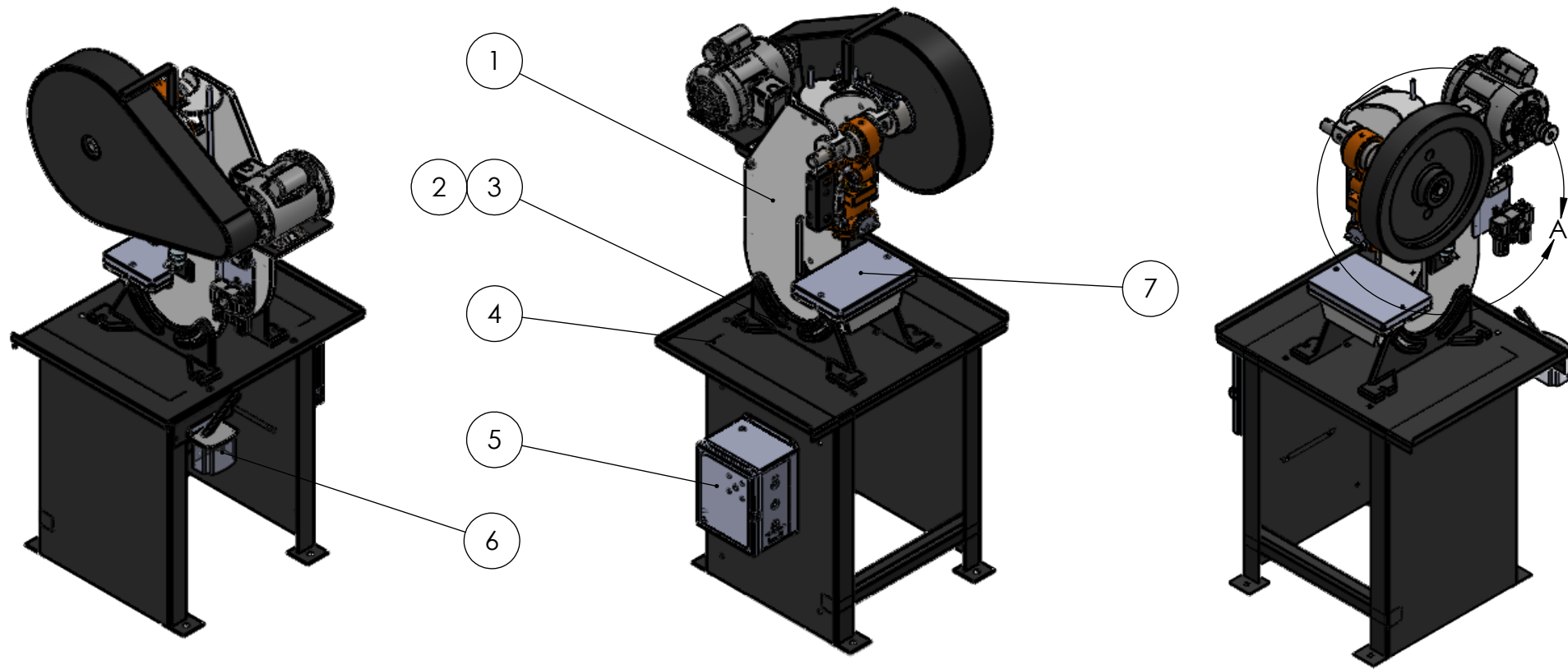




Mechanical press GEN I

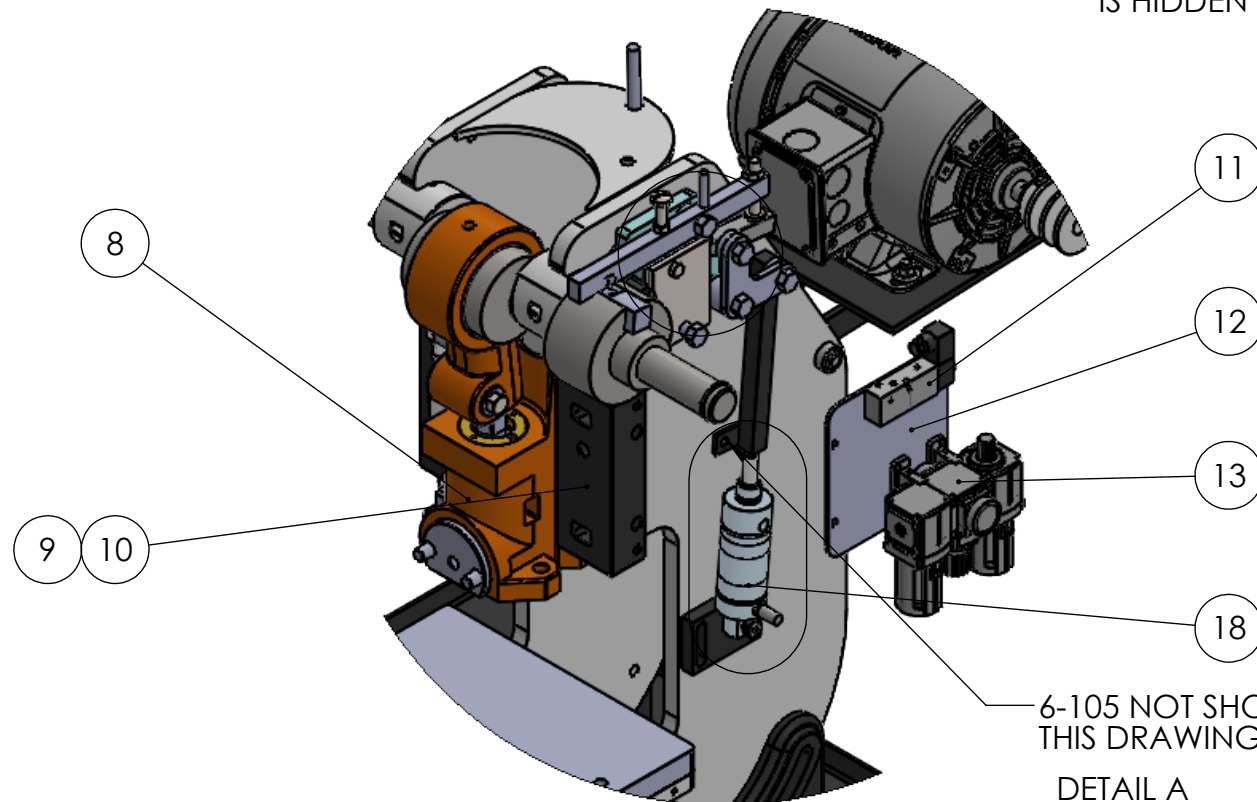
Spare parts

Model 4-IP-44IP



ITEM NO.	PART NO	DESCRIPTION	QTY.
1	6-001	6T FRAME STD	1
2	6-063R	6 TONS LEG, RIGHT	1
3	6-063L	6 TONS LEG, LEFT	1
4	4-002	PUNCH PRESS BENCH	1
5	1000-002	AZIMUTH CONTROL PANEL	1
6	1300-018	MANUAL OILER	1
7	6-016	6T BOLSTER PLATE	1
8	6-023AS	6T RAM ASSEMBLY	1
9	6-022	6T GIB, LEFT	1
10	6-022.1	6T GIB, RIGHT	1
11	4-151	4 TO 66T SOLENOID VALVE	1
12	4-262	FRL AND SOLENOID VALVE BRACKET, 4-6T	1
13	1310-020	MODULAR FRL 1/4NPT	1
14	6-033AS	6T CRANKSHAFT ASSEMBLY	1
15	6-049AS	6T MECHANICAL CLUTCH ASSEMBLY	1
16	6-041AS	6T FLYWHEEL ASSEMBLY	1
17	6-069AS	6T MOTOR ASSEMBLY	1
18	6-150AS	6T AIR CYLINDER ASSEMBLY	1
19	6-125AS	6T FLYWHEEL GUARD ASSEMBLY	1

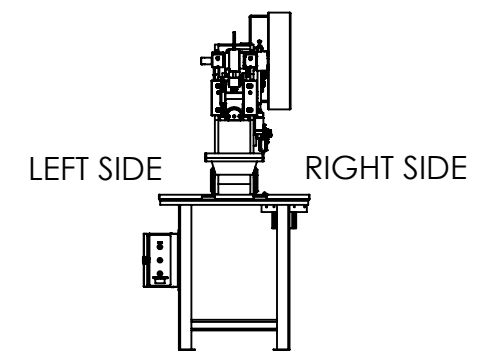
*6-125AS (6T FLYWHEEL GUARD ASSEMBLY) IS HIDDEN IN THIS VIEW



6-105 NOT SHOWN ON THIS DRAWING

DETAIL A
SCALE 1 : 6

*6-125AS (6T FLYWHEEL GUARD ASSEMBLY) AND 6-041AS (6T FLYWHEEL ASSEMBLY) ARE HIDDEN IN THIS VIEW



FRONT VIEW, WHEN OPERATING PRESS



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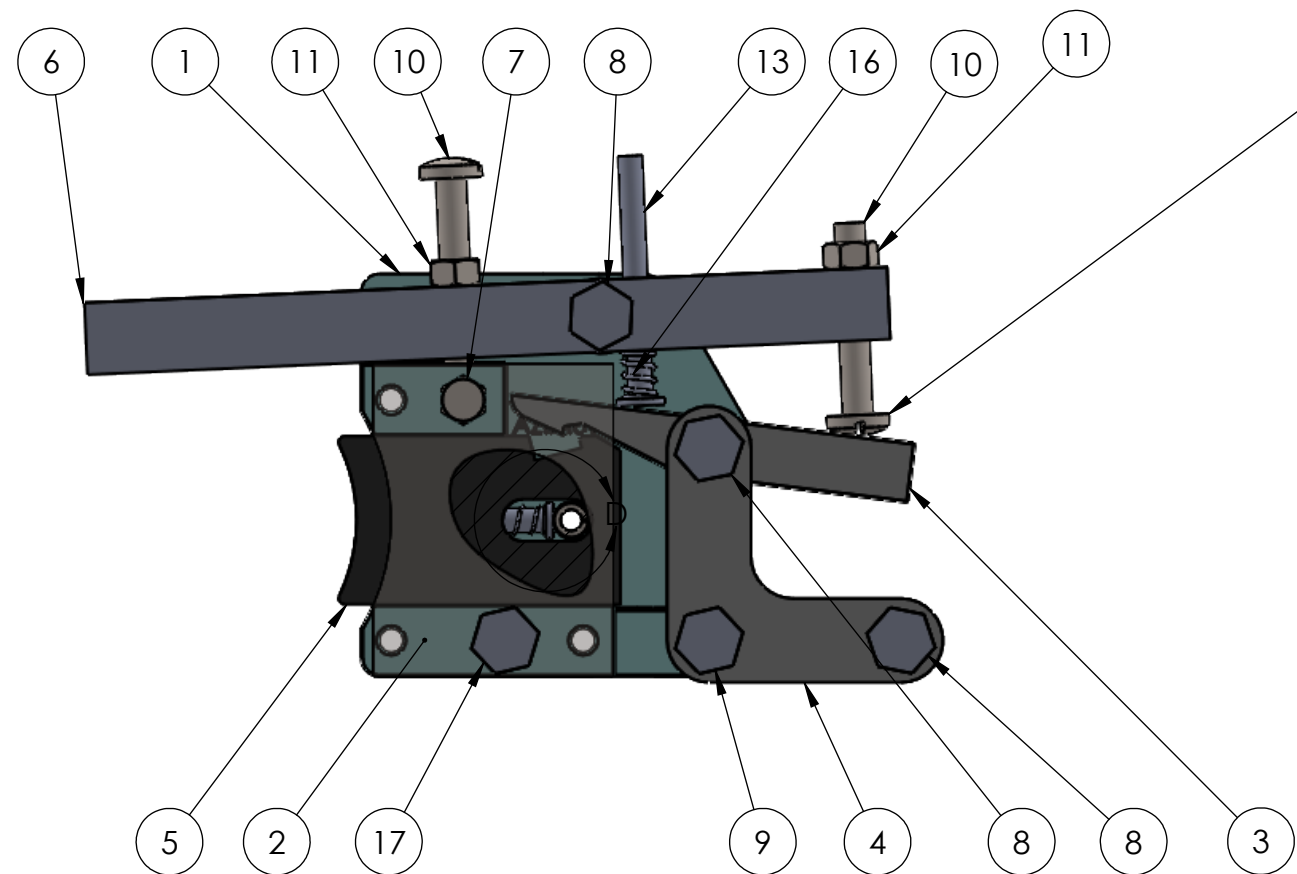
DESCRIPTION	
6 TONS STD	
CUSTOMER	
DRAWN BY	DATE
AZIMUTH	2018-12-11
ISSUED FOR	DWG. #
	6-IP-AS
COMMENTS :	

PROPRIETARY AND CONFIDENTIAL

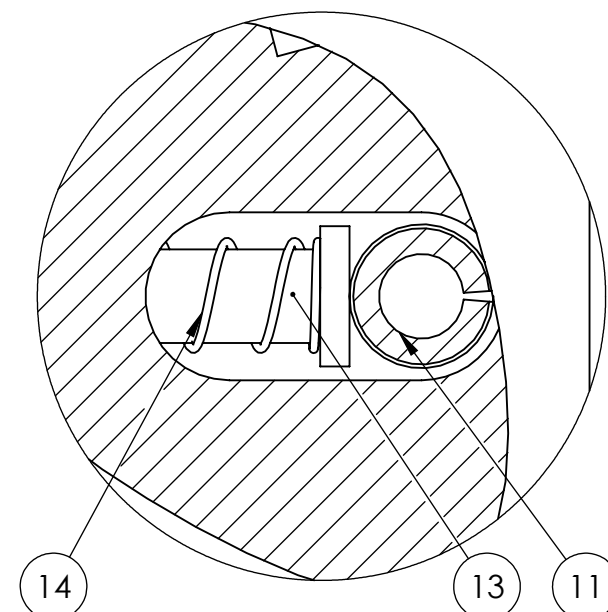
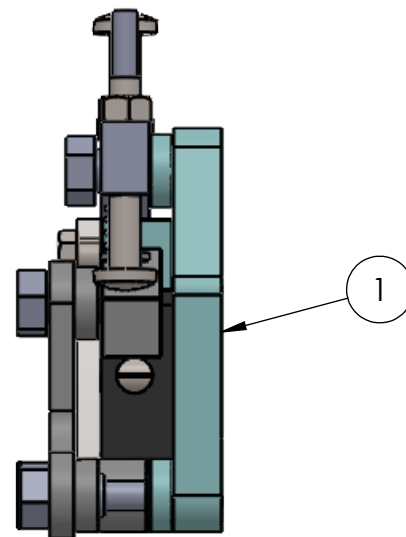
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CLUTCH ADJUSTMENT PROCEDURE (IF PRESS IS DOUBLE STROKING)

1. SET TIMER RELAY INSIDE THE CONTROL PANEL TO 10S
 2. LOSSEN NUT #11
 3. BRING BOLT #10 DOWN ABOUT 1/8"
 4. PRESS & HOLD THE PEDAL TO MAKE A STROKE
 5. IF THE PRESS IS STILL REPEATING, REPEAT STEP #3&4*. IF NOT, GO TO #6
 6. TIGHTEN THE NUT NUMBER 11
 7. SET TIMER RELAY INSIDE THE CONTROL PANEL TO 0.2S
- *IF PRESS IS STILL REPEATING AFTER THIS PROCEDURE, VERIFY SPRING #16 (6-106), SPRING #15 (6-104) AND 6-043 ON CRANKSHAFT



BRING THIS BOLT **DOWN** TO PREVENT DOUBLE STROKE
BRING THIS BOLT **UP** TO DOUBLE STROKE



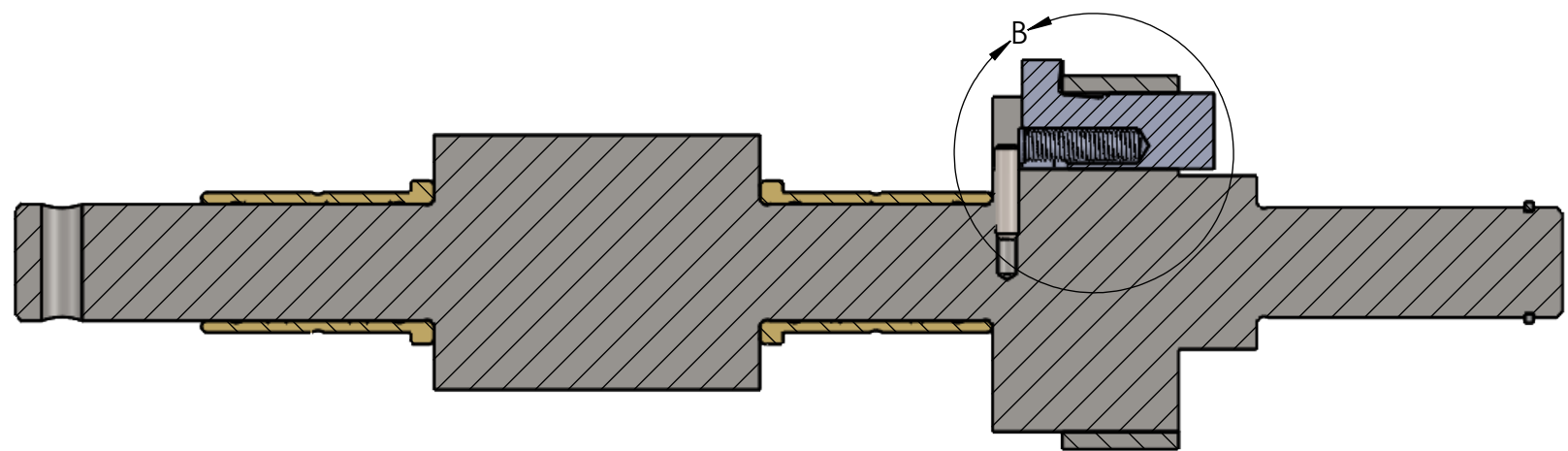
DETAIL D
SCALE 2 : 1

ITEM NO	PART NO	DESCRIPTION	QTY
1	6-049	CLUTCH BRACKET	1
2	6-050	CLUTCH COVER PLATE	1
3	6-046	HOOK, DISENGAGING LATCH	1
4	6-055	LEVER, LATCH HOOK	1
5	6-045	DISENGAGING LATCH	1
6	6-047	RELEASE LEVER	1
7	6-053	HEX BOLT 1/4-20 X 1.5LG	1
8	6-074	SHOUDLER SCREW, CLUTCH LINKAGE	3
9	6-076	SHOUDLER SCREW, LINKAGE PIVOT	1
10	6-098	LOCKING SCREW - RELEASE LEVER	2
11	6-098.1	HEX NUT 5/16-18	2
12	6-121	SPRING PIN 0.375" X 1.25"LG	1
13	6-048	SPRING PIN, RELEASE LEVER	1
14	6-104.1	PUSHER. LATCH SPRING	1
15	6-104	SPRING, DISENGAGING LATCH	1
16	6-106	SPRING, LATCH HOOK	1
17	6-073	SHOUDLER SCREW, CLUTCH BRACKET	1



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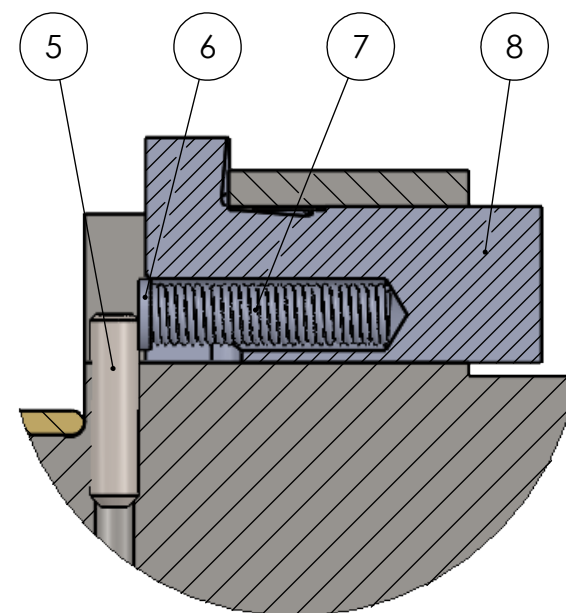
DESCRIPTION	
MECHANICAL CLUTCH ASSEMBLY	
PART NO 6-049AS	
DRAWN BY JOEY TRUDEAU	DATE 21/21/2015
ISSUED FOR CUSTOMER REVIEW	MATERIAL
COMMENTS :	
<p>PROPRIETARY AND CONFIDENTIAL</p> <p>THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF AZIMUTH MACHINERY. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF AZIMUTH MACHINERY IS PROHIBITED.</p>	



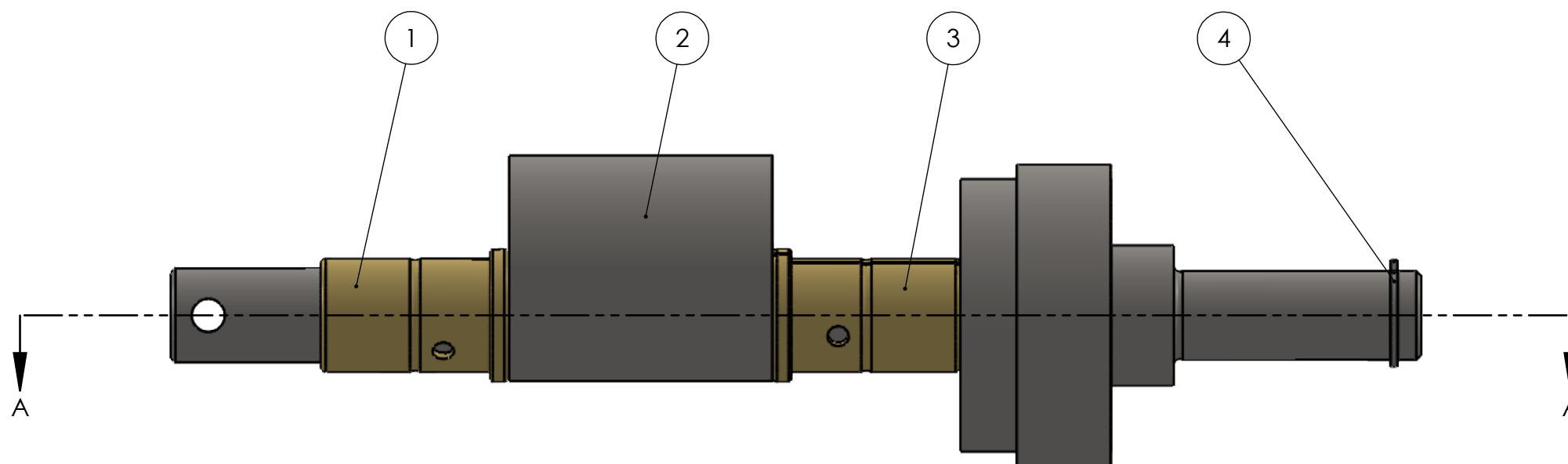
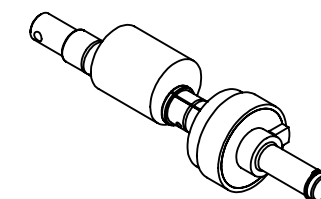
SECTION A-A

ITEM NO.	PartNo	DESCRIPTION	QTY.
1	6-034SO	6T BRONZE BUSHING, SOLID	1
2	6-033	6T CRANKSHAFT	1
3	6-034SP	6T BRONZE BUSHING, SPLIT	1
4	6-101	6T CRANKSHAFT RETAINING RING	1
5	6-086	SET SCREW 1/4-20X1 LG.	1
6	6-044	6T PUSHER, KEY SPRING	1
7	6-043	6T SLIDING KEY (CLUTCH DOG)	1
8	6-042	6T CLUTCH DOG	1

FOR DIFFERENT SIZE PRESSES, CHANGE THE FIRST DIGIT
 EX : 6-033 IS A 6T CRANKSHAFT
 10-033 IS A 10T CRANKSHAFT



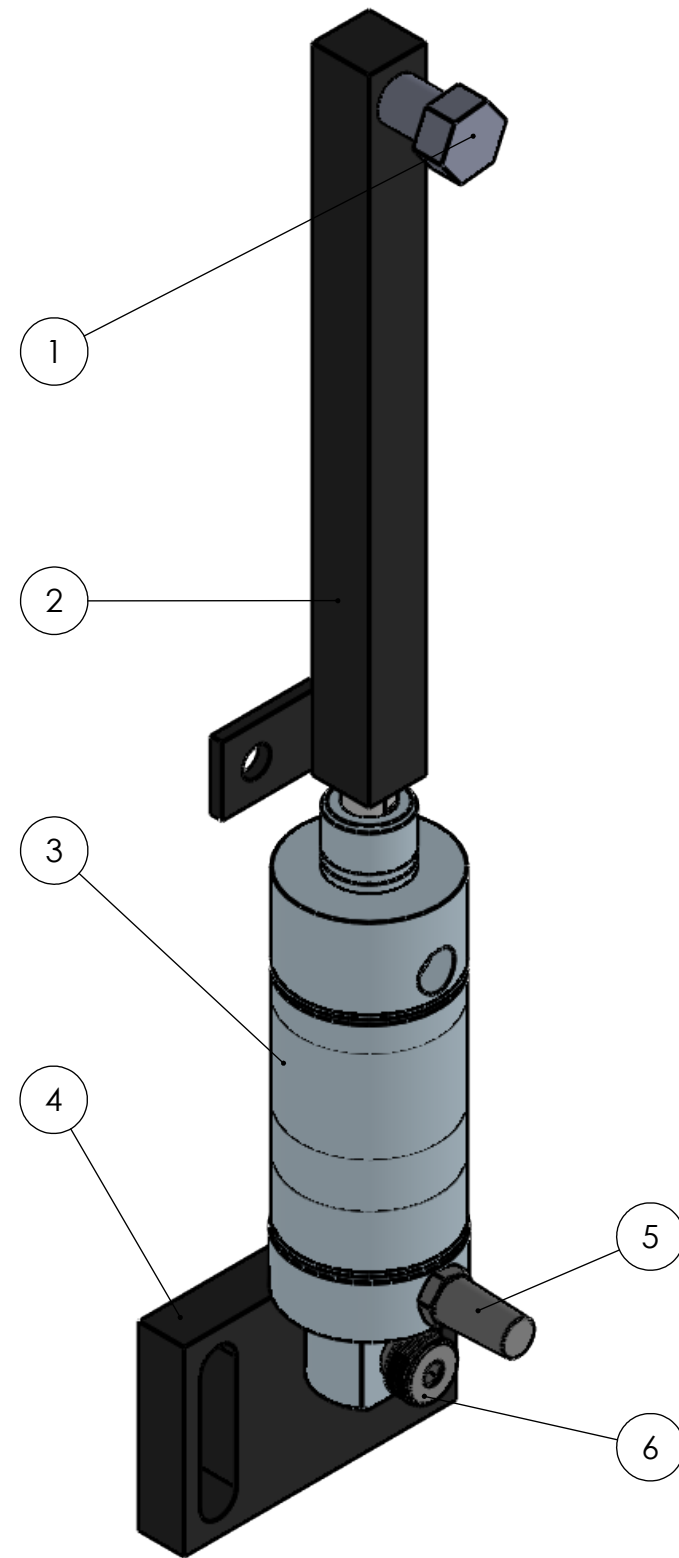
DETAIL B
 SCALE 1 : 1



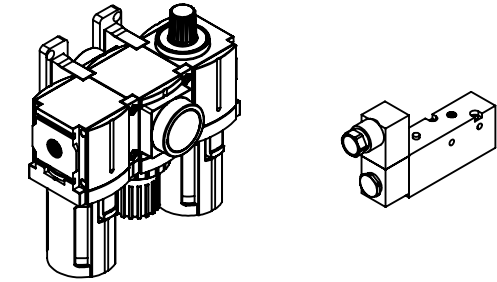
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DESCRIPTION	
6T CRANKSHAFT ASSEMBLY	
CUSTOMER	
DRAWN BY	DATE
AZIMUTH MACHINERY	2018-04-16
ISSUED FOR	DWG. #
COMMENTS :	

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ITEM NO.	PartNo	DESCRIPTION	QTY.
1	6-074	1/2 LG. SHOUDLER SCREW	1
2	6-057	6T PULL ROD	1
3	6-150	AIR CYLINDER	1
4	4-204	4T AIR CYLINDER MOUNTING BRACKET	1
5		MUFFLER 1/8NPT	1
6		SHOULDER SCREW 3/8-16, ϕ 3/8" X 1" LG.	1



*THIS ASSEMBLY COMES WITH PARTS :
 4-151 SOLENOID VALVE
 1300-020 MODULAR FRL 0.25NPT

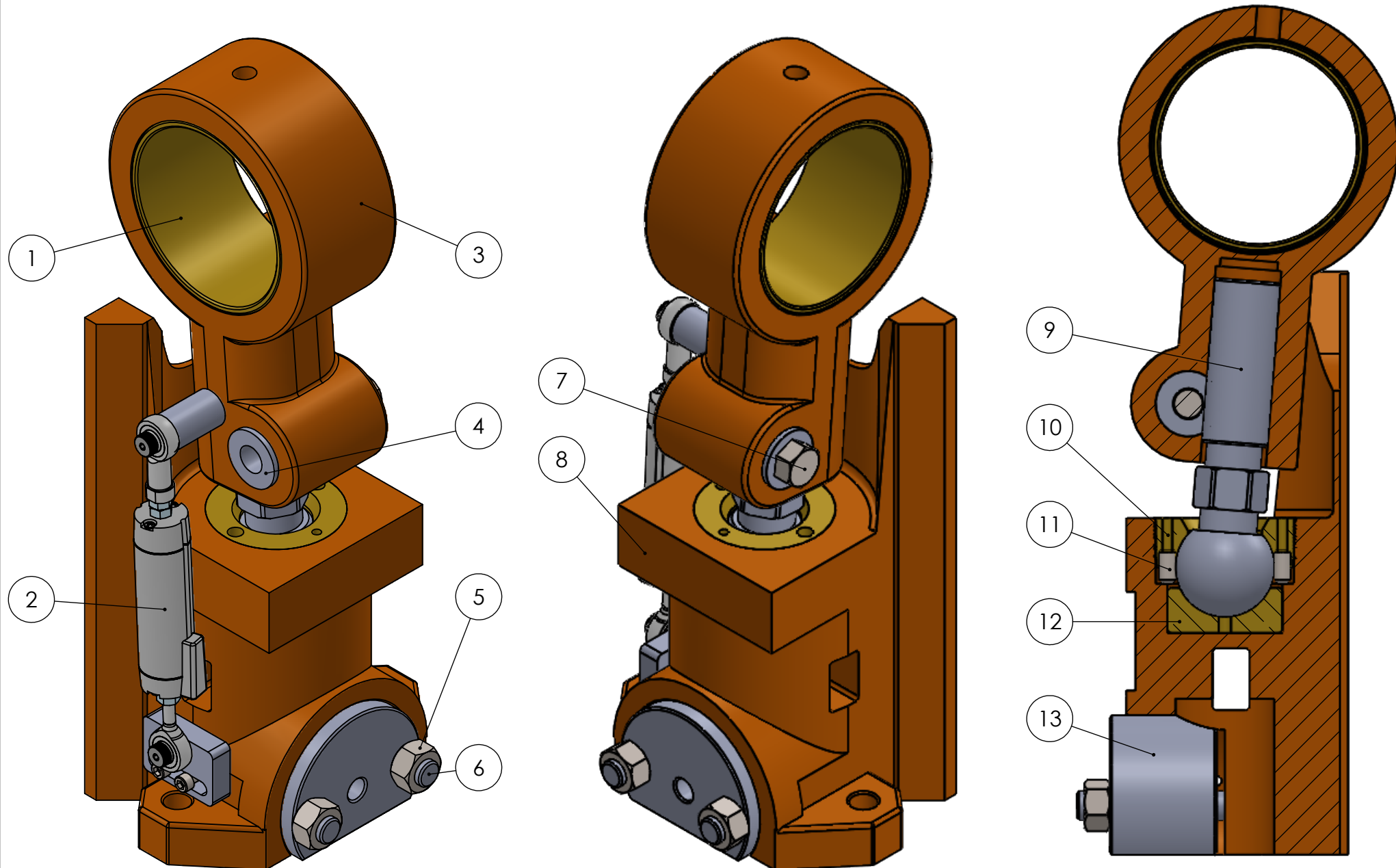


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DESCRIPTION AIR CYLINDER ASSEMBLY	
CUSTOMER	
DRAWN BY AZIMUTH MACHINERY	DATE 2018-04-23
ISSUED FOR	DWG. # 6-150AS
COMMENTS :	
PROPRIETARY AND CONFIDENTIAL	
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NOTE	DESCRIPTION
1	MAKE SURE TO ALWAYS TIGHTEN SET SCREWS #11 AFTER REPLACING PART #10 (6-026). TO READJUST CUP-BALL ADJUSTMENT, LOOSEN UP SCREW #11, THEN ROTATE CW THE CUP-BALL ADJUSTMENT UNTIL IT IS TIGHT. ONCE TIGHT, LOOSEN UP THE CUP-BALL (6-026) OF APPROXIMATELY 1/16 OF A TURN CCW TO GIVE A SMALL LOOSE TO THE BALL-SCREW
2	LOOSEN BOLT #7 TO ADJUST SHUT HEIGHT. MAKE SURE TO ALWAYS RETIGHTEN BOLT AFTER ADJUSTMENT

ITEM NO.	PartNo	DESCRIPTION	QTY.
1	6-136	6T PITMAN BUSHING	1
2	6-403AS	DIGITAL SHUT HEIGHT INDICATOR ASSEMBLY (OPTIONAL)	1
3	6-029	6T PITMAN	1
4	6-028	6T CLAMP BLOCK, PITMAN	1
5		HEX NUT 7/16-14	2
6	6-090	6T RAM CLAMP STUD	2
7		HEX BOLT 7/16-14X1-1/4 LG.	1
8	6-023	6T RAM	1
9	6-027	6T BALL SCREW	1
10	6-026	6T CUP BALL ADJUSTMENT	1
11		SET SCREW 1/4-28X1/2 LG.	2
12	6-025	6T BALL SEAT	1
13	6-024	6T CLAMP BLOCK, RAM	1



SECTION VIEW



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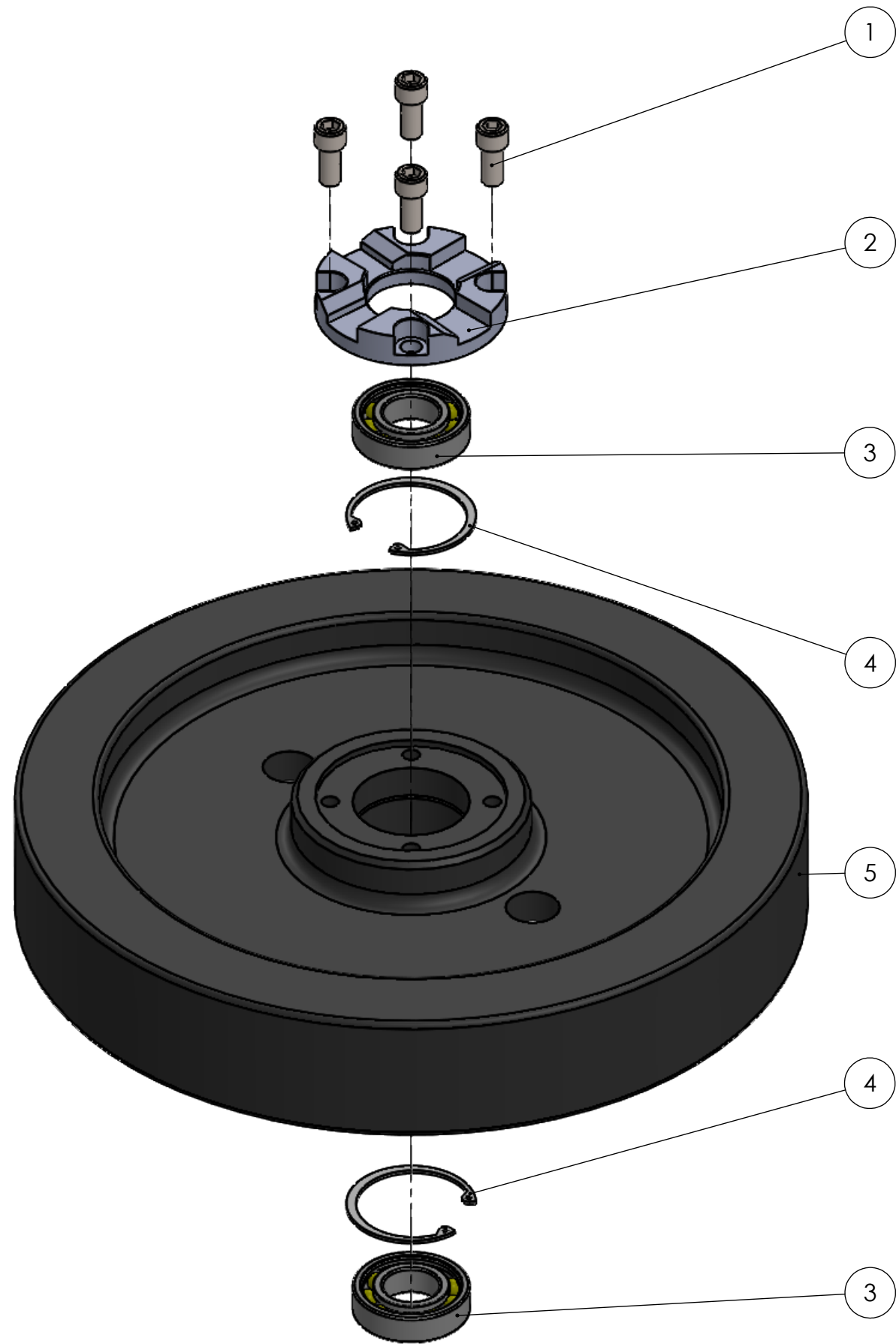
DESCRIPTION
6T RAM ASSEMBLY

CUSTOMER

DRAWN BY AZIMUTH MACHINERY	DATE 2018-05-24
ISSUED FOR	DWG. # 6-023AS

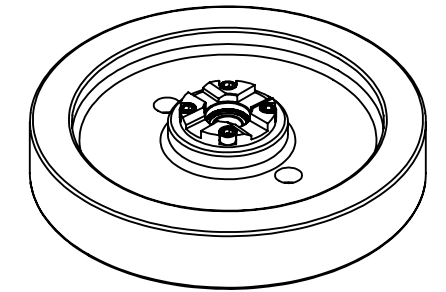
COMMENTS :

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ITEM NO.	PartNo	DESCRIPTION	QTY.
1	6-085	SOCKET HEAD 7/16-14X1 LG.	4
2	6-038	CLUTCH PLATE	1
3	6-122	6T FLYWHEEL BEARING	2
4	6-109	6T FLYWHEEL RETAINING RING	2
5	6-041	6T FLYWHEEL	1

FOR DIFFERENT SIZE PRESSES, CHANGE THE FIRST DIGIT
 EX : 6-041 IS A 6T FLYWHEEL
 10-041 IS A 10T FLYWHEEL




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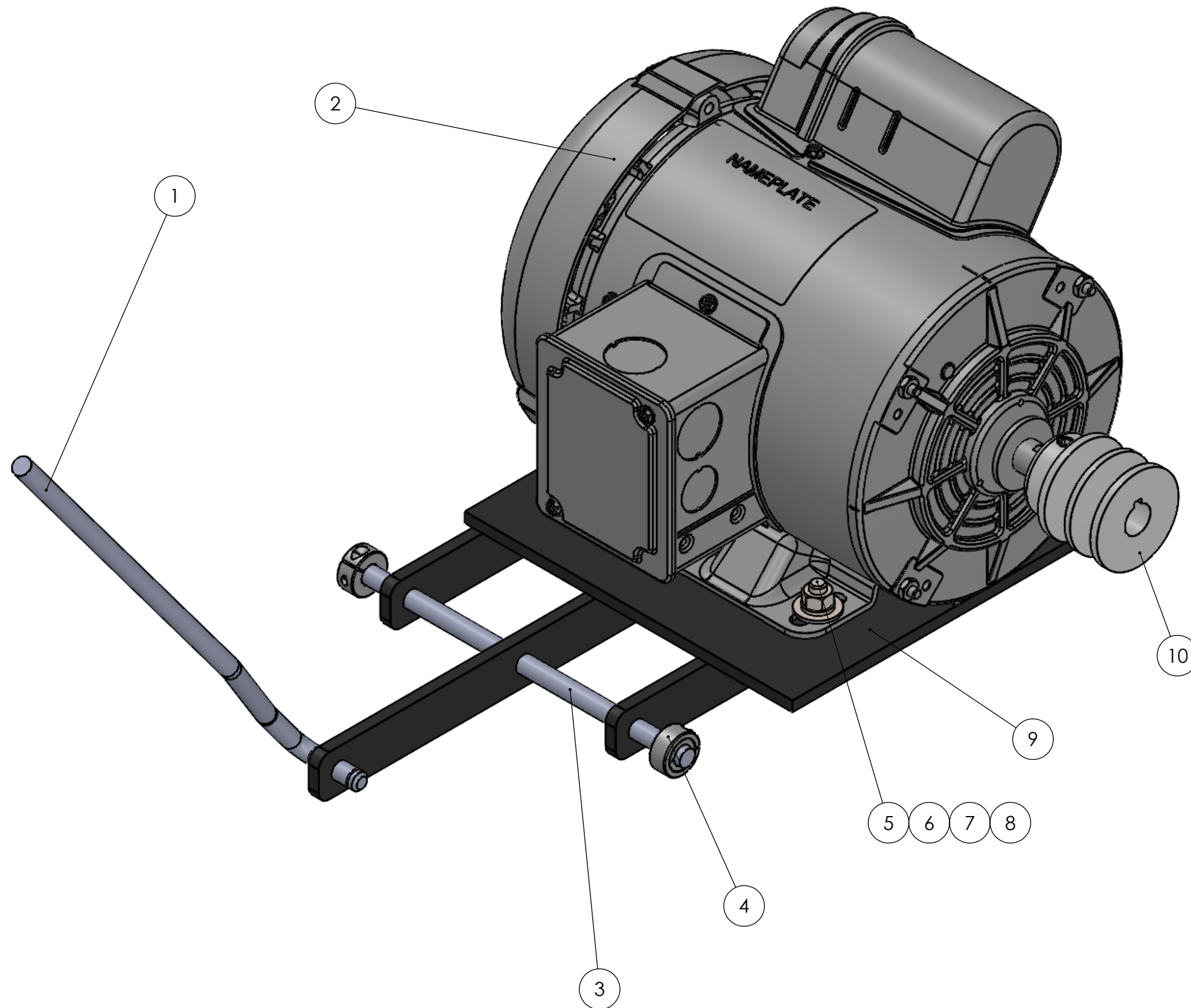
DESCRIPTION
 6T FLYWHEEL ASSEMBLY

CUSTOMER

DRAWN BY AZIMUTH MACHINERY	DATE 2018-04-24
ISSUED FOR	DWG. # 6-041AS

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ITEM NO.	PartNo	DESCRIPTION	6-IP/QTY.
1	6-071	6T STD MOTOR BRACKET STUD	1
2	6-126	6T ELECTRIC MOTOR	1
3		STEEL ROD 3/8X7-1/4 LG.	1
4		3/8 SHAFT COLLAR	2
5		HEX BOLT 5/16-18X1 LG.	4
6		HEX NUT 5/16-18	4
7		5/16 SPRING LOCK WASHER	4
8		5/16 FLAT WASHER	8
9	6-069	6T MOTOR BRACKET	1
10	6-123	6T MOTOR SHEAVE	1



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DESCRIPTION
 6 TONS PRESS ELECTRIC MOTOR ASSEMBLY
 CUSTOMER

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ISSUED FOR	DWG. #

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