



USER ARTICLE

SERVICE PUNCH DEFORMING

HOLES



Version 2026.1

SCOTTSDALE

THE TRUSTED STEEL-FRAMING PARTNER

SERVICE PUNCH DEFORMING HOLES

Problem/Question

Service punch deforms the hole when running automatically with the rollformer but works correctly in manual mode.



Possible Causes

- Punch not fully seated or tightened.
- Hydraulic oil pressure too low, causing slow punch retraction.
- Cold oil conditions increasing viscosity and slowing punch speed.

Possible resolution

- Verify that the punch is fully seated and locked in place.
- Inspect the hydraulic pressure gauge while running a service punch operation.
- Ensure system oil pressure matches factory specifications.
- If operating in cold environments, warm up the oil before starting production to restore correct punch speed.

Quick Tip

- Always check oil level first if drive errors appear.
- Loose wiring in the E-stop circuit can mimic drive fault conditions.
- Verify both hardware (drives, wiring) and software (ScotRF error logs).