

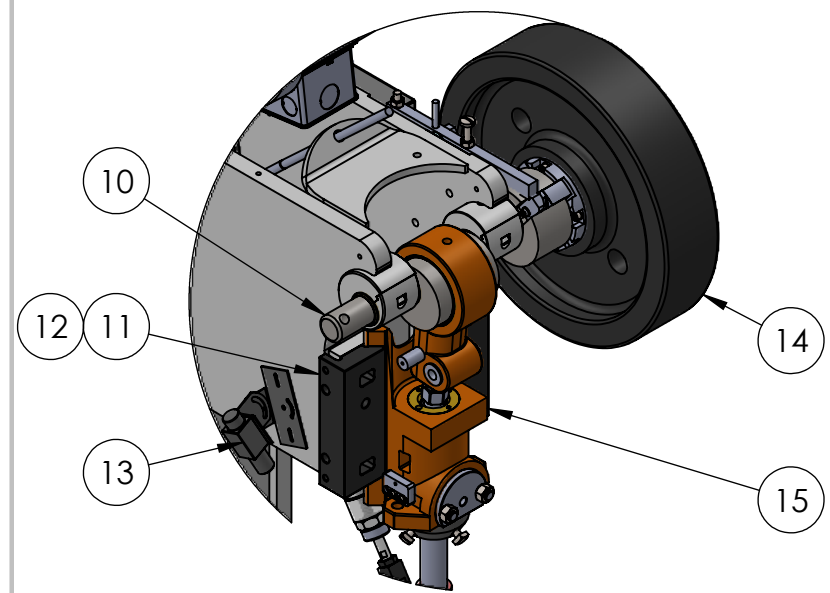
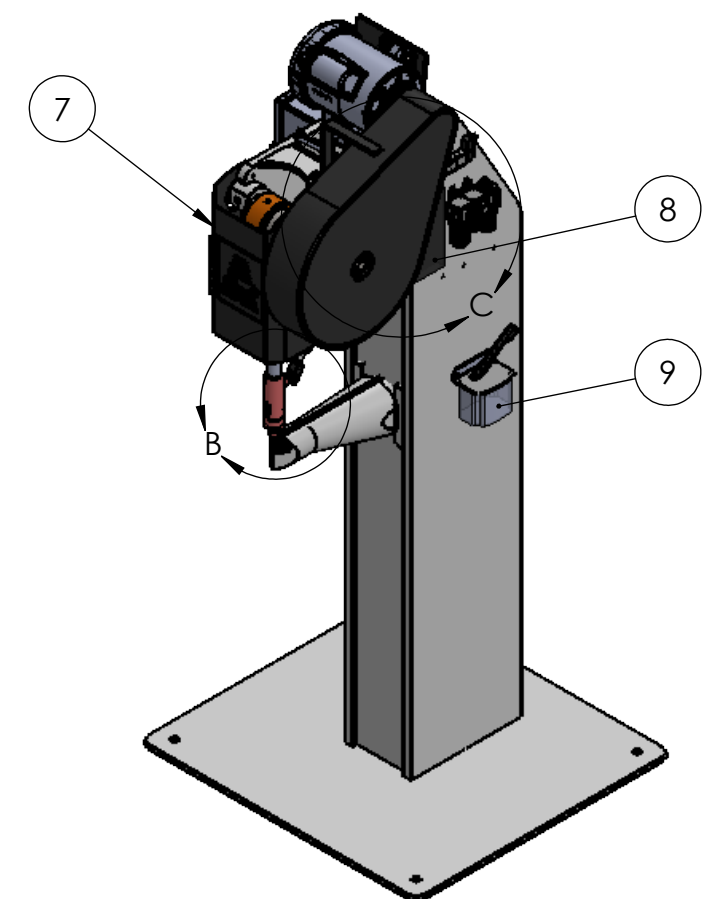
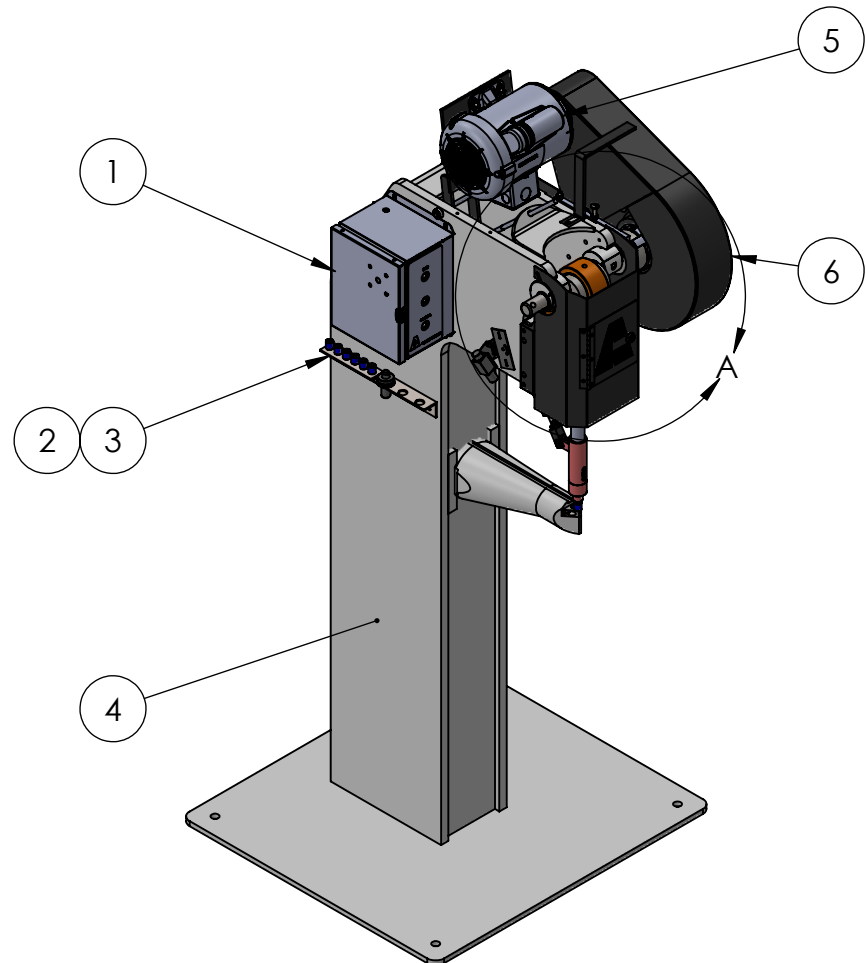
A large industrial machine, the AZIMUTH Clinching PRESS GEN I, is shown in a studio setting. The machine is primarily black with a large, circular, dark-colored upper component. A white label with the word 'AZIMUTH' in black capital letters is mounted on the upper component. The machine has a complex mechanical structure with various pipes, valves, and a clear protective enclosure around the lower part. The background is a plain, light-colored wall.

# Clinching PRESS GEN I

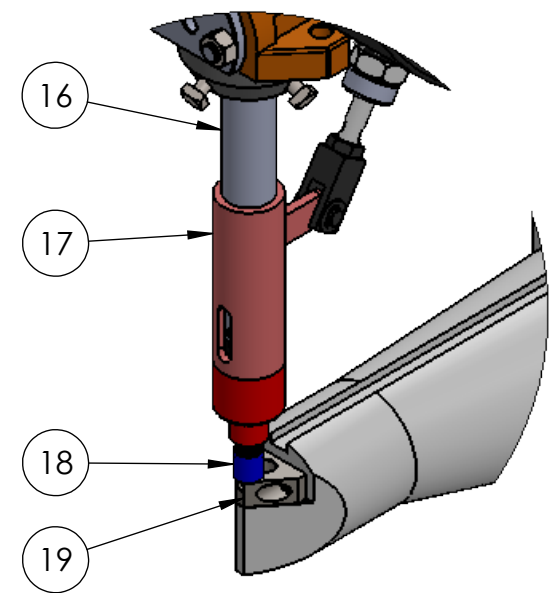
## Spare parts

**Model H600 GEN I**

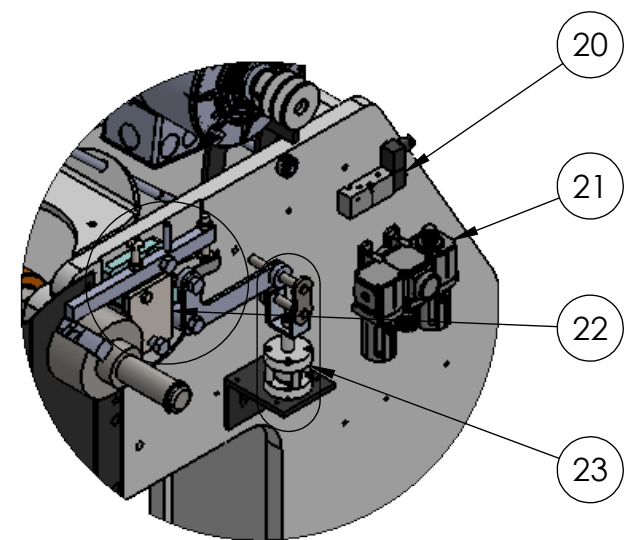
ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	1000-002	AZIMUTH CONTROL PANEL	1
2	6-311	PUNCH MOUNTING BRACKET	1
3	6-311.1	DIE MOUNTING BRACKET	1
4	H612-001	FRAME H612	1
5	6-369AS	MOTOR ASSEMBLY	1
6	6-325AS	6T CLINCHING FLYWHEEL GUARD	1
7	6-326	6T CLINCHING FRONT GUARD	1
8	6-228	6T CLINCHING ACTUATOR GUARD	1
9	1300-018	MANUAL OILER	1
10	6-033AS	6T CRANKSHAFT ASSEMBLY	1
11	6-022	GIB, LEFT	1
12	6-022.1	GIB, RIGHT	1
13	6-315	LASER ALIGNMENT TOOL	1
14	6-341AS	6T CLINCHING FLYWHEEL ASSEMBLY	1
15	6-023AS	6T RAM ASSEMBLY	1
16	6-302.1AS	NARROW PUNCH HOLDER ASSEMBLY	1
17	6-328.1AS	Fingersafe interlock guarding	1
18	20032AS	DIE ASSEMBLY	1
19	6-306	DIE BLOCK	1
20	4-151	SOLENOID VALVE 3/2-110VAC	1
21	1310-020	MODULAR FRL 1/4NPT	1
22	6-049.1AS	6T CLINCHING MECHANICAL CLUTCH ASSEMBLY	1
23	6-149AS	PANCAKE CYLINDER ASSEMBLY	1



DETAIL A  
SCALE 1 : 8



DETAIL B  
SCALE 1 : 4



DETAIL C  
SCALE 1 : 8

\* 6-325AS (CLINCHING FLYWHEEL GUARD)  
\* 6-326 (CLINCHING FRONT GUARD)  
ARE HIDDEN IN THIS VIEW

\* 6-326 (CLINCHING FRONT GUARD)  
ARE HIDDEN IN THIS VIEW

\* 6-325AS (CLINCHING FLYWHEEL GUARD),  
\* 6-341AS (CLINCHING FLYWHEEL ASSEMBLY)  
\* 6-228 (ACTUATOR GUARD)  
ARE HIDDEN IN THIS VIEW



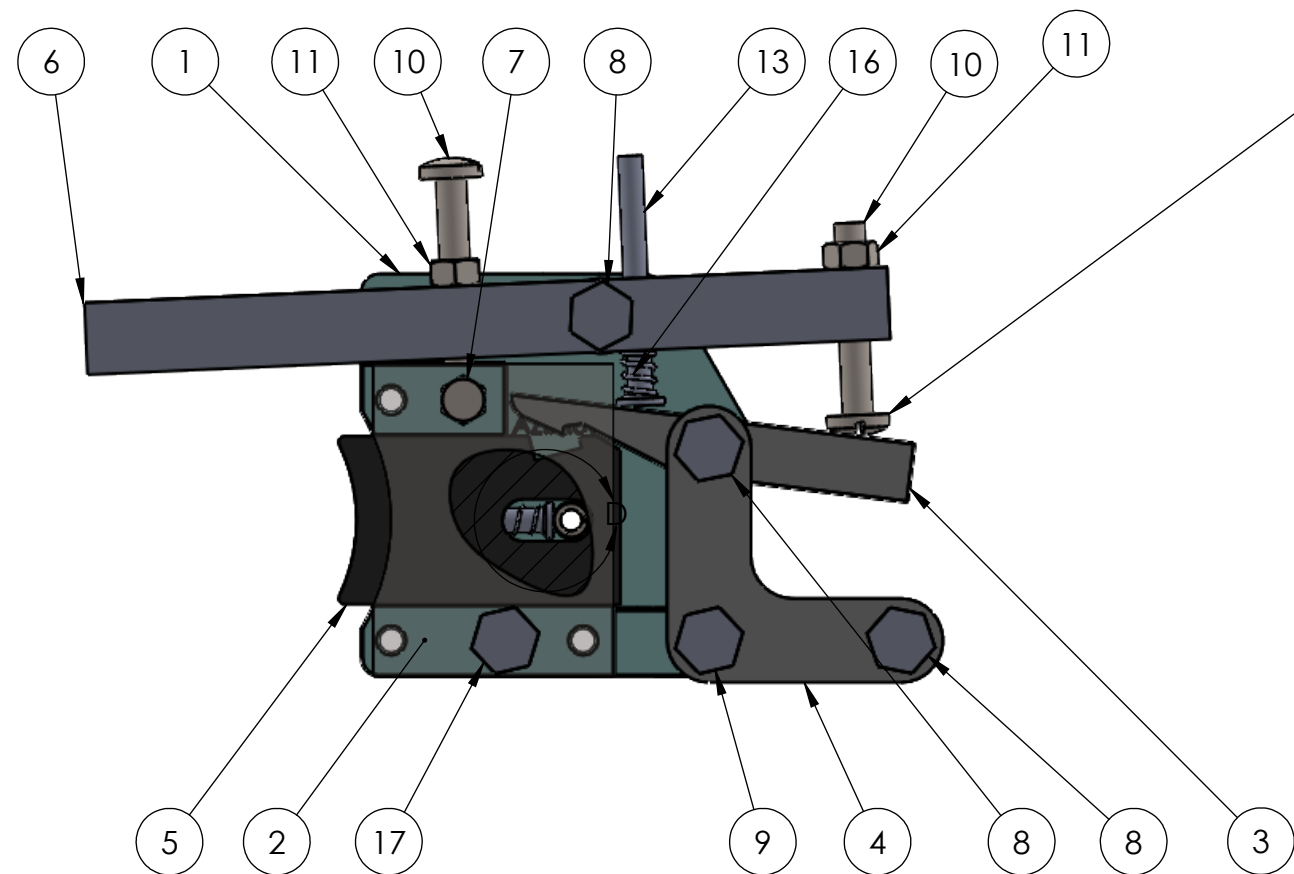
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QC, Canada, J5C 1B6

DESCRIPTION	
H612	
CUSTOMER	
DRAWN BY	DATE
AZIMUTH MACHINERY	2020-02-14
ISSUED FOR	DWG. #
COMMENTS :	

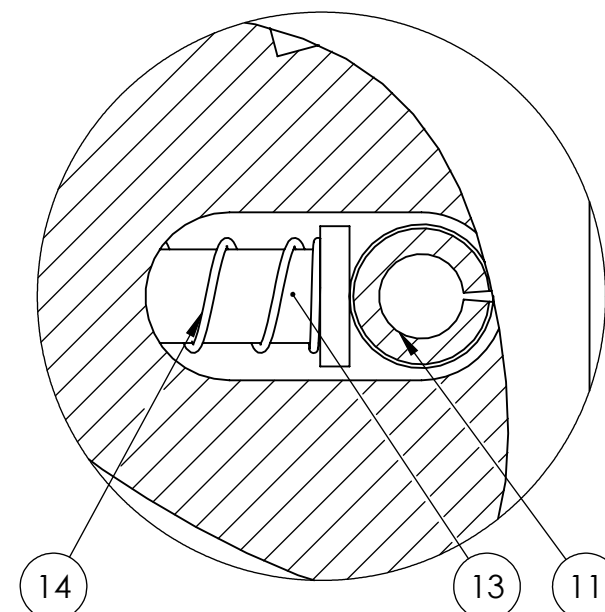
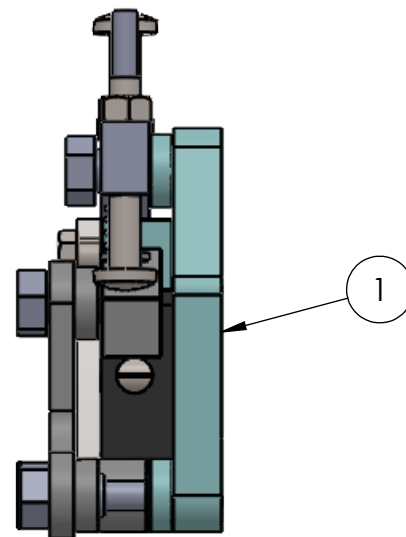
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CLUTCH ADJUSTMENT PROCEDURE (IF PRESS IS DOUBLE STROKING)

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	SHOULDLER SCREW, CLUTCH LINKAGE	3
9	6-076	SHOULDLER 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	SHOULDLER SCREW, CLUTCH BRACKET	1



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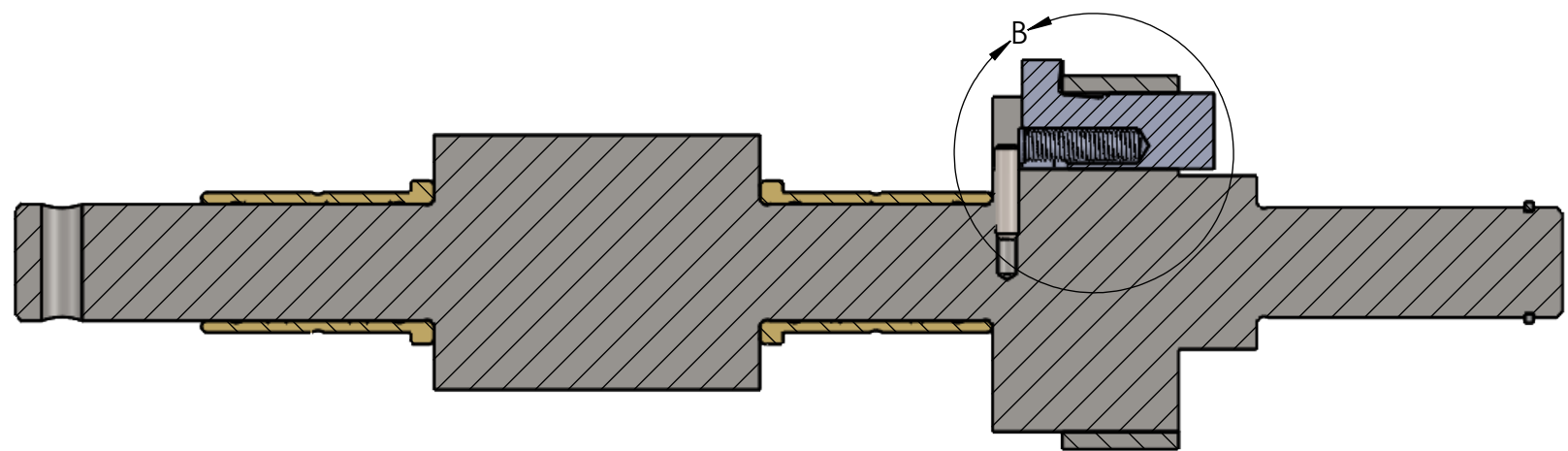
DESCRIPTION  
MECHANICAL CLUTCH ASSEMBLY  
PART NO  
6-049AS

DRAWN BY JOEY TRUDEAU	DATE 21/21/2015
ISSUED FOR CUSTOMER REVIEW	MATERIAL

COMMENTS :

**PROPRIETARY AND CONFIDENTIAL**

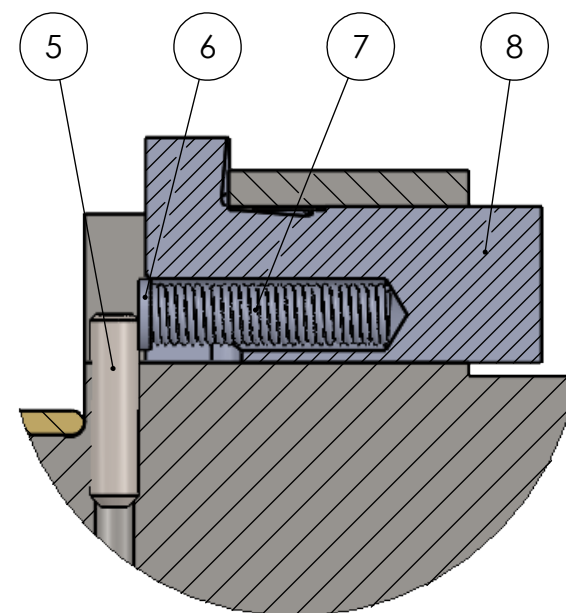
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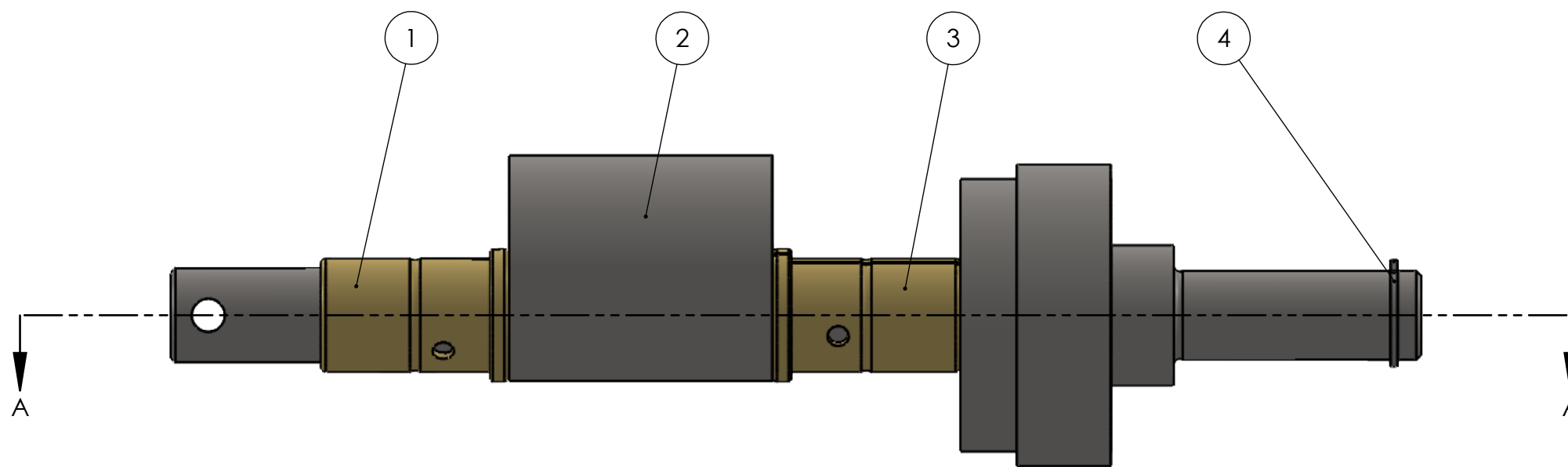
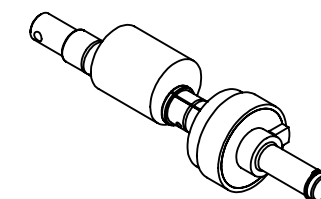
SECTION A-A

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

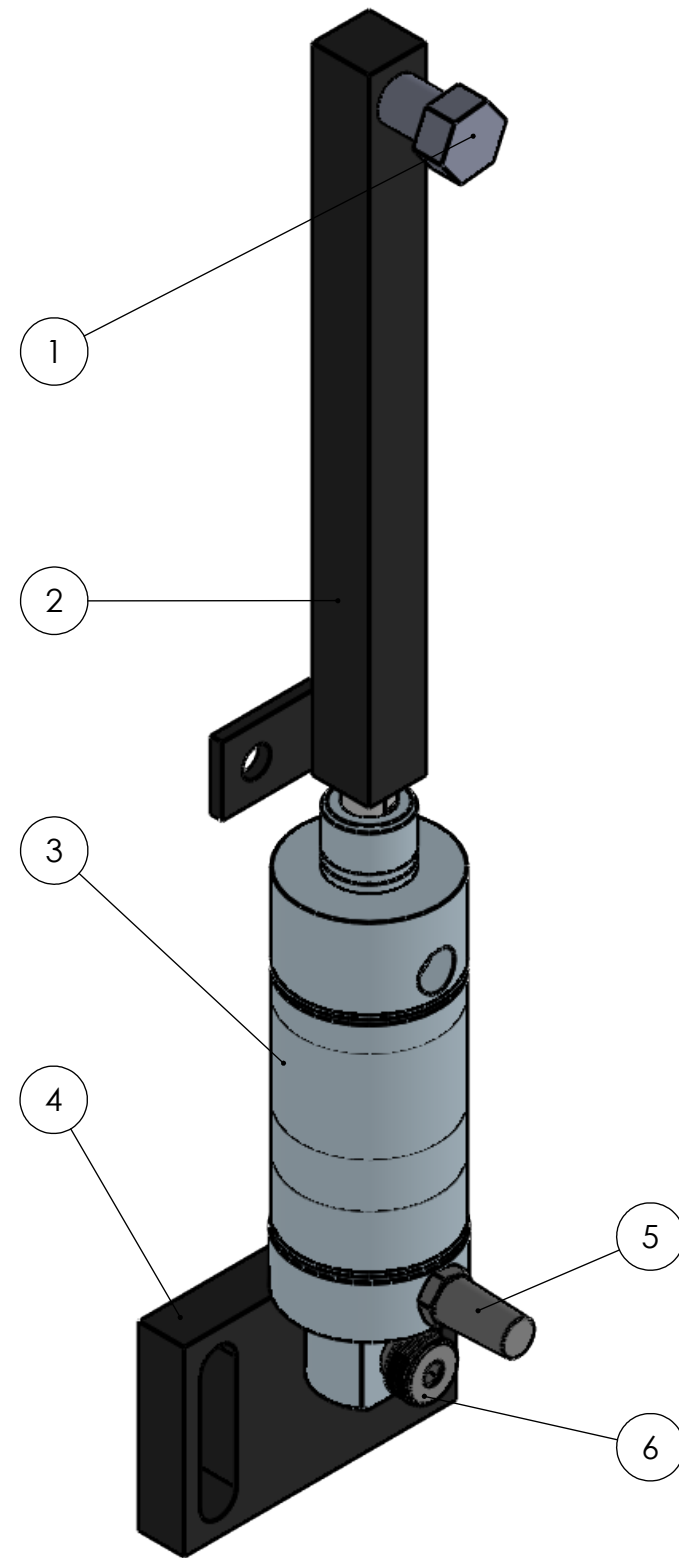


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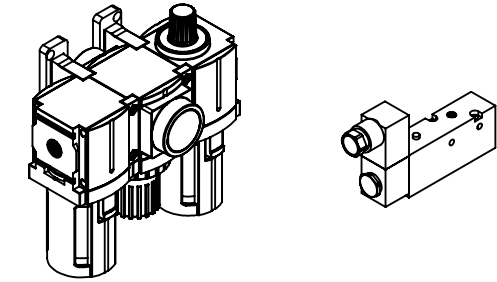
DESCRIPTION	
6T CRANKSHAFT ASSEMBLY	
CUSTOMER	
DRAWN BY	DATE
AZIMUTH MACHINERY	2018-04-16
ISSUED FOR	DWG. #

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, $\phi$ 3/8" X 1" LG.	1



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



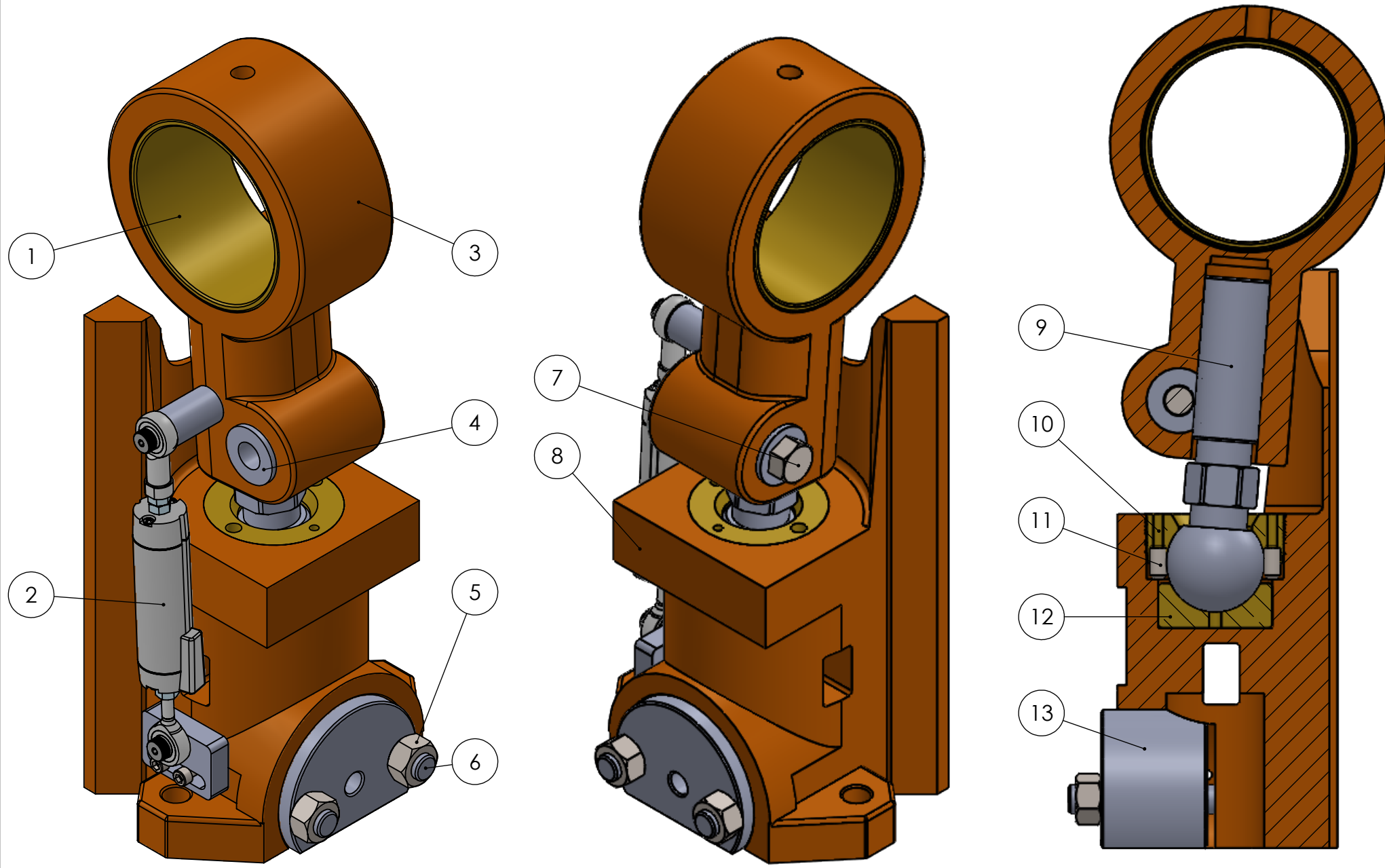
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DESCRIPTION	
AIR CYLINDER ASSEMBLY	
CUSTOMER	
DRAWN BY	DATE
AZIMUTH MACHINERY	2018-04-23
ISSUED FOR	DWG. #
	6-150AS
COMMENTS :	

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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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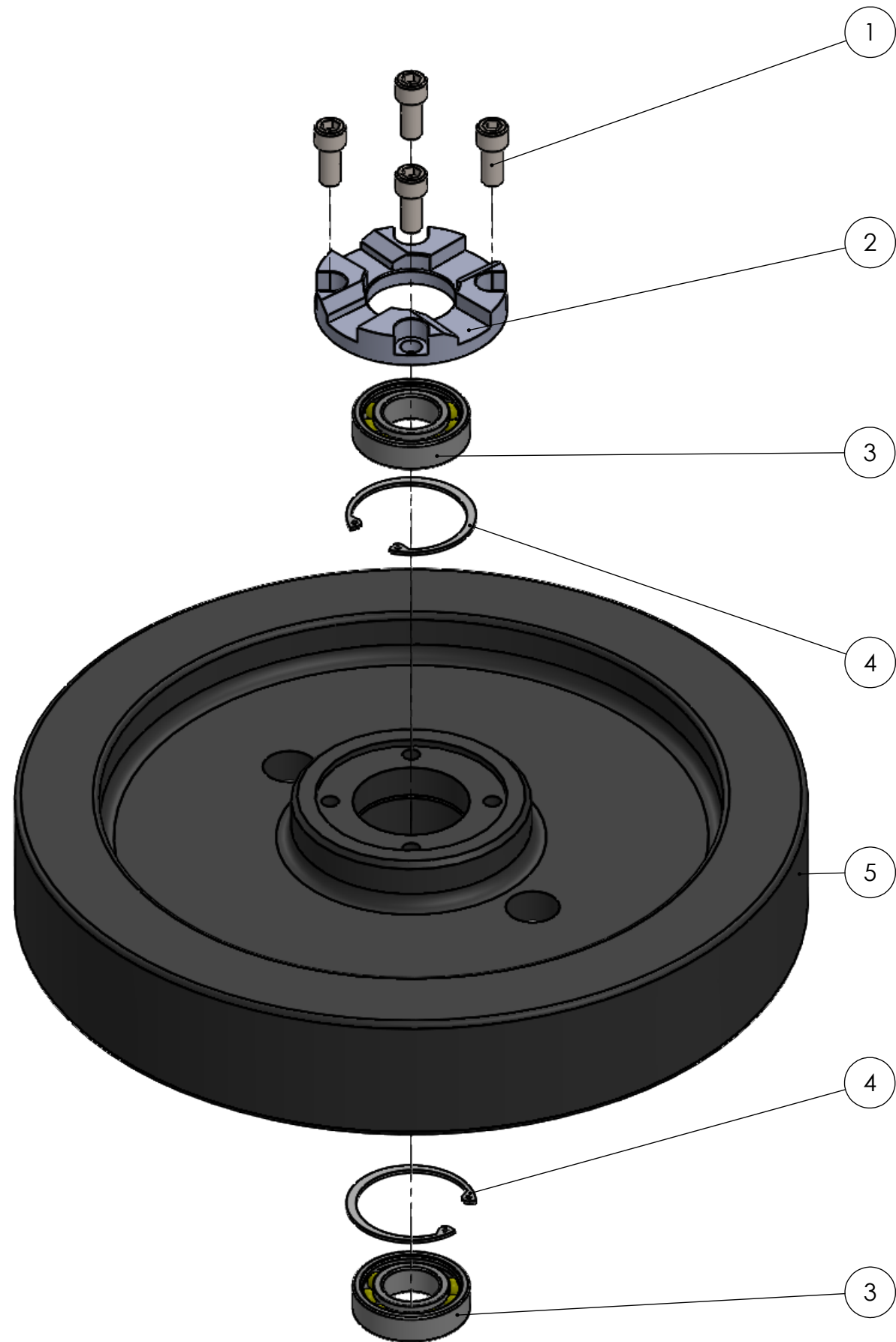
DESCRIPTION  
6T RAM ASSEMBLY

CUSTOMER

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

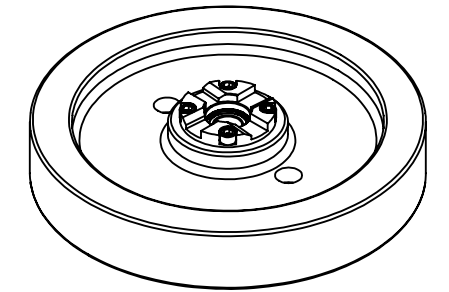
COMMENTS :

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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

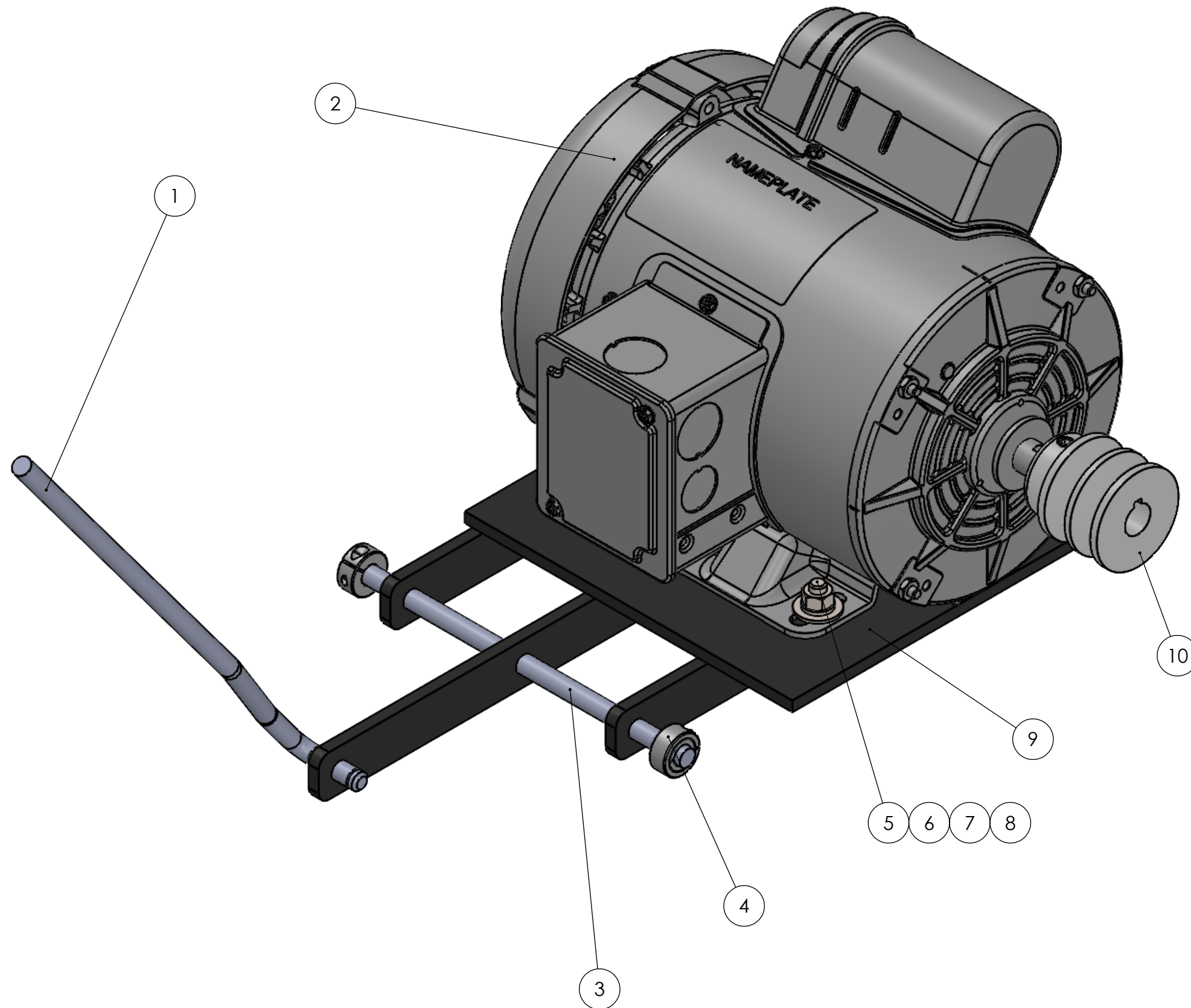
CUSTOMER

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

COMMENTS :

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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

DRAWN BY AZIMUTH MACHINERY	DATE 2018-04-04
ISSUED FOR	DWG. #

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