

#1 PRESS SAFETY AND OPERATING PROCEDURES

A. OPERATION

1. Ensure bed of press is clean.
2. Ensure the ram of press is high enough to allow for the form tool to fit in.
3. Check to make sure form tool is clean, no burrs or dirt should be on top or bottom of the tooling.
4. Place form tool in the center of the press, this will minimize the shifting of the ram.
5. Making sure the press is in jog mode slowly lower the ram of the press down until it contacts the form tool.
6. Using an adequate number of fastening devices, secure the form tool to the top and bottom of the press. Double check all fastening devices.
7. With the form tooling secure in the press, jog the press up to a workable height and set upper limit (jog button is located on the front of the press).

This is done by sliding the bottom spool on the rod until it contacts the bottom micro switch.
8. Lubricate the part to be formed.
 - Super Slam for press wheels.
 - Acculube for smaller parts.
9. Place the part into form tool.
10. With press still in jog mode, using hand control jog press down until form tool contacts part to be formed. This is a good time to set the slow down setting of the press. This is done by sliding the lower spool on the rod besides the power box up or down so the step on this spool contact the top micro switch.

When forming the operator should set the press to partially form using **rapid speed**, then finish the forming in the **slower speed**.
11. After the speed is set, continue to jog the press down to where the part looks to be formed properly.
12. Set the bottom limit, this is done by bringing the micrometer down until it contacts the bottom limit switch. A light on the bottom of the control panel will come on, indicating contact.
 - Center the micrometer over the micro switch.

- Have the micrometer extended only half-way, this will allow for fine tuning up or down.
13. When bottom limit is set, turn the mode selector to run. This will raise the ram to its upper limit. There is also an up button on the front of the press that will raise the press in jog mode.
 14. Remove part from form tool and do a First Parts Check. If you feel your part is within specifications have another person do a Part Check.

When forming press wheels or barton parts it is a good idea to get an okay from a welder who is familiar with the part.
 15. When parts check is done continue to form the parts, do frequent checks for quality, "Every 50 parts, minimum".

B. A FEW HINTS FOR BETTER FORMING:

1. Make sure bottom limit light comes on at the bottom of each cycle.
2. If parts seem to vary, set up a dial indicator on the press and zero it out at the bottom. This will tell you if the press is consistent and if the micro switches are working properly.
3. If the part sticks in the form tool **do not** use a ball-pien hammer or wrench to tap the part. These are both hard objects and may cause damage to the form tool; you should use a **brass** or **rubber mallet**.