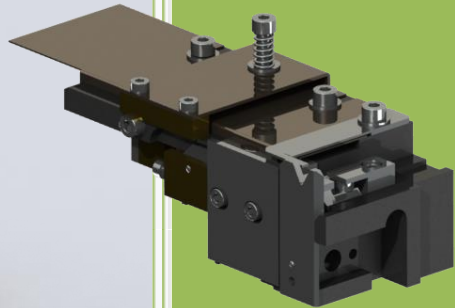
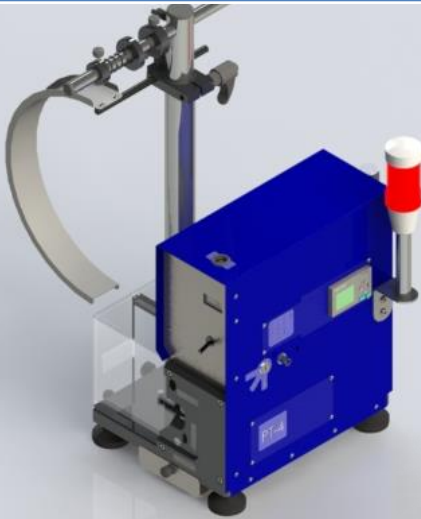
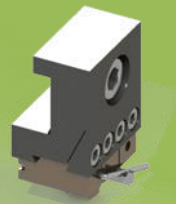


PT3/PT4/PP3- The pneumatic side passing contacts

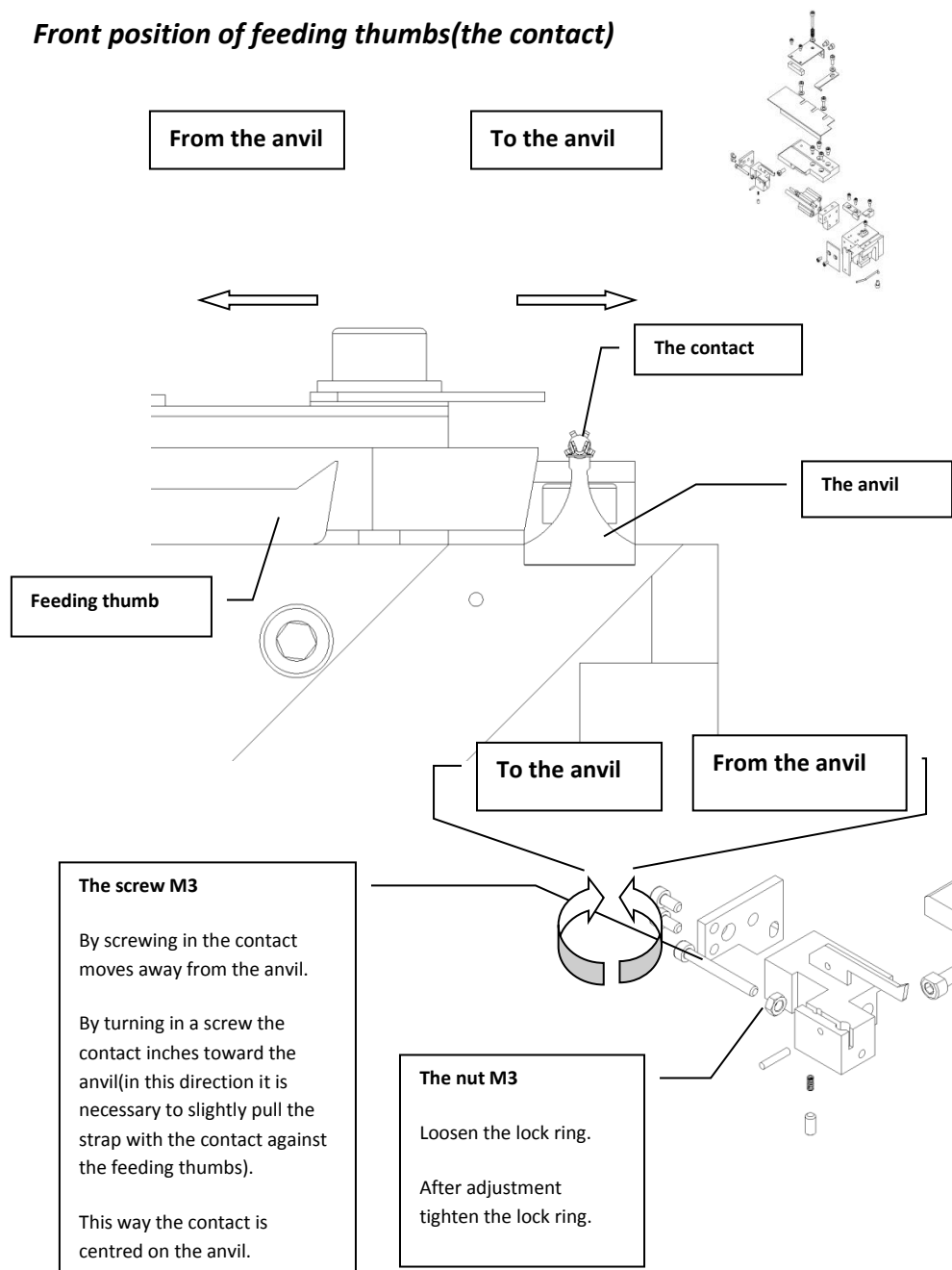


***The operating
instructions and
adjustment***



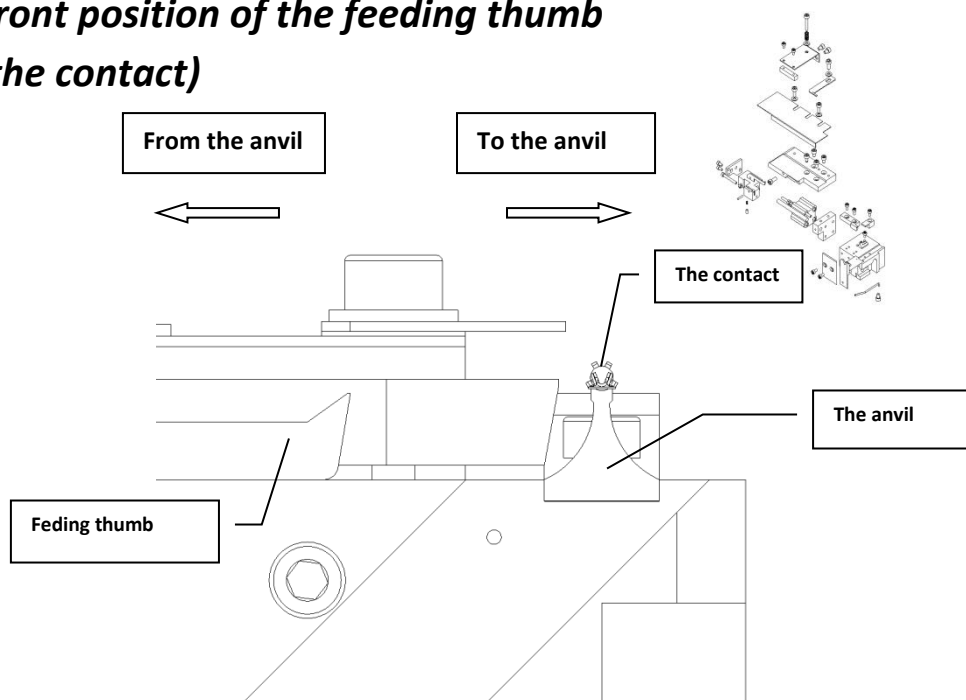
The setting for passing contacts and centring on anvils.

Front position of feeding thumbs(the contact)



The setting for passing the contacts

Front position of the feeding thumb (the contact)



The screw M3

When you screw in, the contact moves away from the anvil.

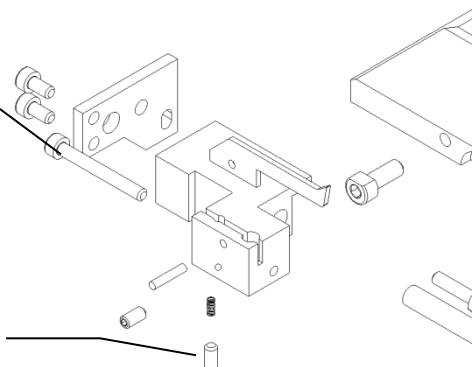
By turning out the screw, the contact inches toward the anvil (in this direction it is necessary to slightly pull the strap with the contact against the feeding thumbs).

This way the contact is centred on the anvil.

Adjusting screw M3

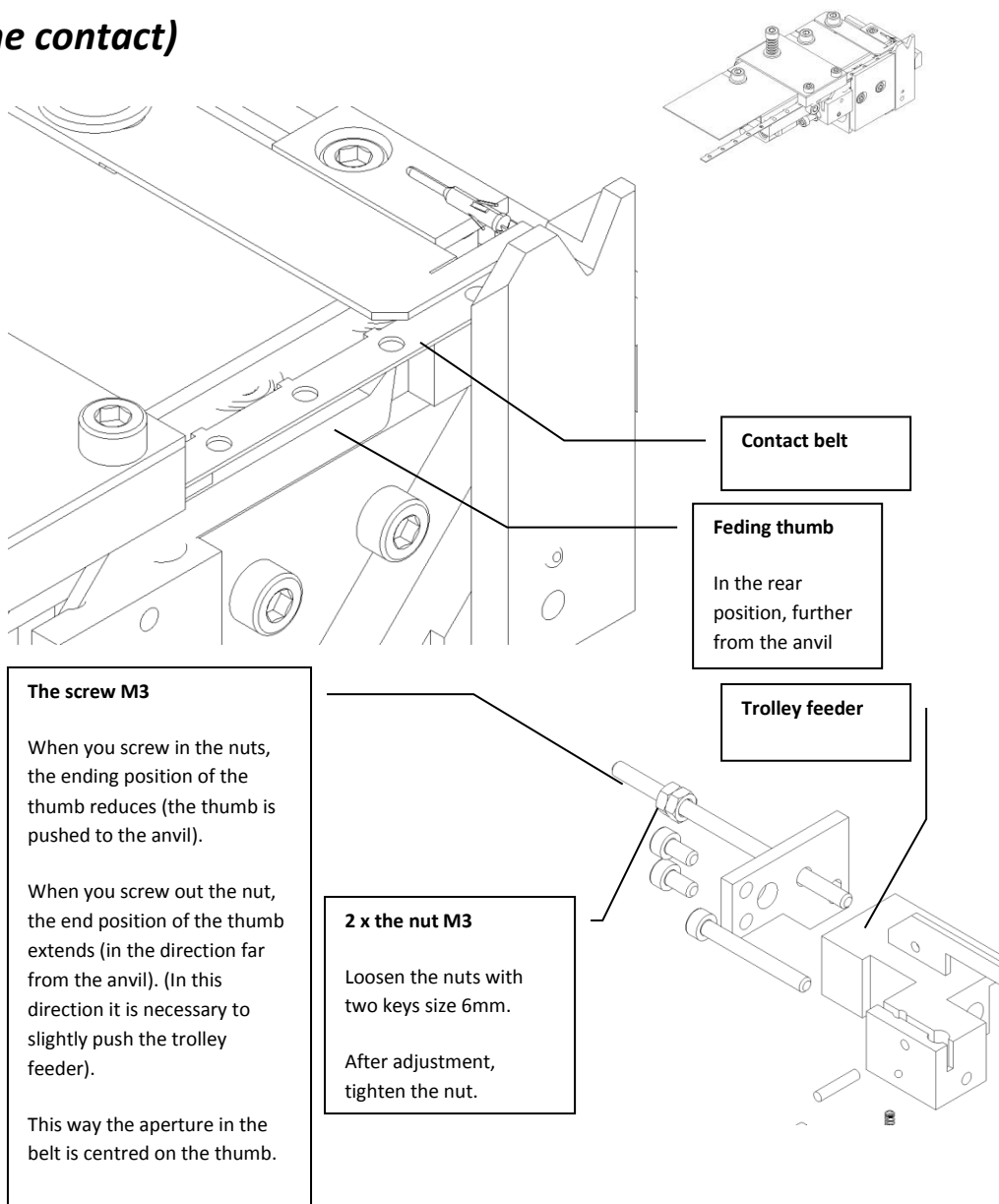
Loosen the adjusting screw.

After adjusting, tighten the adjusting



The setting for passing contacts

Rear position of the feeding thumb (the contact)

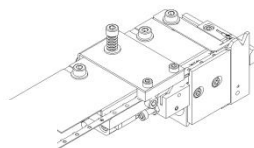


Setting up and extracting of contacts

Feeding thumb

By setting up of the belt with contacts, it must be in the position far from the anvil (if there is air connected, it is automatically in this position).

By removing the tape with the contacts, it is necessary to push the feeding thumb downward.



The belt with contacts

It is set in a position so as the contact remains one position in front of the anvil.

It is setting up toward the anvil and extracting backward the anvil.

The anvil

The contact

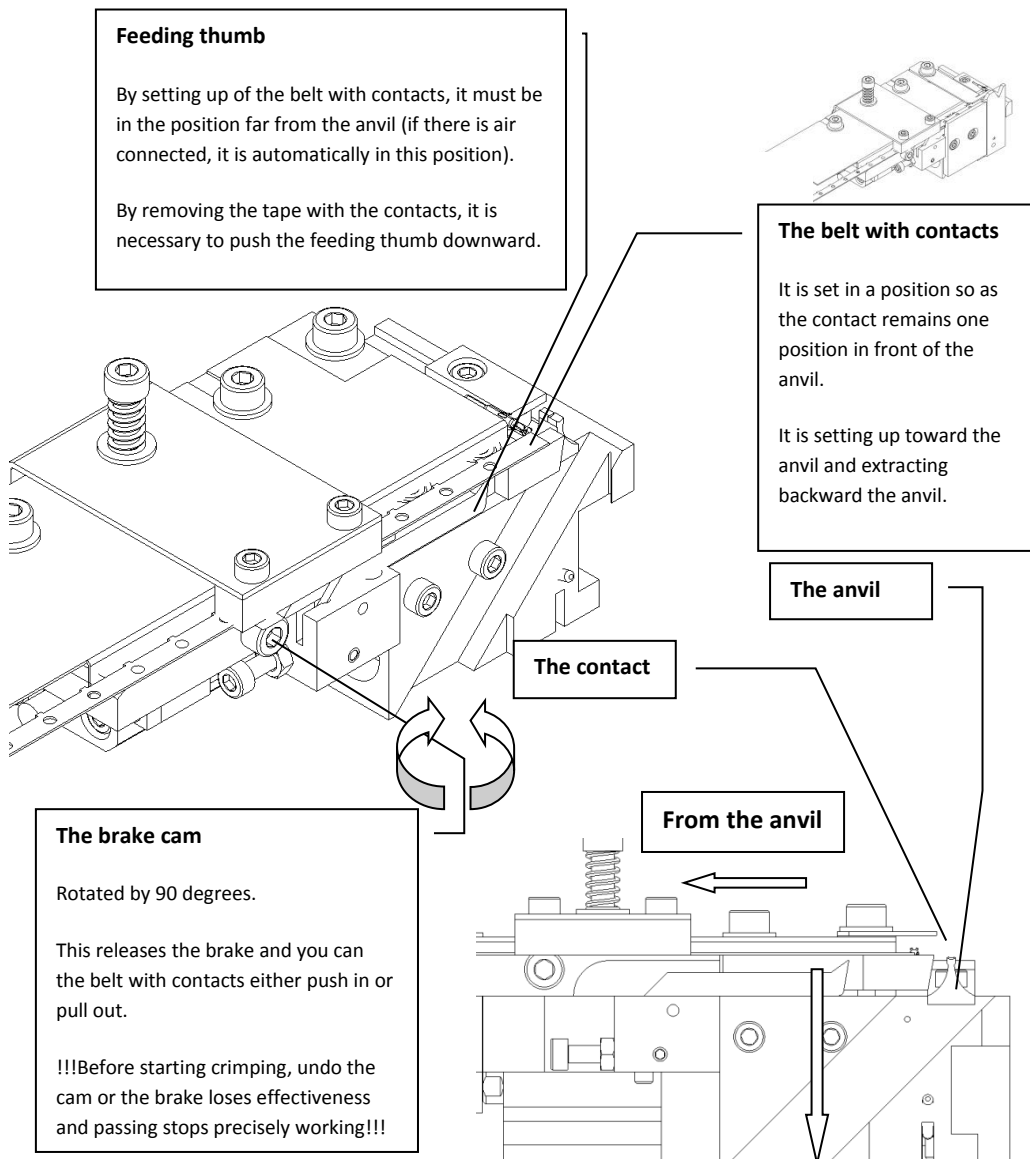
From the anvil

The brake cam

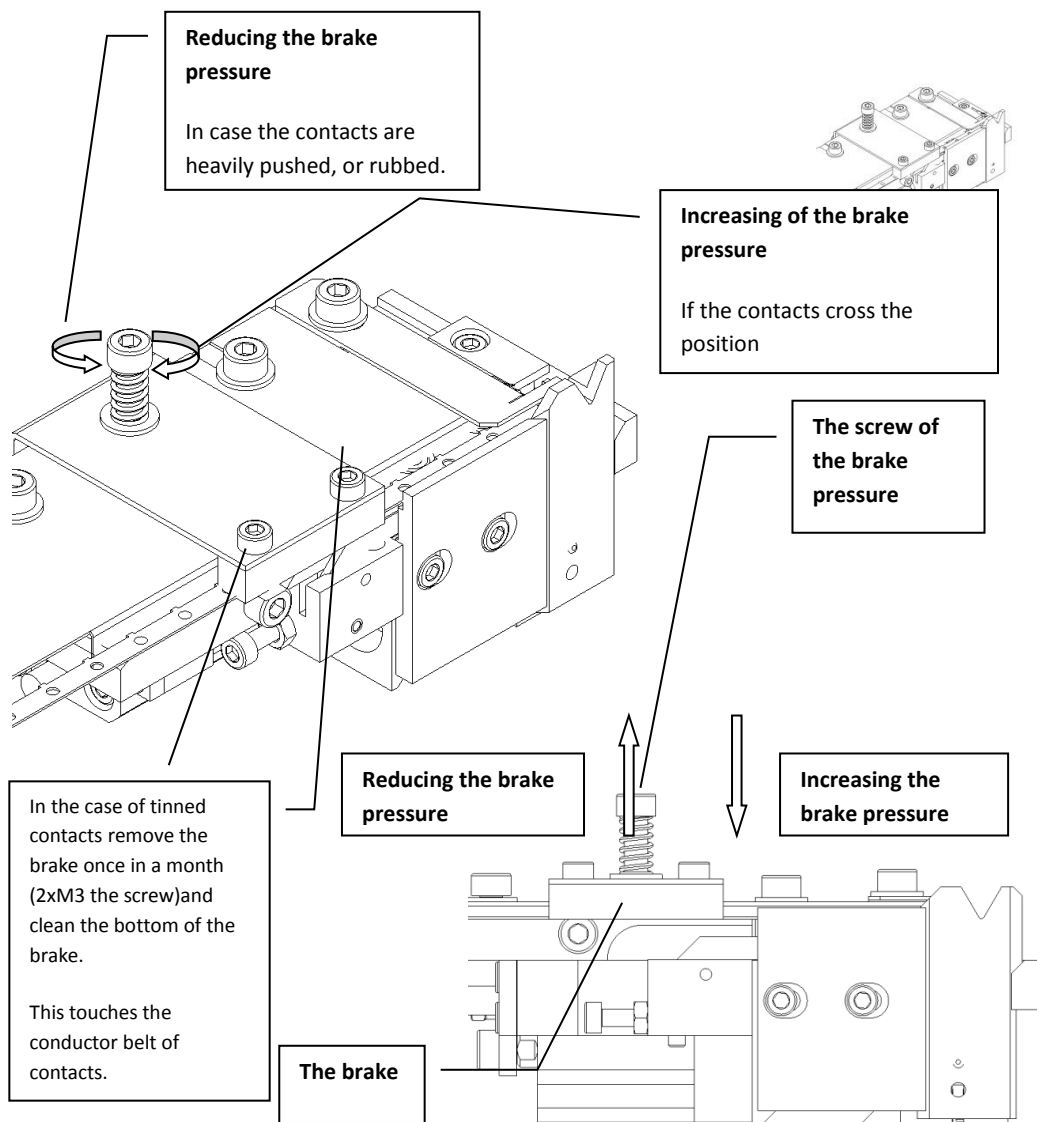
Rotated by 90 degrees.

This releases the brake and you can the belt with contacts either push in or pull out.

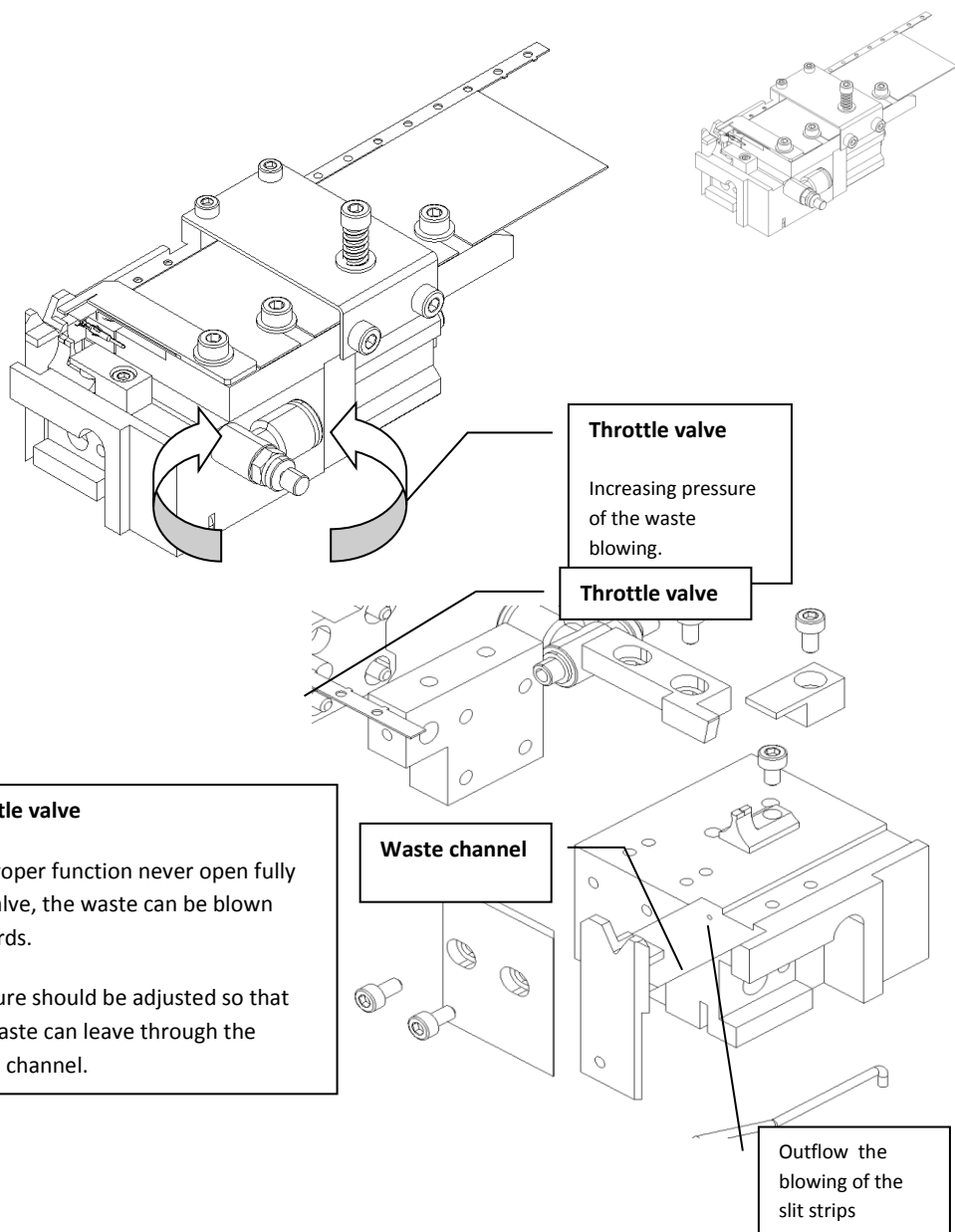
!!!Before starting crimping, undo the cam or the brake loses effectiveness and passing stops precisely working!!!



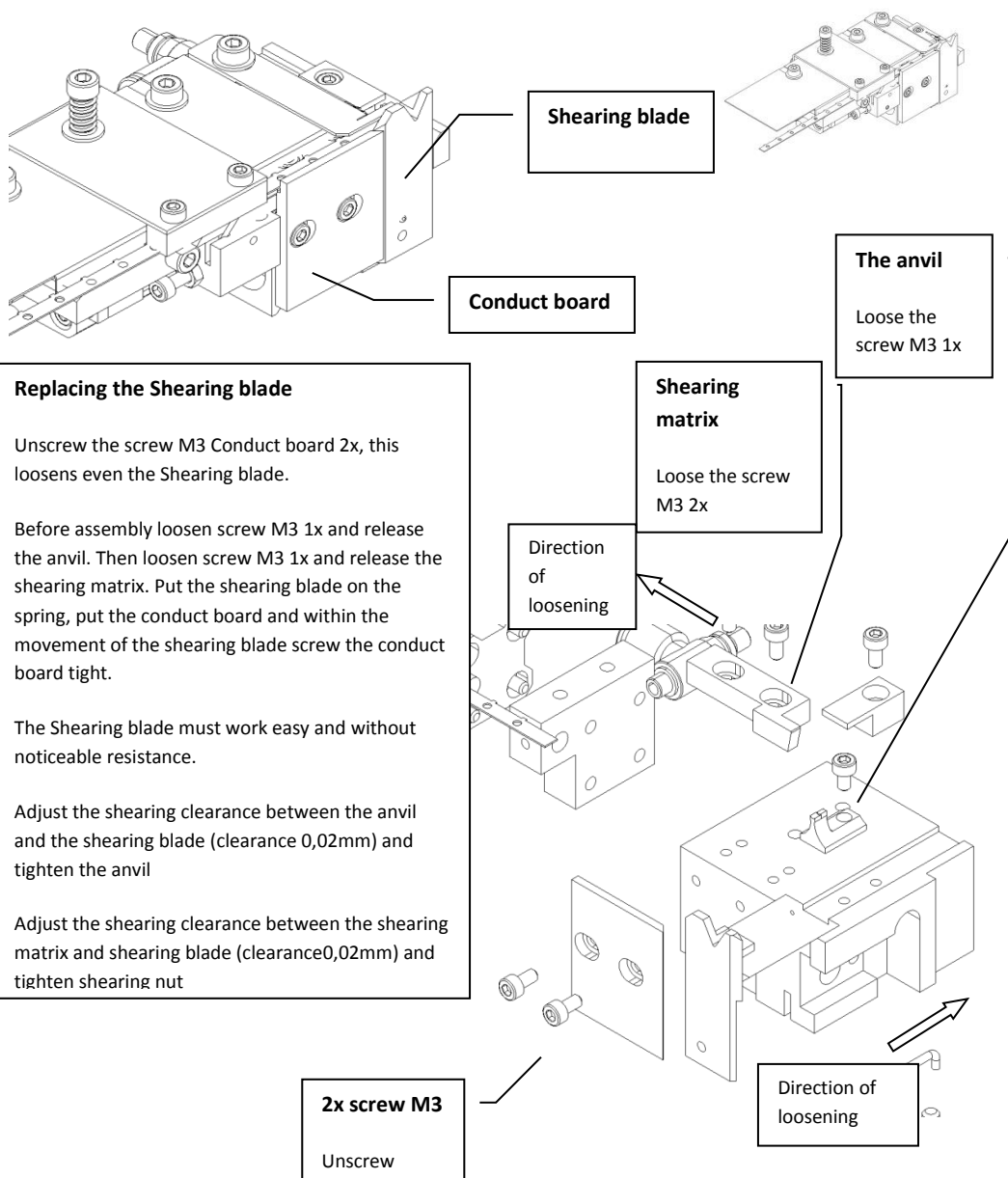
Setting of the pressure (the brake) on contacts



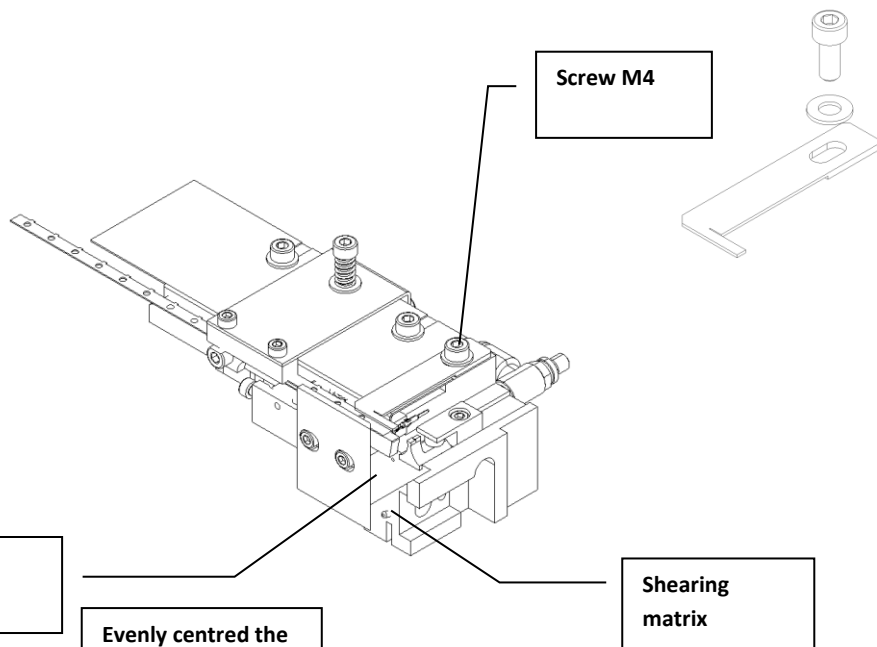
Setting blowing of contacts



Replacing + setting of the Shearing blade and Conduct board



Replacing + setting of the stripper

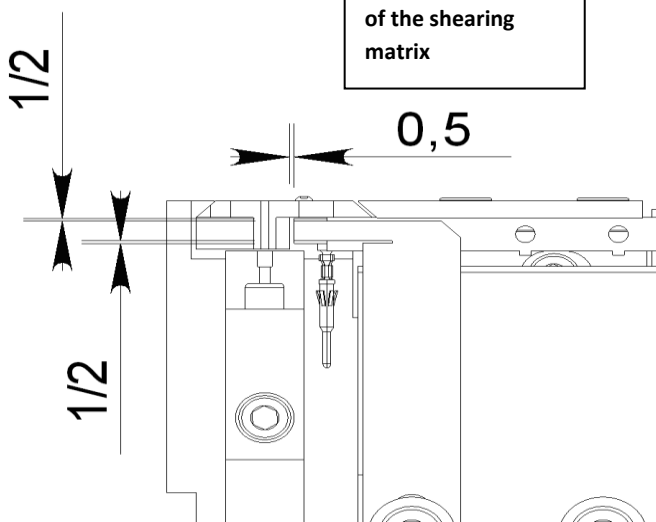


Replacing the stripper

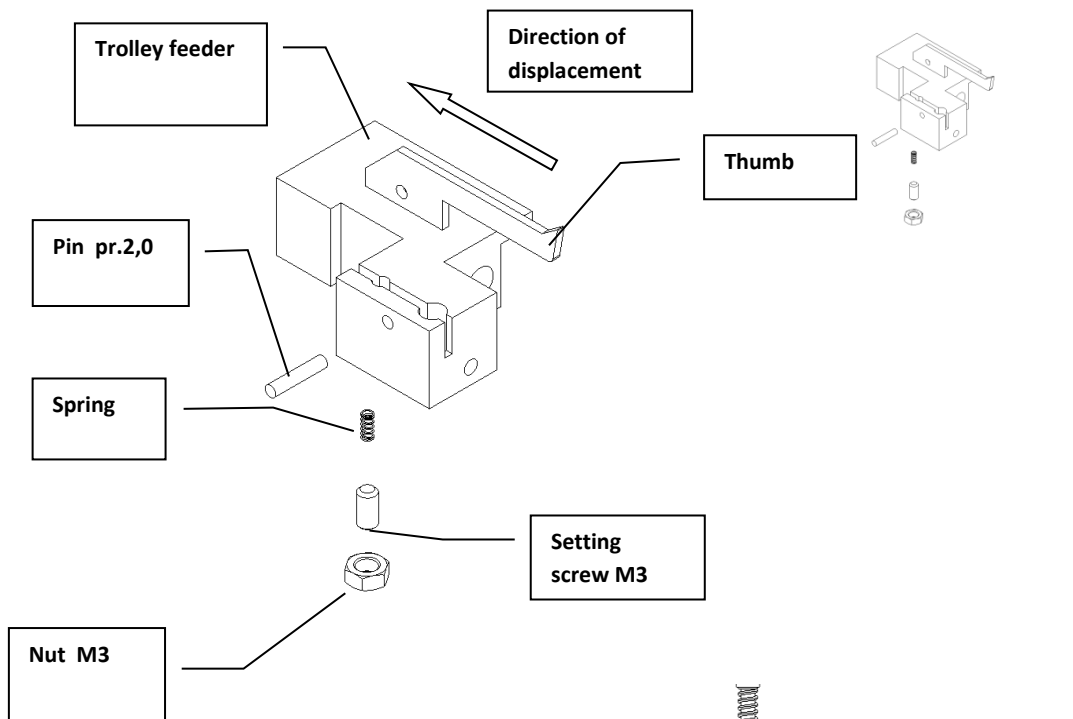
Unscrew the screw M4, remove the damaged stripper.

Take a new stripper, lightly tighten the screws M4 (so that it is possible to move the stripper) and adjust the stripper by the outline.

The shown values are related to the shearing matrix. These values must be respected; otherwise it causes a collision between the stripper and shearing tools.



Replacing the thumb



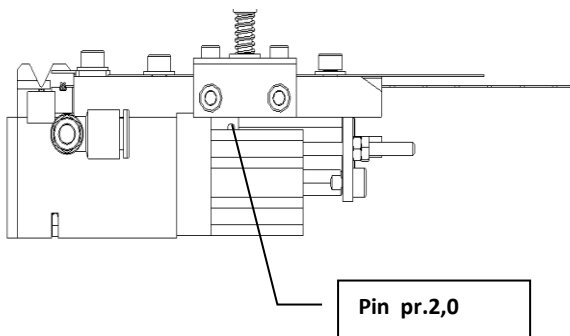
Replacing the thumb

Move away the trolley feeder from the anvil.

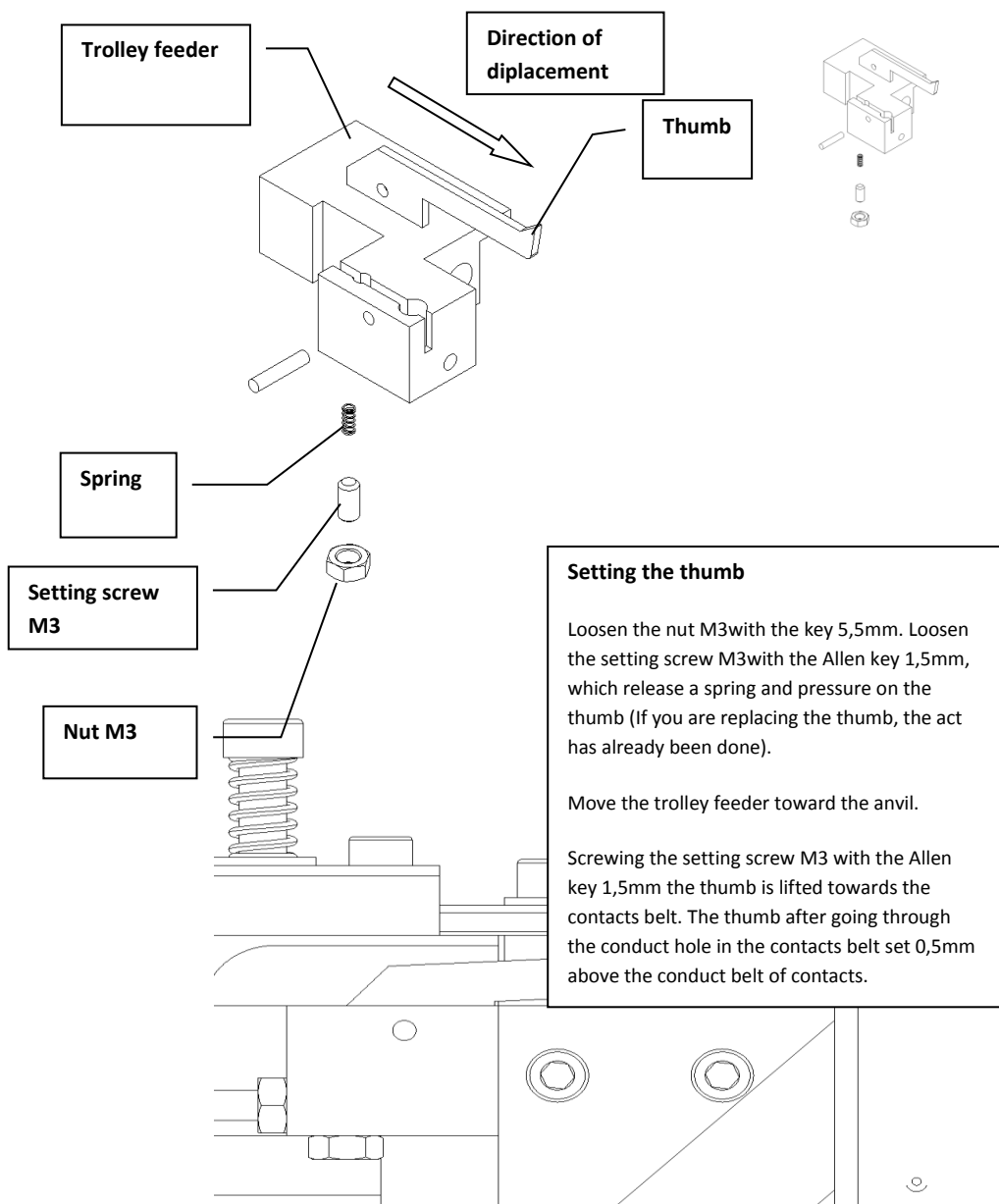
Loosen the nut M3 with the key 5,5mm.
Loosen the setting screw M3 with the Allen key 1,5mm, which releases the spring and pressure on the thumb.

From the back of the instrument knock out the pin pr.2, 0 by a thorn pr.1, 9mm.
Remove the thumb.

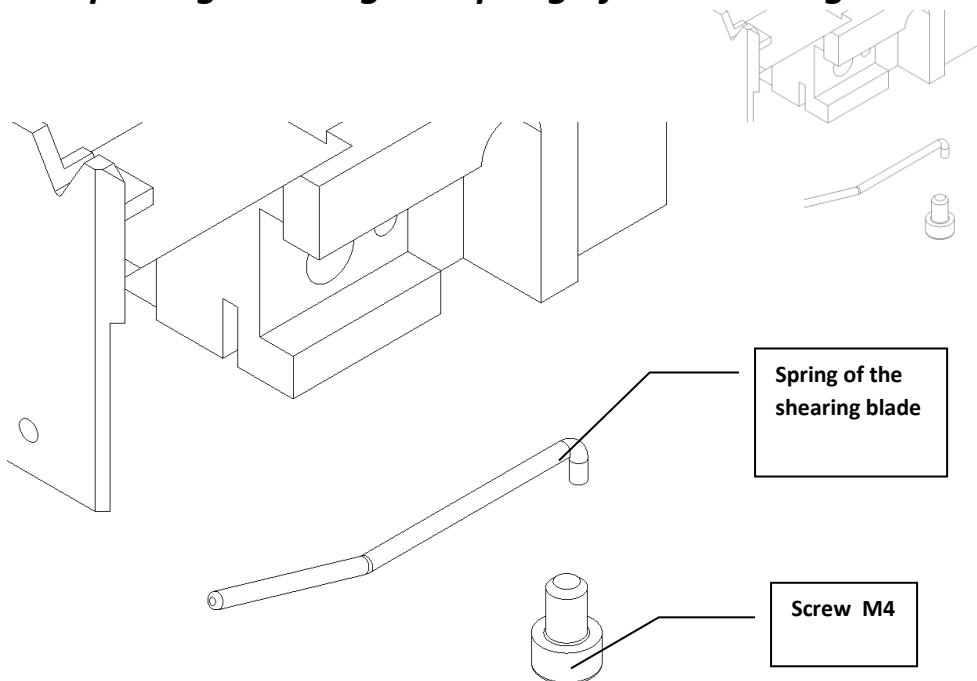
Assembly of the new thumb do in the reverse order.



Setting of the Thumb



Replacing + setting the spring of the shearing blade



Replacing the spring

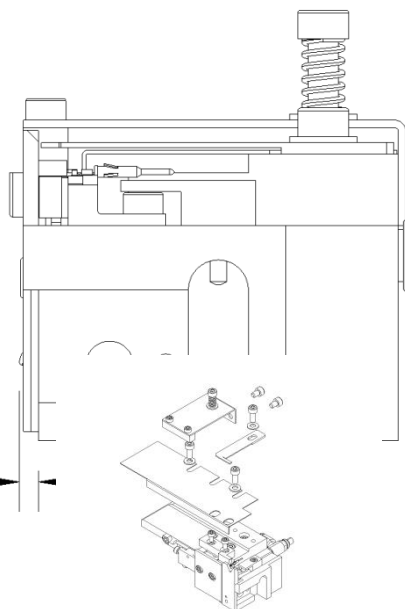
Unscrew the screw M4 with the Allen key 2,5mm.

Take out the spring and inset the new one in direction of bending down.

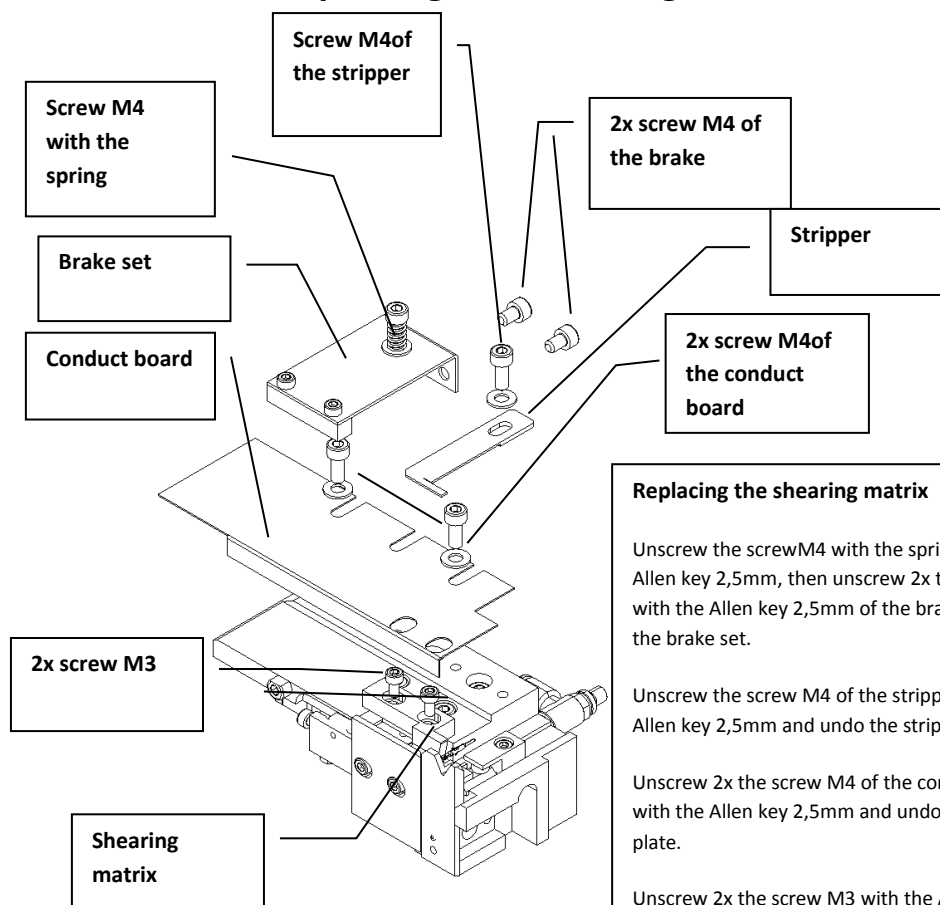
Screw the screw M4 with the Allen key 2,5mm (don't tighten tight, only tighten that the spring can move).

Adjust the spring so that the overlap is up 2,50mm. Tighten the screw M4.

Max
2,50



Replacing the Shearing matrix



Replacing the shearing matrix

Unscrew the screw M4 with the spring of the Allen key 2,5mm, then unscrew 2x the screw M4 with the Allen key 2,5mm of the brake and undo the brake set.

Unscrew the screw M4 of the stripper with the Allen key 2,5mm and undo the stripper.

Unscrew 2x the screw M4 of the conduct board with the Allen key 2,5mm and undo the conduct plate.

Unscrew 2x the screw M3 with the Allen key 2,5mm and remove the shearing matrix.

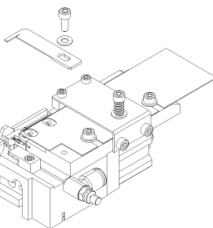
Give a new shearing matrix and assembly in reverse order.

!!!After installation it is necessary to adjust the shearing matrix (see the chapter Setting the shearing matrix)!!!

Setting the Shearing matrix

Stripper

Screw M4 of the
stripper



Conduct

2x screw M3
of shearing
matrix

Shearing
blade

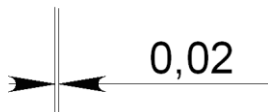
Setting the shearing matrix

Unscrew the screw M4 of the stripper with the Allen key 2,5mm and undo the stripper.

With the Allen key 2,5mm loosen 2xM3 of the shearing matrix through the assembly holes in the conduct plate.

Adjust the shearing clearance between the shearing matrix and shearing blade by using a feeler gauge 0,02mm.

0,02



Replacing the Anvil

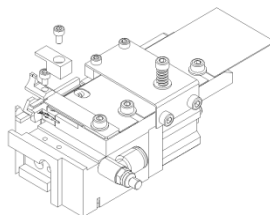
Replacing the Anvil

Unscrew the screw M3 of the contact support with the Allen key 2,5mm and undo the contact support.

Unscrew the screw M3 of the anvil with the Allen key 2,5mm and remove the anvil.

Give a new anvil and do the assembly in reverse order.

!!! After the installation it is necessary to adjust the anvil (see adjustment of the anvil)!!!

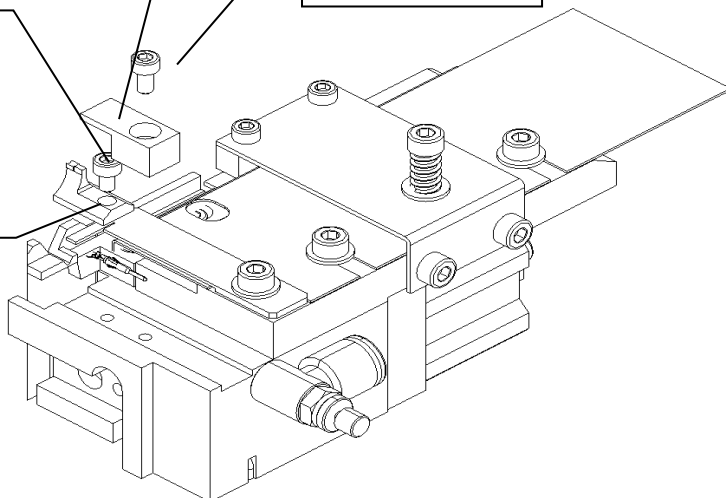


Contact support

Screw M4 of the contact support

Screw M4 of the anvil

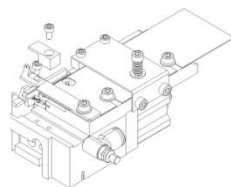
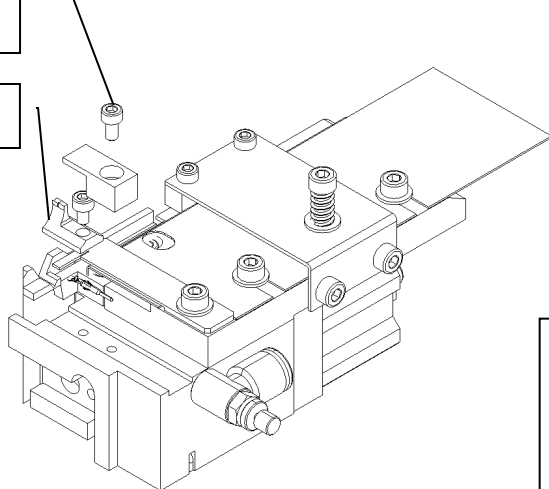
Anvil



Adjustment of the Anvil

Screw M4
of the
anvil

Anvil

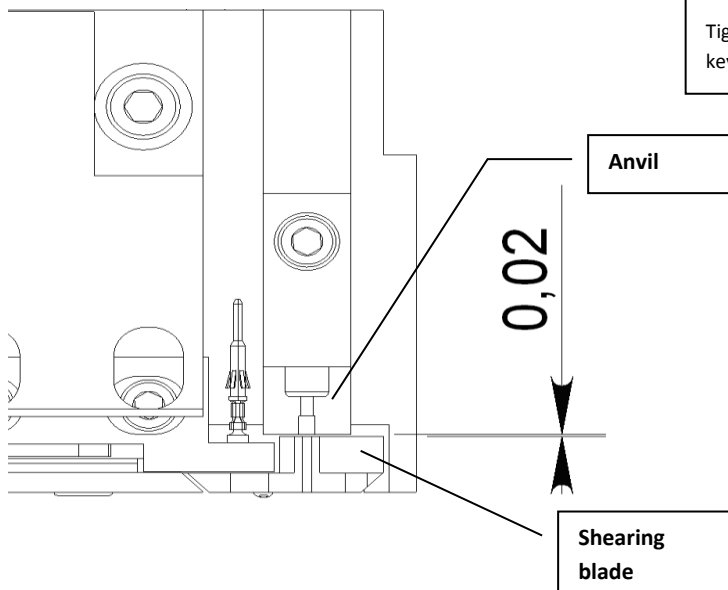


Adjustment of the Anvil

Unscrew the screw M3 of the anvil with the Allen key 2,5mm.

Adjust the shearing clearance between the anvil and the shearing blade by using a feeler gauge 0,02mm.

Tighten the screw M3 with the Allen key 2,5mm.



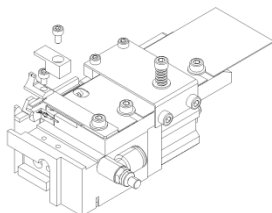
Replacing of the Contact support

Replacing of the contact support

Unscrew the screw M3 of the contact support with the Allen key 2,5mm and undo the contact support.

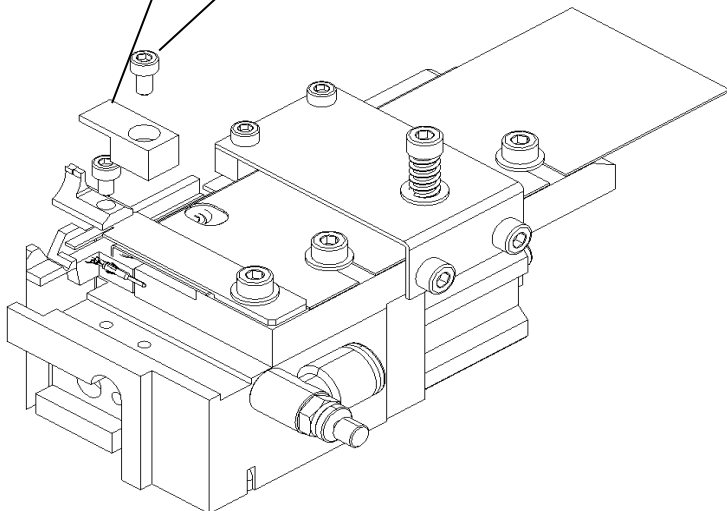
Give a new contact support and do the assembly in the reverse order.

The contact support is further not adjusted, only check visually if it is correctly positioned in the groove.



Contact support

Screw M4 of the contact support

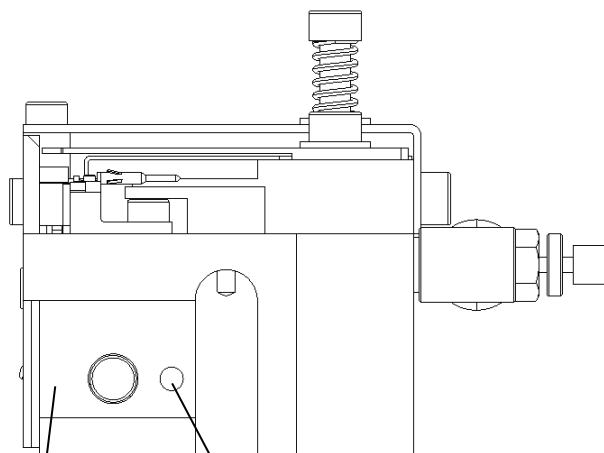
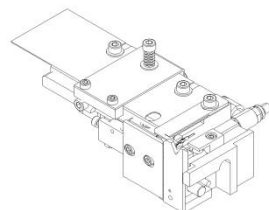


Clamping the machine into the press PP3

Clamping the machine into the press PP3

It is very important before clamping the machine into the press PP3 to make sure there is no dirt on the contact surfaces and the pin pr.3, 00.

These parts should be thoroughly cleaned.



Contact
surface

Pin pr.3,00