

Installment and operation interpretation

1. Please make sure the power source of the "Pneumatic presses" to install, then put the controller's plug on the insertion in correct voltage.
2. Send the compressed air to the in-port of Air units, the pressure setting on 5kg/cm².
3. Eliminate the T board, switch the POWER button from the control panel, according two sides of switches (or the hand switch on solenoid valve) to drop the piston rod in order to make sure the power and compressed air source have turned on press correctly. If the piston rod is unable to drop, please consult to the agent.
4. It is a theoretical amount on the catalog, the practical will be 80% approximately of the theoretical amount, and must consider the pressure source from the factory.
5. The space height for using should involve both of the Tooling and the Product height.
6. After the mentioned steps, the installation and test for Pneumatic presses has finished, you may start to assemble the Tooling.
7. Put the Tooling on the T-board, according two sides of switches (or the hand-switch on solenoid valve) to drop the piston rod. Couple the handle of upper mold to the pin hold. Keep on pressing the mold to be close, then fix the screw tightly and fix the lower mold. If the bottom deal center must be accurate, use the adjustable screw on the top of the cylinder. Leave the buttons after all the steps. Please contact with the agent if you have the Tooling assemble problem. The products can be produced after the Tooling assembled.
8. Take the Product into the Tooling, according two sides of switches for producing. Switch the TIMER SW button to "OFF" to rise the piston rod immediately if any problems on producing.
9. Notice to the water draining function on Air Units. If expires, uses the manual way to drain water or renew the product.
10. After work or production stopped, the pressure should be released from presses machine.

Waring

Presses using should take the security as first. Refuses to keep bodily in any operating region when operators working for the piston rod drop, by plan security.

Maintains & Service

※Please periodic maintenance. If have the question during using, please stop and solve the problem first, in order to avoid a serious malfunction. There are some basically maintains and simple repair method as the following. Excepts these problems, please stop to use the machine and contact to the agent then fix the malfunction.

(A) Lubrication: Lubricating positions as follows

1.anti-rotation guide: Clean the anti-rotation guide completely, then spreads light oil once a week.

2.The pressure system: Check the oil cup of Air Units while start to work everyday. If does not have the lubricating oil, please turn off the air pressure source first. Open the bolt on the top of oil cup by the counter time direction, refuels the lubricating oil (ISO VG32) to the upper limit position, then locked the bolt by along direction.

(B) Air leakage check:

The power supply of presses is provides by the air compressed. The air leakage will affect the pneumatic stress system operates normally. It will not be able to achieve the predetermined high thrust force. When air leakage, please check by follows:

Step 1: Turn on the air pressure.

Step 2: Stop all the actions. If the noise happened, means the leakage from the pressure pipes.

Step 3: Drop the piston rod by the switches (or the hand-switchs on solenoid valve). If the noise happened, means the leakage from the air pressure pipes.

After all the checking steps, if it is unable to find the correct leakage place, please spread the soapy-water. It'll easy to figure out the leakage place.

The solution for pressure pipes leakage as follows:

- 1.PU tube broken: Please change PU tube with the same caliber.
- 2.The connecter leakage: If leakage from inside, please take this connecter off, grips the tapes then lock the connecter again. If leakage from the tube, please inserts PU pipe to the connecter. If the method is invalid, please cut PU pipe about 10~15mm, then inserts it again. If problem doesn't improve, please switch the connecter or contact to the agent.

 **Maintains & Service**

3.If the cylinder or the solenoid valve leakage, please contact with the agent to overhaul.

(C) Electrically controlled:

Generally, the user must inform the agent about the voltage of power supply before order. Please use the correct voltage, this point is very important. The wrong voltage makes the electrically controlled part damaged, we will not guarantees damage responsibility. The user please turn off the power as fast as possible, contact to the agent to overhaul completely.

Electrically controller do not need to maintain. User just has to make sure the connecter and post tight fixed. About the other electric controller damaged, please contact to the agent who you purchase to overhaul completely.