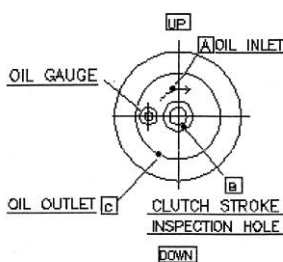




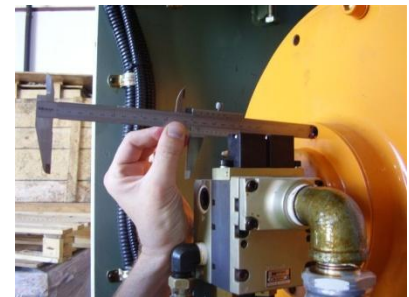
Checking the Clutch/Brake Clearance

The clutch/brake clearance should be checked every time the oil is changed or if there is a noticeable change in the stopping or starting time of the clutch/brake.

The following is a detailed procedure for properly checking the clutch/brake clearance.



1. Cycle the press (ram/slide) to bottom dead center.
2. Turn off power to press, follow proper lock-out/tag-out procedures. (Make sure the air is still on to properly check the clutch/brake clearance.)
3. Remove the die block and place between the bolster and slide plate.
4. Remove the back guard.
5. Remove plug "B" Inspection Plug (**see drawing at left**).
6. Rotate flywheel by hand until the inspection hole is at approximately 1 O'clock.
7. Insert a rod, approximately 5/16" diameter into the inspection hole. (You may need to rotate the flywheel to make sure the rod completely seats in the inspection hole)
8. At this point you may want to use a set of depth micrometers to measure the depth of the hole (**see photo at right**).
9. The next step is to manually energize the Ross clutch brake valve by depressing the two manual buttons located on top of each solenoid.
10. Now that the valve is energized reinsert the depth micrometer and write down the measurement.
11. **The difference between the two readings is the clearance.**
12. Compare the measurement against the tag that is provided on the clutch/brake unit to make sure it is within the safe operating range. (**reference photo at left**).
13. If the clearance is within the required range reinstall the inspection plug and the press can be placed back into production.
14. If the clearance is not within the required range, do not operate the press until the necessary repairs can be made. Failure to make the necessary repairs could result in serious injury or even death.



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.