INSTALLATION SECTION

BuckUp Legger

401 N. Lincoln ⩓ P.O. Box 72 ⩓ Colville, WA 99114-0072 ⩓ U.S.A.
Tel: (509) 684-4505 ⩓ Fax: (509) 684-4500
E-mail: sales@colmacind.com ⩓ Website: www.colmacind.com

9/2016

INSTALLATION

Your Colmac press should be uncrated and carefully checked for shipping damage.

Upon delivery, visually inspect the crate and visible parts for shipping damage. If the crate or cover is damaged or signs of possible damage are evident, have the carrier note the condition on the shipping paper before the shipping receipt is signed. **Carrier must have signed for damage before any damage claims can be processed.** Colmac Industries, Inc. is not responsible for freight damage.

Check for internal damage or unsecured parts.

PLACEMENT INSTRUCTIONS

Before moving this machine into the operating area, plans should be made for its position and placement.

Consider the workflow to and from the machine,
Allow room for the comfort and convenience of the operator,
Allow sufficient space for utility connections and maintenance access.

Refer to the INSTALLATION AND SALES drawing at the end of this section for layout dimensions.

Begin by moving the press to the approximate desired location.

IF A FORKLIFT IS USED TO POSITION THE PRESS, MAKE SURE THAT THE FORKS ARE POSITIONED UNDER THE HEAVIEST PART OF THE PRESS.

BE SURE THAT THE FORKS EXTEND ALL THE WAY UNDER THE FRAME AND ARE NOT LIFTING ON THE SHEET METAL PANELS.

DO NOT LIFT THE PRESS BY THE SHEET METAL PANELS.

THE PRESS MAY BE TOP HEAVY. USE CAUTION WHEN POSITIONING THE PRESS.

INSTALLATION INSTRUCTIONS

Set and level the machine:

1. Level the press with a spirit level and the leveling pads provided (or metal shims).
2. Use concrete anchor bolts to secure the press to the floor (Figure 1).

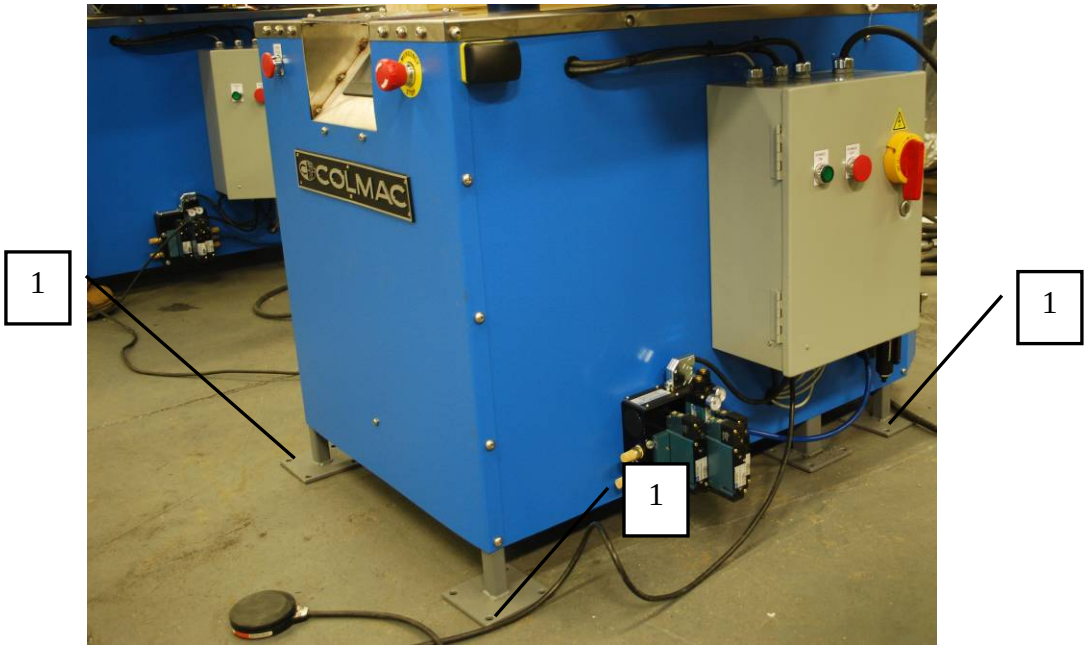

Figure 1 – Installation Bolt Holes

3. Recheck that the press is still level after bolting to the floor or adjusting the leveling pads.

Undo the wire bindings that hold the pressing head down.

SUPPLY CONNECTIONS

During the winter season the factory will run anti-freeze through the steam system and then blow it out to prevent frozen pipes in shipment. Before operating, open traps and purge, and also check solenoid steam valves to be sure they are not stuck.

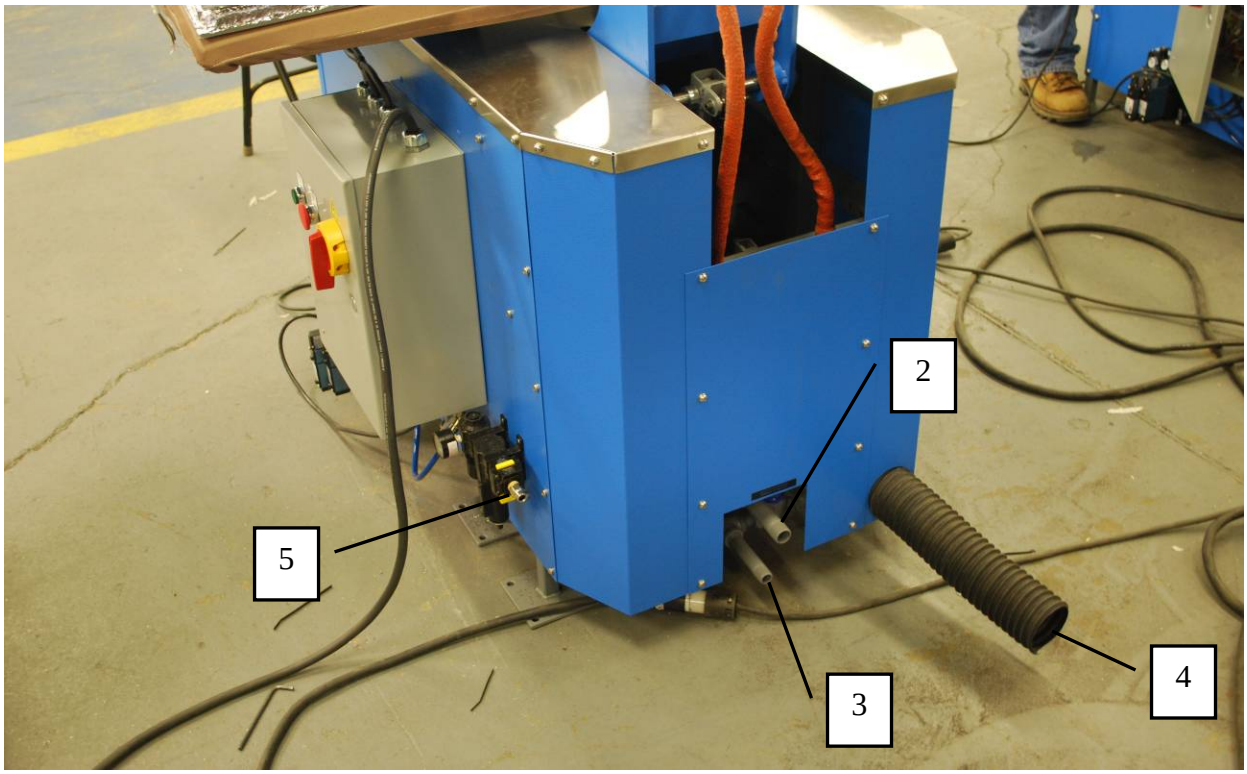

Figure 2 – Utility Connections

"STEAM IN" (2)

"CONDENSATE RETURN" (3)

"VACUUM CONNECTION" (4)

"COMPRESSED AIR IN" (5)

STEAM

To ensure an adequate supply of steam to the press, the steam line should be 1-1/2" (38mm) or larger. A smaller size line will compromise the performance of the press. Be sure that a strainer is installed in the steam line near the machine and that the steam lines are insulated to prevent heat loss and possible injuries to personnel. A shut-off valve should be installed at the machine, to turn steam off, if necessary.

PROPERLY INSULATE ALL STEAM LINES TO PROTECT PERSONNEL AND INCREASE OPERATING EFFICIENCY.

PROPER STEAM HOOK-UP

The steam and return system connections are very important. Poor steam quality or incorrect connections directly affect its performance. (Figure 3).

1. To ensure adequate steam supply, the steam line should be 1-1/2" (38mm) or larger and the return line should be 3/4" (19mm). The factory recommends the larger supply sizes to compensate for line loss. Since the machine is equipped with steam traps, no additional traps are required. Never put one trap in line with another, as the traps will no longer function. Be sure to check all steam connections for leaks. A strainer should be put into the steam line. All steam lines should be insulated to prevent loss of heat and possible injury to personnel.

2. **Supply Line:** Connect the steam line to the top of the steam headers as shown in Figure 3 to ensure a clean, dry steam supply.

3. **Shut-off valves** installed ahead of the union and strainer on the "steam-in" and "steam-out" lines and between the union and return header on the "Main Header Trap System" (**8**), will simplify shut-off for repair and maintenance. "Ball" or "Gate" type valves are recommended for maximum flow. Shut-off valves need to be in the “ON” position during machine operation.

4. **Unions** placed between the shut-off valve and the machine will simplify hook-up and disconnection between the steam supply and the machine.

5. The **strainer** is important to ensure that the steam is free of foreign materials that could foul electric valves, traps and other components in the steam system of the machine.

6 **Condensate Return System:** Connect the condensate, return pipe to the top of the return header to prevent foreign material from being drained back into the return system of the machine.

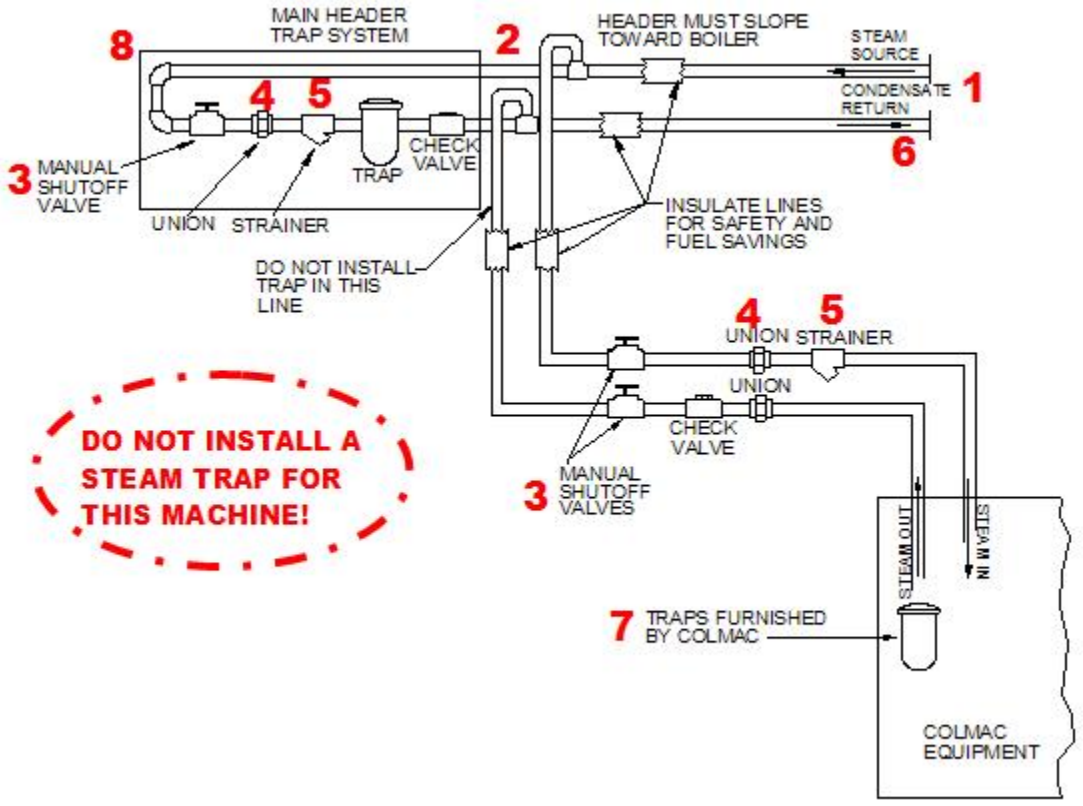

Figure 3 - Proper Steam Plumbing Example

7 **Do not install a steam trap for this machine.** Your press already has this part installed as part of the return system. If a trap is installed outside the machine, the steam and return systems will not function properly.

8 To assure clean, unsaturated steam to your equipment, the main steam header(s) should be trapped. This will help prevent condensate in the steam lines and increase the efficiency of the steam-heated equipment.

CONDENSATE RETURN LINE

The return line should be 3/4" (19mm) or larger to insure a fast, even removal of the condensate from the press. The return line should have a check valve and a shut-off valve installed close to the machine. Traps are installed in the press. Do not install any additional traps in the return line. This would only cause all the traps to malfunction. The condensate return line should be insulated to conserve heat and prevent possible injury to personnel.

AIR

Air should be supplied by a 3/4" (19mm) or larger line to insure an ample volume for proper operation of the machine. It is recommended that a 3-way plug type valve be installed at the machine for quick shut-off and exhausting of the air on the machine. The air supplied to the machine should be at 85psi (5.8atm) to 100psi (6.8atm). The airflow and pressure should remain reasonably constant. Too much fluctuation of air pressure will affect the operation of the machine.

Steps should be taken to insure the air is clean and dry. Dirt and moisture shorten the life of the air system components and can cause valve and cylinder problems. Oil level and moisture traps of the incoming air supply should be checked daily.

ELECTRICAL

Check to be sure that the electrical supply is the same as that required by the machine. It is the customers' responsibility to insure that all electrical connections are in accordance with all applicable national, state, and local codes.

This machine may be plugged directly into a standard 110 volt, AC, single phase (120/60/1) wall socket. The wall socket used should be protected by a UL489 rated circuit breaker.

This machine must be electrically grounded. Failure to attach an earth ground will results in damage to the electrical system. Plumbing should not be used for grounding purposes.

PADS AND COVERS

NOTE: Pads and covers differ between models of press.

The press will ship from the factory with pads and protective covers installed.
These pads and covers are used to achieve a proper press as well as operator safety.

Upon installation, verify the lower chest pressing pad is installed properly and snugly fitted around the lower pressing chest (Figure 4).

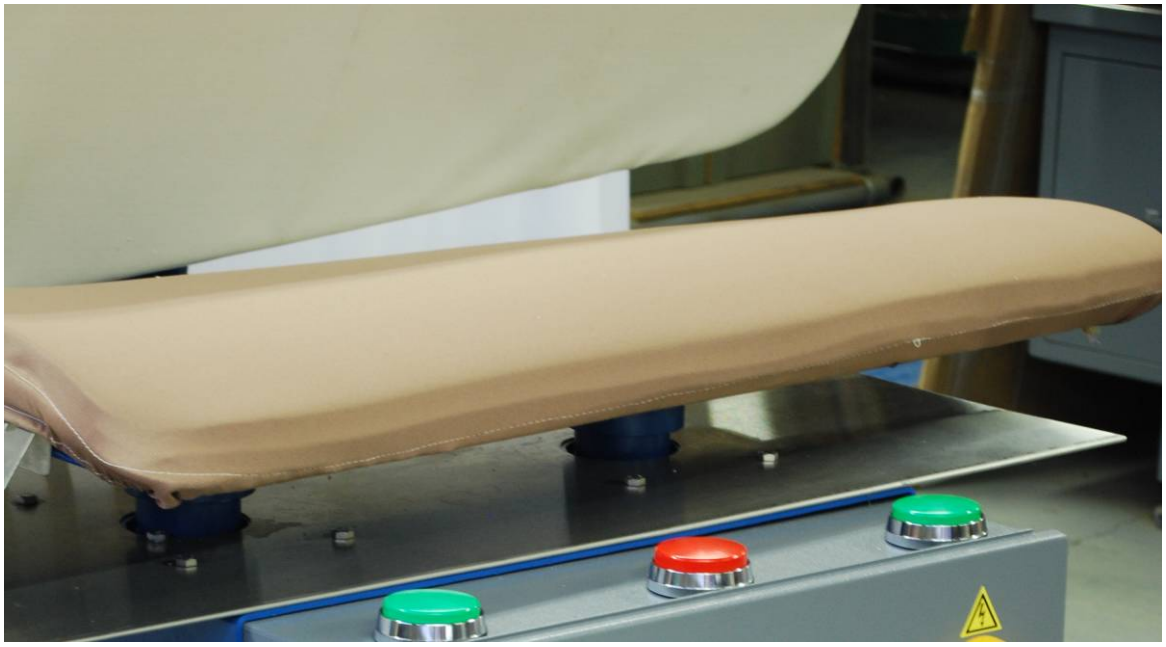

Figure 4 - Lower Pressing Chest Pad

The upper pressing chest utilizes both a pad and a cover. The protective pad should be installed as shown below (Figure 5) at all times during press operation to protect the operator from the heat of the pressing chest.

The upper pressing chest pad is installed in a similar manner as the lower chest, fitted snugly around the contour of the pressing chest and secured with the drawstring and springs as shown in Figure 5.

Figure 5 - Upper Pressing Chest Pad and Cover