

***K-A 75  
Air Striking Hammer***

***Operation & Maintenance***



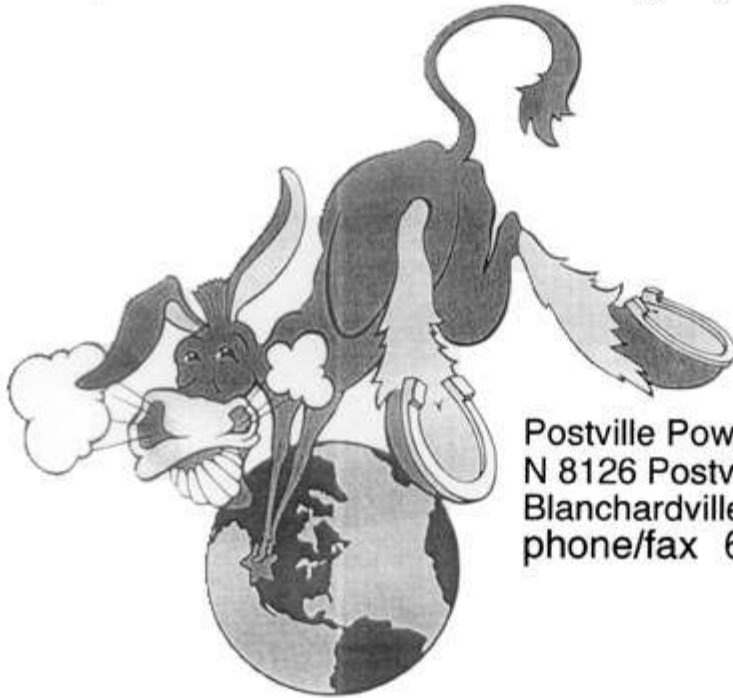
*Postville Power Hammers  
N8126 Postville Road  
Blanchardville, WI 53516*

*Phone 608-527-2494  
Fax 608-527-6908  
e-mail [postvilleblacksmith@tds.net](mailto:postvilleblacksmith@tds.net)*

Congratulations! Your purchase of the KA-75 Air Striking Hammer puts you in an ever growing number of blacksmiths who recognize the value of this hammer as a profitable addition to their shop.

As you become familiar with the operation of the machine and practiced with the control pedal you will find the hammer responds with infinite precision. Please read all the instructions carefully and be sure you understand them in order to get the most from the machine and ensure safe operation.

We always want you to be satisfied with this machine and we will help in any way we can. Please feel free to call us at any time with your questions or comments. Our home phone number is included for emergency needs.



Postville Power Hammers  
N 8126 Postville Road  
Blanchardville, WI 53516  
phone/fax 608 527 2494  
608 523 4750 home

# SAFETY

RAM POPS UP WHEN AIR IS TURNED ON - STAND CLEAR

KEEP FOOT OFF PEDAL BETWEEN OPERATIONS AND WHEN PLACING SMALL PIECES ON DIE

TURN AIR OFF WHEN NOT IN USE TO PREVENT OTHERS FROM CYCLING RAM UNINTENTIONALLY

DON'T LET UNTRAINED PEOPLE USE THE HAMMER

DON'T SET TOOLS ON TOP OF RAM

DON'T ALLOW PEOPLE TO LEAN ON RAM

WATCH OUT FOR CUT OFF ENDS. THEY CAN FLY OFF AND HIT SOMEONE OR LAND IN A CORNER AND START A FIRE

BLOCK RAM WHEN CHANGING DIES

---

## KICKASS 75 INSTALLATION AND OPERATION

### INSTALLATION

#### FOUNDATION

The best results are obtained when the hammer is mounted on a reinforced concrete inertia block of approximately one half cubic yard. Mounting on a heavy concrete floor (6" to 8" reinforced) is also possible.

#### CONCRETE BLOCK FOUNDATION

If a block foundation is to be used, it is best to contact the factory regarding the most suitable layout for your soil conditions. In general, the softer the soil, the larger the footprint should be. A pad two foot square by one foot thick works well.

The machine should be set on a pad of rubber belting or wood two by two's

#### STEEL BLOCK FOUNDATION

A steel plate from your local steel supplier is also a very good solution. Use a plate four to six inches thick and about two foot square. This can be buried flush with the floor and the hammer bolted or welded down. No padding is used in this installation. It can be free standing and moveable also.

#### BOLTING

Holes are provided for three anchor bolts. These may be cast in the foundation or anchors may be used. Thick (1") rubber washers with steel flat washers or valve springs should be placed under the bolt heads. If springs are used, the bolts or nuts should be tightened so the springs are about three-quarters compressed.

#### FLOOR MOUNT

If floor mounting is chosen, make certain the floor is at least 6" thick reinforced concrete. Some local cracking may occur as the vibration of the machine causes the soil underneath to settle. Isolation material should be placed under the machine. Fabreka or vulcanized fabric belting work well. Bolt as above.

## **AIR SUPPLY**

Machine must be supplied with CLEAN, DRY compressed air at 125 p.s.i.g. Minimum volume to operate is about ten S.C.F.M. under typical conditions (such as hobby blacksmithing), more air may be required for production work or unusual conditions. All air lines should be 1/2" N.P.T. or larger. The best configuration is to use a tank of at least 20 gallon capacity near the hammer supplied from a regulator/filter at 125 p.s.i.g. Please safety wire or epoxy adjustment after setting so that it cannot be inadvertently changed.

A line from the tank feeds the hammer. A line oiler is placed in this line with a SAFETY SHUT-OFF VALVE OR LOCKABLE 90 degree ball cock/shut-off valve close to the operator. If a ball cock is used a bleed-off valve should be installed after it to bleed down any remaining air to the hammer. If the bleed valve is pointed up it can be used as an oiler by shutting off the main valve and opening the bleed valve and squirting in a little oil. Close bleed valve before opening shut-off valve!! Oiler should be adjusted to allow only a few drops per hour of light hydraulic oil to be used.

## **LUBRICATION**

Lubricate with light hydraulic oil. A squirt can should be kept at the machine for this purpose. Cylinder guides should be kept just wet with oil.

## **REMOVING DIES**

Open shut-off valve slowly. Place a block of wood (2 x 4 ) about 12 inches long between ram and anvil cap. Close shut-off valve and open bleed valve to lower ram. BLEED VALVE SHOULD REMAIN OPEN UNTIL READY TO RUN HAMMER!!! MAKE SURE RAM IS RESTING SECURELY ON BLOCK! LOCK SHUT-OFF VALVE WITH OPERATORS SECURE KEY PADLOCK!! drive wedge loose from operator side. When removing top die it must be held up by hand or prop as the wedge is withdrawn. Remove wedge and die should be free to come out.

## **INSTALLING DIES**

With hammer blocked as described above, put die in place with center pin (locating pin) and insert proper wedge. Tighten wedge just snug ( from side opposite operator ). Close bleed valve and open shut-off valve SLOWLY. When ram raises remove block, close shut-off valve and open bleed valve to lower ram. Sock wedges tight with two pound hammer. RE-CHECK WEDGES AFTER ONE OR TWO STRIKES OF THE RAM. RE-CHECK POSITION OF DIES OFTEN AFTER CHANGING DIES.

## **OPERATING**

**ALWAYS CHECK TO MAKE SURE DIE WEDGES ARE TIGHT. RE-CHECK WEDGES REGULARLY WHEN OPERATING.** A light coating of anti-seize or grease on wedges is recommended. Regular inspection and tightening of all connections and fastening on this and any power hammer is mandatory.

Open shut-off valve slowly. **ALWAYS STAND CLEAR WHEN THE RAM COMES UP!!!** Lubricate guides before each session.

This is a single blow hammer with fantastic control. As with any manually operated machine, operator skill plays a large part in the satisfactory performance of the machine.

In most cases, the operator needs to anticipate the blow and let off the treadle just before the hammer strikes so that the hammer can bounce off the work. If a more holding blow is used, a lot of heat is sucked from the work and another may be required.

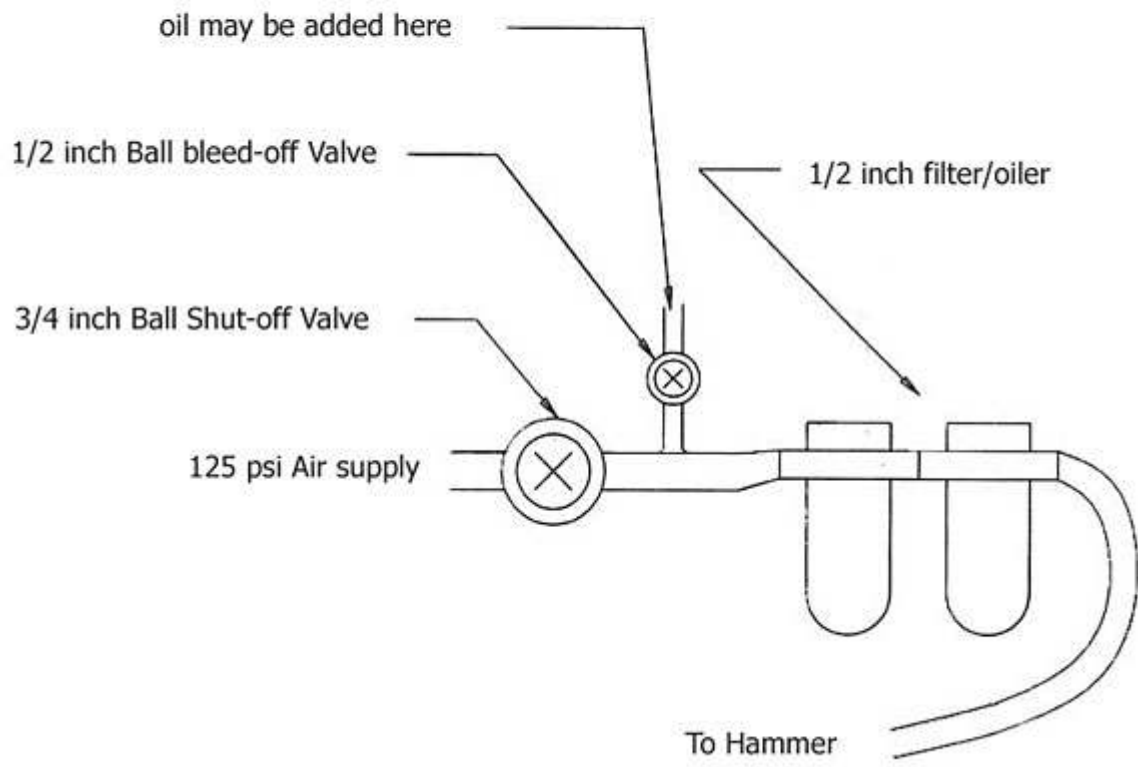
When striking repeated blows, it is not necessary (or even desirable) to let the hammer return all the way to the top of its stroke. Come down on the treadle soon enough so the hammer only raises about six or eight inches off the work. **ENJOY!**

We offer many standard dies for your hammer and would be happy to quote on any special dies for your requirements.

If you have any questions, please feel free to call us at:

**POSTVILLE POWER HAMMERS**  
N8126 Postville Road  
Blanchardville, WI 53516

Phone 608-527-2494  
Fax 608-527-6908



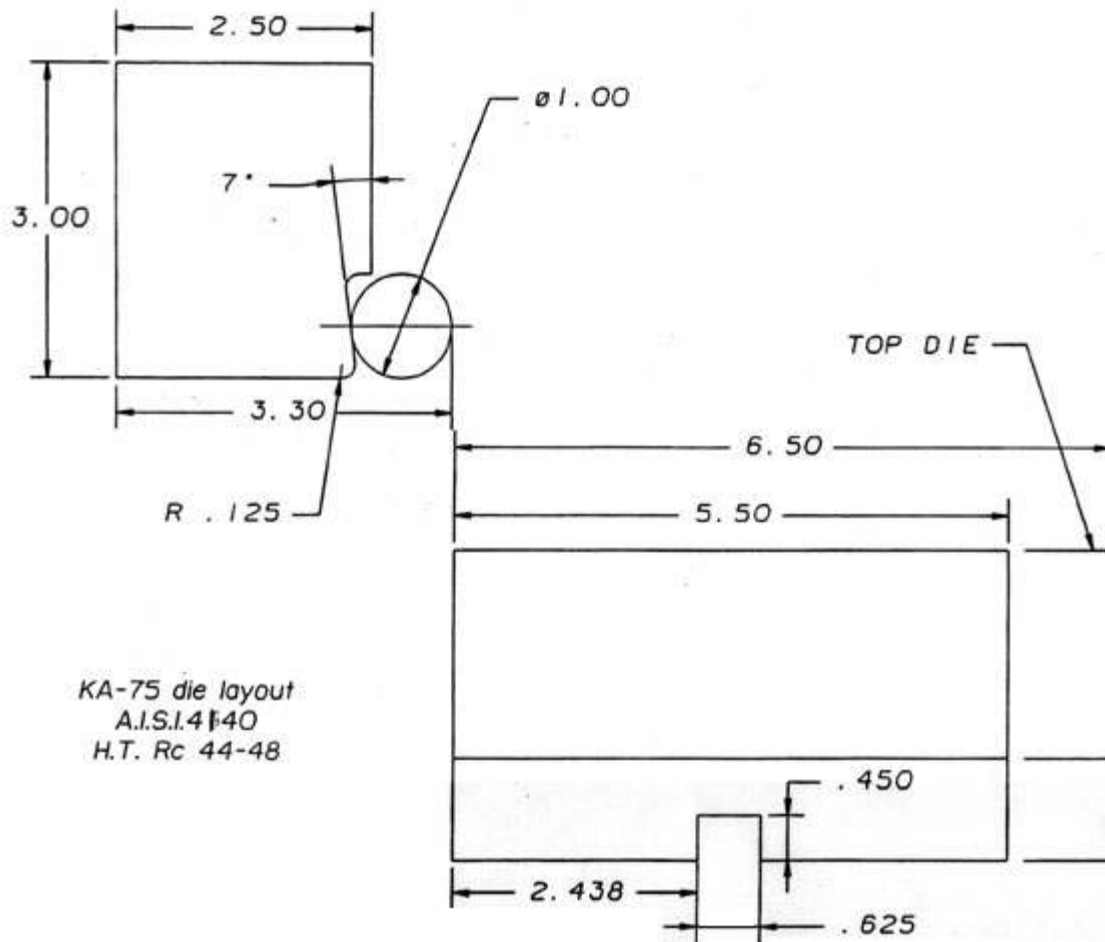
## Machine Specifications

Single Blow Striking Hammer

Interchangable Dies

Weight	400 lbs.
Ram Weight	100 lbs.
Ram Stroke	10"
Dimensions	16" x16"x 45" high
Raised	55" high
Blows per minute	up to 120
Air required	10-2- cfm @ 100psi

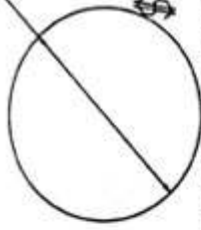




KA-75 die layout  
 A.I.S.I.4140  
 H.T. Rc 44-48

# JUST A FEW OF THE AVAILABLE DIES

#6.30

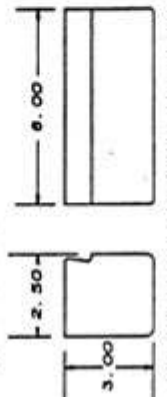


\$200.00

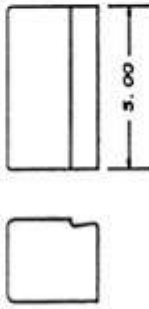
6 1/2 in. round die - fits top or bottom



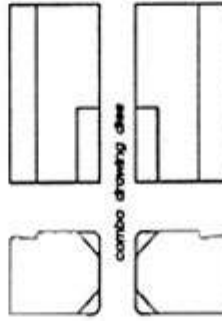
\$250.00



standard flat die-top & bottom interchangeable

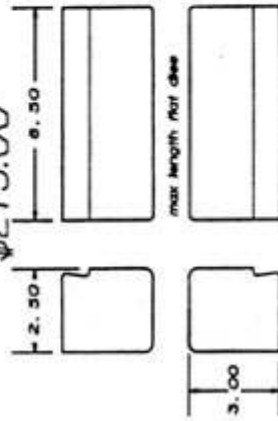


\$275.00



combo drawing die

\$275.00

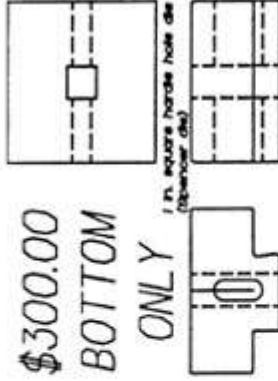


max length flat die

\$300.00

BOTTOM

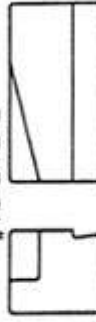
ONLY



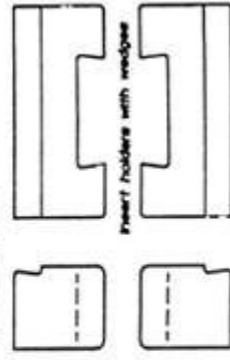
1 in. square handle hole die (bottom only)

chipper offset die  
use with standard  
flat top die

\$150.00



\$350.00



insert holders with wedges