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HOW THE HOLD DOWN SYSTEM WORKS **PAY EXTRA CARE HOLD-DOWNS USE EXTREME PRESSURE**

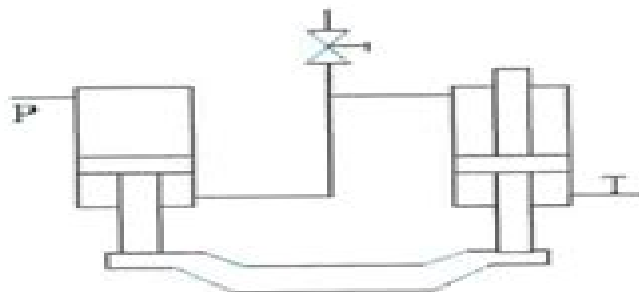
This machine is equipped with hydraulic hold-downs for the punch, plate, or angle sections. Following is how each system works and how to adjust or take care of any malfunctions that may occur.

Punch Section

The punch section contains 2 hydraulic hold-downs to hold the plate in place and to hold the plate down during the stripping action. You can manually move the hold-down up and down by the 3 position switch located on the cylinder cover. You will need to make this adjustment when changing dies to give yourself enough clearance to remove the die. The machine is set up using timer KT1 in the electrical box to only allow a return stroke of approx. 1/8". When punching a new thickness plate use the manual up switch to raise the hold-down all the way to the top of its stroke and then punch your first hole. After this has been done the stroke will only return approx. 1/8". The hold-downs pressure is controlled by pressure switch SP1. It is preset for 30 mpa.

Problems that may occur

These two cylinders work on the principle of a series connection. 1 cylinder is a double sided ram the other is a single ended. Due to leakage around the seals of both cylinders you can have the cylinders come out of parallel. When this happens it is important to remedy this problem as soon as possible. On the left hand side of the punch cylinder cover is a guard held on with 4 screws. Behind this cover is a ball valve. While holding the manual switch to the down position open the ball valve and then close. You should then see that the hold-down cylinders become level again. Punching with the hold-down out of level can and will damage the pistons. It is the responsibility of the operator to check this point.



Iron Worker Safety Manual

Wenbin Ji



Iron Worker Safety Manual:

Reviewing **Iron Worker Safety Manual**: Unlocking the Spellbinding Force of Linguistics

In a fast-paced world fueled by information and interconnectivity, the spellbinding force of linguistics has acquired newfound prominence. Its capacity to evoke emotions, stimulate contemplation, and stimulate metamorphosis is actually astonishing. Within the pages of "**Iron Worker Safety Manual**," an enthralling opus penned by a highly acclaimed wordsmith, readers set about an immersive expedition to unravel the intricate significance of language and its indelible imprint on our lives. Throughout this assessment, we shall delve into the book's central motifs, appraise its distinctive narrative style, and gauge its overarching influence on the minds of its readers.

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