R0015336 Pneumatic Output Testing Part 2

Details for manual pneumatic output testing on module

Difficulty **Medium** | Duration **1 minute(s)**

Contents

Introduction

Tools Required

PCL airline connection
12mm blanking ports
Valve Manual over ride tool
Standard screwdriver set
Additional colleague when setting regulator pressures for outputs

Parts required

R0015040 completed module

Step 1 - Safety

Output testing will require valve operation with no e/s circuit

Ensure the following

Work area is clear from all components not required for testing

All colleagues are aware of the procedure being undertaken

No additional colleagues are working on the module

PCL coupling is accessible to release pressure in case of emergency

Testing procedure is fully adhered to

Step 2 - Y206 Centralise

Fire and hold valve

Set regulator to 0.2 M.P.A

Saw head should move towards rear of machine

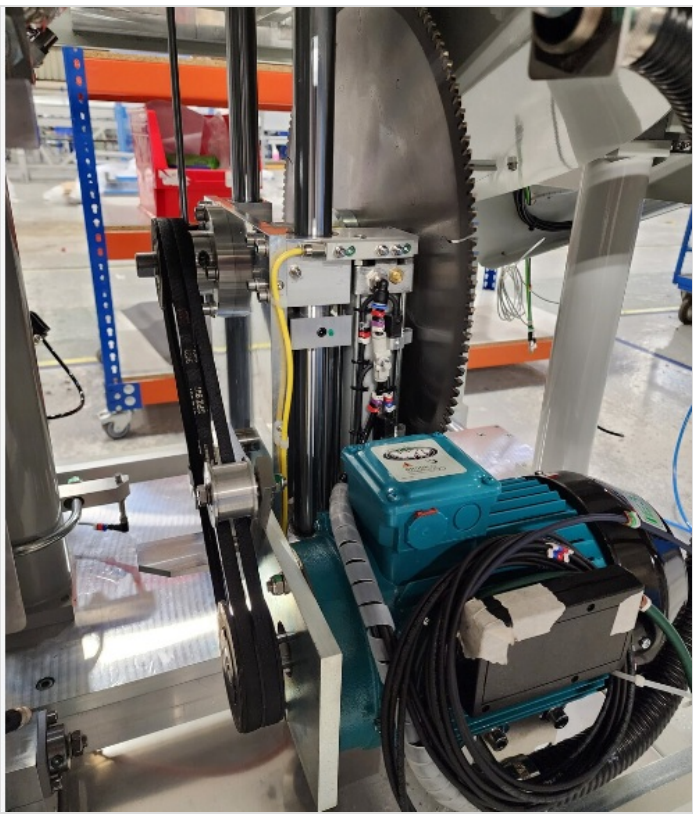
Should retract when valve released

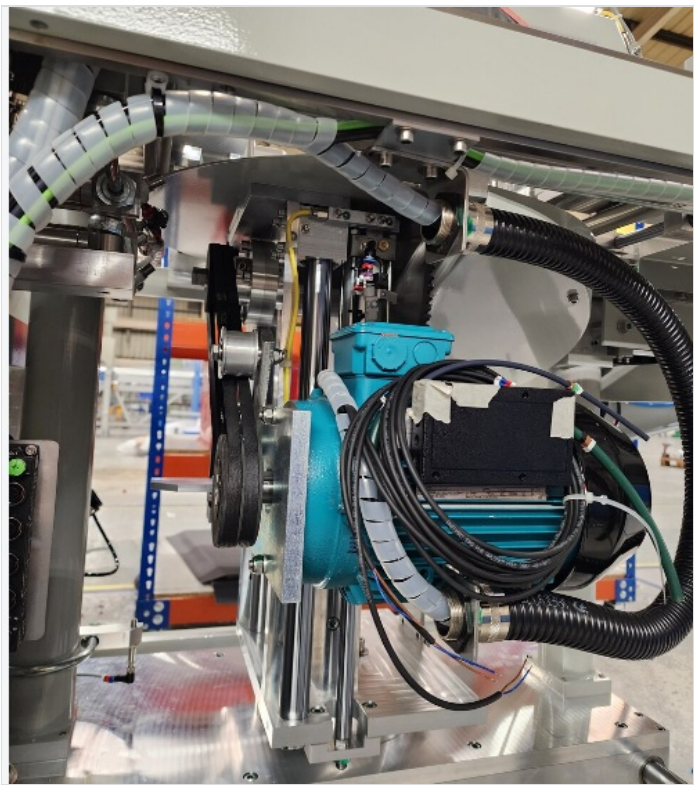
Step 3 - Y207 saw cut

Fire and hold valve

Saw head should raise up

Should retract when valve released
Adjust damper thumb wheel to allow good speed when saw cut stroke upwards





Step 4 - Y210 Z support infeed

Fire and hold valve

Infeed side z block should fire towards back fence

Should retract when valve released

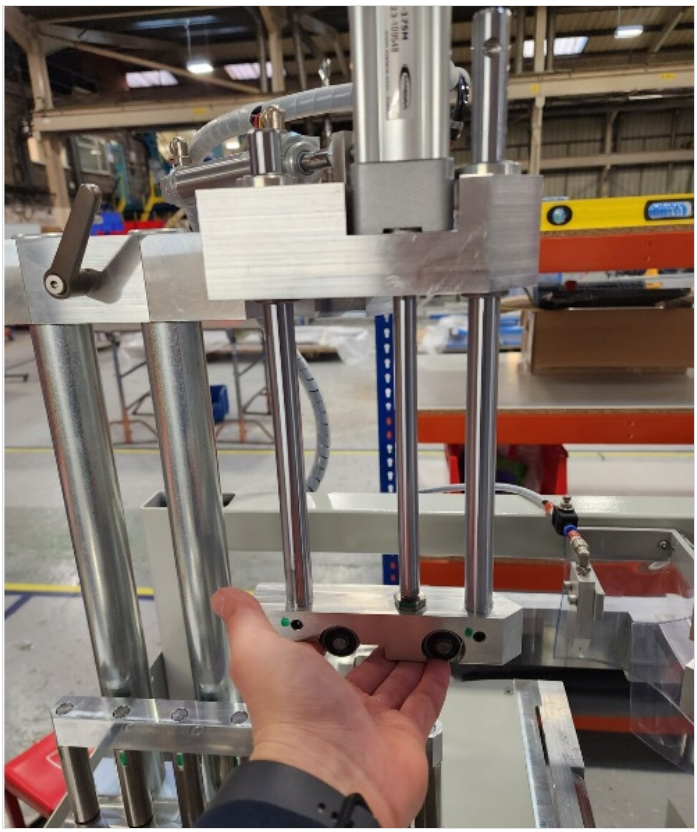
Step 5 - Y212 Hi low pressure

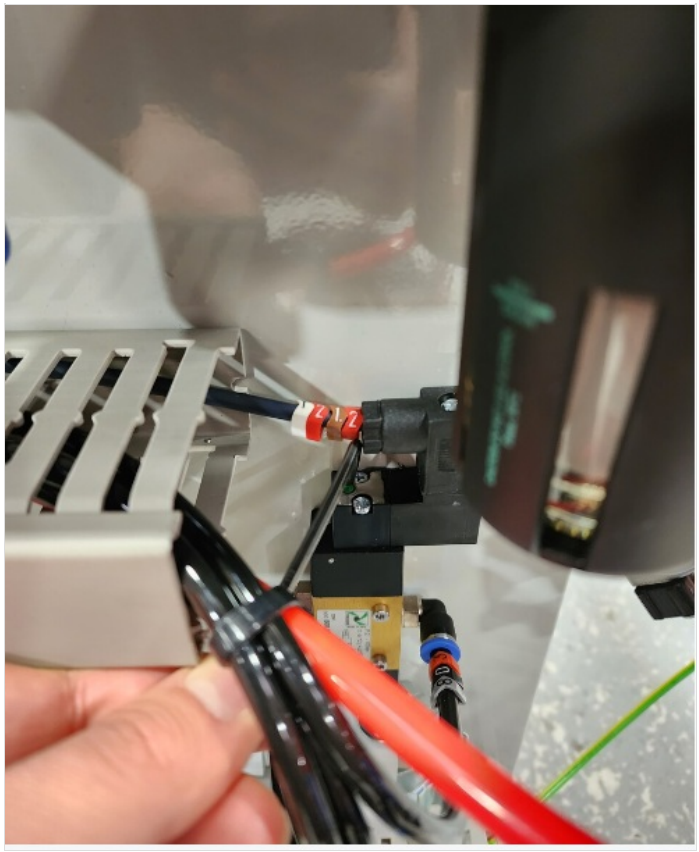
assistance required from colleague

Fire and hold Y80 output , infeed top clamp should move down. Keep Y80 held down

Top clamp block pressure should be weak enough to override by hand and move clamp back towards cylinder

Additionally fire Y212, this should switch clamp to high pressure and stop clamp being able to be over ridden by hand





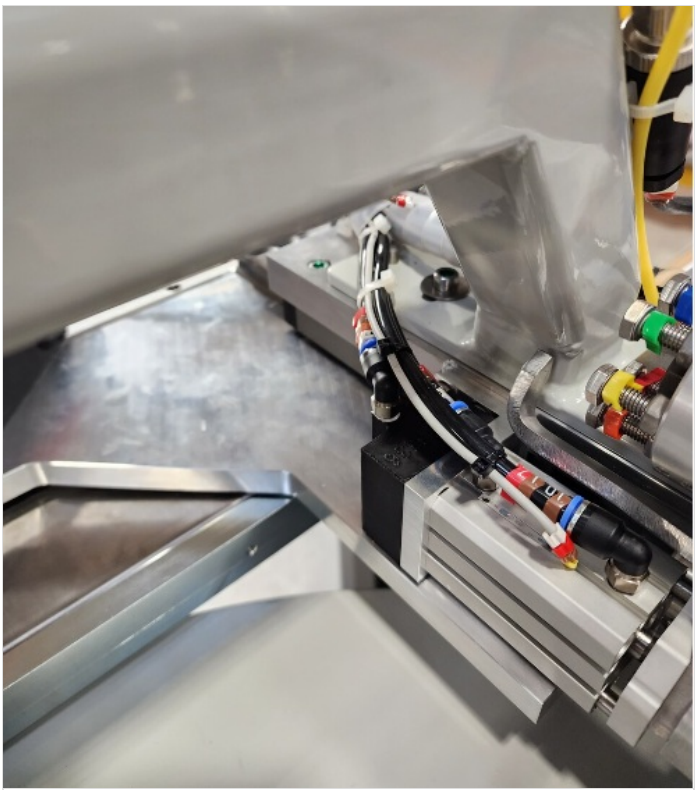
Step 6 - Y213 Saw blowers

Fire and hold valve

Blowers should switch on

Check operation of inline flow controllers .

When fully closed air flow should stop completely. If air flow can not be completely stopped by flow controller, it is fitted the wrong way around. Change and recheck if this occurs



Step 7 - Y214 Z turret infeed

Fire and hold valve

Infeed turret should rotate once

Release and fire valve again and turret should again rotate one position

Step 8 - Y215 Z turret outfeed

Fire and hold valve
Outfeed turret should rotate once
Release and fire valve again and turret should again rotate one position

Step 9 - Y224 Z support outfeed

Fire and hold valve
Outfeed side z block should fire towards back fence
Should retract when valve released

Step 10 - output testing complete

Disconnect pcl air supply

Remove temporary blanks fitted