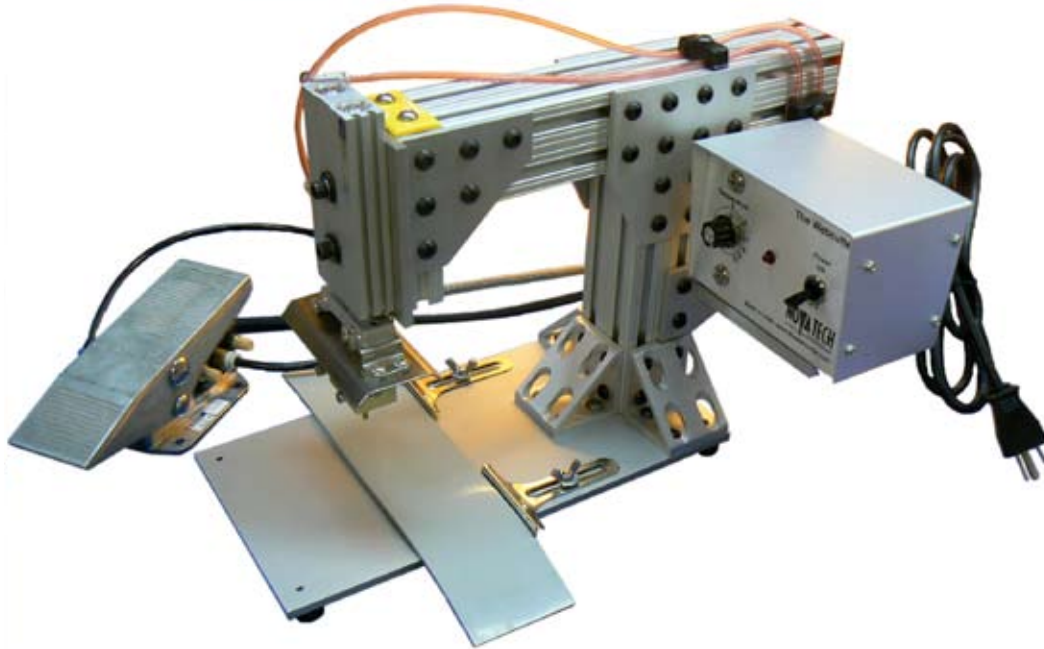


ARX-95

Pneumatic Hole Punch & Press

USER MANUAL



Abbeon Cal, Inc.
Industrial Plastic Working Equipment & Precision Instruments

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ARX-95 Setup & Quick Start

This User Manual covers several models, including (but not limited to) ARX-95-PS1, ARX-95-PS2, ARX-95-PM2 ARX-95-PC2 with either -WK, -DK, -TK or -RK Controllers. See the Manufacturer's label on the unit for the model type.

Air pressure required is 60 - 125 psi. Connect the air line to your air supply. Listen for air leaks.

Connect the plug to the power supply.

Place the foot pedal in an appropriate position on the floor.

TOOLING TEMPERATURE

Set the tooling temperature between 60% and 80% and allow 5 - 10 minutes for the tooling to reach full temperature. The optimum temperature is when the knife or tooling sufficiently melts through the material being used. Excessive temperature will cause premature heater failure. Insufficient temperature will prevent the tooling from burning off residue.

TOOLING SPEED & TIMER CONTROL

Please note that these models are designed to cut, punch or press using HEAT, not force. As such do not set the tooling speed to operate faster than the tooling can melt through the work. Excessive tooling speed will cause damage and premature wear to the tooling and the air cylinder.

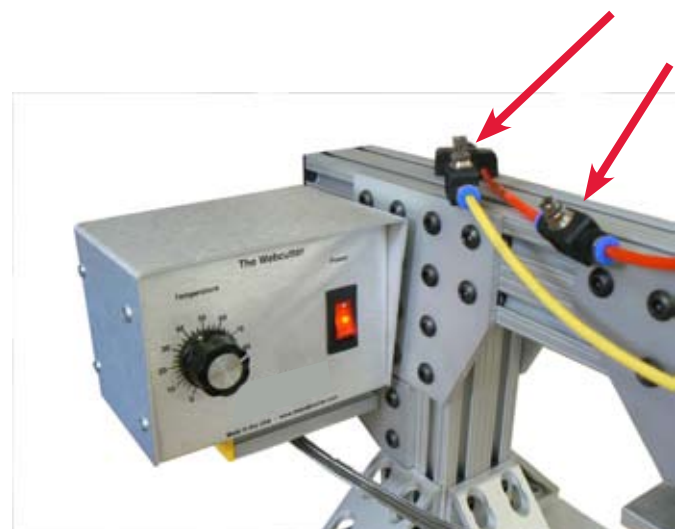
The speed of the tooling is set by the manufacturer. Should the speed need to be adjusted, set the up and down speed of the tooling air cylinder by turning the Speed Control Valves. Turning clockwise will decrease the speed; turning counterclockwise will increase the speed. Tighten the thumbnut under the adjustment screw to prevent the setting from changing.

The valve on the RED line controls the downward speed. The valve on the YELLOW (BLUE, or BLACK) line controls the upward speed. Do not allow the tooling to move very quickly up or down.

-TK Timer models use an electrically operated switch to start the punch timer.



Temperature Control



Speed Control Valves

-RK, DK, WK and all other models use a pneumatic foot pedal connected by air lines. Pressing the pedal moves the punch down, releasing the pedal moves the punch up.

ADJUSTING THE TOOLING HEIGHT

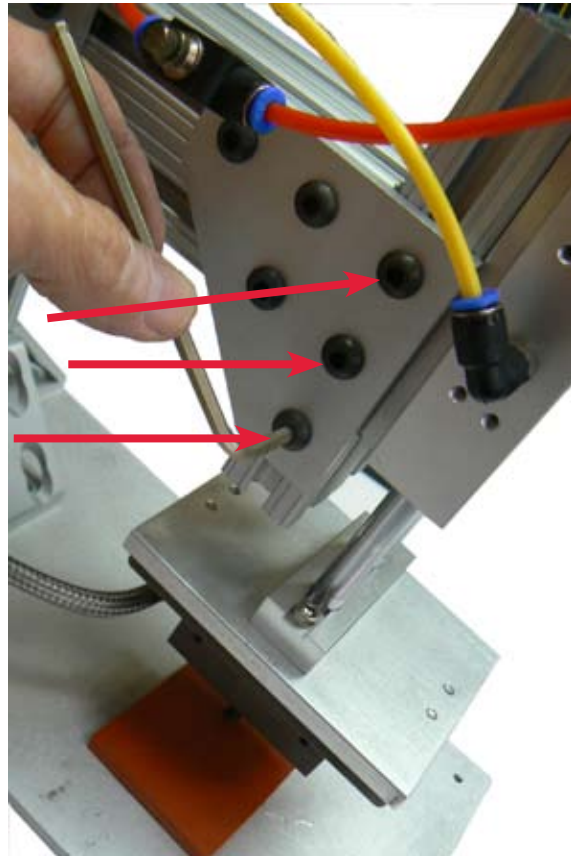
It is important to set the lower stop of the tooling to prevent damage during operation. The tooling height is adjusted by loosening the 6 button head screws (3 on each side of the tooling mount) as shown. Loosen the 6 screws so that the entire air cylinder assembly can be moved up or down.

Place a punch pad under the tooling and lower the air cylinder to its lowest position. Fix the height so that the punch tooling will just slightly into the punch pad about 1/16" - 1/8". Tighten the 6 button head screws.

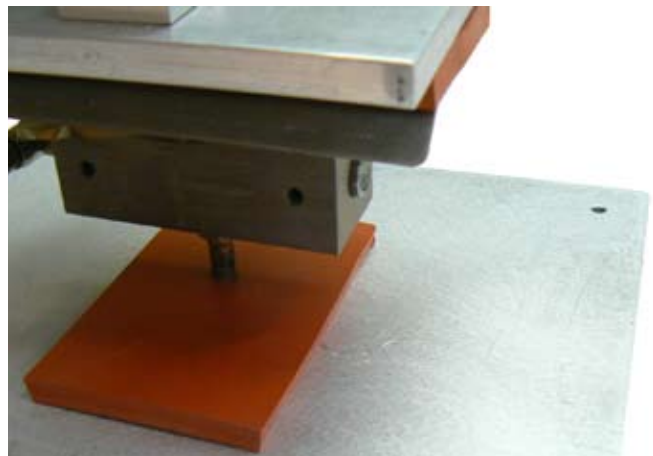
If there is a knife included with the tooling, ensure that the knife edge is aligned with the anvil (not shown) for complete cutting.

Once the tooling height is adjusted and tightened, turn on the power and set the heat controller to normal operating temperature. Place some sample material under the tooling on the punch pad and make some test cuts when the unit has reached operating temperature.

Adjust the temperature, speed and/or tooling height as needed to achieve desired results.



Setting the Tooling Stop



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