Owner's Manual & Safety Instructions

Save This Manual Keep this manual for the safety warnings and precautions, assembly, operating, inspection, maintenance and cleaning procedures. Write the product's Date code in the back of the manual near the assembly diagram (or month and year of purchase if product has no number). Keep this manual and the receipt in a safe and dry place for future reference. 26h

PITTSBURGH™

DOMING BLOCK AND PUNCH SET



Visit our website at: https://www.harborfreight.com **93539**
For product assistance, visit harborfreight.com/customer-support/contact-us

When unpacking, make sure that the product is intact and undamaged. If any parts are missing or broken, please visit harborfreight.com/customer-support/contact-us as soon as possible.

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No portion of this manual or any artwork contained herein may be reproduced in any shape or form without the express written consent of Harbor Freight Tools.
Diagrams within this manual may not be drawn proportionally. Due to continuing improvements, actual product may differ slightly from the product described herein. Tools required for assembly and service may not be included.

⚠WARNING

Read this material before using this product. Failure to do so can result in serious injury. SAVE THIS MANUAL.

Specifications

Doming Block	18 Hemispheres (Sizes: 4.5mm to 38.5mm)
Punches	24 Punches (Sizes: 2.3mm to 25mm)

IMPORTANT SAFETY INFORMATION

1. Use only according to these instructions. Improper use can create hazards.
2. Wear ANSI-approved safety goggles, full face shield and heavy-duty work gloves during use.
3. Keep work area clean and well lit.
4. Keep bystanders out of the area during use.
5. Do not use when tired or when under the influence of drugs or medication.
6. This product is not a toy. Do not allow children to play with or near this item.
7. Use for intended purpose(s) only.
8. Inspect before use; do not use if parts are damaged.
9. Maintain product labels and nameplates. These carry important safety information. If unreadable or missing, contact Harbor Freight Tools for a replacement.
10. Harbor Freight Tools cannot be held responsible for damage to jewelry or other items resulting from use of this Punch/Block Set.
11. The face of these tools may chip if struck against another striking tool or hardened surface. This will damage the tool and possibly result in eye or bodily injury. Always check tool before using, and always discard a chipped tool.

Operating Instructions



Read the ENTIRE IMPORTANT SAFETY INFORMATION section at the beginning of this document including all text under subheadings therein before set up or use of this product.

Note: The quality of shapes produced by this tool is largely dependent on the quality and preparation of the workpieces and also the care of the user.

1. This tool is used to shape metal sheet material, such as Copper, Aluminum, Soft Steel and Brass.
2. The material must be smaller in diameter than the hemisphere it will be placed in. If the material is too thick , or placed in a hemisphere that is too small, the material may dimple, crease, or fail to take on the shape and radius of the hemisphere.
3. If the punch is too small the edges of the material will buckle.
4. Choose a hemisphere and punch based on the size of the material to be shaped.
5. Center the material in the hemisphere. Place the punch directly on top of the material.
6. Hold the punch firmly. Make sure your fingers are clear of the top surface of the punch.
7. Using a wooden mallet, strike the top surface of the punch in a tapping motion.
8. Periodically remove the punch and check the progress of the shaping.
9. Repeat Steps 7 and 8 until material takes on the smooth, curved radius of the hemisphere.

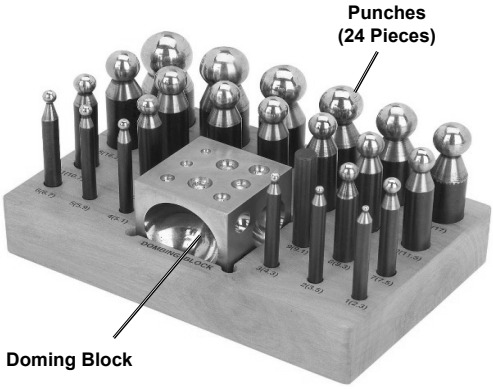
Maintenance and Servicing

1. **Before each use,** inspect general condition of doming block and punches. Check for cracked or broken parts, and any other condition that may affect its safe operation. **Do not use damaged equipment.**
2. **After opening and each use,** wipe the heads and block with a soft, dry cloth to remove protective oil, moisture, and residue.
3. **Before long-term storage,** apply a thin layer of light machine oil to the steel surfaces.
4. Store the punches in the provided wooden stand to prevent contact and maintain the polished finish.
5. **CAUTION!** All maintenance, service, and repairs not mentioned in this manual must only be performed by a qualified service technician.

Component List and Diagram

PUNCH	
NO	PUNCH FACE SIZE (MM)
1	2.3
2	3.5
3	4.3
4	5.1
5	5.9
6	6.7
7	7.5
8	8.3
9	9.1
10	9.9
11	10.7
12	11.5
13	12.3
14	13
15	13.8
16	14.6
17	15.4
18	16.2
19	17
20	18.6
21	20.2
22	21.8
23	23.4
24	25

DOMING BLOCK (49MM X 49MM)	
FACE	CAVITY SIZE
1	4mm, 5mm, 6mm, 7mm, 8mm, 9mm, 10mm, 11mm, 12mm, 13mm, 14mm
2	16mm , 18mm , 20mm
3	25mm
4	30mm
5	35mm
6	40mm



The component list and assembly diagram are shown for reference only. To view all currently available replacement parts, please visit harborfreight.com/parts

R**ecord Product's Date Code Here:**_____

Note: If product has no Date Code, record month and year of purchase instead.

Note: Some parts are listed and shown for illustration purposes only, and are not available individually as replacement parts. Specify UPC 193175552327 when ordering parts.

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To take advantage of this warranty, the product or part must be returned to us with transportation charges prepaid. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection verifies the defect, we will either repair or replace the product at our election or we may elect to refund the purchase price if we cannot readily and quickly provide you with a replacement. We will return repaired products at our expense, but if we determine there is no defect, or that the defect resulted from causes not within the scope of our warranty, then you must bear the cost of returning the product.

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