

Setting the Hydraulic Pressure

Checking the Pressure Setting

- Check the pressure by watching the digital readout on the pressure switch. Note the peak value reached when the machine is operating a hydraulic function.

Check the pressure limit

- Press the Mode/Enter button until the screen displays SP1.
- Press the Set button a number will appear. This is the set limit. (The peak pressure reached when the hydraulics operate should be the same as the set limit).

If the peak pressure is not the same as the limit then the pressure relief valve will need to be adjusted. (Detailed Below).

Note: the factory set pressure is approximately 126 Bar.

To set the Pressure Switch

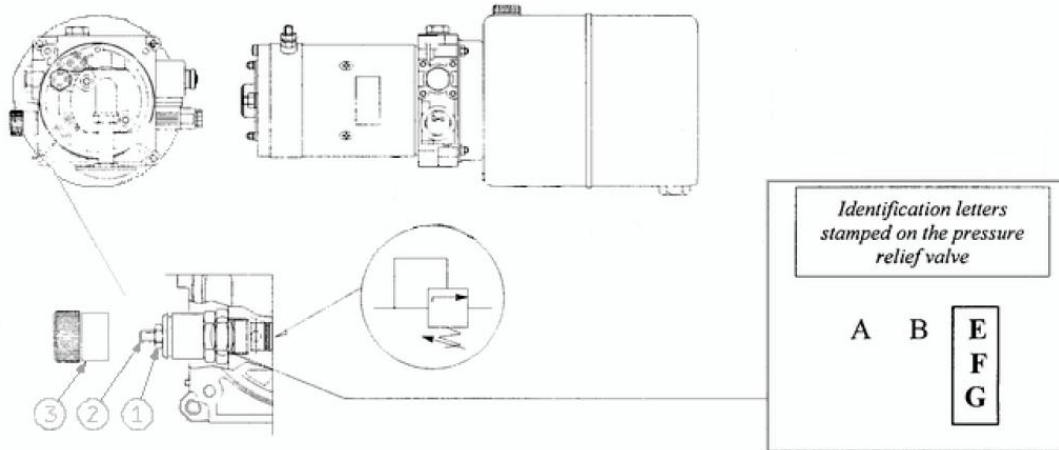
- Press the Mode/Enter button until the screen displays SP1.
- Press the Set button a number will appear. This is the set limit.
- Press and hold the set button to increase the number.
- Press the Mode/Enter button again to confirm the new setting.
- Operate a punch and see if the pressure switch is reaching the newly set level.
- If it is not you will need to reset the pressure relief valve.

Note: If the buttons are not pressed within a few seconds the switch will return to normal function.



Adjusting the Pressure Relief Valve.

If the pressure is not set high enough to activate the pressure switch, the relief valve will need to be adjusted.



Valve identification

Letter	Rated adjustment range (bar)
E	20-110
F	50-210
G	higher than 150

- Remove the cover plug (3).
- Loosen the locking nut (1).
- Turn the screw (2) to adjust the pressure.
- Operate a hydraulic function on the machine and watch the pressure switch to see that it reaches the set limit. If it doesn't readjust the valve.
- Tighten the locknut (1) while keeping the screw Stationary (2).
- Replace the cover plug (3).

The pressure relief valve should also be adjusted if the pressure switch limit is lowered. This will reduce the loading on the pump.

Use the same method as above but reduce the pressure until the pressure switch peaks below the limit, then increase it again until the pressure relief valve is set just above the pressure switch limit.

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