

# Quick Die Change System

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# Service Manual

## Quick Die Change System

1. No display in the control panel ?

Please check page 3~4 for detail.

2. Control panel display is normal but system will not operate ?

Please check page 3~4 for detail.

3. Pump runs continuously ?  
(an no signs of leaking fluid)

Please check page 5 for detail.

4. Clamp does not hold die securely ?

Please check page 6 for detail.

5. Upper clamps functioning normal, but lower clamps are not working?

Please check page 7 for detail.

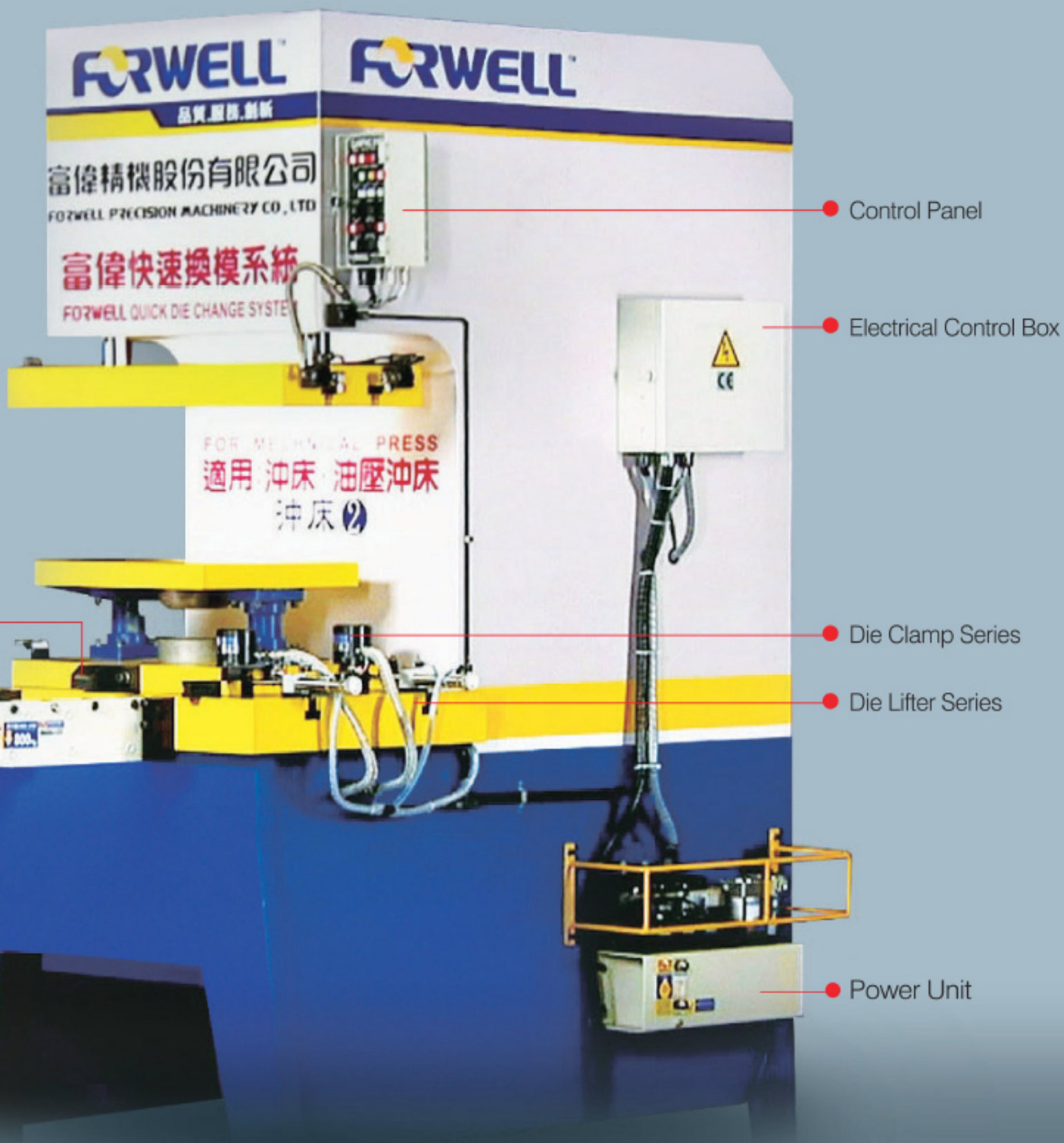
6. Die lifter dies not rise ?

Please check page 7 for detail.

7. Unusually slow pumping action  
(the voice of the pump is very slow)

Please check page 8 for detail.







# 1 No signal display in the ontrol panel.

Ensure that power switch is in the ON position.



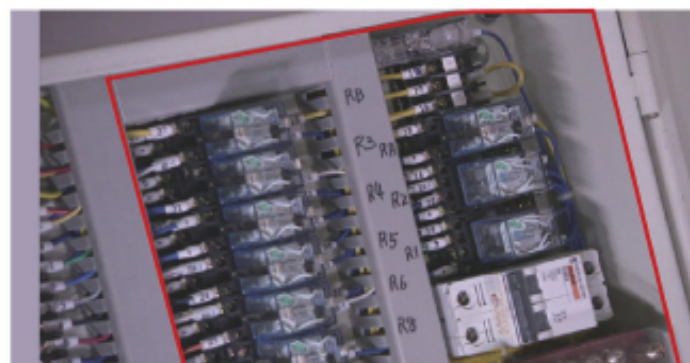
**Step 1** Dese the Power lights shows ON.



**Step 3** Check for loosen electrical plugs.



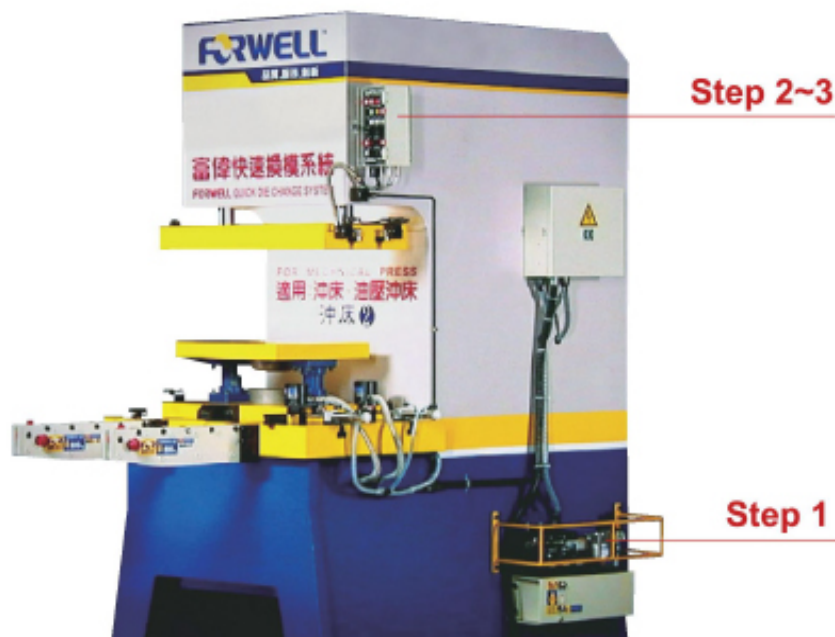
**Step 2** Check for loosen signal cable connections.



**Step 4** Check for the fuse blows.

## 2 Control panel display is normal but system will not operate ?

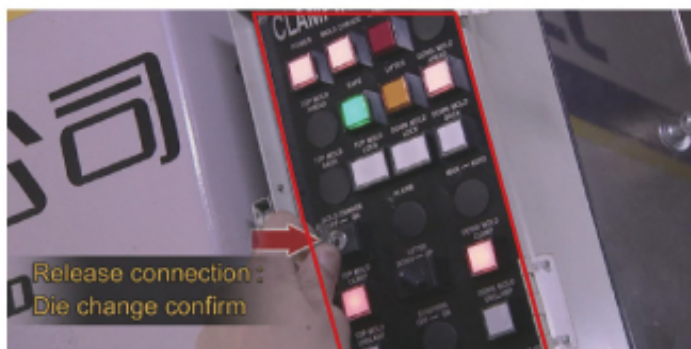
Ensure that the sliding switch between the two-point set is open.



**Step 1** Ensure that the sliding switch between the two-point set is open.



**Step 3** Turn the key switch to the "OFF" position, and check the Lock switch is relief.



**Step 2** Check for the key switch is turn to the "ON" position.



### 3 Pump runs continuously ? (an no signs of leaking fluid)

Check fluid level indicator to see if fluid is too low, if level is normal, turn the release valve to let out some of the air in the pressure line.



**Step 1** When the pump keeps running and can't be stopped, please check and repair with following steps!



**Step 3** Please check for oil leaks with the Die Lifters.



**Step 2** Please check for any oil leaks with any clamps.



**Step 4** Please check for oil leaks problem with the pipelines.

## 4 Clamp does not hold die securely ?

Ensure that the sliding switch between the two-point set is open.

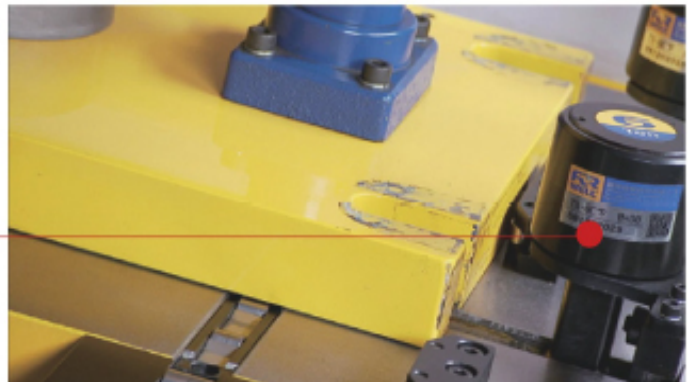


**Step 1** Ensure that the sliding switch between the two-point set is open.

**Step 2** Check for the key switch is turn to the "ON" position.

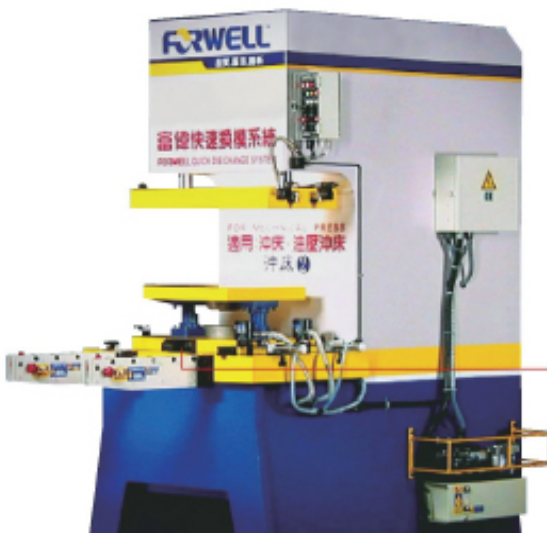
## 5 Upper clamps functioning normal, but lower clamps are not working?

Turn off die lifter so that lower die clamp can return to normal operation.



## 6 Die lifter dies not rise ?

Turn off die lifter so that lower die clamp can return to normal operation.





## 7 Unusually slow pumping action (the voice of the pump is very slow)

Internal lubrication pump



## 8 Air pressure is insufficient and hydraulic pressure too low ?

Check to see that compressor is turned on and air lines are free and clear, if there are no problems with the air supply, inspect the air pressure regulator on top of the two-point set and adjust the pressure as needed. (Check first to see if PU hose is ruptured or damaged)



**FORWELL PRECISION MACHINERY CO., LTD.**

TEL: +886-4-8345196 FAX: +886-4-8345197

E-mail: [forwell@forwell.com](mailto:forwell@forwell.com)

**[www.forwell.com](http://www.forwell.com)**

**FORWELL PRECISION MACHINERY (NINGBO) CO., LTD.**

TEL: +86-574-8659-9196 FAX: +86-574-8659-9197

E-mail: [forwell@forwellnb.com](mailto:forwell@forwellnb.com)