

PRESSMATE FEEDER INSTALLATION INSTRUCTIONS

The Pressmate feeder is furnished with a hinge mount that is slotted for both vertical and horizontal movement for the centering of the feeder to the press.

To mount the bracket to the press, locate the mounting holes with the use of the template that is furnished with the feeder. (Illustration "A")

Line up the template with the feedline and center of the punch. Drill and tap one hole. Remove the front part of the hinge mount from the feeder and bolt it to the machine for spotting the remaining three holes. Drill and tap 3/8-24 approximately 1" deep (4 holes). Mount hinge with (4) aircraft bolts (from the bolt bag) to the machine with the bolts in the center of the slots (Illustration "B") for approximate heights.

Jog machine until the punch leaves the die. Stop the machine. Attach the Split Sprocket to the Cam Shaft with the (2) bolts showing and loose enough to turn. (Illustration "C")

Attach the feeder with the pin through the bottom hole of the hinge mount and tighten the (2) 1/2"-20 side bolts. Reinsert Cotter Pin to Pin.

Find the proper location for the Filter-Regulator assembly, as close as possible to the feeder and visible to the operator. Be sure that the air line you are using is not connected to any other Regulators, as this would affect your air pressure to the Filter-Lubricator we supply. The Regulator is preset at approximately 40 P.S.I. for most job applications. Connect the air hose to the On/Off valve.

With the air on, turn the Feeder Shaft (Illustration "D"), via allen wrench, clockwise until the front Clamphead is trying to move forward. (Illustration "E") Stop 3° before.

Cut chain to the proper length and connect the chain over the Split Sprocket and Drive Sprocket on the feeder (with the Split Sprocket still loose on the machine shaft). Adjust the tension of the chain utilizing the slotted holes in the Drive Shaft bracket by pulling down and toward you. Tighten all (4) bolts.

Now for proper timing we turn the Drive Shaft with an allen wrench until the front Clamphead is trying to move forward. Stop. Tighten the Split Sprocket to the machine shaft, going back and forth on the (2) bolts for proper tooth

alignment. Before entering the strip, jog the machine to check if the timing is correct. (Remember, the punch should be out of the dieset before the front Clamphead is moving forwards.) Insert material strip (air should be switched off) and set with guides on left side of material under punch. (Illustration "F")

Adjust guides so that when the material is moved the Rollers will move also. Turn on the air and check clamping by grasping the material and trying to pull it back out of the feeder. Thickness and soft material will affect clamping and might need only 25 to 30 P.S.I. of air pressure. Punch out (3) blanks. Check to see that punched holes are centered in strip. If punched holes are cutting into either edge of the strip, and your material is centered in the Clampheads, it is necessary to loosen the (4) ½" bolts on the mounting bracket and realign the feeder, either to the left or to the right, and retighten the (4) bolts. Minor adjustment can be made utilizing the material guides. Be sure that the material moves freely between the Guides and through the Oiler Pad.

Make sure the back side of area from punch is level to the scrap chopper for skeleton to glide freely.

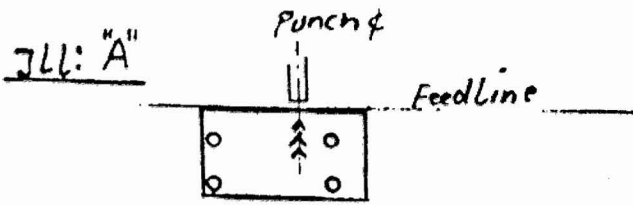
If the unit is furnished with a Pilot Relief Valve, set the Pilot Relief Valve as soon as the punch pierces the material. Stop the press, and set the Cam Lever to relieve both the Clamping Heads. In case of irregular feeding, this allows material to straighten itself out.

On larger models (2) pieces of tubing with (2) Clamps and hardware to mount to unit are provided for extra support from the rear of the feeder to the lower press frame.

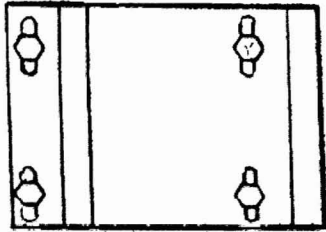
Before starting the machine install the cover.

CAUTION:

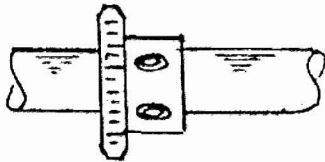
Never put any part of your body in the Feeder while the machine is running!!



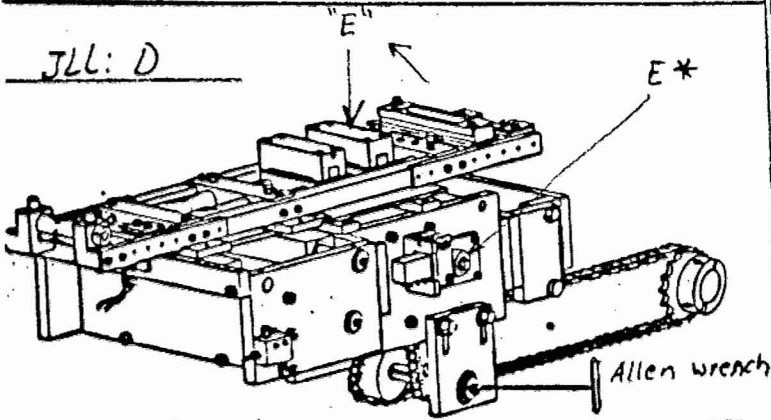
JLL: "B"



JLL: "C"



JLL: D



JLL: "E"

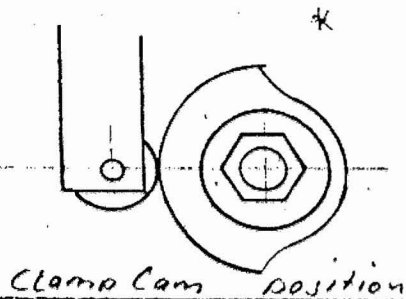


Illustration "F"

