
Inspecting / Adjusting the die head – Opening / closing

The die head is equipped with a prestressed spring that works to move the switch ring and the die holders from opened to closed position when the halter has reached approx. half way between the positions during the switch.

Upon delivery, the prestress of the spring, the sensor and the bar (Safety opening of die head) have all been carefully adjusted for best possible precision.

The switching mechanism can be hard worked the first time the die head is operated or after the machine have been unutilized for a long period of time.

Inspection

- Press function key "F1" in menu II to start Jog mode and close the die head cover.
- Inspect the function of the spring by opening (press function key "F3") and closing (press function key "F4") the die head.
- If the die head does not release correctly, adjust the stress of the spring by turning the adjustment screw (section 1.2.3, pos.9). Adjust no more than $\frac{1}{4}$ of a revolution between every test release. Turning the screw clockwise increases the stress.
- If the adjustment screw is turned excessively, the spring can become completely compressed and lose all room for movement which will result in the thread dies not staying in closed position (which causes tapered threads) during operation or the die head not functioning at all.
- If the spring loses its strength or if the screw is tightened too hard resulting in deformation of the spring, it has to be replaced. The spring can be ordered from your HMV machines supplier or directly from JBL Mekan AB (item no. 444801-5). Replacing the spring with a spring of different properties will result in the die head not functioning as intended.

- In order to inspect the function of the sensor, open the die head cover and press function key "F5" in menu II to feed the sled towards the die head until it opens.
- Close the die head cover. The distance between the sled and the die head must be at least 15mm.
- In order to inspect the function of the sensor, press function key "F2" in menu II to feed the sled from the limit position to the start position.
- Adjust the position of the sensors if necessary.



CAUTION

Be aware of the risk of crushing when adjusting