in Fig. 4.2.

4.6 MACHINE LEVELING

To set your machine up so that it operates to optimum performance, apply the following procedure.

After your machine has been anchored to a concrete slab floor, it then needs to be leveled. Loosen the hold down bolts and place a level on the surface of the working table. Metal shims need to be placed under the corner of the base of the machine until level. Once level then tighten the hold down bolts. (Fig. 4.3).

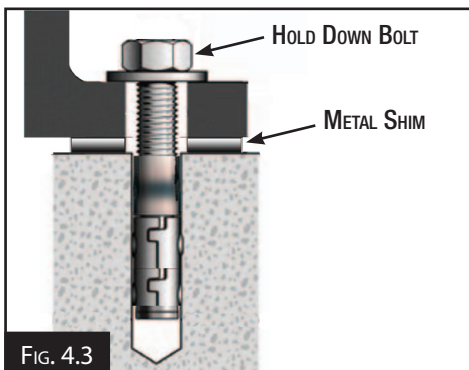


Fig. 4.3



CAUTION

The machine must not rest on supports other than those defined in Fig. 4.3

4.7 ASSEMBLY

NOTE: For additional information regarding the parts listed in the following pages, refer to the Parts Diagram.

1. Unpack the Power Hammer components on the floor where the unit will be located and mounted. The floor must be able to support the weight of the Power Hammer and the workpieces.
2. Mount the Power Hammer to the Stand using four Bolts, Washers, and Nuts.

4.8 TEST RUN

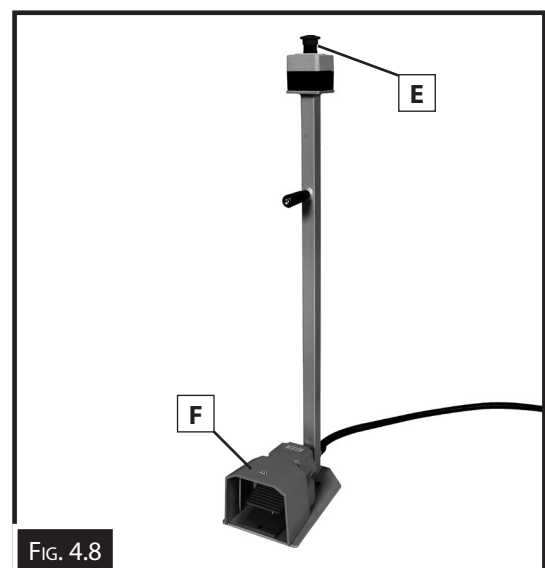
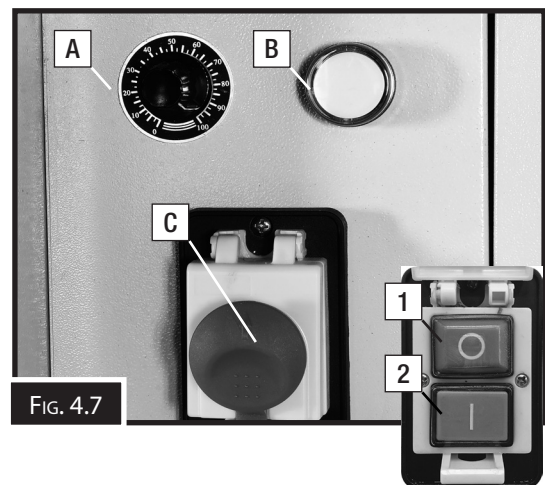
Before installing any tooling, test run the machine to ensure it is properly connected to power and safety components are functioning correctly. If you find an unusual problem during the test run, immediately stop the machine, disconnect it from power, and fix the problem BEFORE operating the machine again. If no solution can be found, then consult your service engineer for help.

The Test Run consists of verifying the following:

1. The motor powers up and runs correctly, and
2. The safety disabling mechanism on the emergency stop button works correctly.

To test run the machine:

1. Clear all setup tools away from machine.
2. Press the Emergency STOP button (E in Fig. 4.8) This will help prevent unexpected startup when the machine is connected to the power
3. Connect the machine to the power supply.
4. Reset the EMERGENCY STOP button by twisting the top until the top pops up, then release the yellow cover so it can be raised to expose the ON/OFF buttons.
5. Press the ON button (2 in Fig. 4.7) and the power lamp will illuminate (B in Fig. 4.7) then press the foot pedal (F in Fig.4.8). The machine should run smoothly without any rubbing noises.
6. Hold the pedal down and press the OFF button (1 in Fig 4.7) and the machine should stop.
7. Repeat steps 5 then press the Emergency stop button on the roving foot pedal (E in Fig. 4.8). The power lamp will go off and the machine should not operate
8. Without resetting EMERGENCY STOP button, press the foot pedal (F in Fig.4.8). The machine should not start.
9. Reset the emergency stop button (E in Fig. 4.8) and press the foot pedal and the machine should work.
10. Once the machine is working correctly then the Test Run is completed.



5. OPERATION

This machine may perform many types of operations that are beyond the scope of this manual. Many of these operations may be dangerous or deadly if performed incorrectly.

The instructions in this section are written with the understanding that the operator has the necessary knowledge and skills to operate this machine. If at any time you are experiencing difficulties performing any operation, stop using the machine!

If you are an inexperienced operator, we strongly recommend that you read books, trade articles, or seek training from an experienced operator before performing any unfamiliar operations.

Above all, your safety should come first!

5.1 RIGID & SPRING MODES

The Rigid or Spring mode are used for various functions. Rigid mode is used only for planishing, there is noticeable sound difference between rigid & spring modes when tools are making contact. The hammer springs are deactivated and the top die bolted rigid. (Fig.5.1)

To set the machine to Rigid Mode:

1. DISCONNECT THE MACHINE FROM THE POWER
2. Using the hand wheel on the back of the motor, lower the top die to the lowest part of the stroke. (Fig. 5.2)
3. Lower the bottom die so there is a 25mm gap between the top and lower dies
4. Open the perspex cover on the side of the head and rotate the black knob half a turn until it is in the position of the rigid mode and is secured with the spring loaded detent pin. (Fig. 5.3)
5. Once the change has been made to Rigid mode and the dies have been added, then move the upper die to the lowest point again using the hand wheel and set the gap between the top and bottom dies.

NOTE: *With the tools installed, it is very important that the tool gap is set properly or the machine will fail. The gap should be set to the material thickness.*

6. Once the lower die has been set the bottom die must be locked by using the "C" spanner to adjust the lock nut against the adjusting spindle. (Fig. 5.4)
7. Complete the locking of the adjusting shaft by securing the locking collar with an Hex key. (Fig. 5.5)

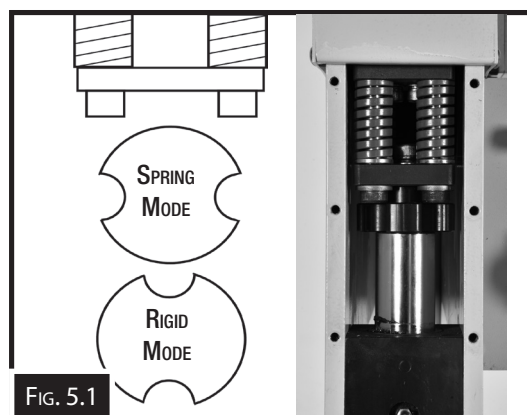


FIG. 5.1

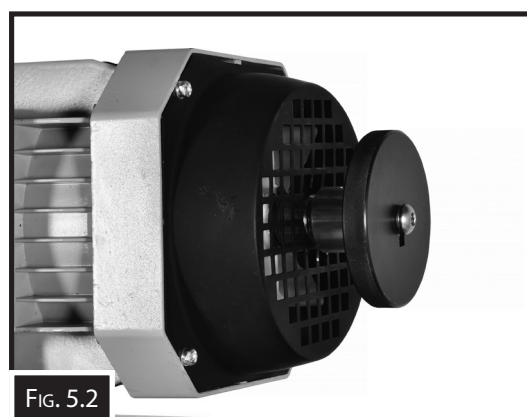


FIG. 5.2

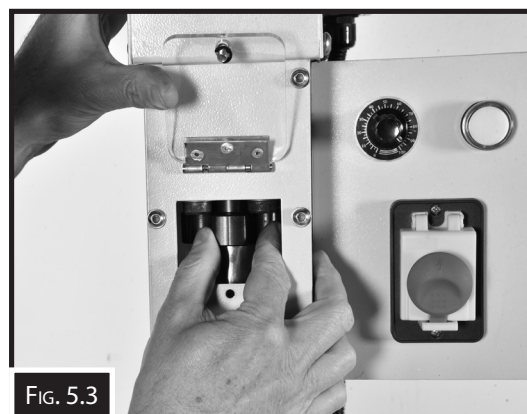


FIG. 5.3



FIG. 5.4



FIG. 5.5

5.2 CHANGING THE SPRINGS

Stroke length adjustment is used to provide the amount of force desired to produce the results desired. The longer the stroke, the greater the force will be generated. Three different spring sets are supplied and can be changed in the machine depending on type of material being used.

3 x Spring Sets
Soft, Medium, Hard



SPRING COLOUR	RED	GREEN	BLUE
SPRING HARDNESS	SOFT	MEDIUM	HARD
STEEL GAUGE	0.8mm	0.8~1.0mm	1.0~1.2mm
ALUMINIUM GAUGE	0.8~1.0mm	1.0~1.6mm	1.2~2.0mm

- 1. Disconnect Power:** Ensure the machine is powered off and unplugged to avoid any electrical hazards during the process.
- 2. Remove Top Cover:** Unscrew or detach the top cover of the machinery to access the internal components.
- 3. Remove Crank Link:** Disconnect the crank link (this is the linkage that connects to the crank mechanism), ensuring all fasteners or pins are removed.
- 4. Remove Shaft and Coupling:** Carefully detach the shaft that connects with other moving parts. Ensure the coupling is also removed.
- 5. Remove Hammer Assembly:** Unscrew or disconnect the hammer assembly from the system. Be mindful of any other components that may be attached or in the way.
- 6. Separate Assembly:** Carefully separate the assembly components to access the springs.
- 7. Note Any Shims:** As you disassemble, make note of any shims or washers. These are small parts that maintain proper spacing and alignment. Document their positions.
- 8. Change Springs:** Remove the old springs and replace them with new ones. Ensure the new springs match go back the same way the old ones came out.
- 9. Refit Any Shims:** After the springs are replaced, refit any shims you noted during disassembly in their correct positions.
- 10. Reassemble in Reverse Order:** Begin reassembling the machine by reversing the disassembly steps, ensuring everything is securely fitted, and connections are properly made.
- 11. Test Run:** Once reassembled, turn the power back on and test the machinery to make sure everything functions properly.

5.3 TOOL SET-UP & ADJUSTMENT

The machine's top tool holder and bottom tool holder are designed for 16mm square shank tools. The tools are held in place by collet chucks for both the top and bottom tools. The collet chuck for the top tool is tightened to hold the tool in place. Before locking the tools in place, the tool's shank must be inserted into the tool holder until its shank bottoms out in the tool holder. The top collet chuck is fixed but the collet chuck for the bottom tool is set but has a mechanism so the bottom tool can be moved up after each pass for multiple pass work without loosening the collet chuck. (Fig. 5.6)

Tooling Adjustment

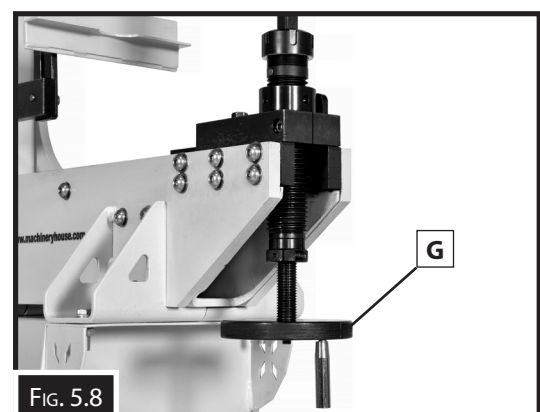
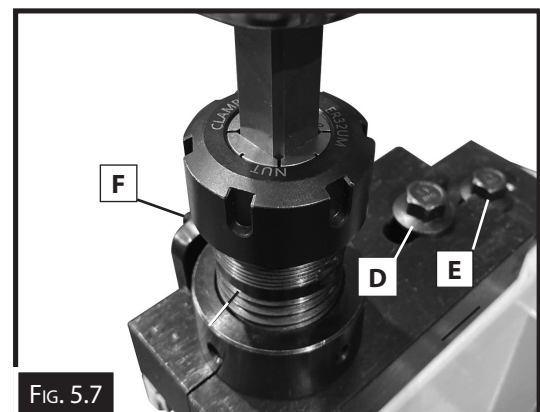
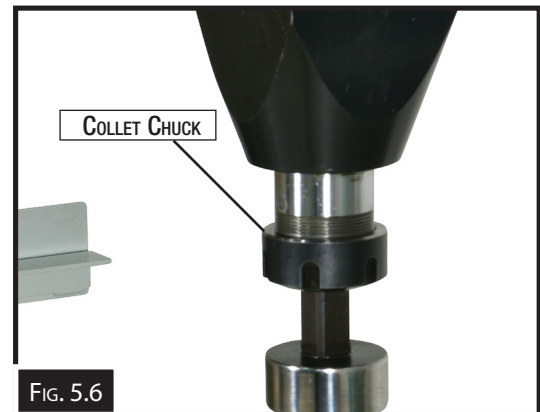
The bottom tool holder is adjustable "in-out" and "side to side" relative to the top tool holder.

To adjust the bottom tool holder "in-out", loosen the screw holding the adjuster lock plate in position.

Loosen the screw holding the bottom post base and move it in and out as required. (D in Fig. 5.7) Check the "side to side" alignment. After final position is obtained first lock the bottom post in position, then slide the adjuster lock plate (E in Fig. 5.7) in position against the bottom post base and lock in position.

Up and down adjustment of the tool holder is usually not changed from the factory setting. Factory furnished dies are cut to a standard length for the factory setting of the up/ down position.

When it is necessary to adjust the bottom tool up or down follow this procedure. Rotate handle (G in Fig. 5.8) to move tool up or down as needed. Nylon top lock set screw "F" is adjusted so to allow the bottom tool adjuster screw to be turned, but not shake loose during operations.



5.4 FENCE SET UP & ADJUSTMENT

Straight Fence (Fig.5.9)

The standard straight fence is a stop and support for straight edge work. It can be adjusted “up-down” to support the work piece (Y in Fig. 5.11) and “in-out” by loosening the stop clamp (X in Fig.5.10) to adjust the work piece in relation to the tooling. The vertical adjustment should support the work piece without putting a bow in the work piece.

Vertical adjustment is made by loosening the screw on the side of the frame and moving the straight fence to the desired position. (Y in Fig. 5.11)

Horizontal adjustment is made by loosening the clamp handle (X in Fig. 5.10) on the side of the frame and moving the straight fence in and out as required.

You can move the whole fence assembly with the extra hole in the frame, if required.

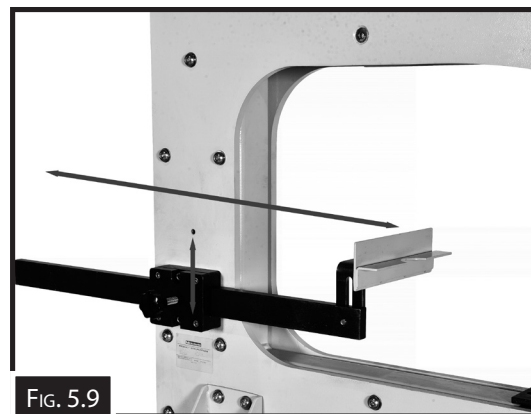


FIG. 5.9

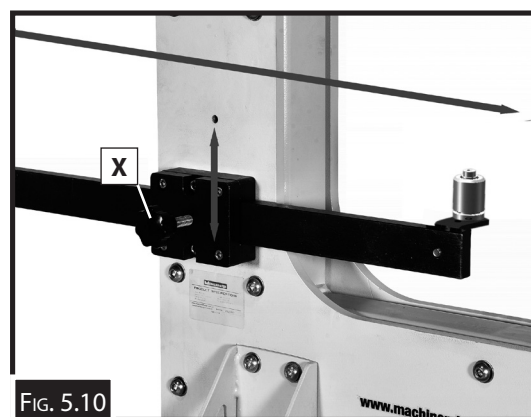


FIG. 5.10

Contour Fence (Fig. 5.10)

The contour fence is a stop for parts where a curved edge is required.

To change from the straight fence to the contour fence, remove the straight fence back stop from the support rods, and install the contour fence assembly. Adjust the contour fence “up-down” (Y in Fig 5.11) so the center of the roller on the contour fence is on the centerline line of the tools. The “up-down” and “in-out” adjustments of the contour fence is the same as straight fence.

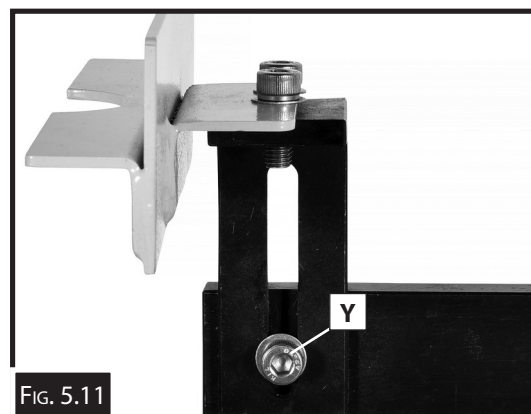


FIG. 5.11

5.5 SHRINKING & STRETCHING DIES SET-UP

Sometimes knowing whether to shrink or stretch the material can be a problem. A paper template with cuts from the high line to the edge of the paper may help with this discussion.

Thumbnail Shrinking Dies are used to shrink and create a compound curves. (Fig. 5.12)

Linear Stretching Dies are used to stretch material. Use the flat "U" as the upper die and Stretching Die "L" as the Lower Die. (Fig. 5.13)

NOTE: With the tools installed, it is very important that the tool gap is set properly or the machine could fail.

Set the machine to **Spring Mode** and load the dies.

1. DISCONNECT THE MACHINE FROM THE POWER.
2. Using the hand wheel in front of the motor, and lower the top die to the lowest part of the stroke.
3. Set the gap between the top and bottom dies to the material thickness by raising the bottom die and lock.
4. Align the bottom die so that it lines up with the top die and then secure.

NOTE: Always set the tools with the hand wheel on the side of the machine. The gap should be set to the material thickness.

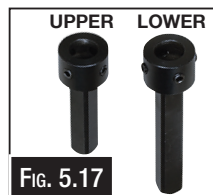
5.6 PLANISHING DIES SET-UP (Fig. 5.14)

Planishing is where the dies impact both sides of the material to stretch or smooth the metal. The advantage of planishing dies is that it can work in very tight spaces and affect a precise area on the panel. A more rigid mode should be set for all planishing operations.

Planishing dies can vary from very tight radius to low crown radius, eg. 3/4" - 36" radius.

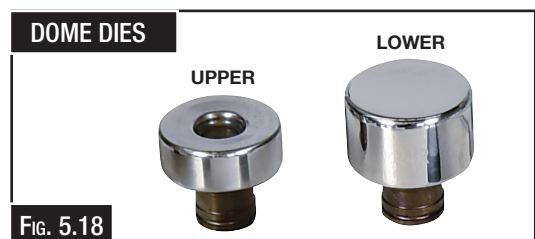
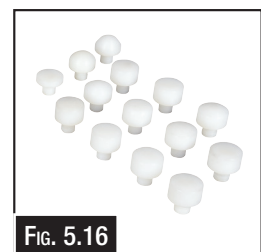
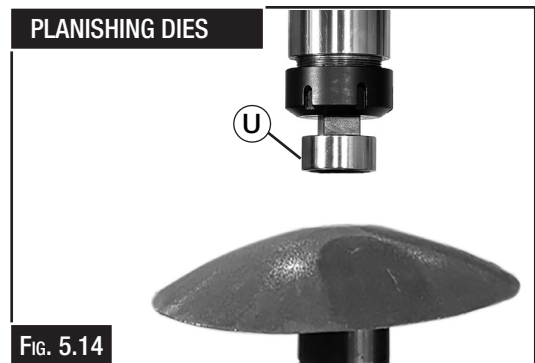
All steel & nylon dies. (Fig. 5.15 & 5.16) use the round die holders (Fig. 5.17). Note: Nylon dies are used for non marking applications etc, or on soft materials such as copper, brass or aluminium.

Set machine to **Spring Mode**.



5.7 DOME DIES SET-UP (Fig. 5.18)

Dome Dies are used when roughing metal into a dome bowl shape. Use dome dies with the round die holders (Fig.5.17). Set machine to **Spring Mode**.



5.8 BEADING DIES SET-UP

Tool Alignment. (Fig. 5.19)

From the operator side of the machine the bead runs L to R, place the dies in the tool holders appropriately with the male beading die being the top die (Fig. 5.19). For alignment use a straight edge. For checking the “in-out” alignment, place the straight edge against the diameters on front of the top tool and front of bottom tool.

For checking the “side to side” alignment, place the straight edge 90 degrees from front face against the sides of the top tool and bottom. Adjust bottom tool to align with the top tool. The principal adjustment for the bottom die is “in-out” from the operator position. Minor adjustments in the “side to side” direction can be made. The dies should be aligned as close as possible “front to back” to avoid pinching the metal.

Set the machine to **Rigid Mode** and load the dies.



FIG. 5.19

5.9 LOUVRE DIES SET-UP (FIG. 5.20)

NOTE: *With the tools installed, it is very important that the tool gap is set properly or the machine could fail.*

Set the machine to **Rigid Mode** and load the dies.

1. DISCONNECT THE MACHINE FROM THE POWER.
2. Using the hand wheel in front of the motor, and lower the top die to the lowest part of the stroke.
3. Set the gap between the top and bottom dies to the material thickness by raising the bottom die and lock.
4. Align the bottom die so that it lines up with the top die and then secure.

NOTE: *Always set the tools with the hand wheel on the side of the machine. The gap should be set to the material thickness.*

MUST PRE-CUT LOUVRE SLOTS.

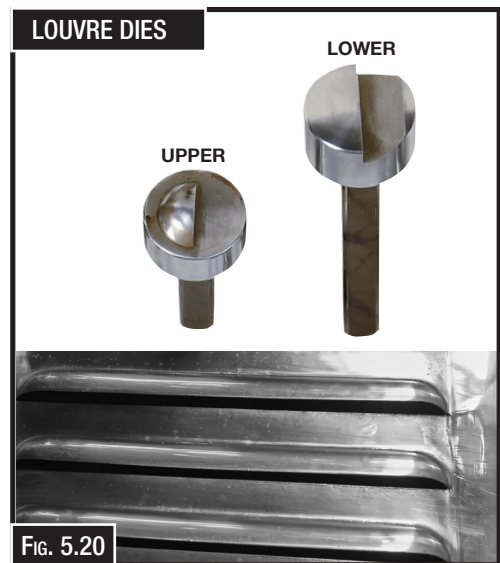


FIG. 5.20

5.10 UNIVERSAL DIE HOLDERS SET-UP (FIG. 5.21)

Universal Die Holders allow you to create custom tooling from materials like Aluminum, Plastic, Wood, or Steel. Mount your shaped material (up to 14mm thick) securely using two grub screws. Design your custom profile as needed for your application.

Set the machine to **Rigid Mode** and load the dies.

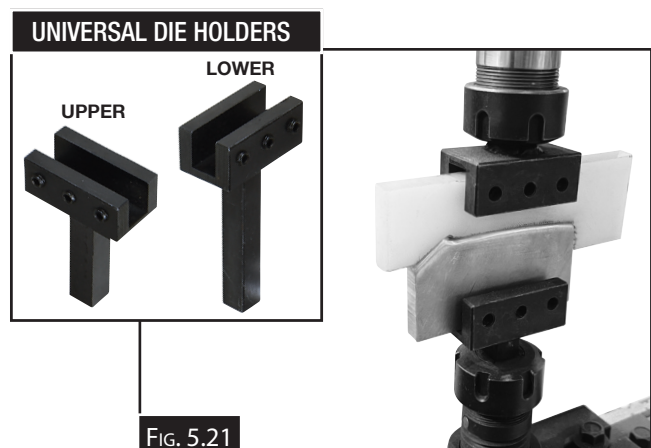


FIG. 5.21

6. OPTIONAL ACCESSORIES**PHT-SMLD (S2290)**

Small Louvre
Die Set
16mm Square Shank

**PHT-SMTSD (S2294)**

Small Thumbnail
Die Set
16mm Square Shank

**PHT-MDTSD (S2295)**

Medium Thumbnail
Die Set
16mm Square Shank

**PHT-MDNYTSD (S2296)**

Medium Nylon Thumbnail
Die Set
16mm Square Shank



7. MAINTENANCE



WARNING Before maintaining or cleaning the machine, turn off the circuit breaker, or disconnect the machine from the power supply. Post a sign to inform other workers that the machine is under maintenance.

For optimum performance from the machine, it is important that the machine is well cleaned and maintained. Follow the maintenance schedule listed in the following section and refer to any specific instructions given.

7.1 SCHEDULE

Daily Check

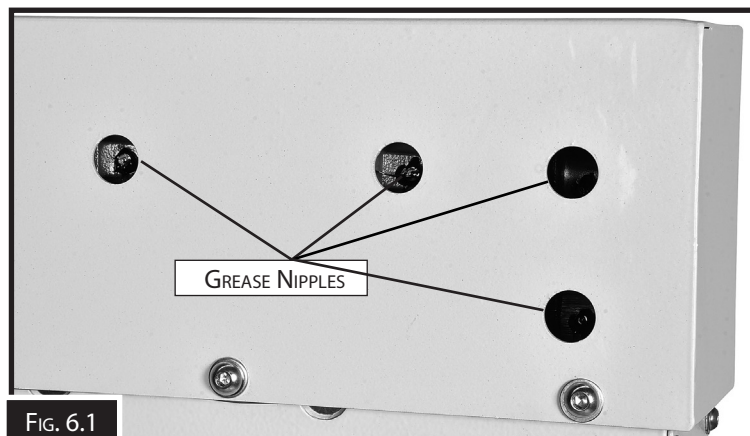
- Loose mounting bolts.
- Worn or damaged wires.
- Check/adjust lubrication.
- Any other unsafe condition.

Cleaning

Cleaning the machine is relatively easy. Wipe down all unpainted and machined surfaces daily to keep them rust free and in top condition. This includes any surface that is vulnerable to rust if left unprotected. Use ISO 68 machine oil or any other quality metal lubricant.

7.2 LUBRICATION

Below are the grease point for the machine (Fig. 6.1). These should be lubricated weekly.



Recommended Grease – (High Temperature Rated)

For smooth operation, long service life, and reliable performance under heavy loads, use a high-temperature NLGI 2 grease on your Power Hammer. Proper lubrication reduces wear, prevents overheating, and protects components during demanding use.

Recommended Greases

Penrite Heavy Duty Bearing Grease 450GM – HDBG00045

Nulon Earth Moving & Construction NLGI 2 Grease 450g – EMCG-C

Lubrication Tips

- Apply grease regularly, especially during continuous or heavy use.
- Clean grease points before applying new grease.
- Avoid mixing different grease types unless compatibility is confirmed.

SPARE PARTS SECTION

POWER HAMMER

Model. PHM-560MK2

Order Code S228

EDITION No : PHM-560MK2

DATE OF ISSUE : 02/2026

The following section covers the spare parts diagrams and lists that were current at the time this manual was originally printed. Due to continuous improvements of the machine, changes may be made at any time without notification.

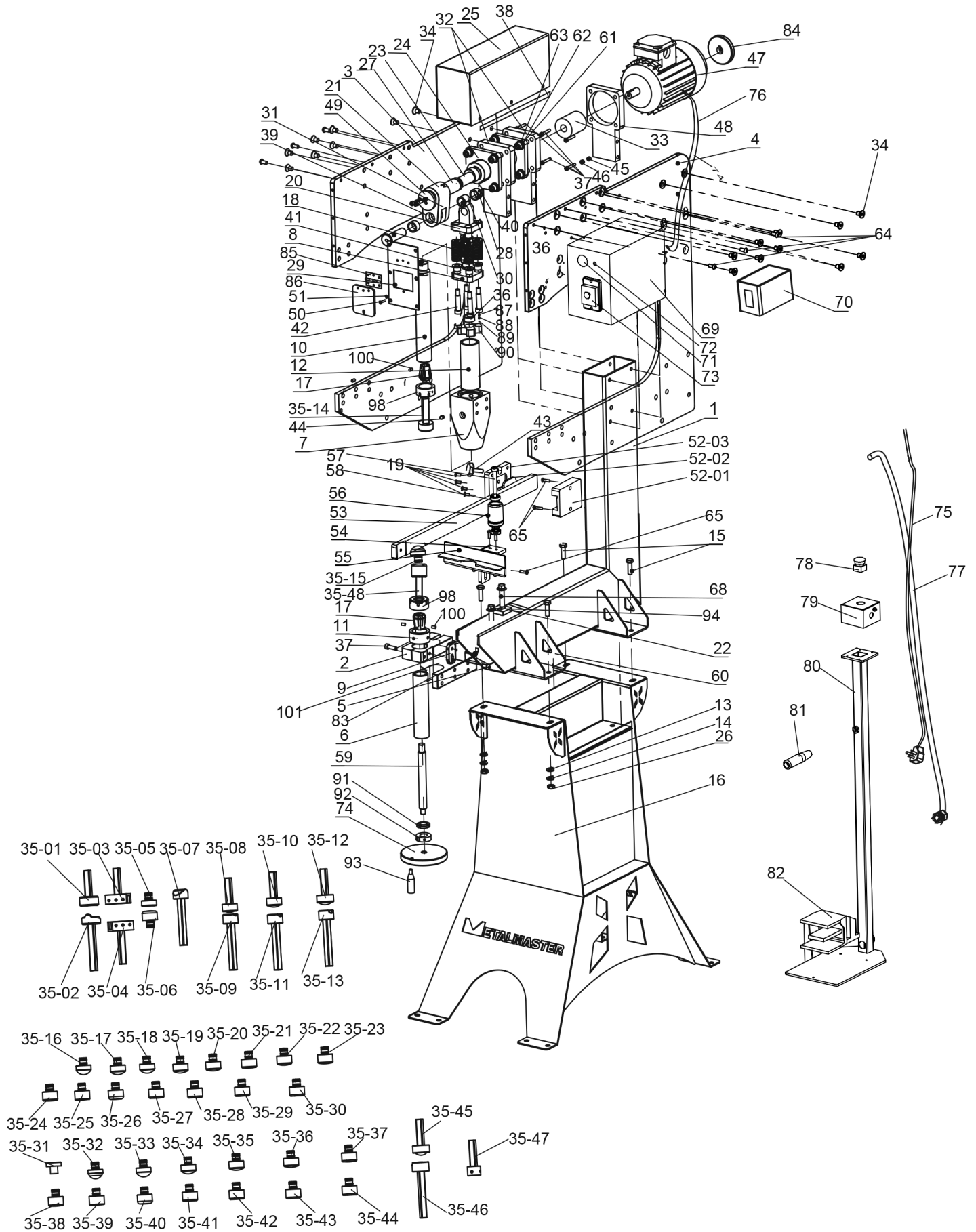
HOW TO ORDER SPARE PARTS

1. Have your machines **model number, serial number & date of manufacture** on hand, these can be found on the specification plate mounted on the machine
2. A scanned copy of your parts list/diagram with required spare part/s identified
3. Go to www.machineryhouse.com.au/contactus and fill out the inquiry form attaching a copy of scanned parts list.

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SPARE PARTS DIAGRAM

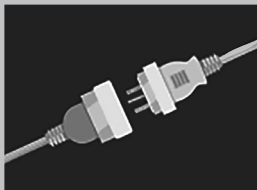


SPARE PARTS LIST

Item	DESCRIPTION	Qty.	Item	DESCRIPTION	Qty.
1	Main Frame	1	35-15	1 pc Steel Lower Die-3/4"	1
2	Bottom Post Base	1	35-16	1 pc Steel Lower Die-7/8"	1
3	Left Plate	1	35-17	1 pc Steel Lower Die-1"	1
4	Right Plate	1	35-18	1 pc Steel Lower Die-1-1/8"	1
5	Screw	1	35-19	1 pc Steel Lower Die-1-1/2"	1
6	Bottom Post	1	35-20	1 pc Steel Lower Die-1-7/8"	1
7	Top Post Base	1	35-21	1 pc Steel Lower Die-2"	1
8	Upper Spring Seat	1	35-22	1 pc Steel Lower Die-3"	1
9	Lock Plate	1	35-23	1 pc Steel Lower Die-4"	1
10	Piston	1	35-24	1 pc Steel Lower Die-5"	1
11	Lock Nut	1	35-25	Steel Lower Die 6"(1/16" Rad)	1
12	Copper Bushing	1	35-26	Steel Lower Die-6"(1/4"Rad)"	1
13	Washer 10mm	8	35-27	1 pc Steel Lower Die-8"	1
14	Spring Washer 10mm	8	35-28	1 pc Steel Lower Die-14-1/2"	1
15	Bolt M10X25	4	35-29	1 pc Steel Lower Die-24"	1
16	Stand	1	35-30	1 pc Steel Lower Die-36"	1
17	collet	2	35-31	1 pc Nylon Upper Die	1
18	Spring	4	35-32	1 pc Nylon Lower Die-3/4"	1
19	Screw M6X16	4	35-33	1 pc Nylon Lower Die-7/8"	1
20	Lower Spring Seat	1	35-34	1 pc Nylon Lower Die-1-1/8"	1
21	Crank Link	2	35-35	1 pc Nylon Lower Die-1-1/2"	1
22	Lock Shaft	1	35-36	1 pc Nylon Lower Die-1-7/8"	1
23	Crank Shaft	1	35-37	1 pc Nylon Lower Die-4"	1
24	Bearing UCF206	2	35-38	1 pc Nylon Lower Die-5"	1
25	Cover	1	35-39	Nylon Lower Die- 6""(1/16"" Rad)	1
26	Nut M10	12	35-40	Nylon Lower Die- 6""(1/4"" Rad)"	1
27	Copper Bushing	1	35-41	1 pc Nylon Lower Die-8"	1
28	Screw M5X20	1	35-42	1 pc Nylon Lower Die-14-1/2"	1
29	Cover Plate	1	35-43	1 pc Nylon Lower Die-24"	1
30	202620 Copper Bushing	1	35-44	1 pc Nylon Lower Die-36"	1
31	202615 Copper Bushing	2	35-45	Upper Louvre Die	1
32	Bearing Seat	2	35-46	Lower Louvre Die	1
33	Shaft Coupling	1	35-47	20mm Upper Round Die Holder	1
34	Screw M10X12	14	35-48	20mm Lower Round Die Holder	1
35-01	Upper Shrinking Die	1	36	Bushing	1
35-02	Lower Shrinking Die	1	37	Screw M8X35	5
35-03	16mm Upper Universal Die Holder16mm	1	38	Rubber Plate	2
35-04	Lower Universal Die Holder	1	39	Pin	1
35-05	Upper Doming Die	1	40	Collar	1
35-06	Lower Doming Dies	1	41	1218 Copper Bushing	4
35-07	1 pc of Linear Stretching Dies	1	42	Bolt 12X70	4
35-08	Upper 1/4" Beading Dies	1	43	Adjustable Handle	2
35-09	Lower 1/4" Beading Dies	1	44	Oil Cup	3
35-10	Upper 3/8" Beading Dies	1	45	Washer 8mm	6
35-11	Lower 3/8" Beading Dies	1	46	Spring Washer 8mm	6
35-12	Upper 1/2" Beading Dies	1	47	Motor	1
35-13	Lower 1/2" Beading Dies	1	48	Motor Base	1
35-14	1 pc Steel Upper Die	1	49	Plate	1

SPARE PARTS LIST

Item	DESCRIPTION	Qty.	Item	DESCRIPTION	Qty.
50	Screw M6X10	6	75	Power Cord	1
51	Spring Washer 6mm	6	76	Motor Cable	1
52-01	Stop Support	1	77	Foot Pedal Cable	1
52-02	Stop Plate	1	78	Emergency Stop	1
52-03	Stop Clamp	1	79	Emergency Stop Box	1
53	Stop Rod	2	80	Foot Pedal Stand	1
54	Fence Bracket	1	81	Handle	1
55	Straight Fence	1	82	Variable Speed Foot Pedal	1
56	Contour Fence Roller	1	83	Nut M6	1
57	Bolt M10X65	1	84	Hand Wheel	1
58	Bearing	2	85	Hinge	2
59	Adjusted Screw	1	86	Acrylic plate	3
60	LEG	1	87	Screw M6X6	4
61	Screw M12X30	8	88	Spring	5
62	Washer 12mm	10	89	Steel Ball	6
63	Spring Washer 12mm	8	90	Adjusting block	1
64	Screw M8X20	6	91	Nut	1
65	Screw M8X25	3	92	Collar	1
66	Screw M8X10	8	93	Handle	1
67	Screw M8X8	8	94	Screw M12X50	1
68	Screw M12X30	1	95	Hex Key	1 set
69	Control Box	1	96	15mm wrench	1
70	Inverter	1	97	Wrench	1
71	Power Lamp	1	98	collet nut	1
72	Potentiometer	1	99	collet wrench	1
73	Power Switch	1	100	collet pin	4
74	Handle	1	101	Seat	1

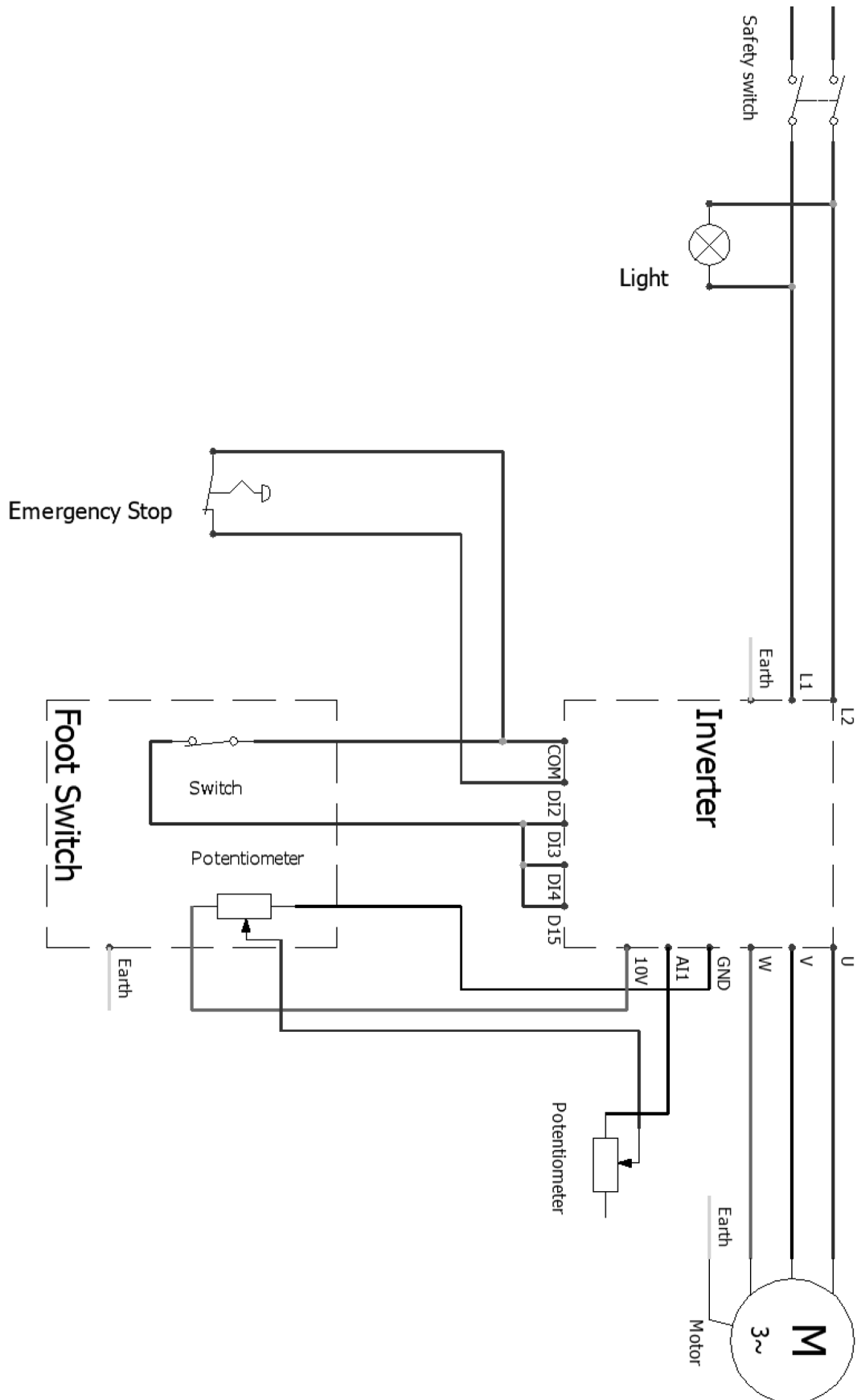


WARNING

Always disconnect the power to the machine before servicing or doing maintenance to the machine.

NOTE: SOME INDIVIDUAL PARTS MAY ONLY BE AVAILABLE AS AN ASSEMBLY

ELECTRICAL DIAGRAM





ENVIRONMENT PROTECTION

Recycle unwanted materials instead of disposing of them as waste. All tools, accessories and packaging should be sorted, taken to a recycling centre and disposed of in a manner which is compatible with the environment. When the product becomes completely unserviceable and requires disposal, drain any fluids (if applicable) into approved containers and dispose of the product and fluids according to local regulations.

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