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

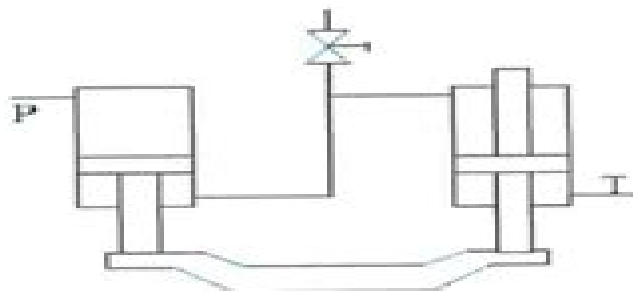
This machine is equipped with hydraulic hold-downs for the punch, plate, or angle sections. Following is how each system works and how to adjust or take care of any malfunctions that may occur.

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

Sebastian Brünink



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medical and administrative costs is close to 1.2 trillion dollars in the US alone. It is imperative by law and ethics for engineers and safety and health professionals to drive down these statistics by creating a safe workplace and safe products as well as maintaining a safe environment. Safety and Health for Engineers is considered the gold standard for engineers in all specialties, teaching an understanding of many components necessary to achieve safe workplaces, products, facilities, and methods to secure safety for workers, users, and the public. Each chapter offers information relevant to help safety professionals and engineers in the achievement of the first canon of professional ethics to protect the health, safety, and welfare of the public. The textbook examines the fundamentals of safety, legal aspects, hazard recognition and control, the human element, and techniques to manage safety decisions. In doing so, it covers the primary safety essentials necessary for certification examinations for practitioners. Readers of the fourth edition of Safety and Health for Engineers will also find updates to all chapters informed by research and references gathered since the last publication. The most up-to-date information on current policy, certifications, regulations, agency standards, and the impact of new technologies such as wearable technology, automation in transportation, and artificial intelligence. New international information including U.S. and foreign standards, agencies, professional societies, and other organizations worldwide. Expanded sections with real-world applications, exercises, and 164 case studies. An extensive list of references to help readers find more detail on chapter contents. A solution manual available to qualified instructors. Safety and Health for Engineers is an ideal textbook for courses in safety engineering around the world in undergraduate or graduate studies or in professional development learning. It also is a useful reference for professionals in engineering, safety, health, and associated fields who are preparing for credentialing examinations in safety and health.

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