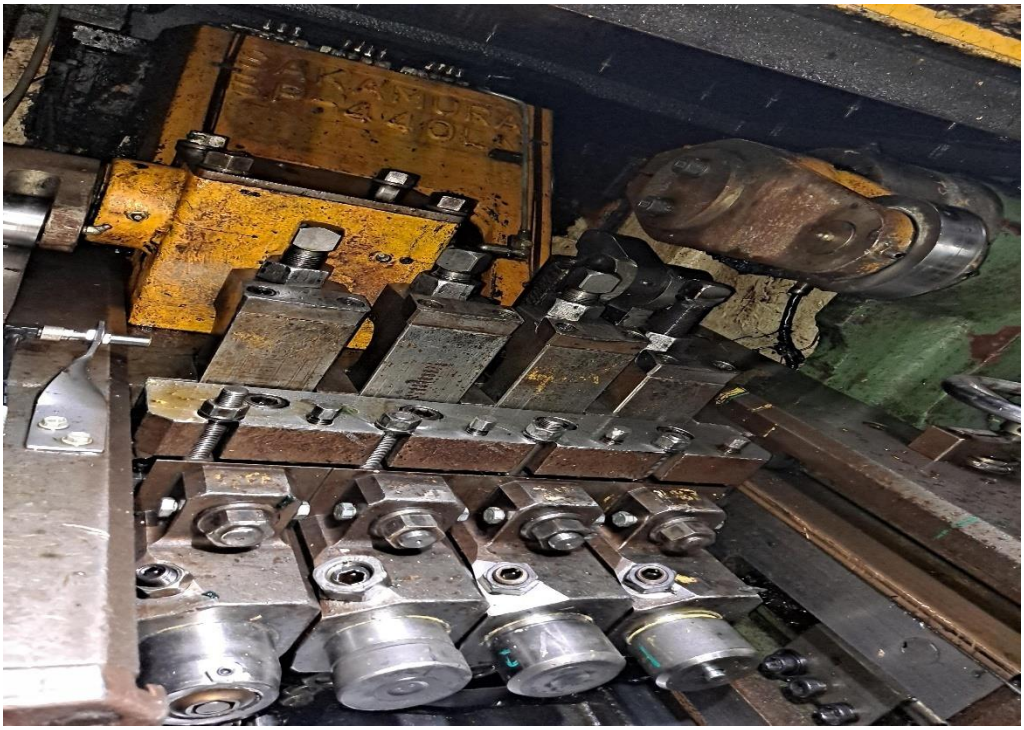
# Sakamura 4-Die Progressive Header (BP440LL)

Setup, Operation, and Troubleshooting

*Written by: Austin Baumgart*

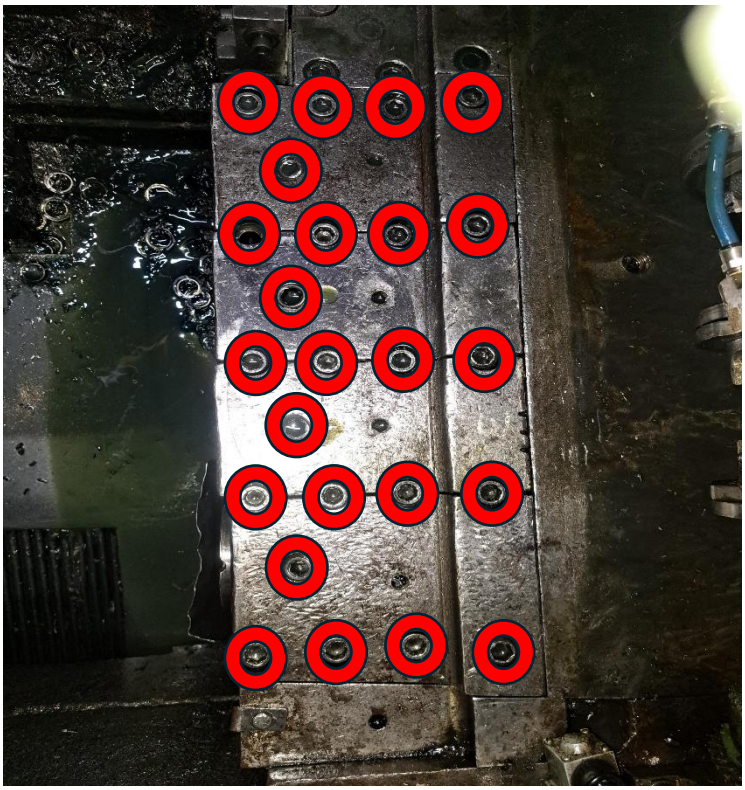



**Sections**

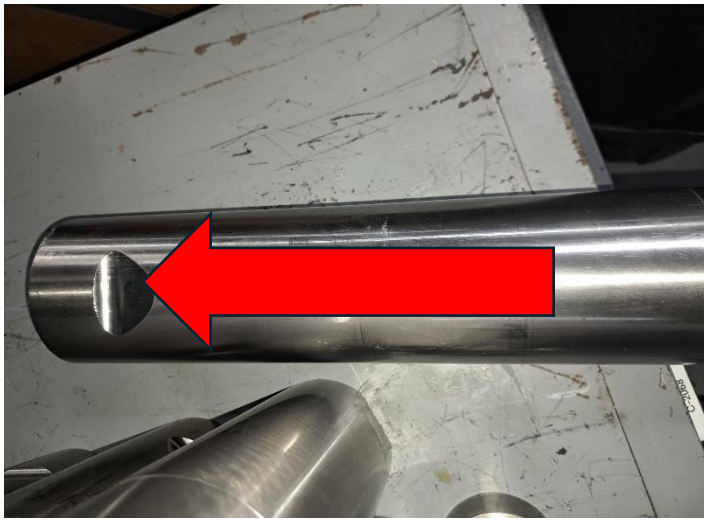

- **Inserting and Removing Tools – Page**
- **Trap Points, Chutes, and Conveyors - Page**
- **KO Guide Tubes – Page**
- **Changing Die Blocks – Page**
- **Setting Die Lengths – Page**
- **Setting Punch Wedges – Page**
- **Setting KO Stroke – Page**
- **Setting Feed Stroke – Page**
- **Setting Trim Snap – Page**
- **Changing and setting Stock Stop – Page**
- **Setting, Lining-Up, and Gapping Knife and Quill – Page**
- **Setting Transfers – Page**
- **Changing Feed Wheels – Page**
- **Draw Powder, Drip Oil, and Machine Grease – Page**
- **Loading Wire – Page**
- **Setting Wire Straightener – Page**
- **Setting Trim Snap, Trim Die, and Trim Punch – Page**
- **Balancing and Centering - Page**
- **Troubleshooting – Page**
- **Resources and Contact Information – Page**

# Section 1 – Inserting and Removing Tools

## Section 1a. Removing Dies



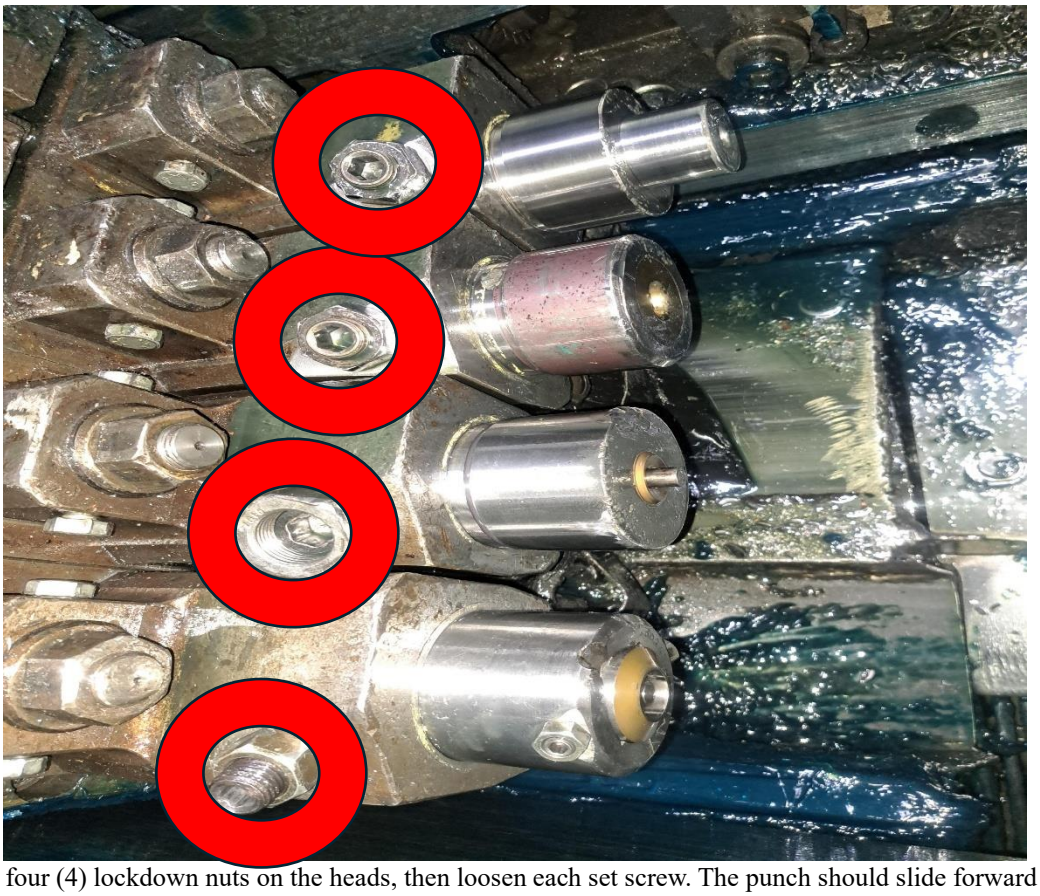
Remove all twenty (20) die cap lock down bolts, then back off all four (4) whistle stop bolts. Next, remove the four (4) die lockdown guards that sit below the dies. Once all the bolts are removed, use an eyelet to remove each individual die cap from the machine.



Hit the area marked with a brass hammer to draw the die forward out of the pocket, the knockout pin should come out with it. Repeat the process with the other three dies and once they're out clean any excess oil and grease from the dies. To put new dies into the machine, work in reverse. Put the knockout pin into the KO Guide Tube, then slide the die all the way back in the pocket. Insert the four die lockdown guards, place your die caps on and run down all twenty of the die cap lock down bolts. Now, you must seat the dies in the pocket. Back off each die lockdown bolt

one flat, and run down your whistle stops while hitting the face of the die with a brass hammer. Once the whistle stops are tight, use an impact to tighten up all of the die bolts.

## Section 2a. Removing Punches



Loosen all four (4) lockdown nuts on the heads, then loosen each set screw. The punch should slide forward when loose, if it is a little tight smack the punch and/or the wedge with a brass hammer. When you take the punch out make sure to remove all plugs, spacers, donuts, and PKO pins from behind the punch. They stay with the punch and get put away with the job. To insert new punches, put in the spacers and PKO pins first, then slide the punch all the way in the holder. Tap the face of punch with a hammer while tightening the set screw to make sure it is seated. Once all your punches are tight, lock down all four of the lock down nuts.