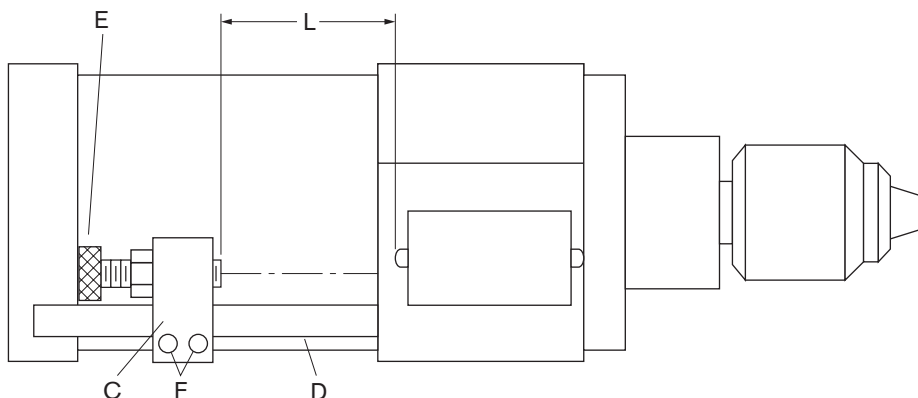
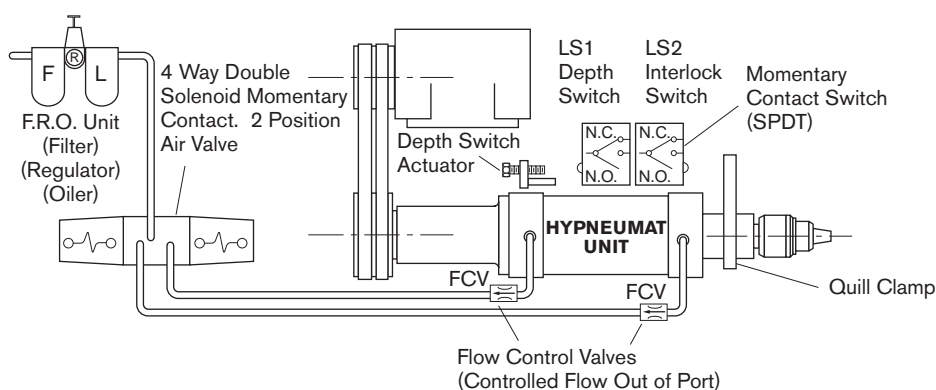


SET-UP INSTRUCTIONS UNITS WITH ELECTRIC STROKE CONTROL



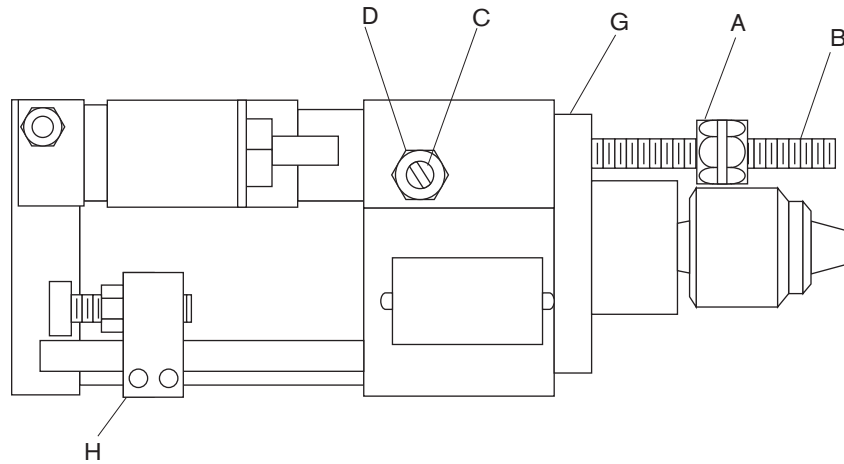
- Unit in Full Retract position, Interlock Switch is actuated (factory set).
- To set Depth Switch, loosen Lock Set Screws ("F") – Move Depth Actuating Cam ("C") along Actuating Rod ("D") for approximate Stroke Length ("L"). Lock Set Screws ("F"), Depth Adjusting Screw ("E") for Fine Depth Adjustment. Adjusting Screw is 28 pitch. (One turn equals .036").
- Overtravel Protection:**
200 Series Hypneumat Units – A Stop Collar is provided on actuating rod. Set Stop Collar to bottom against stroke control base just after Depth Switch is actuated.
300, 400 & 500 Series Hypneumat Units – Overtravel protection is built into the Depth Cam. Switches supplied are Single Pole-Double Throw. Double Pole-Double Throw Switches are available.

SET-UP PROCEDURE FOR DRILLING



- Adjust feed flow control valves to allow the tool to approach the work reasonably fast without excessive dive into part. Adjust retract flow control valve for fast retract but slow enough to prevent excessive hammer type action. Speed of a retract also effects chip removal.
- Hypneumat recommends that for most operations each unit be controlled by its own four-way air valve and regulator and that each system should be equipped with a filter and oiler. Flow control valves should be mounted adjacent to the port of the Hypneumat unit with controlled flow out of the port.

SET-UP INSTRUCTIONS UNITS WITH HYDRA-BRAKES



The Hypneumat Hydra-Brake is a self contained hydraulic cylinder with an adjustable feed rate through a Needle Valve. The Hydra-Brake is mechanically actuated by the Quill Clamp ("G") of the Hypneumat Stroke Control Assembly. The forward stroke of the Hydra-Brake is controlled through the needle valve ("C"). The return stroke of the Hydra-Brake is not restricted.

1. Set Depth Cam ("H") for proper stroke length. (See 02-SET-UP1).
2. Set Adjusting Nuts ("A") on Actuating Rod ("B") for actuation by Quill Clamp ("G") at the desired point of rapid stroke. Hydra-Brake is reset automatically by the Quill Clamp ("G") on the retract stroke of the Hypneumat unit. Actuating Rod ("B") is replaceable and can be cut off to suit.
3. The feed rate is determined by Needle Valve ("C"). (Slow Feed - Turn Clockwise) (Fast Feed - Turn Counter Clockwise)
4. Locknut ("D") secures Needle Valve setting.

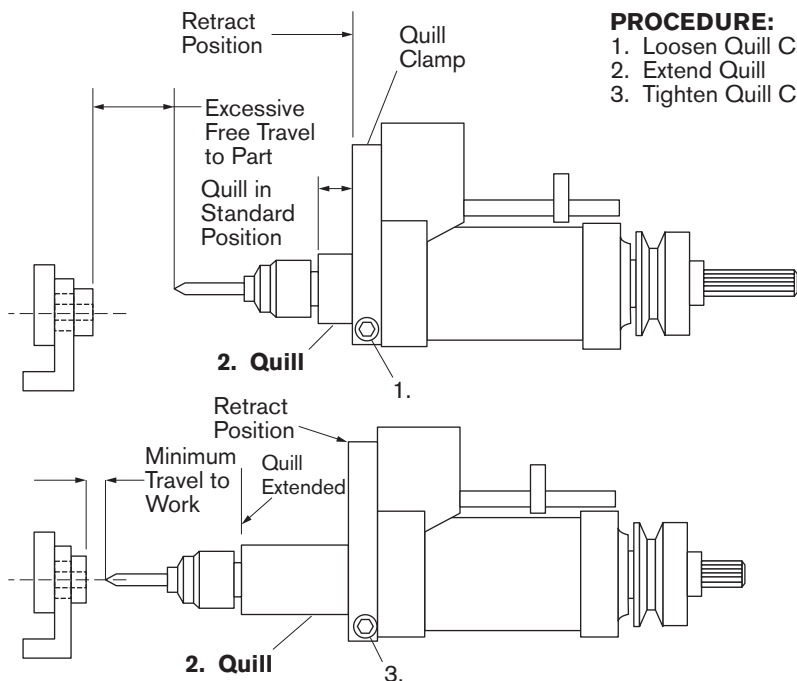
Maintenance consists of maintaining the oil level in Hydra-Brake.

QUILL ADJUSTING INSTRUCTIONS

To bring the drill or tap closer to the part without relocating unit, follow the steps outlined below. Extending the Quill eliminates excessive travel to the part being drilled or tapped. It also allows a closer radial grouping of several Hypneumat units.

NOTE: The distance the Quill is extended lessens the amount of usable stroke length of the unit.

EXAMPLE: Model 350 - 3 1/2" stroke unit - Quill extended forward 1", remaining stroke length is 2 1/2".



- PROCEDURE:**
1. Loosen Quill Clamp
 2. Extend Quill
 3. Tighten Quill Clamp