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5. Commissioning

Before commissioning Sections 9, 2, 3, 4 of these operating instructions must be read through carefully.

We recommend the services of our trained fitters for fault-free commissioning and training of your personnel.

After anchoring down and cleaning, the machine should be taken into service according to the following scheme.

Caution: Before carrying out any work on the hydraulic system switch the machine off and wait until the pressure gauges indicate no pressure.

5.1 Filling hydraulic tank

Hydraulic fluid types and quantities as given in Section 2. Fill only into filler pipe through strainer.

When commissioning the fluid temperature must be at least 15°C, pre-heat if necessary.

When filling for the first time the filling level must be up to the top of the oil-level gauge.

5.2 Charging accumulator with nitrogen

Use only the nitrogen charging equipment for this purpose.

The procedure for charging is as laid down in the accumulator operating instructions. The charging pressure as given in the table of Section 3 must be kept to. Make final measurements after waiting 10 minutes. When the correct charging pressure is reached, screw back the stem of the charging equipment, unscrew the charging equipment, screw the valve cap on to the accumulator and test the accumulator for leaks by applying a soap solution. Tighten all slack screw connections.

5.3 Lubricating machine

Diagram of lubricating points given in Section 2 - lubricant according to the Table Section 2.

Fill the reservoir of the central lubrication system with lubricating oil. (Table under Section 2).

5.4 Making electrical connections in the switching cabinet

Connect free terminals of the main switch to the electrical mains (ensure correct connection of machine to earth or to neutral).

Switch on main switch at the switching cabinet. The direction of rotation of the motor - which must correspond to the arrow - is checked by briefly switching on (pushbutton "Hydraulic system on"). If the motor rotates in the false direction, the mains connection in the switching cabinet must be altered.

5.5 Switching on hydraulic drive

Set the throttles for closing and for injection to a low speed (rotate clockwise).

Set pressure reduction valve Pos. 29, 30 to a high pressure by rotating clockwise. Switch on hydraulic motor.

5.6 Manual sequence

The individual machine movements are to be run through manually with caution. Subsequently the individual speed-regulating throttles are opened and the movement made at high speed, in order to drive out any air from the hydraulic system.

By turning the pressure reduction valve 29 counterclockwise, a lower injection pressure can be set relative to the system pressure. When this valve has also been checked, then follows:

5.7 Automatic sequence

The automatic sequence can be switched in after a successful manual sequence (see Section 4).

5.8 Check of depressurization

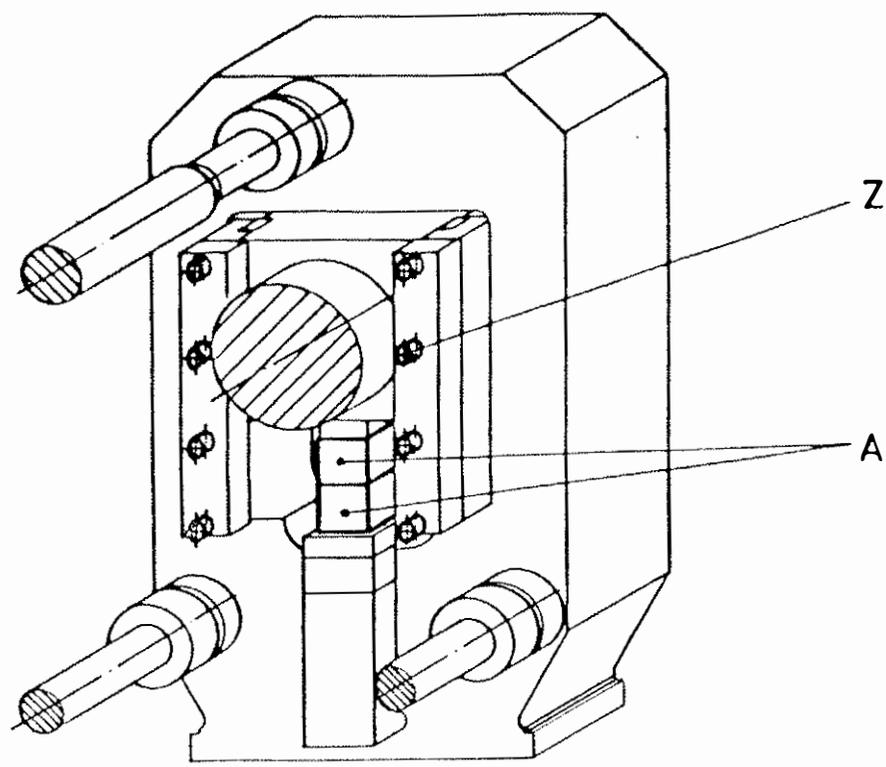
Upon switching off the machine, the solenoid valve 8 is de-energized and thus switches the pressure-relief valves 28, 31 to tank. This results in the entire system becoming depressurized in a few seconds. This is to be checked at the pressure gauge.

5.9 Setting the casting device to outer middle casting DAK/h

In the horizontal cold chamber machines the change-over to outer middle casting is made by the hydraulic positioning device.

The operation of this device is by means of key operated switch and should be undertaken only by the die-setter. We recommend that the key for the switch "Positioning cylinder" is given only to the responsible die-setter. The change over is to be made in the following sequence:

1. Remove the pressing chamber
2. Undo the fixing screws (2off)
The fixing screws are located on the securing surface of the fixed die shoe plate.
3. Set the casting device to the required position by means of the hydraulic system.
4. Tighten the fixing screws as tight as possible
5. Fit the pressing chamber into the new location.
The machine is now ready for casting operations in the new casting position.



5.9. SET UP PROCEDURE FOR CHANGING TO
UPPER OR LOWER CASTING POSITION

1. Remove casting plunger and plunger rod.
 2. Remove injection sleeve.
 3. Loosen the eight locking bolts located on either side of the injection cylinder one turn. (Pos. Z)
 4. Raise the injection unit hydraulically by means of the key operated switch located on the control panel.
- NOTE: This key should be given to a responsible set up man
5. Insert or remove spacer blocks for the casting position required. (Pos. A).
 6. Hydraulically lower the injection unit onto the spacer blocks.
 7. Tighten the eight locking bolts on either side of the injection cylinder.
 8. Reassemble the injection sleeve, casting plunger and plunger rod.

The machine is now ready for operation.