Wabash Press Start-Up

1. Turn on the Main Power button on right side of machine (Figure 1)
2. Turn on the WATER VALVE (Valve 1) and AIR VALVE (Valve 2) on the right side of machine (Figure 2)
3. Check OIL LEVEL and COLOR from the left side of the machine (Figure 3)
4. Ensure the "Manual" position is selected for "MAN/SEMIAUTO" knob (Figure 4)
5. The use of Low Pressure or High Pressure is optional
    a. The Low Pressure knob should be pulled "ON" and the High Pressure knob should be pushed "OFF." No light will come on until the SLOW DOWN is initiated.
    b. No explicit instructions on High Pressure (assumption is that both Low Pressure and High Pressure needs to be pulled
    c. Programming allows for unit to bounce between low and high pressure settings for a set amount of time
    d. Low and High Pressure is set with the knobs at bottom of control panel when the clamp is closed (Figure 5)
6. Press green buttons labelled "Control On", "Pump On", and "Heat On" and allow everything to boot up (Figure 6)

Wabash Press Operation

1. Use the up and down arrows to move the set temperature to desired value and it will automatically accept the setting after a couple seconds. (Figure 7)
    a. It may take 10-30 minutes to get up to temperature. This is dependent on the temperature selected.
2. Once the platen temperatures are at desired temperature, the tool can be placed into the open platens. **Caution: Tool is heavy and platens are hot. Wear 100% cotton or high temperature gloves.** Position tool in center of press.
3. Close the door.
4. Press both "Clamp Close" buttons to raise the bottom platen (Figure 8). The "slow down" sensor should be engaged roughly ¼" – ½" prior to the top of the tool contacting the top platen.
    a. Adjust slow down sensor by twisting the knob left to loosen, move up or down as needed, and then tighten by twisting to the right.
    b. You can raise and lower the clamp as needed to ensure the setting is correct.
    c. There will be an audible change in sound of the pump when the slow down is initiated. At this point the clamp close buttons can be released.
        i. If it is too high, the pump will continue to run loud even after contact with tool.
        ii. If it is too low, it will take a very long time to fully close the tool.
5. After the clamp is closed, the Pressure gage will increase (Figure 9) and the Temperature controllers (Figure 10) will indicate a drop from set temp. Adjust the pressure down to 1 ton and

wait until the platens get back up to temperature. At this point the tool and material in tool should be at the platen temperature.

6. Use your guide to increase the hold pressure to the desired tonnage based on material and tool size and start a timer for hold time.
7. When the time expires, pull on the “Water” and “Air” Toggles (Figure 11). The heaters will turn off and the water will not engage until the platens are below 210 °C.
8. Once platen is below desired temperature, reduce the applied pressure back down to 1 ton.
9. When cooled to ambient, open tool all the way, open door, and remove tool.
10. Turn off “Water” and “Air” toggles to re-engage heaters. Air will run for a bit to remove water from lines.

Wabash Press Shut Down

1. When the machine is cooled and the air has dried the lines, the red buttons for “Control Off”, “Pump Off”, and “Heat Off” can be used to turn off the machine.
2. Turn off the Water Valve and Air Valve.
3. Turn off the Power Switch.