

**1.4.5
BLEEDING THE
HYDRAULIC SYSTEM**

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Pump housing

Before the machine is switched on as well as after every oil change, the housing of the pump must be filled with hydraulic oil.

In order to do this and prior to filling the tank, the upper leakage oil connection of the pump (s) must be removed, and hydraulic oil must be filled into the housing until the oil overflows. Thereafter, fix again the oil leakage connection.

Procedures:

Clamping unit

Closing cylinder

opening ring area

- Open V24
- Adjust about 100 bar setting pressure in line 50.02
- Put the operation mode selector switch into position **Setting**
- Activate key **Open mould** for about 30 seconds
- Close V24
- Move machine up to the mechanical stop

Suction valve ER5:

- Put the operation mode selector switch into position **Setting**
- Open bleeder screw V16 for about 5 sec. until bubble-free oil flows out
- Close bleeder screw V16
- Repeat procedure after 10 cycles

*Both driving
cylinders*

- Adjust about 100 bar setting pressure in line 50.02
- Open bleeder valve
- Activate key **Close mould** until bubble-free oil flows out

Pressure transducer

Additional equipment, K 175 - K 450, S version

- Put operation mode selector switch into position **Setting**
- Adjust at least 100 bar setting pressure in line 50.02
- Close mould (key **Close mould**)
- If mould is closed, do not release key **Close mould** and simultaneously activate manually valve Y9017.1 until the piston of the pressure transducer is in forward position. To do this a second person is necessary.
- Put operation mode selector switch into position **Manual**
- Open mould and close mould with max. clamping pressure for several times until the piston of the pressure transducer has reached again its rear rest position after the release of clamping pressure.