

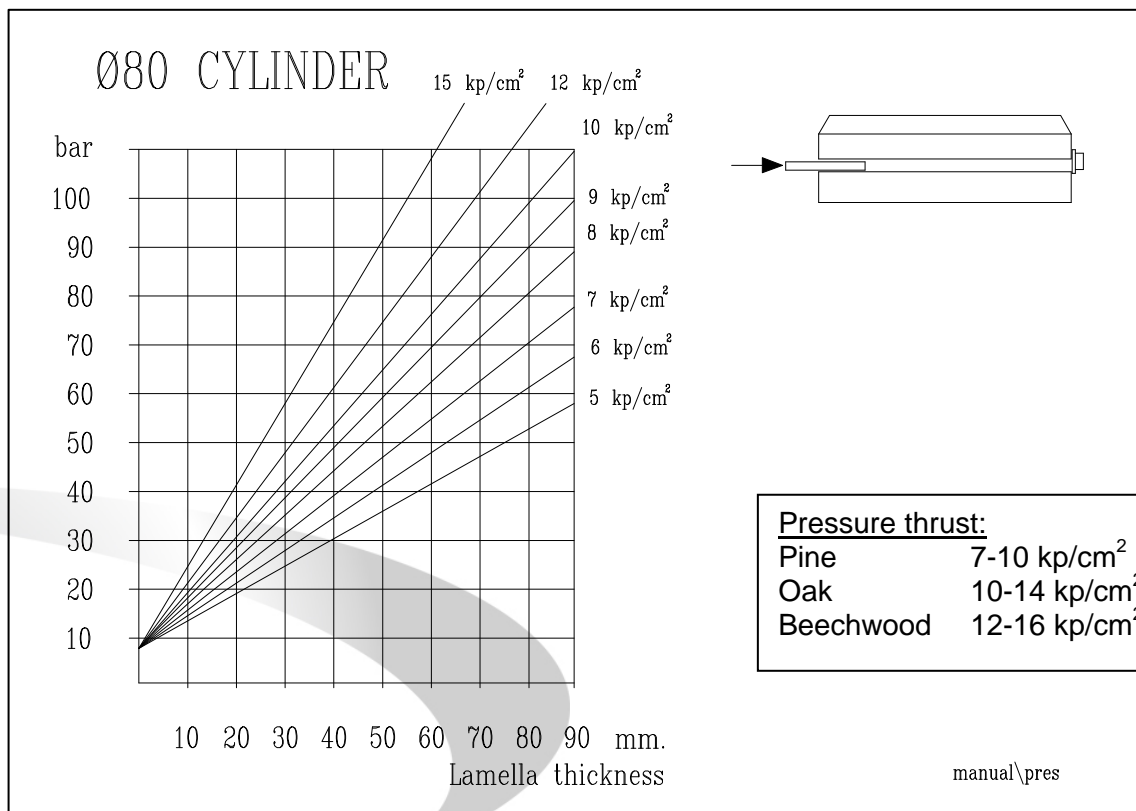
Adjusting thrust pressure of LV-press.

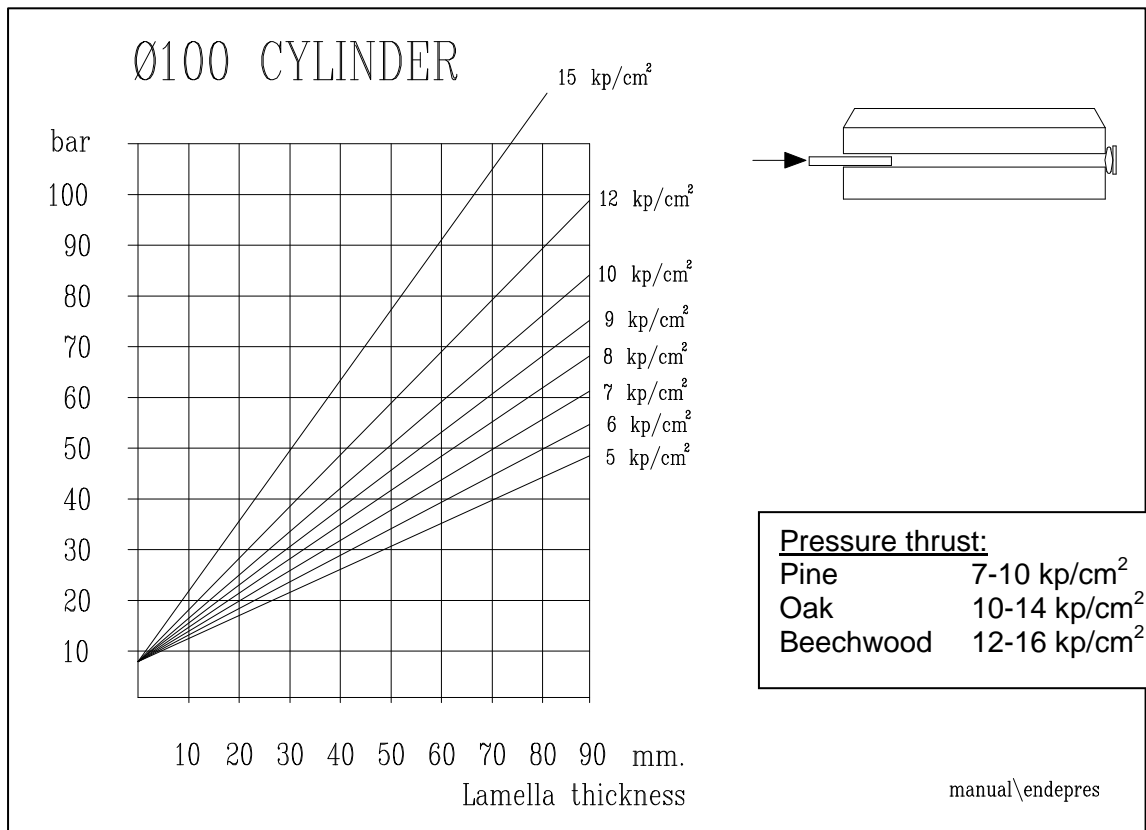
The adjustment of the pressure thrust is done on the two pressure regulators which are placed at the front end of the press.



Adjustment screw

SIDE PRESSURE

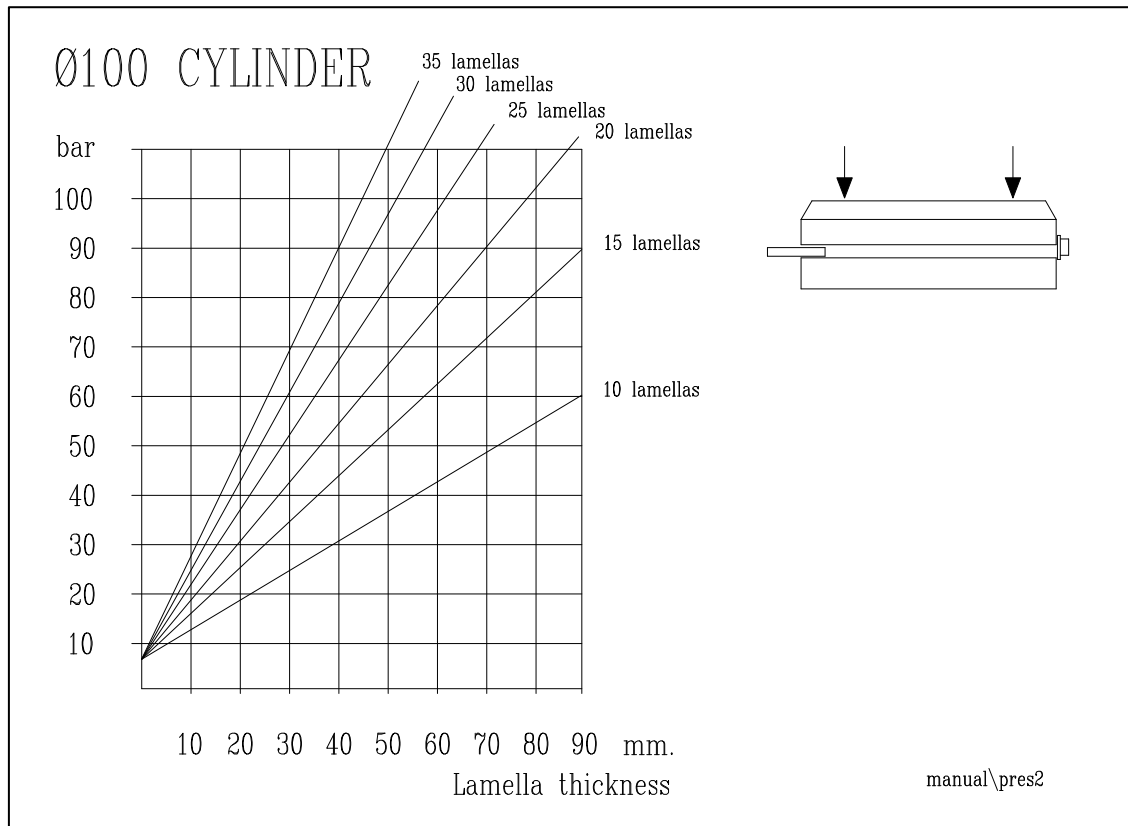




The tables shown above have been calculated based on a fully loaded press, mounted with respectively Ø80 and Ø100 cylinders.
 If the press is NOT fully loaded the pressure thrust must be reduced; you can calculate the adjusted pressure thrust as follows:

<u>With Ø80 cylinders:</u>	<u>With Ø100 cylinders:</u>
$\frac{E \times T}{A \times 50} + 8 = XX \text{ BAR}$	$\frac{E \times T}{A \times 78} + 8 = XX \text{ BAR}$
<p>E = Work piece size cm² (length x height) T = Desired pressure thrust (kp/cm²) A = Number of pressure cylinders</p>	

TOP (VERTICAL) PRESSURE



The top pressure thrust depends on the number of lamella led into the press and on the height (thickness) of the lamella, i.e. the total surface to be glued.

The table shown above allows for a friction tension of 1.9 kp/cm².
If the press is NOT fully loaded the pressure thrust must be reduced accordingly; you can calculate the adjusted pressure thrust as follows:

With Ø100 cylinders:

La x E x T

A x 78 + 8 = XX bar

La = Number of lamella across

E = Size of work piece cm² (length x width)

T = Desired pressure thrust (1,6 - 2,2 kp/cm²)

A = Number of pressure cylinders.