

September 25, 1995

100 SERIES INDEX TABLE ADJUSTMENT

- A) First check pressure of index table while table is running as slow as possible. See pages 3 & 4. At either check point, pressure must measure approximately 575-650 p.s.i. If pressure is higher or lower, adjust the index table relief valve as required.
- B) See Page 3, remove the 4 bolts, item 26. Remove cover and gasket. Note, some oil may come out.

This will expose the end of the control cam follower, see page 5.

Loosen the hex nut (item 6, page 5) via tool shown on page 6 and back out set-screw, item 5, one full turn.

- C) Start up unit with index table running slow. The table should barely keep turning.

Begin turning the set-screw inwards 1/8 turn at a time. Sooner or later the index table will start to stop on station while also skipping a couple of stations - you are now close. Continue turning set-screw until you have total sequence, one table turn and one ram hit.

Note: If you use skip station, the table will skip that station.

Notice where the unit went into total sequence, for example at the 10 o'clock position. With your "T" handle Allen wrench, keep turning the set-screw in until the unit starts to double ram hit.

Now begin to back out the set-screw until the index table is back in sequence again. Notice where unit went into sequence, for example the 2 o'clock position. Turn the set-screw in to mid-point which for our example is the 12 o'clock position.

This should adjust your 100 series index table.

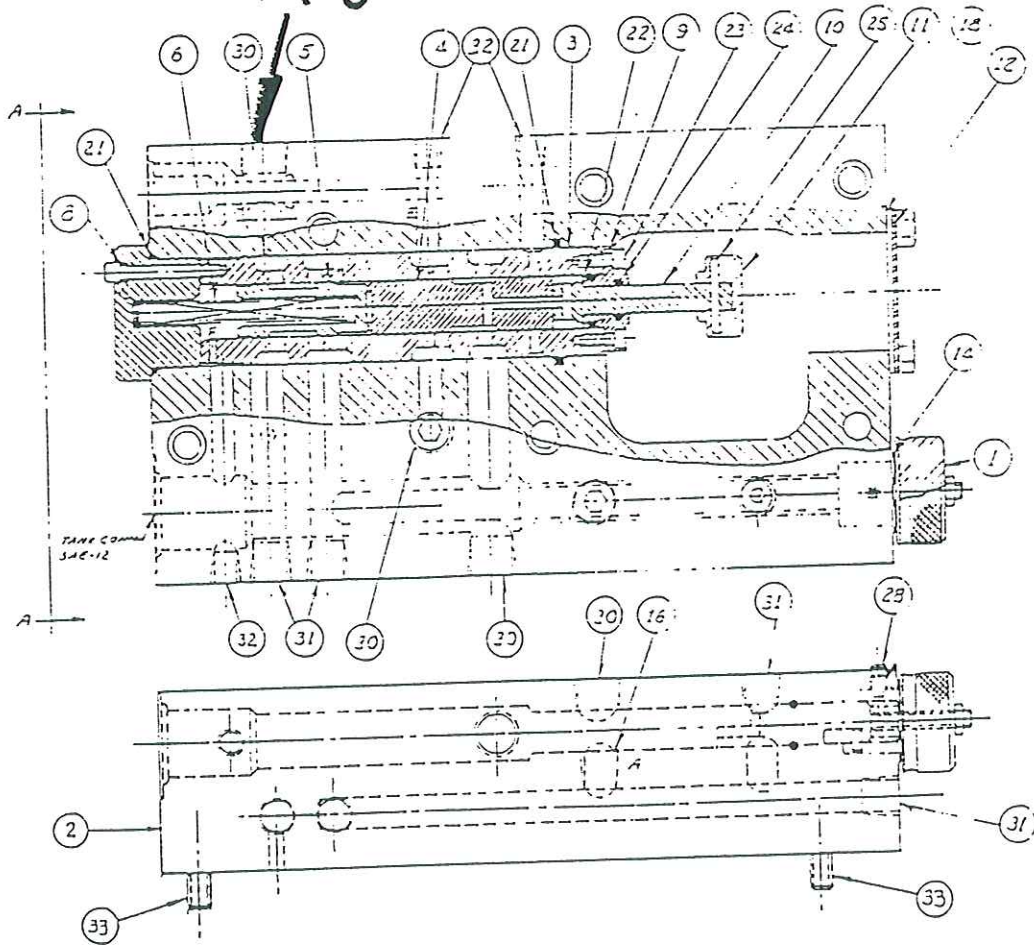
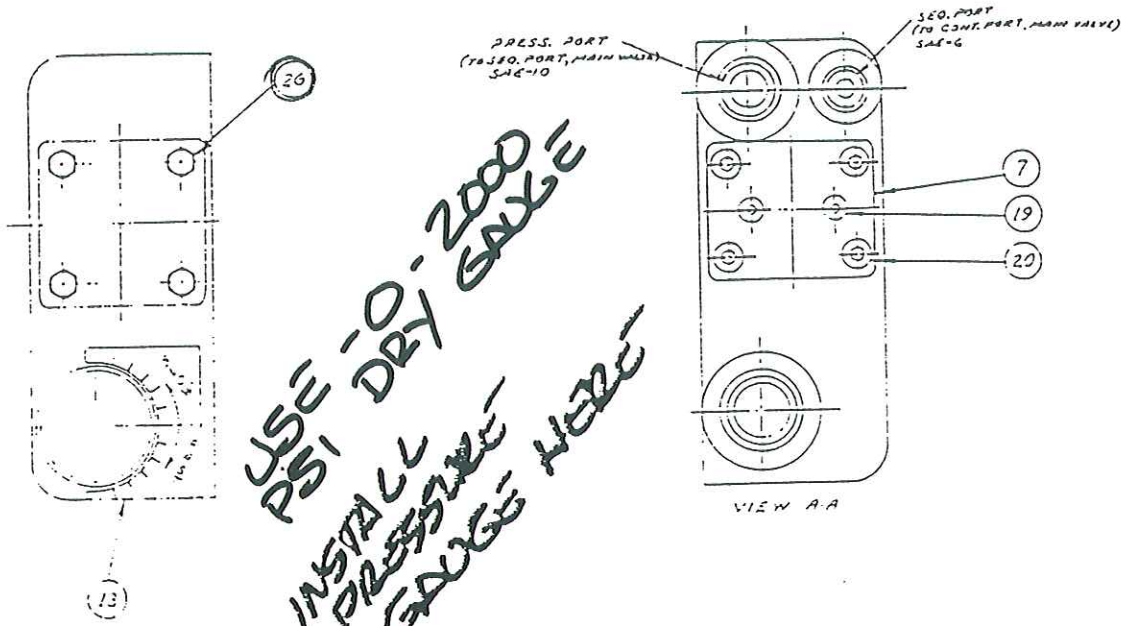
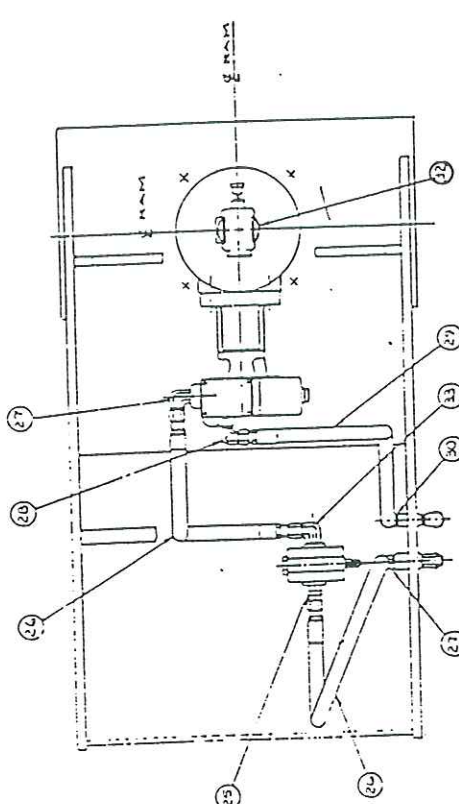


FIGURE 3

SUB-ASSEMBLY — VALVE, SEQUENCE
INDEX TABLE



PLAN VIEW FH 20 PRESS

INSTALL TEE HERE WITH PRESSURE GAUGE

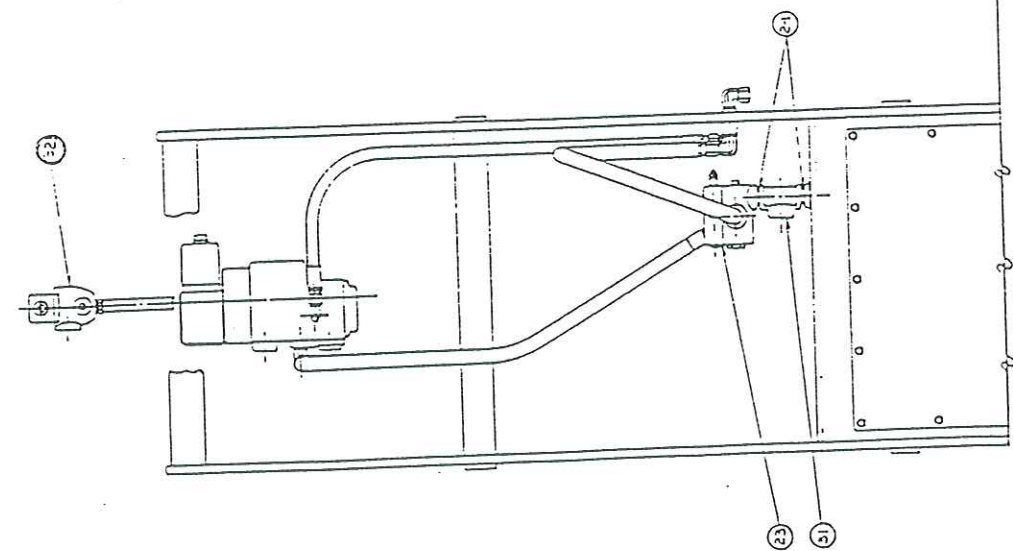
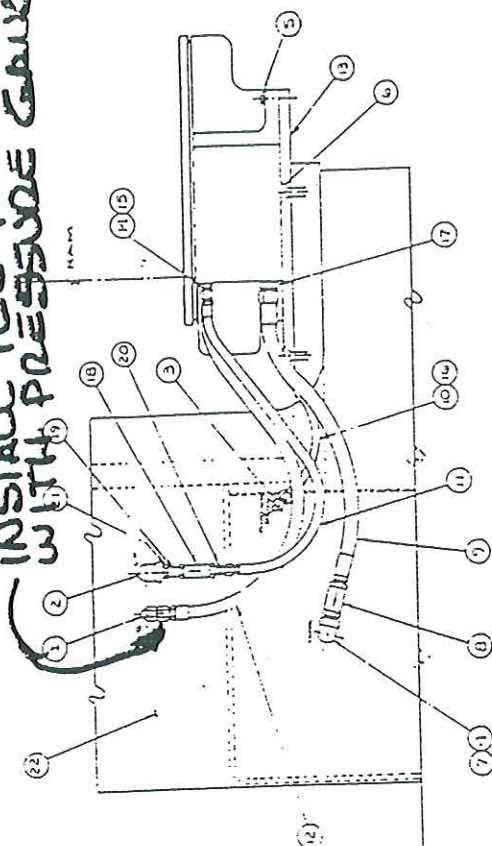


FIGURE 17

ADAPTION ASSEMBLY
 INDEX TABLE TO PRESS
 FH20 W/C300SSI OR C360SSI
 CONTROL VALVE

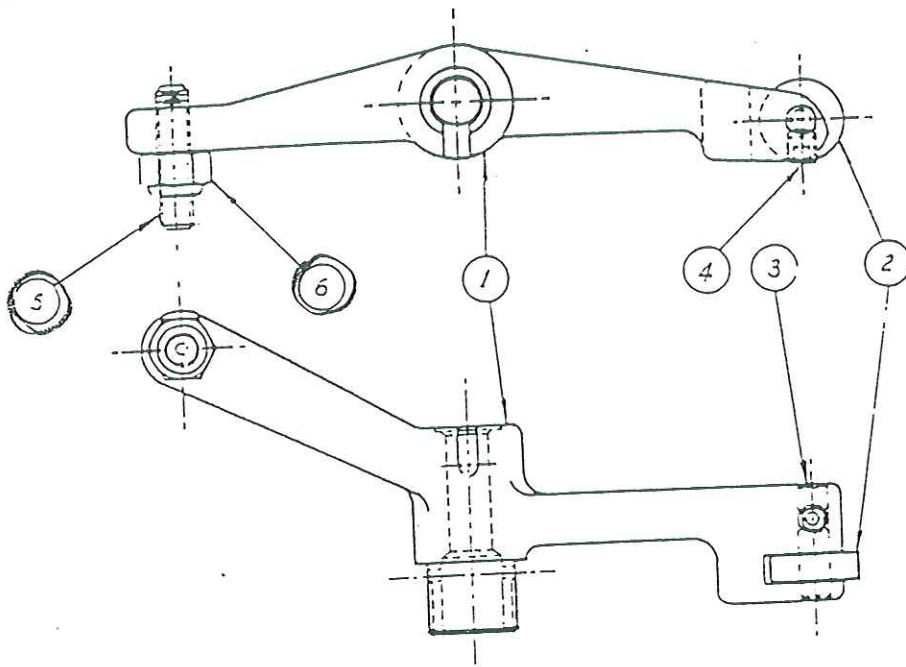


FIGURE 6

CONTROL CAM FOLLOWER ARM SUB-ASSEMBLY S11-13166

Item	Part No.	Description	Qty
1	031-29497	ARM—Control Cam Follower	1
2	031-29499	ROLLER—Control Cam Follower	1
3	031-40695	PIN—Control Cam Follower Roller	1
4	311-10060	SCREW—Soc. Set. Cup Pt. #10—24 x 3/8"	1
5	312-15222	SCREW—Soc. Set. Flat Pt. 3/8"—24 x 1-3/4"	1
6	331-15000	NUT—Elastic Stop 3/8"—24	1

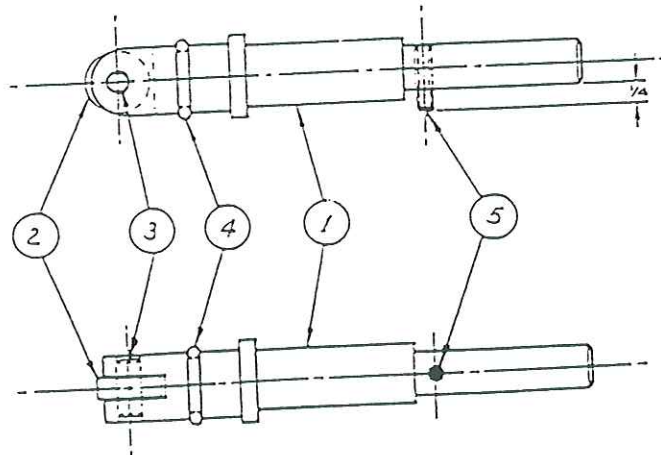
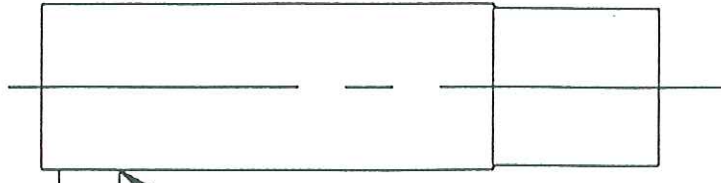
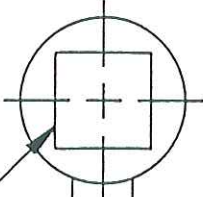


FIGURE 7

PUSH ROD SUB-ASSEMBLY S11-13491

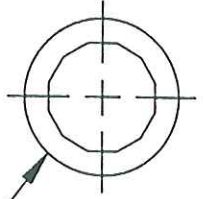
Item	Part No.	Description	Qty
1	031-29501	ROD—Skip Station Push	1
2	031-29502	ROLLER—Skip Station Cam	1
3	324-21610	PIN—Dowel 1/4" dia. x 5/8"	1
4	671-00113	"O"RING	1
5	325-12120	PIN—Roll 3/16" dia. x 3/4"	1

1/2" DRIVE



BRAZE ON HANDLE TO SUIT

9/16" HEX



WRENCH FOR ADJUSTING INDEX TABLE

SHOWN FULL SIZE