

## SERVICE TIP FROM...



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## Tonnage Monitor

Are you making full use of your current tonnage monitor? Many stamping facilities we are visiting are not utilizing the tonnage monitor to its full potential. A large portion of the end users are only using the monitor to observe the current tonnage. When used properly the tonnage monitor can:

- Reduce unnecessary wear on load bearing components
- Detect die malfunctions through tonnage variations
- Help track tool wear
- Offer reverse load protection
- Help ensure quality of parts

Let's cover a few of the setpoints that you will need to be aware of:

- 1. High setpoint:** This is the maximum allowable tonnage per strain link based on the percentage entered in to the tonnage monitor. Example, 100-tons divided by two strain links equals 50 tons per strain link, a percentage of 10% (5-tons per strain link) is entered in to the tonnage monitor. If the maximum tonnage exceeds 55 tons on either strain link, the tonnage monitor will top stop the press giving a high tonnage alarm. This could indicate a problem with the tooling.
- 2. Repeatability setpoint:** This setpoint enables the tonnage monitor to provide precise, yet nuisance-free monitoring because it can ignore normal gradual variations in load and can detect the small sudden changes in tonnage that usually indicate problems. Using the example above (100-tons), if the repeatability was set at 5% , (2.5 tons per strain link) and there is a variation in tonnage of 2.5 tons based on the last stroke,(either high or low), the tonnage monitor will top stop the press and issue an alarm.
- 3. Low setpoint:** This setpoint is used to monitor low tonnage in the same manner as the high setpoint. Example, no material/end of stock.
- 4. Reverse Load setpoint:** This parameter is a percentage of total press capacity determined by the press manufacturer. SEYI recommends this setpoint to be set at no more than 15% of total press capacity. Example: A 100-ton press should not exceed a total of 15-tons of reverse load.

Your tonnage monitor should be calibrated every year. If you need assistance with calibration please contact Dave or Glen.

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](mailto:david@seyiamerica.com) with your service question.

For more on SEYI service, visit us at [www.seyi.com](http://www.seyi.com).

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