

Pneumatic presses manual

1 Connect the power

Please make sure the voltage is correct 110V or 220V.

2 Connect the compressed air

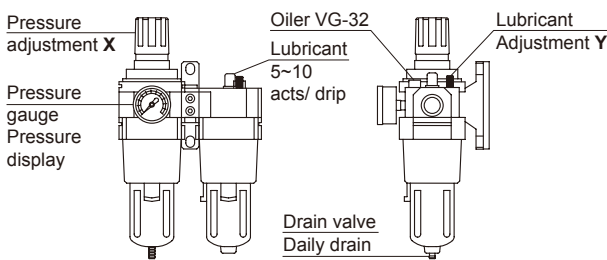
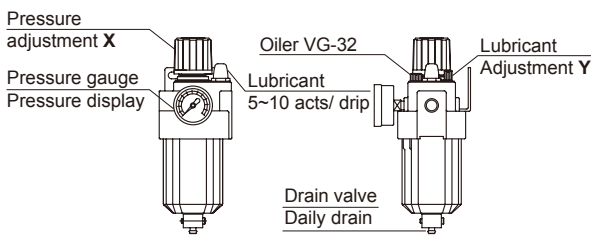
The pressure and the discharge volume should be in working condition.

3 Operation

Use Both hands or feet on the pressure switch bottom.

4 Output Adjustment

Adjust the exhaust valve to proper pressure kg/ cm².

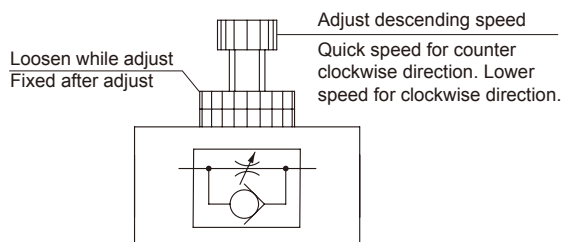


X: Clockwise direction → pressure increase
Counter clockwise direction → pressure decrease

Y: Clockwise direction : Less Lubricant
Counter clockwise direction : More Lubricant

5 Adjust descending speed

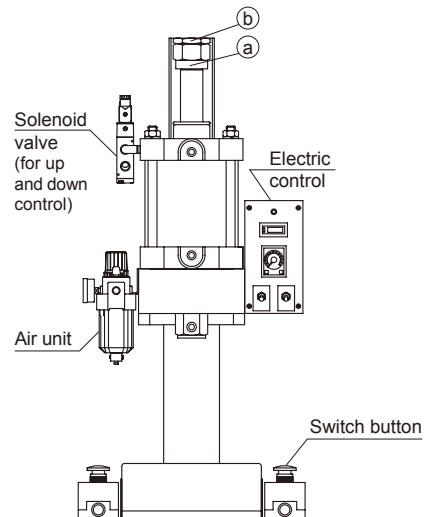
The control knob can adjust the descending speed of die spindle. Quick speed for counter clockwise direction, lower speed for clockwise direction.



6 Adjust operation height

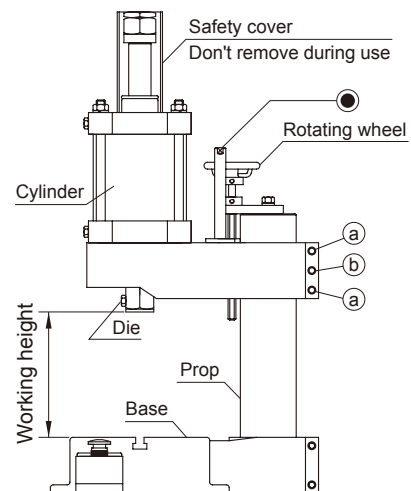
Fine adjustment (follow the steps)

- ① Descending (a) to end point.
- ② Fixed (b) after fine tuning.



Adjustment (follow the steps)

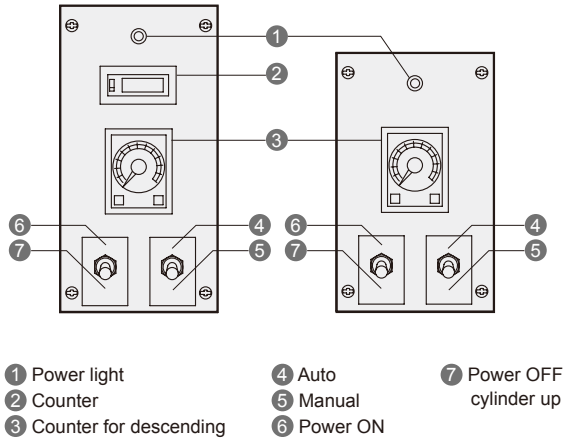
- ① Loosen the (a) screw
 - ② Fasten the (b) screw
 - ③ Adjust the working height by rotating wheel
 - ④ Loosen the (b) screw after adjustment
 - ⑤ Fasten the (a) screw
- Rod to Prevent rotation (do not put hands here)
* MF103-A/B No adjustment design.



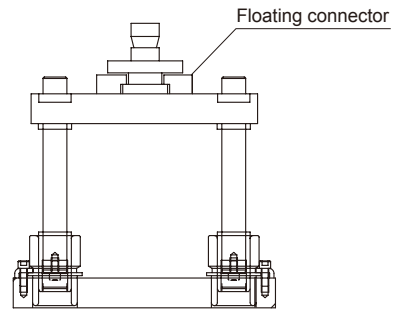
7 Power control

(a) Timer and counter control

(b) Timer control

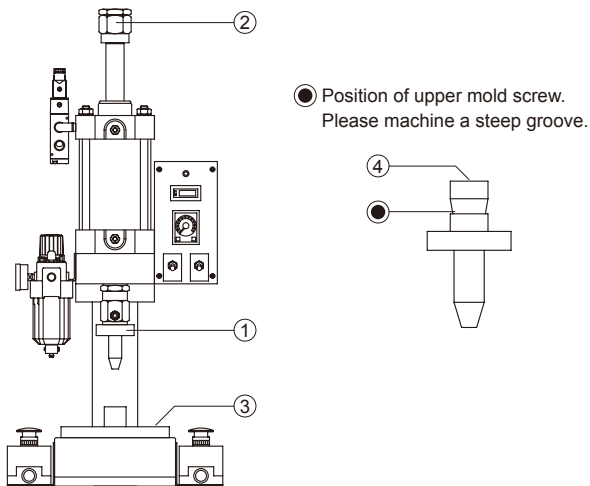


(5) Setting precision mold (Design example)

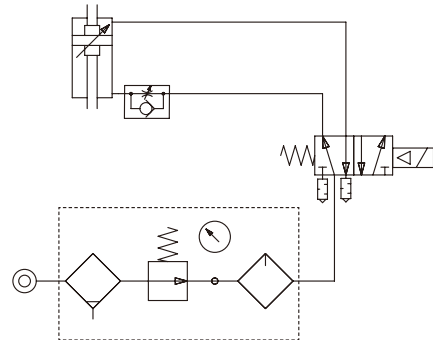


8 Set Mold

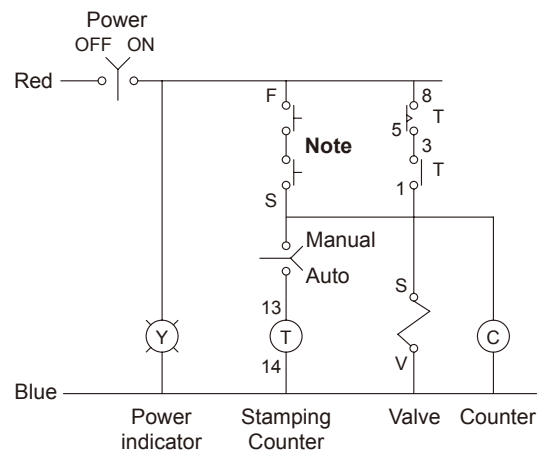
- ① Fixed upper mold
 - ② Release the pressure, using hammer, tapping gently the upper side of cylinder, make it descend.
 - ③ Make sure the upper and lower mold in right position, fasten the lower mold.
 - ④ Suggest the position of screw for upper mold like picture ④.
- * ① & ③ Not included in the product.



Pneumatic circuit diagram



Electrical wiring diagram



Note
Press the power switch by both hand at the same time to start the machine.