

SERVICE TIP FROM...



SEYI PRESSES, INC.

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Procedures for Resetting the Hydraulic Overload

The press cannot be operated under a working load which is higher than the maximum rated tonnage. The allowable blanking tonnage capacity should be lower than 70% of the maximum rated tonnage for all presses. The reverse load should not exceed 10% of the maximum rated tonnage (if the load exceeds this limit, damage to the connecting portion of the slide and other parts may occur). The load should also be uniformly distributed over 65% of the bolster area, avoiding concentrated loads and off-center loading. When concentrated loads or off-center loading cannot be avoided, contact SEYI America for assistance. **In the instance an overload does occur, the following procedures need to be followed:**

1. Determine at what position the ram has stopped. (After or before bottom dead center)
2. If the overload occurred **after bottom dead center**, place the selector switch in the inch mode and inch the press back to top dead center. The pump will automatically reset at the top of the stroke and the fault condition will clear.
3. If the overload occurs **before bottom dead center**, shut off the main motor, wait for the flywheel to completely stop and also check that the main motor has come to a complete stop by looking at the fan on the back of the motor. Once everything is stopped, place the forward/reverse key switch in reverse and restart the main motor. Once the motor is up to speed, place the selector switch in the inch mode and inch the press back to top dead center. The pump will automatically reset at the top of the stroke and the fault condition will clear. Turn the main motor off again wait for the flywheel and main motor to come to a complete stop and place the forward/reverse key switch back to the forward position and restart the main motor.
4. If the pump will not reset at the top of the stroke and continues to pump you may need to “Bleed the Pump”. Simply open and close the air bleed screw located on the top of the pump. (Do not remove the screw) you may need to open and close the bleed screw several times before the pump pressurizes.

If you are unable to resolve this problem, please contact SEYI's David Hattabaugh (Service Manager) at 931-455-7700 ext 262) for technical assistance.

Or send Dave an email at david@seyiamerica.com with your service question.

For more on SEYI service, visit us at www.seyi.com.

