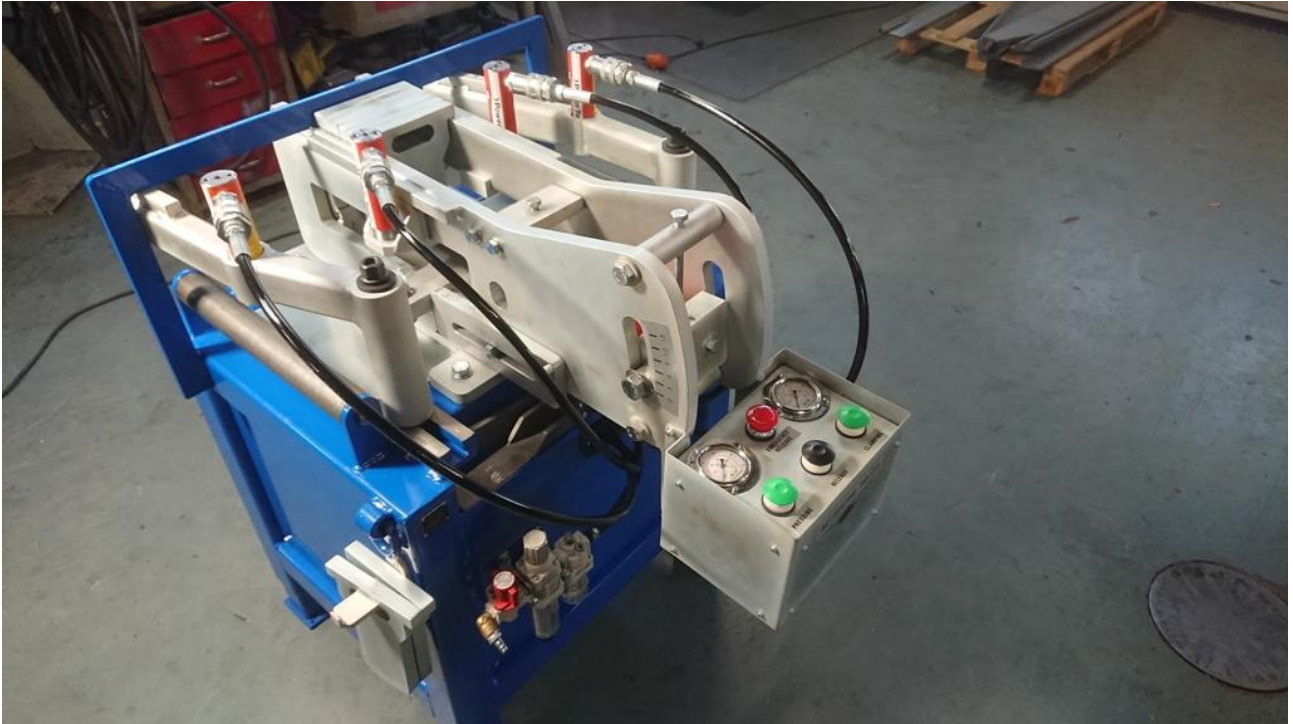


ALLIGATOR PRESS

This machine is designed to bend “alligator mouth” cut-outs of bulb flats (i.e. Holland Profiles). Use for other purposes is prohibited.



Operating Instructions

1. Connect air supply, open valve



2. Insert bulb bar, bulb towards the front of the press.



3. Place necessary amount of shims behind the bulb flat. E.g. HP 160 = 6 shims.



4. Position holding cylinders and tighten swinging arms moderately.



5. Push sliding support under the flat



- Place the hold-down support on the end of the bulb flat. This is to prevent the bent bulb from rising up during and after the press. Supports are specific for each size of bulb flats and are stamped accordingly.



- Press "CLAMPING" to clamp down the flat. Clamping pressure will vary depending on the size of the flat. Clamping pressure also affects the hold-down support's down force thus affecting the downward pre bend of the bulb. Clamping pressure for HP160 is app. 200-250 bar and for HP280 the maximum. The geometry of the cut-out also affects suitable clamping pressure.
- Press "PRESSING" to press the bulb. Keep pressing the button until desired gap is achieved. It may be necessary to over press slightly to compensate the spring back of the bulb. Pressing cylinder will return once button is released.
- Press "RELEASE" to release clamping cylinders. Cylinders are retracted by continuous pressing of the button.



10. "EMERGENCY RELEASE" will release the clamping cylinders. This will happen even if there is no air supply because of a small air reservoir in the system.



VERTICALLY MISALIGNED BULB

If pressed bulb is vertically misaligned with the rest of the flat, either one of the cylinders in swing arms can be used to press down the bulb.

1. Slide the bulb flat forward so, that the pressed part is under the so far unused swing arm cylinder and adjust the swing arm also accordingly. Tighten the nut. Make sure that there is free space under the flat. I.e. do not attempt to press against the roller. Operate "CLAMPING" to press down the bulb. Press carefully perhaps few times until alignment is correct. Alligator Press is not designed to correct error if bulb is pressed too far down at this point.



MAINTENANCE

1. Keep machine clean
2. Check oil levels of pumps periodically. Refer to SPX Power Team instructions.
3. Check oil level of lubricator periodically. Refer to SMC manual