

Pre-Operation Adjustments



Spindle Motor Guards

End Finish Stroke Limit Switches

The Hydraulic Feed Cylinders have end-of-stroke limit switches for both inward and outward travel. In order to operate consistently, the machine must detect these limit switches during operation. To start the machine in automatic mode, the machine must detect the outward travel limit switches. If the machine will not start when the operator has pressed CYCLE START, the outward travel switches must be checked for proper function or adjustment. When the spindles contact the inward travel limit switch, the dwell time is actuated. Once the dwell time is complete, the spindles retract. The inward switch is pre-set to be detected .020" (.50mm) before the cylinder hits the physical stop. The stop is there for length tolerance control. It is not necessary to adjust the limit switch if the stop is adjusted.

Note: to access the limit switches for replacement, the Spindle Motor Guards must be removed.



Inward Switch

Outward Switch

