

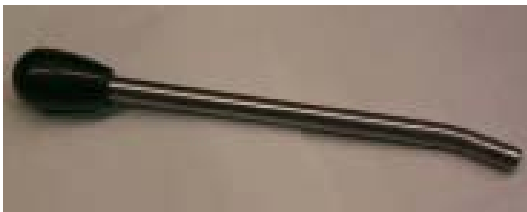
No. 33, 34 & 36 Service Tools & Setup Instruction

Service Tools:

Tooling for adjustment of micrometer (straight pins)



Tooling for extending and retracting ram manually for No 34 & 36 Only
(dog-leg pin with knob)



Allen wrench adjusts total ram stroke on the 33-36, height adjustment of head on column for the No 33 and loosens locking nuts on the No. 33.



Wrench for loosening and tightening locking nuts on the No. 34 & 36 Only.



Setup Instructions for No. 34 & 36



1

Disconnect air supply to cylinder via Lock-Out valve



2

Increase or shorten overall stroke via adjustment screw. Use Allen Wrench at top of screw.



Cover On

3

To view toggle joints, remove cover plate **WARNING!!** Be sure to install cover prior to starting production.



Cover Off

4

Insert Dog-Leg Pin with knob into hole of main toggle joint and move lever down until ram is fully extended.





5

Loosen bolts on the head unit and lower the head until tooling touches part while ram is fully extended.

6

WARNING: Tighten bolts on press head before operation

7

Raise ram with dog-leg pin

8

Place part in the fixture

9

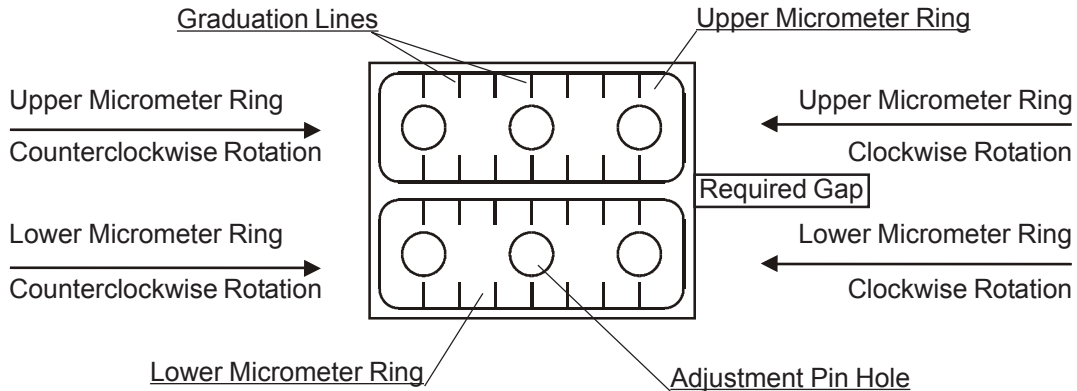
Lower ram with dog-leg pin and verify if more or less stroke is required.



10

Remove plexiglass cover to access the fine adjustment rings

Micrometer Ram Adjustment Device



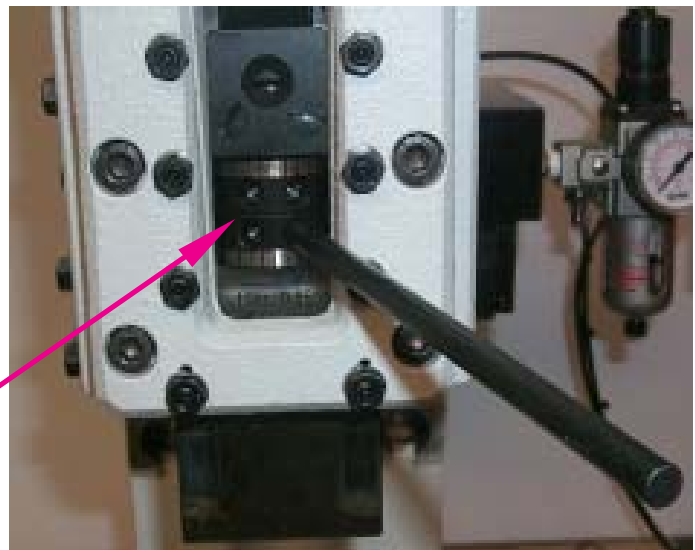
11

FOR MORE STROKE/OR TO LOWER RAM, place tooling (straight pin) into upper adjustment ring and turn from right to left - approximately one full turn. This will provide the necessary gap between the top side of the adjustment ring and the ram.



12

Insert pin into lower ring and move from right to left. Each increment is 0.05mm. Once the desired position has been reached, insert straight pin into upper adjustment ring and move it from right to left in order to lock the new stroke setting in place. The two adjustment rings must be separated and not locked together. Must have gap in the center.



Gap in center



- 13 When adjusting **FOR LESS STROKE/OR TO RAISE RAM**, insert pin in lower adjustment ring and move ring from left to right by at least on full turn. Remove pin from lower ring and insert into upper ring and reduce the stroke as needed by moving upper ring from left to right in increments of 0.05mm. Once desired stroke extension has been reached, lock adjustment by moving lower ring from right to left and remove pin
- 14 **WARNING!** Make sure the bent pin with knob has been removed from the main toggle link before charging the air cylinder with air. Ram will retract once cylinder is charged with air.
- 15 Cycle the press under power and verify proper stroke extension

Setup Instructions for No. 33

Follow steps 1-9 & 15 for the No. 34 press.

- Step 3: Use straight pin instead of dog-leg pin
- Step 4: Use Allen wrench in back of column to loosen bolts and adjust height of head on column



Insert straight pin here to fine adjust stroke. Make sure toggle link is at its FULL EXTENSION

DO



Must use FULL EXTENDED STROKE to achieve maximum force of press. Toggle is straight at application's completion

DON'T



IMPROPER SETUP! Full force of press can not be achieved! Toggle has not gone to its full extension, therefore press capacity can not be reached.