

## **High Pressure Pump Set Up**

For Uniloy IBS Models With A Piston Pump

### There are Two Pressure Settings for the High Pressure Clamp Hydraulic Circuit:

- 1.) 3,000 psi on the variable displacement piston pump, P4, compensator.
- 2.) 3,400 psi on SV-27 which is a small manifold assembly comprised of an open/close, two position valve and a cartridge relief valve.

Note, in order to set the relief valve on SV-27, the compensator on the pump will have to be temporarily set to 3,400 psi. If just the pump is being replaced, there is no need to set the relief valve for SV-27. Simply follow the "Setting the Compensator on Piston Pump P4" procedure below.

### Setting the SV-27 High Pressure Clamp Relief Valve

- 1.) Verify that there are pressing blocks or a mold in the machine before continuing this setup.
- 2.) Back out the pump pressure compensator located at the end of the P4 pump.
- 3.) Prepare the machine to run a wet cycle:
  - \* Auto cycle
  - \* Extruder sled enabled (with the din plug for extruder sled "IN" disconnected)
  - \* shot size set to zero
  - \* heats on and up to temperature
  - \* inject delay timer set to 15 seconds (to allow ample time to set pressures).
- 4.) Turn the relief valve for (V40), SV-27 clamp high pressure, in all the way.
- 5.) Start the machine in full wet cycle.
- 6.) After the clamps close, start turning the pump pressure compensator in and note the pressure increasing on the P4 pressure gauge (G4.1). Continue until 3,400 psi is achieved.
- 7.) Turn the relief valve for (V40), SV-27 clamp high pressure, out (counterclockwise) until the 3,400 psi just starts to drop, then tighten the locknut.
- 8.) Set the pump pressure compensator (P4) pressure control back to 3,000 psi and tighten the locknut. Stop the machine.

### Setting the Compensator on Piston Pump P4

- 1.) Verify that there are pressing blocks or a mold in the machine before continuing this setup.
- 2.) Back out the pump pressure compensator located at the end of the P4 pump.
- 3.) Prepare the machine to run a wet cycle:
  - \* Auto cycle
  - \* Extruder sled enabled (with the din plug for extruder sled "IN" disconnected)
  - \* shot size set to zero
  - \* heats on and up to temperature
  - \* inject delay timer set to 15 seconds (to allow ample time to set pressures).
- 4.) Start the machine in full wet cycle.
- 5.) After the clamps close, start turning the pump pressure compensator in and note the pressure increasing on the P4 pressure gauge (G4.1). Set and lock at 3,000 psi. Stop the machine.