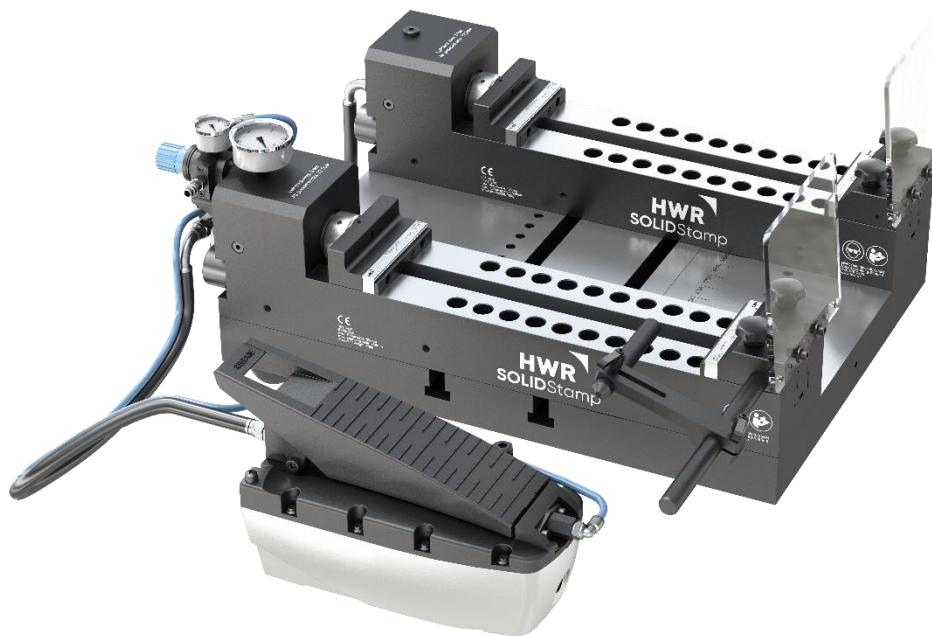


HWR

Assembly instructions

SOLIDStamp - Extension Kit

Double-stamping unit 680351 and 680356



English version (US market) of the original German manual.
Keep this manual for future use!

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Violations may result in criminal prosecution

FOREWORD

ABOUT THIS DOCUMENT

These assembly instructions for the 680351 and 680356 double stamping unit do not constitute an independent operating manual.

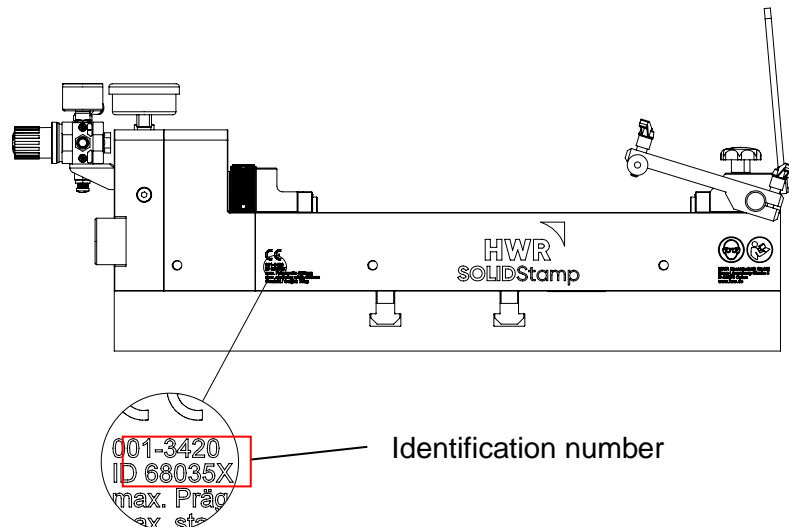
It is only an extension of the operating instructions for the 680351 and 680356 SOLIDStamp, which were provided to you together with the 680350 or 680355 stamping unit.

Therefore, all notes and instructions in the operating instructions for the 680350 or 680355 stamping unit also apply to the 680351 and 680356 double stamping unit.

IDENTIFICATION NUMBER OF YOUR SOLIDSTAMP STAMP STATION

Please contact HWR Spanntechnik GmbH if you have any questions: Have the identification number ready.

Date on the SOLIDStamp stamp station:



NOTICE

We are not liable for errors or mistakes in the documentation.
Please inform HWR Spanntechnik GmbH of any errors in the documentation.

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1 SAFETY

1.1 WARRANTY AND LIABILITY

Our "General Terms for Sales and Delivery" apply. Warranty and liability claims for personal injury and damage to property are excluded for the following:

- Incorrect use of the SOLIDStamp Double-stamping unit
- Incorrect installation, commissioning, operation and maintenance of the SOLIDStamp Double-stamping unit
- Failure to observe the instructions on:
 - Storage
 - Installation
 - Operation (e.g. correct stamping of the workpiece)
 - Maintenance and care
 - Troubleshooting and error elimination for the SOLIDStamp Double-stamping unit
- Changes to the stamping station
- Faulty monitoring of wear parts
- Repairs carried out incorrectly
- Disasters caused by foreign bodies and force majeure

NOTICE

You may not make any **changes, additions or modifications to the SOLIDStamp stamp station** without the manufacturer's approval. All conversion measures require the written approval of the manufacturer.

NOTICE

The manufacturer **only and exclusively assumes liability** for spare parts that it has supplied.

DANGER



Danger of injury when using non-original spare parts!

Using spare parts from a third-party manufacturer can result in risks. These parts are not guaranteed to be designed and manufactured in accordance with stress and safety requirements.

Only use original spare and wear parts supplied by the manufacturer. Using non-original parts is prohibited.

1.2 NOTES ON HANDLING THE DOCUMENTATION

These assembly instructions for the 680351 and 680356 double stamping unit do not constitute an independent operating manual. It is only an extension of the operating instructions for the 680351 and 680356 SOLIDStamp, which were provided to you together with the 680350 or 680355 stamping unit.



Reference

Therefore, all notes and instructions in the operating instructions for the 680350 or 680355 stamping unit also apply to the 680351 and 680356 double stamping unit.

WARNING



Danger of injury in case of non-observance of the documents!

Failure to follow the above listed documents could result in death or serious injury.



Read and understand the above listed documents before using the double stamping unit. Training provided by the manufacturer alone is not sufficient.

Always keep these assembly instructions and other documents on the SOLIDStamp double stamping unit readily available in the immediate vicinity of the double stamping unit.

1.3 EXCLUSIVE USE

The SOLIDStamp double stamping unit 680351 and 680356 is to be used exclusively with the SOLIDStamp 680350 and 680355 and is intended for stamping parallel components for subsequent positive clamping.

2 TECHNICAL DESCRIPTION

2.1 DESIGN

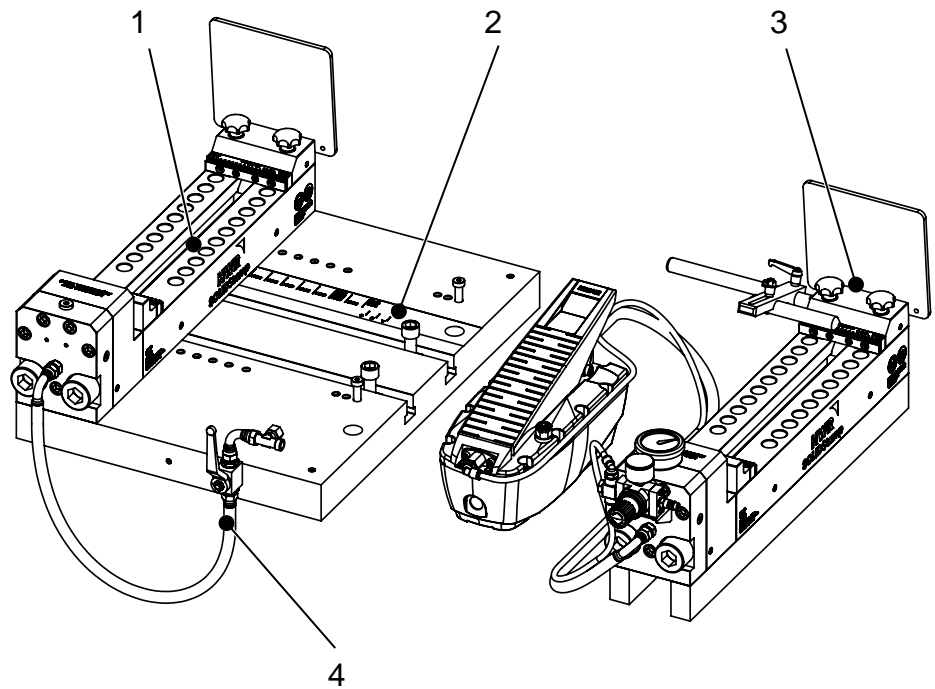


Fig. 2-1: Setup of SOLIDStamp double stamping unit

- | | |
|-----------------------------------|---|
| 1. Stamping unit
Extension set | 3. Basic stamping unit
680350 or 680355 |
| 2. Grooved plate | 4. Shut-off valve for
single or double operation |

3 TRANSPORT AND INSTALLATION

3.1 TRANSPORT

3.1.1 SAFETY



WARNING

Danger of injury due to incorrect transport!

During transport, there may be hazards due to tilting, swiveling or falling of the components. This can lead to personal injuries or material damage.

Therefore, when lifting the stamping unit:

- ▶ Only qualified personnel may carry out the transport work.
- ▶ Use suitable and sufficiently dimensioned lifting equipment for the stamping unit.
- ▶ Use the provided lifting eye bolts (DIN 580). Each lifting eye bolt is marked with the permissible load.
- ▶ Mind the center of gravity.
- ▶ Do not stand under the load while lifting or lowering it and stay out of the danger zone.

NOTICE

Possible damage to the stamping unit!

- ▶ Do not open packaging during transport.
- ▶ Carefully transport the double stamping unit



WARNING

Danger of injury due to malfunctions!

Any damage caused during transport can lead to malfunctions of the stamping unit.

- ▶ Repair transport damage completely and properly before commissioning.

3.1.2 TRANSPORTING THE DOUBLE-STAMP UNIT

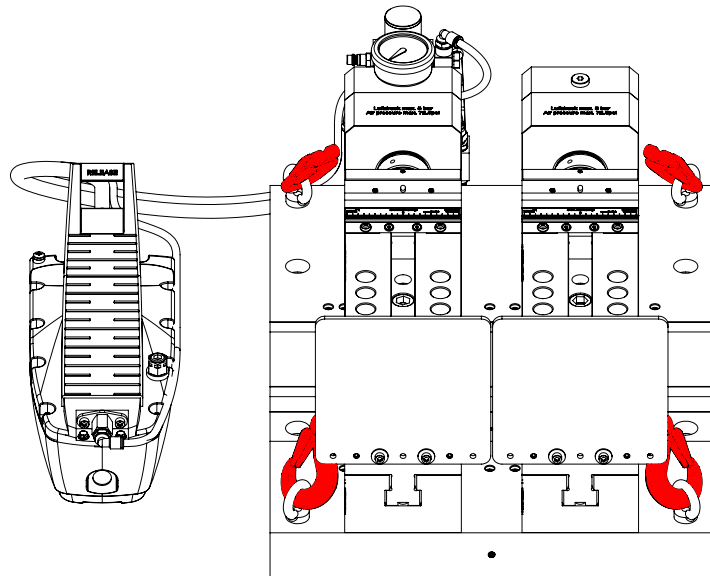


Fig. 3-1: Transport with eyebolts

Proceed as follows:

- Step 1 If necessary, loosen the fastening screws in the middle of the stamping unit.
- Step 2 Slide the stamping units together on the grooved plate and tighten the fastening screws in the middle of the stamping unit to prevent slipping.
- Step 3 Screw the four eyebolts into the grooved plate of the double stamping unit (see figure 3-1).
- Step 4 Hang the hoist (see figure 3-1).
- Step 5 Transport the double stamping unit.

3.1.3 CHECKING AFTER TRANSPORT / RECEIPT OF STAMPING UNIT

Check the condition of the SOLIDStamp double stamping unit immediately after receipt (transport damage).

NOTICE

Report any transport damage that may have occurred to the importer or to HWR Spanntechnik GmbH.

3.2 INSTALLATION

3.2.1 SAFETY

DANGER



Danger of injury due to lack of qualification!

The SOLIDStamp double stamping unit may only be installed by trained and instructed personnel who have also undergone training and received instructions on how to operate the compressed air and the air hydraulic pump.

WARNING



Danger of injury due to malfunctions!

Any damage caused during installation can lead to malfunctions of the stamping unit.

- ▶ Repair transport damage completely and properly before commissioning.

3.2.2 ASSEMBLING THE DOUBLE STAMPING UNIT

Proceed as follows:

- Step 1 Clean the grooved plate. There must be no dirt or chips on the corresponding surfaces. Also make sure that all holes are deburred and clean.
- Step 2 Remove the stabilizer struts (3) from the stamping unit by removing the screws (4) and store both.
- Step 3 Disconnect the pneumatic hose (1) and the hydraulic hose (2) from the stamping unit.

WARNING

Make sure that the compressed air supply line has been disconnected first.

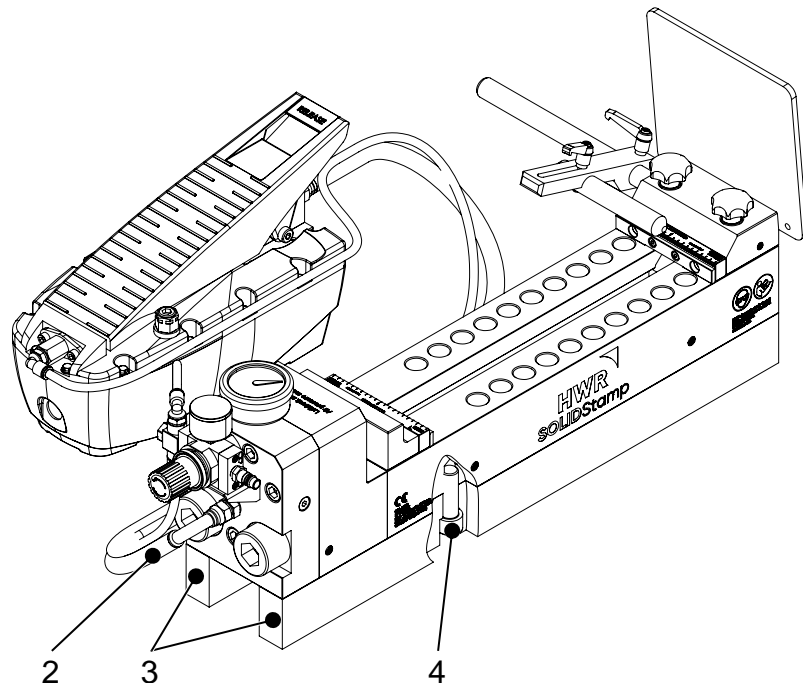


Fig. 3-2: Preparation of the stamping unit

NOTICE

Look out for leaked hydraulic oil and, if necessary, bind it with suitable oil binding agent.

- Step 4 Connect the pre-assembled hydraulic hoses as shown in figure 3-3.

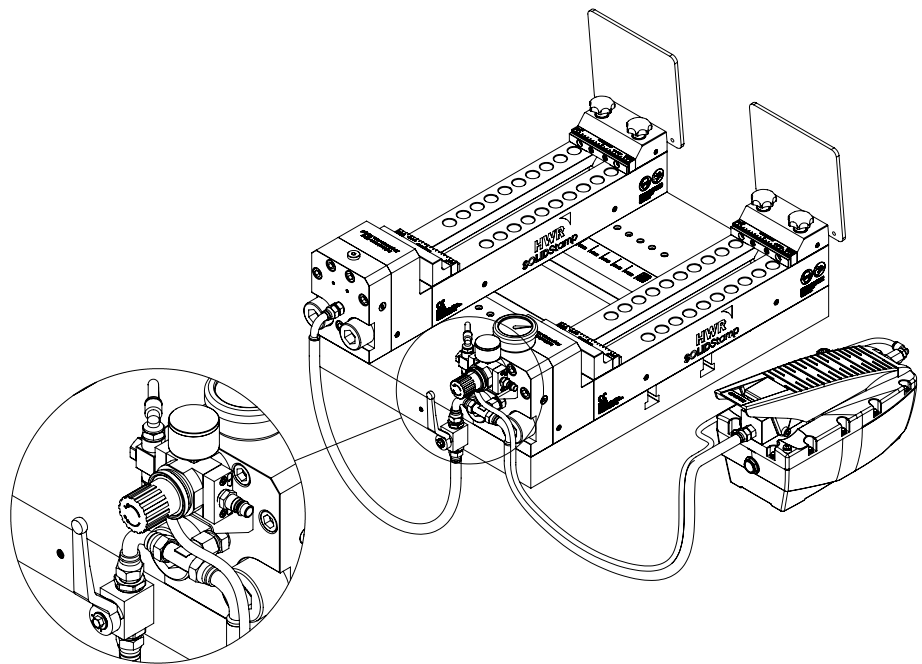



Fig. 3-3: Installation hydraulic hoses

- Step 5 Connect the pneumatic hose to the pressure control valve. Use the enclosed hose for this purpose.
- Step 6 Check the air hydraulic pump oil level and refill if necessary (use HLP 22, 36, or 42).
-  For a description of this procedure, refer to the air hydraulic pump instructions.
- Step 7 Check the hydraulic and pneumatic hoses and their connections for leaks. If necessary, retighten the screw connections.
- Step 8 Connect the pressure control valve to the pressure system.

3.2.3 DISASSEMBLING THE DOUBLE STAMPING UNIT

Disassembly is carried out in reverse order, see chapter 3.2.2.

3.3 VENTING THE SOLIDSTAMP DOUBLE STAMPING UNIT

NOTICE

Improper venting of the stamping unit will result in a loss of embossing force.

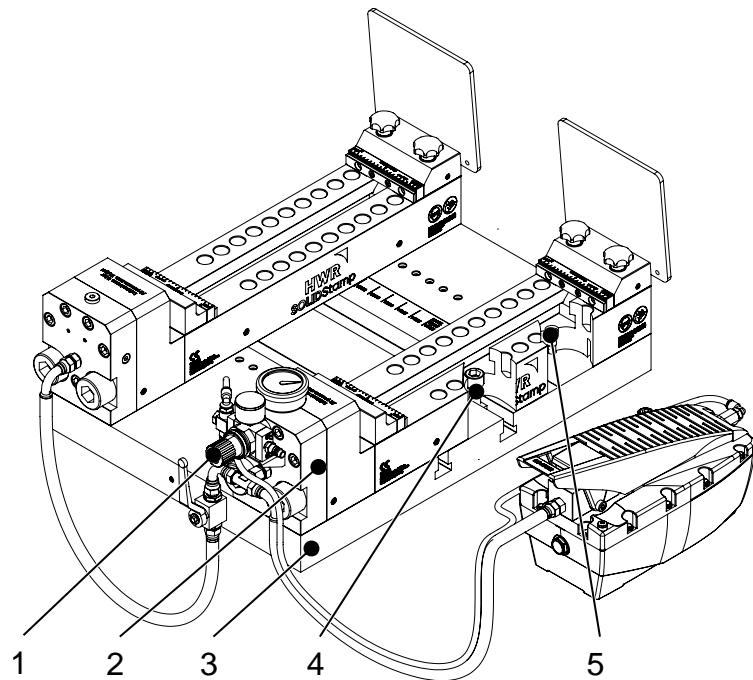


Fig. 3-4: Venting the SOLIDStamp print station

Proceed as follows:

- Step 1 Loosen and remove the fixing screws (4) and the positioning screws (5) from both stamping units.
- Step 2 Place the two stamping units on their sides, on a suitable surface.
Make sure that the vent screw (2) points upwards and that the stamping unit does not rest on the pneumatic components.
- Step 3 Set a pneumatic pressure of 2.8 bar at the pressure control valve (1) of the SOLIDStamp double stamping unit.
- Step 4 Loosen the vent screws (2) of both stamping units.
- Step 5 Operate the air hydraulic pump and bleed the air from the stamping units.
Close the bleed screws (2) as soon as no more air bubbles are visible.
- Step 6 Screw the vent screws (2) firmly back into the stamping units.
- Step 7 Align the stamping units so that the stamping units are on the groove plate (3).

3 Transport and installation



-
- Step 8 Lightly set and tighten the mounting screws of both stamping units.
 - Step 9 Check the hydraulic pressure of the stamping unit and repeat steps 1 to 8 if necessary.

4 OPERATION

4.1 SAFETY

WARNING



Danger of injury due to incorrect operation!

Incorrect operation can result in serious personal injury or material damage. Therefore, when operating the stamping unit:

- ▶ Only suitably trained personnel may operate the stamping unit.
- ▶ Only operate the stamping unit after proper installation.
- ▶ Always wear protective goggles and make sure that the protective screen is always properly fastened at the prescribed position on the stamping unit.



4.2 SETTING THE STAMPING DISTANCE

The following distances can be set:

- Row A 200, 225, 250, 275, 300, 325 and 350 mm
- Row B 156 (3x 52 grid), 208 (4x 52 grid)
- Row C 104 (2x 52 grid), 192 (2x 96 grid)

The rows are marked on the groove plate.

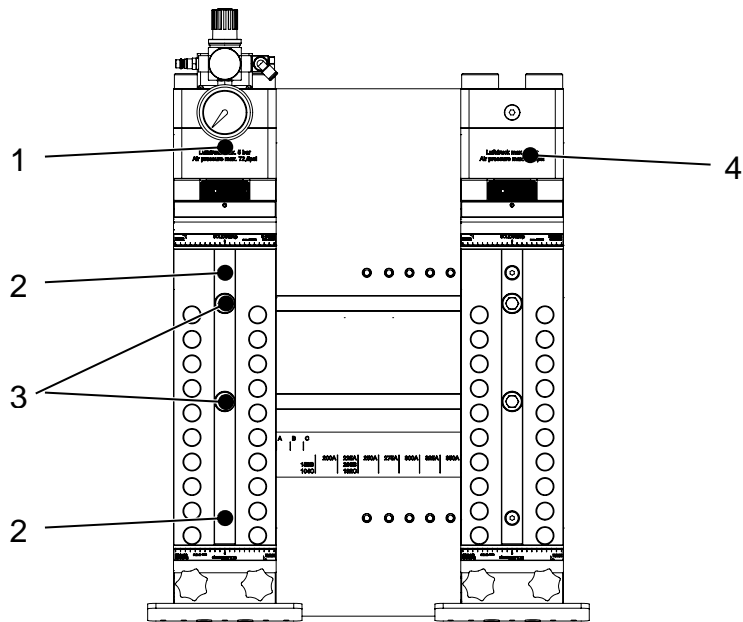


Fig. 4-1: Setting the stamping distance

Proceed as follows:

- Step 1 Loosen the screws (3) in the middle of the stamping unit (1).
- Step 2 Loosen and remove the positioning screws (2) in the middle of the stamping unit (1).
- Step 3 Slide the stamping unit (1) to the desired row (A, B or C).
- Step 4 Insert the positioning screws (2) into the stamping unit (1) and tighten them securely.
- Step 5 Tighten the screws (3) in the stamping unit (1) with 150 Nm.
- Step 6 Loosen the fixing screws (3) in the middle of the stamping unit (4).
- Step 7 Loosen and remove the positioning screws (2) in the middle of the stamping unit (4).
- Step 8 Slide the stamping unit (4) to the desired stamping distance.
- Step 9 Insert the positioning screws (2) into the stamping unit (4) and tighten them securely.
- Step 10 Tighten the screws (3) in the stamping unit (4) with 150 Nm.

4.3 OPERATING THE SINGLE AND DOUBLE STAMPING

The double stamping unit can be operated as a double stamping unit or as a single stamping unit. The changeover is possible via the shut-off valve. The shut-off valve blocks the second stamping unit, which is then inoperative.

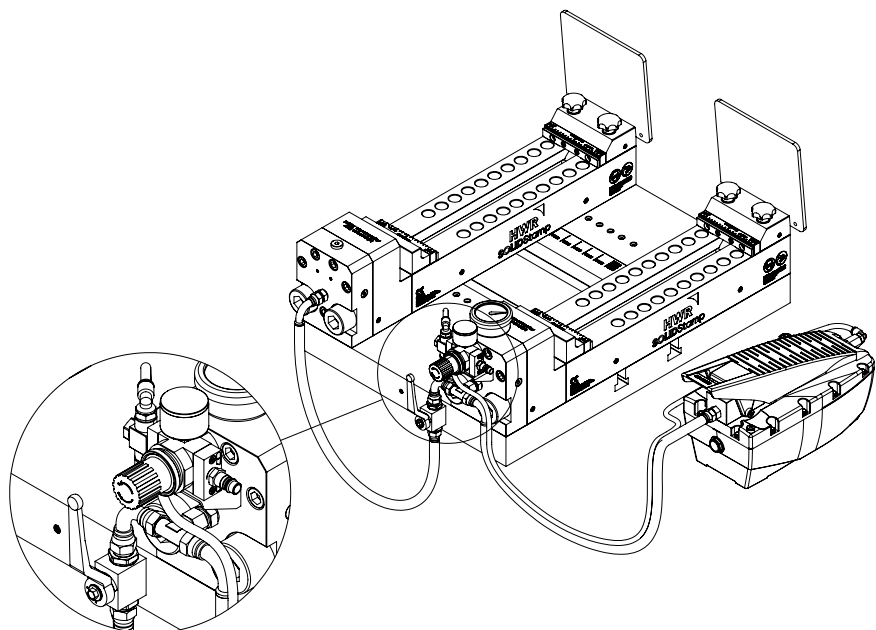


Fig. 4-2: Changeover between single and double stamping

5 FAULTS

5.1 POSSIBLE CAUSES OF ERRORS AND THEIR SOLUTIONS

Error	Cause	Remedy
Second Stamping unit.	No stamping function	Check shut-off valve, clean it if necessary replace
	Can not be switched off	Check shut-off valve, clean it if necessary replace

Table 5- 1: Error causes/ solutions



Reference

Further faults can be found in the SOLIDStamp stamping unit operating instructions 680240, 280245, 680350 and 680355.

6 SPARE PARTS

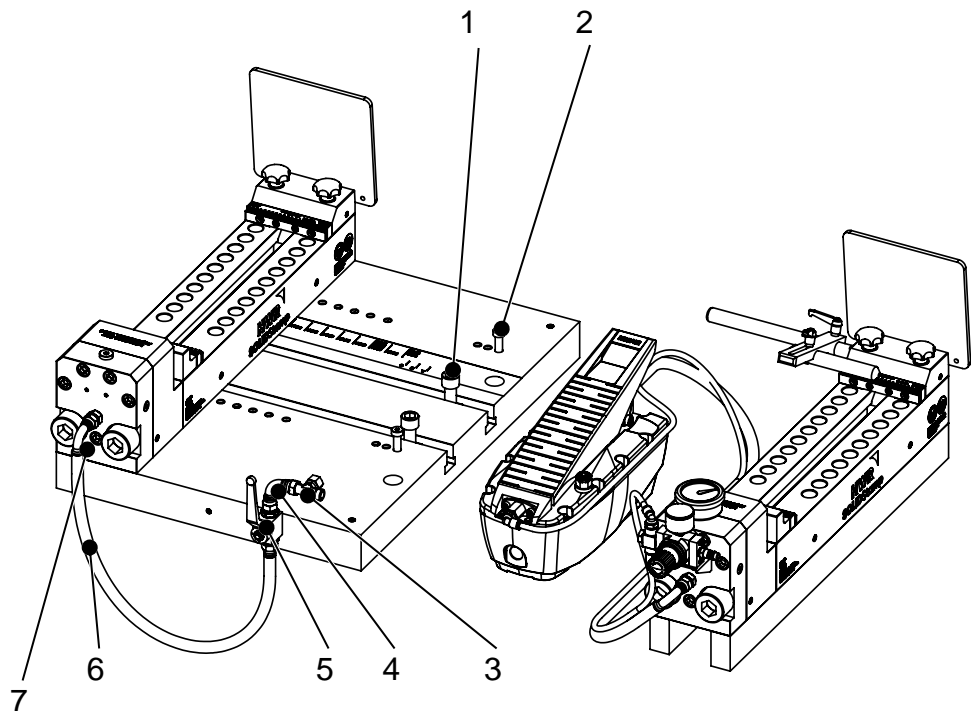


Fig. 6-1: Spare parts double stamping unit

- | | |
|------------------------------------|---------------------|
| 1. Screw incl. slot nut (4 pieces) | 5. Shut-off valve |
| 2. Fitting screw (4 pieces) | 6. Hydraulic hose |
| 3. Screw connection T-shape | 7. Screw-in fitting |
| 4. Connecting piece | |