



KNOWLEDGE BASE

Article Type: **Instructions**

Compression Bean “Down Switch” Adjustment for: CPM series Machines

Description:

Instructions on. “Adjusting the Compression Head Down switch on CPM model machines. Service Tip # 2000

WARNING

Never work on, clean or service this unit, control panel or any machine or open or remove any protective cover, guard, grate, door, or maintenance panel until the power or energy sources has been turned off, locked out / tagged out, and all moving parts have come to a complete stop and or blocked to prevent movement. Machinery is dangerous - avoid personal injury and or death by following manufacture, Local, and OSHA safety procedures. Contact Columbia Machine for safety decals, guards, horns and beacons.

“Compression Beam “Down”- Switch Adjustment - C.P.M Series.

The following steps must be completed to properly adjust the compression beam down switch.

- With the machine out of automatic, using the selector switch manually extend the compression beam to its full up position. Now using the stripper selector switch extend the stripper beam to its full up position. Now lower the compression beam down on to the height stops.
- With the correct compression beam stops installed for the mold being used, lower the stripper beam until the compression beam is approximately 1” above the column spacers as shown in the photos below.
- With the compression beam set at 1” above the column spacer and the height stops held together, adjust the switch flag for the compression down switch. Adjust the flag so it is centered in the diameter of the 30mm proximity switch as shown. With the machine operating in automatic, this will cause the flag to actuate the switch each time the compression beam is 1” above the beam stop on its way down. This centers the compression cylinder valve.
- Some fine adjustment of the switch flag may be required but the 1” gap is a good starting point.
 1. Switch flag.
 2. Compression down switch.
 3. Compression beam stop.
 4. 1” space.

