



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

USER'S GUIDE



RX-75 & RX-78 Hot Hole Punch & Thermal Press

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NOTE: The information in this User Guide includes the General Instruction, Safe Use and Operation of many models, including (but not limited to) these models:

RX-75 (All)	RX-78 (All)	RX-80-BHL	RX-80-SHL
RX-88-PS1	RX-88-PN1	RX-82-PS1	RX-82-PN1

IMPORTANT: READ THIS ENTIRE MANUAL BEFORE USING THIS DEVICE!

~ SET UP ~

1) Carefully inspect the area around the heater and punch tip for combustible or flammable material. Remove any packing material and / or protective film from the machine.

2) The handle may be shipped unattached to the machine to prevent breakage. Attach the handle to the end of the lever as shown. The handle may be attached to either side of the lever. Install the orange insulating washer between the handle and the end nub.



IMPORTANT SAFETY INFORMATION - READ THIS FIRST!

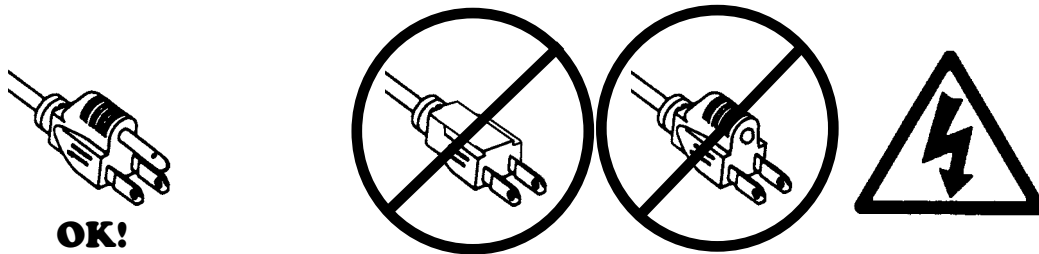
These safety precautions should always be followed when operating this device:

- 1) Read all instructions thoroughly and carefully before operating this device.
- 2) NEVER allow combustible materials to be placed near this device because of the potential for fire.
- 3) NEVER touch hot surfaces on or around the knife. This device may be capable of producing temperatures in excess of 1000° F (540°C).
- 4) NEVER use this device near water; do not immerse this device in water to clean it.
- 5) Cutting any type of material with this device will produce fumes which should be considered hazardous to the user if inhaled. IT IS THE USER'S RESPONSIBILITY TO ENSURE THAT THIS DEVICE IS USED IN A PROPERLY VENTILATED SPACE.
- 6) ALWAYS unplug this device when not in use. Allow all parts to cool before performing any maintenance, replacing parts, or shipping.
- 7) NEVER operate this device with a damaged or modified power cord, or if the unit has malfunctioned or appears damaged in any way. Call the manufacturer or dealer if you encounter any problems with this device.
- 8) NEVER use this device outdoors.
- 9) NEVER allow the power cord to come in contact with a hot surface, knife or heater.
- 10) ALWAYS turn the power switch to "OFF" before unplugging this device.
- 11) NEVER use this device for other than its intended use.

SAVE THESE INSTRUCTIONS !

USER INSTRUCTIONS

- 1) READ FIRST all the important Safety Information on the previous page.
- 2) Remove any packing material or debris from around the heater and punch tooling.
- 3) Plug the device into a properly GROUNDED outlet. Turn on the power. Ensure that the plug on this device is a 3-prong GROUNDED plug. Do not use this machine if any of the prongs on the plug are missing, or if the machine appears to have been modified or damaged in any way.



- 4) Adjust the Material Guide on the base plate by loosening the wing nut. Do not allow the punches or tooling to touch the Material Guide.

NOTE: Both the Material Guide and Handle on this machine may be used on either the left or right side, depending on the preference of the user.

- 5) Set the Heat Control Knob to a setting of about 7 or 8 and allow the device to heat up for about 5 to 10 minutes before using.
- 6) Make a few test holes to ensure that the device is operating at a suitable temperature. Adjust the Heat Control up or down as needed. Note that it takes this device much longer to cool down than to heat up.
- 7) To ensure the longest possible tooling life, **allow this device to punch using heat, not force**. Excessive force on the handle is not needed to punch material with this device.

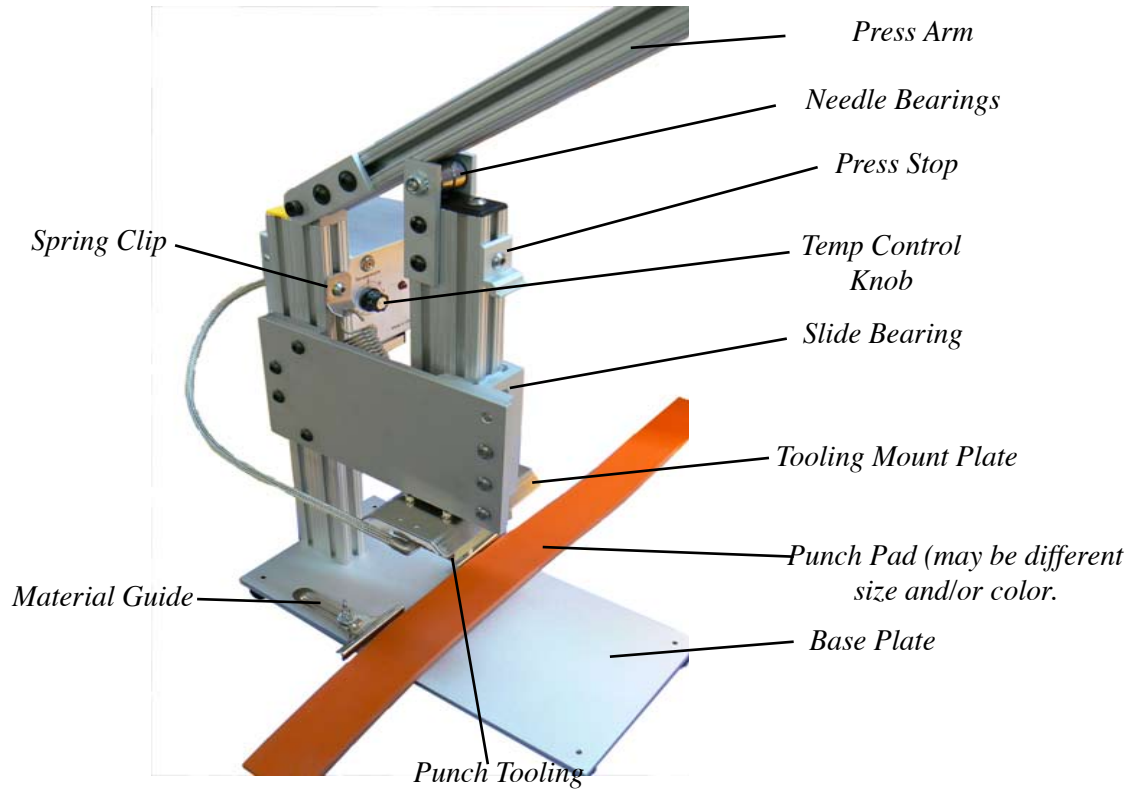
USER INSTRUCTIONS

(continued)

- 8) Do not lubricate this machine. To maintain this device properly, keep it clean and free of paper, webbing, waste, and any debris which can ignite. Keep the Base Plate and the area around clean and free of any material not being cut. A piece of SOFT wood may be used occasionally to remove melted material from the edge of the knife while hot. Use of a razor window-scraper on the Base Plate will remove melted residue that accumulates there.
- 9) Periodically check this device for loose or missing fasteners when cool. Tighten or replace loose or missing fasteners.

If this device fails to heat or appears to malfunction in any way, call the manufacturer or dealer for service immediately. Do not use this device if it appears damaged in any way.

General Component Identification



Troubleshooting

Use this Troubleshooting reference to determine if your device requires factory repair.



NOTE: NEVER perform any electrical repairs on this unit, but refer all electrical problems to the manufacturer for service.

- **PROBLEM:** Lever does not move freely or return to up position.
 - Check that the lever moves freely on the Needle Bearings. Shift the lever from side to side slightly to ensure alignment between the Needle Bearing Side Plates.
 - Check that the spring clip is tightly fastened to the arm. Spring tension is controlled by moving the spring clips up or down.
- **PROBLEM:** No heat; not enough heat.
 - Check the setting of the heat control knob.
 - Check that the heater cartridge is fully inserted in the heater tooling **WHEN THE PUNCH IS COLD**. The heater cartridge should not be loose.
 - Check that the power lamp is lighted when the power switch is ON.
- **PROBLEM:** No heat, power lamp does not light.
 - blown fuse, open heater control, or damaged heater. Call for service instructions.

Adjusting the Punch Depth

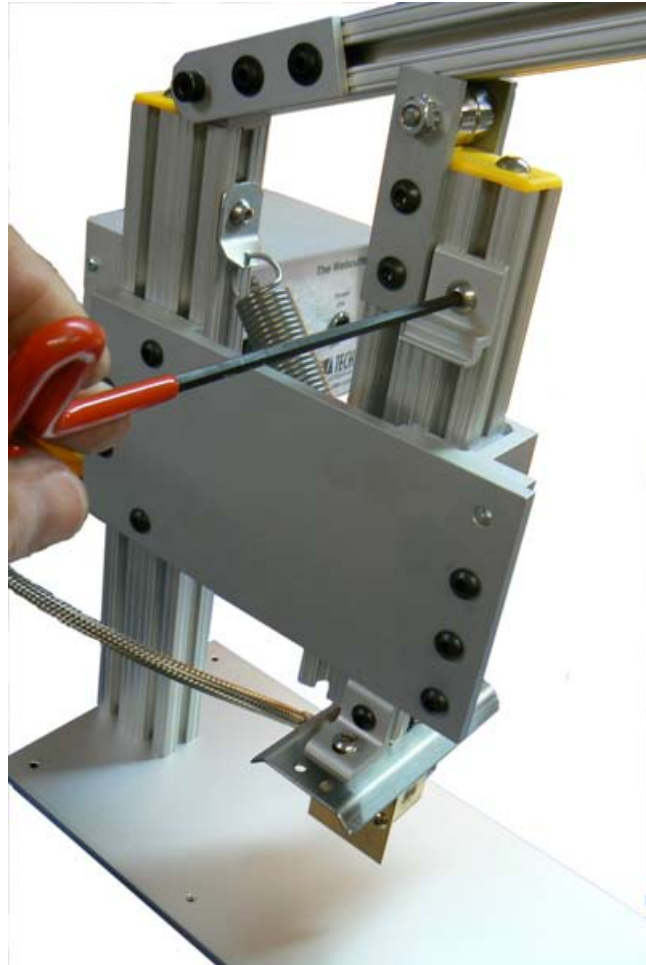
To adjust the Punch Depth:

Loosen the Press Stop.

Lower the punch tooling into a punch pad so that the collet presses into the surface.

Re-tighten the Press Stop while the punch is in the down position.

It is best if punch tooling or punch collets do not come in contact with the base plate.



NEVER adjust the punch tooling or collets when it is hot or when the machine is plugged in!



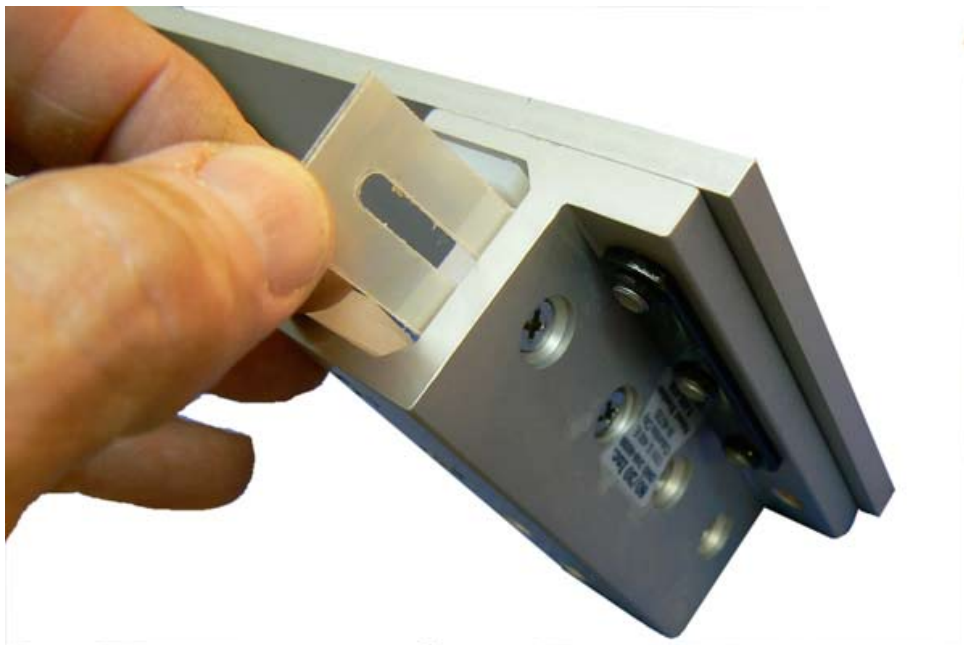
Adjusting Slide Bearing

Adjust the Slide Bearing when there is excessive play from side-to-side or front-to-back while operating the machine.

To eliminate the play, loosen the four philips screws that secure the white bearing pads.

Insert a single bearing shim behind the bearing pad as shown. Insert lower shim from under the bottom bearing pad.

Re-tighten the philips screws lightly. Do not overtighten.



Replacement and Spare Parts

Listed below are some of the parts that may occasionally need to be replaced. A more comprehensive parts list may also be obtained from the manufacturer.

Many replacement part numbers contain a suffix required for a particular model. To ensure you get the correct parts for your particular model, please have the MACHINE SERIAL NUMBER available when you contact the manufacturer. The machine serial number is usually found under the base plate or on the heater control box.

Suffix codes typically define the characteristics of the part for that model, as shown in the parentheses.

Commonly replaced parts:

R75-080-__	Punch collets, round (suffix for size)
R80-010-__	Heater (suffix for 120V or 230V, wattage & length)
R80-007-__	Heater control (suffix for 120V or 230V)
R80-017-__	Handle (suffix for short or long)
R80A-020-__	Heat control box (suffix for 120V or 230V)
R75-060	Bearing pads, white, ea.
R75-061	Bearing pad shims, pkg.
R75-042	Needle bearing, arm
R80-028	Material guide
R75-030	Extension spring

Additional parts such as fasteners, springs, fuses, and custom knives are also available. Please contact the manufacturer for more information.



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