

JST

MP-CB (CE)

Operation manual



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Preface

The MP-CB (CE) pneumatic control box, when combined with the applicable presses gives a consistent terminating operation.

The suitable presses for use with the MP-CB (CE) are:

MP-2AW-RSD/RST
MP-2A-RSDC/RSTC
MP-2LW-RSTD
MP-2AW-RSV
MP-2AW-RSX
MP-2A-RSVC
MP-2LW-RSX

YA-1A
YA-4A

Before using the MP-CB (CE) please read this manual to ensure that you are familiar with its operating controls.

We recommend that you keep this manual near the control box for future reference.

This equipment complies with relevant **CE** Directives for incorporation with other machinery.

WARNING

This unit must only be used with a suitable dry pneumatic supply. Do not operate this unit with any pneumatic tubing disconnected.

CAUTION

Please ensure the appropriate tooling has been selected for the job it is being used for and that it is securely located.

2. Specifications

Model: MP-CB (CE)

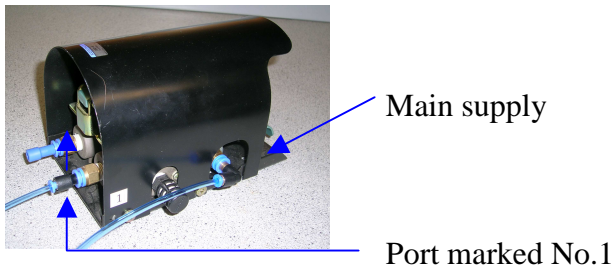
Dimensions (mm): 200(H) x 130(W) x 320 (D)

Weight: 4kg

Air supply: 75 – 100 Psi

3. Connecting the control box to the MP termination press

1. Footswitch – Connect pipe No.1 from the control box to port marked No.1 on the footswitch. Connect pipe No.2 from the control box to the main air to the footswitch connection.



2. Carriage sensor – Connect pipe No.3 from the control box to the lower connection on the carriage sensor. Connect pipe No.4 from the control box to the upper connection on the carriage sensor.



3. Connecting the control box to the MP termination press

3. MP press connection – Connect pipe No.1 from the control box to the No.1 connection on the MP press cylinder.
Connect pipe No.2 from the control box to the lower connection on the press.

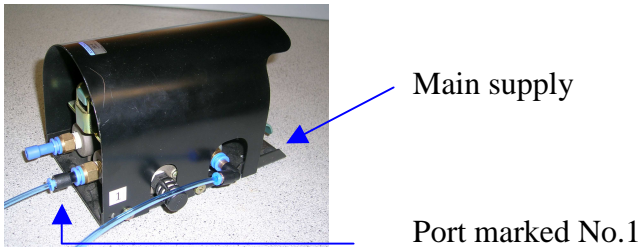


4. Connect the main air supply to the control box and check the air pressure is 75 – 100 Psi.



4. Connecting the control box to a MP cover fitment press

1. Footswitch – Connect pipe No.1 from the control box to port marked No.1 on the footswitch. Connect pipe No.2 from the control box to the main air to the footswitch connection.



2. Carriage sensor connection – There is not a carriage sensor on the cover fitment presses. Connect the small length of 4mm pipe into No.3 and No.4 carriage sensor connections on the control box.



4. Connecting the control box to a MP cover fitment press

3. MP press connection – Connect pipe No.1 from the control box to the No.1 connection on the MP press cylinder. Connect pipe No.2 from the control box to the lower connection on the press.

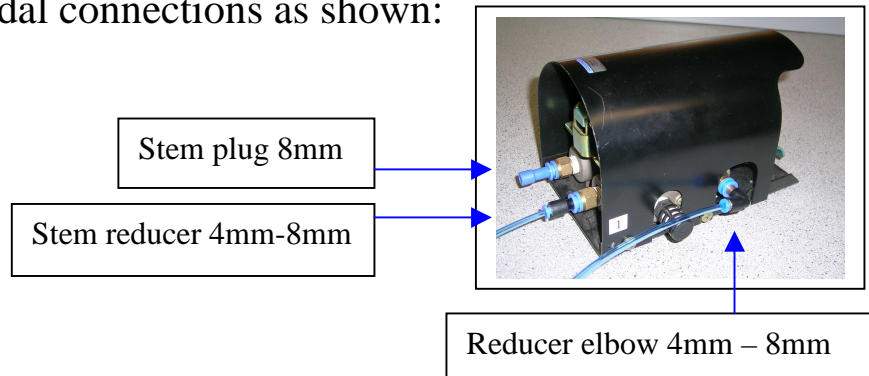


4. Connect the main air supply to the control box and check the air pressure is 75 – 100 Psi.

Note: When the press is in standby waiting for termination there should be no air leaks. If anything appears to be working abnormally check all connections are correct or see the trouble shooting section.

5. Connecting the control box to a YA tool

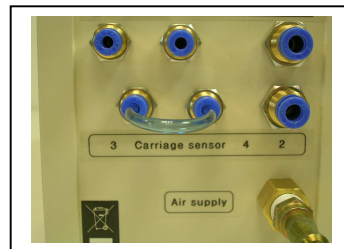
1. Fit the foot pedal connections as shown:



2. Connect the red port on the foot pedal to number 1 footswitch connection on the MP-CB(CE) control box.

3. Connect the main port (right angle connector) on the foot pedal to number 2 footswitch on the control box.

4. The carriage sensor should have a loop fitted between 3 and 4 as shown:



5. Connect the red port on the YA tool to press 1 on the control box.

6. Connect the black port on the YA tool to press 2 on the YA tool.

7. Connect the main air supply to the control box.

6. Air pressure adjustment

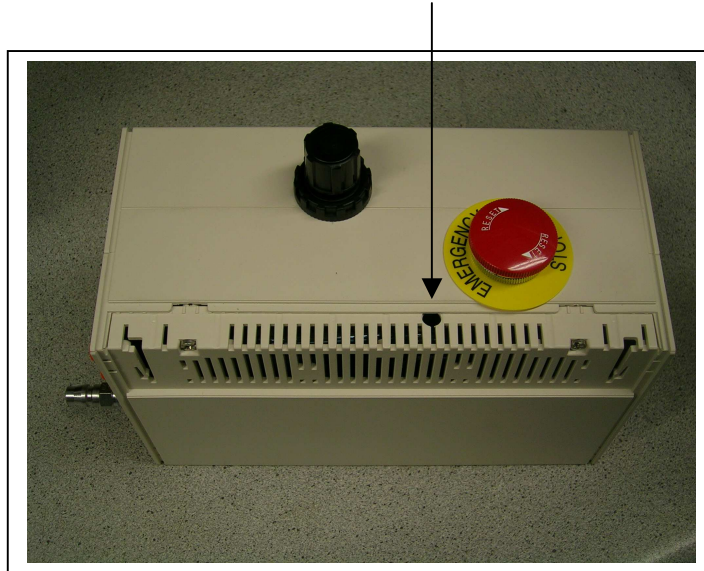
1. Move the air pressure control knob upwards, this will allow any adjustment that is required. Turn the knob to achieve the recommended air pressure, push it back downwards to lock the adjustment.



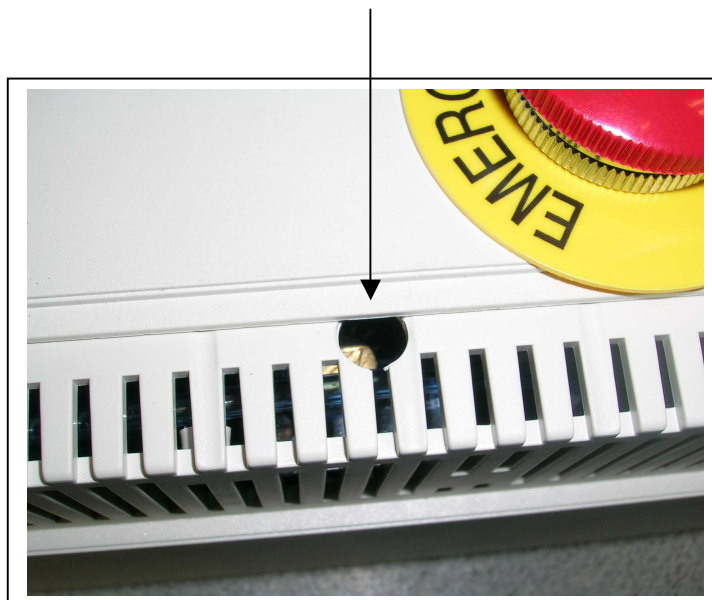
Air pressure = 75 – 100 Psi

7. Timer delay adjustment

1. Slide the upper vent cover upwards and off.
2. On top of the control box is a small hole, in this hole is the screw to adjust the timer delay.



3. Turn the screw to adjust the timer delay. Turning the screw clockwise will increase the timer delay.



4. Refit the vent cover after adjustment is complete.

8. Counter

To reset the counter to zero press the blue button.

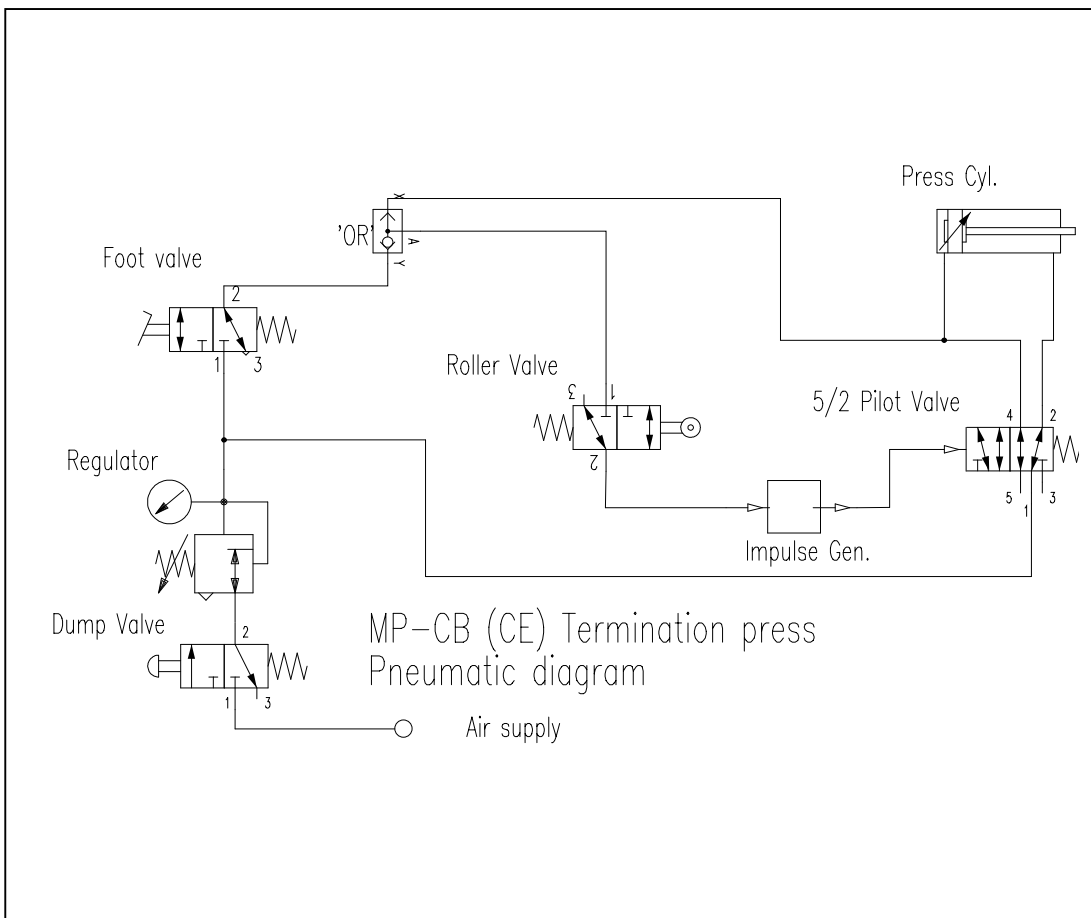


9. Trouble shooting

| Problem | Check |
|--|---|
| Air blows when the carriage or connector plate is not pushed to the terminating position. | Pipes No. 3 and 4 are connected into the correct carriage sensor positions on both the control box and the press. |
| All pipes are connected correctly and nothing happens when the foot switch is pressed. | The emergency switch button is pushed on. |
| The termination cycle completes when the connector plate is pushed forward to the carriage sensor. | Check that the foot switch is connected correctly. |
| The press ram is continually in the termination (down) position. | Check that the main cylinder pipes are connected correctly both at the press and at the control box. |
| An air leak from the foot switch stops leaking when the foot switch is operated. | Check the foot switch connections are correct at the control box. |
| There is no timed delay at the termination position | Check the air pressure. |
| The termination is insufficient | Check the air pressure. |
| The timer delay is inconsistent. | Check the foot switch and carriage pipes, they could be connected incorrectly. |

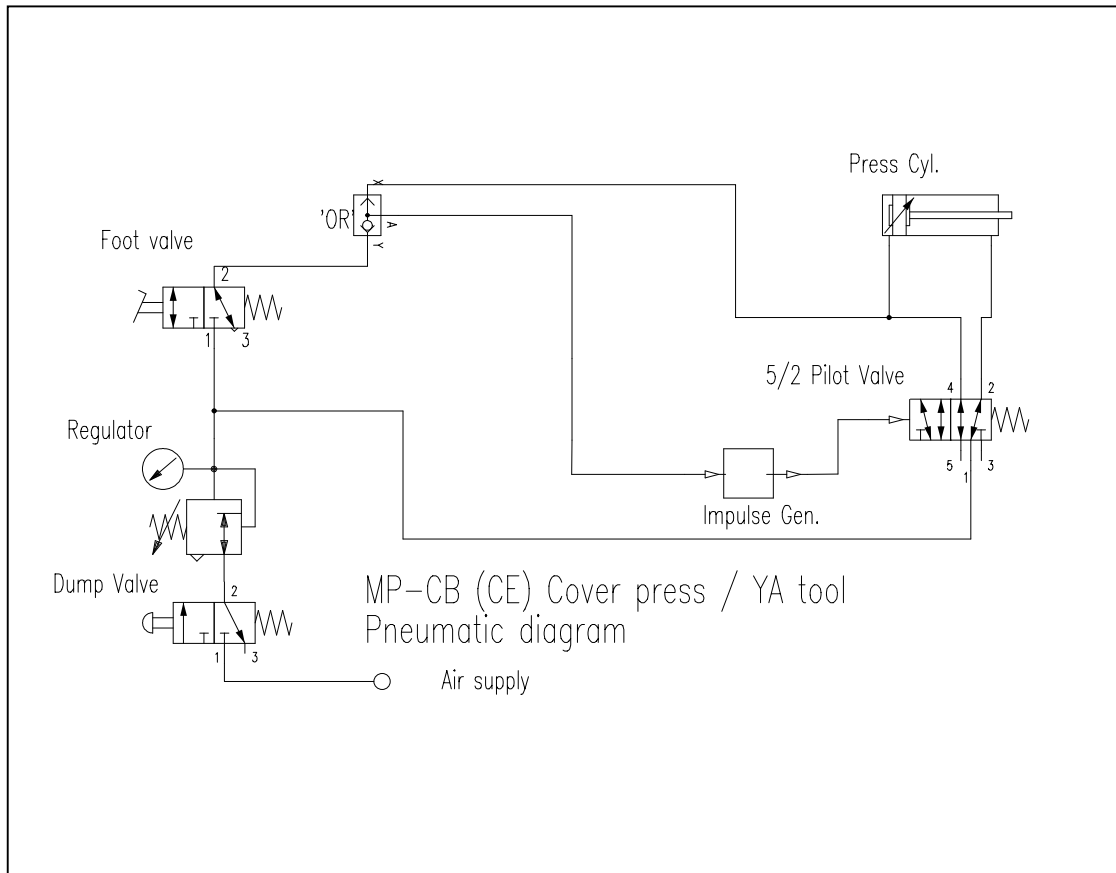
10. Pneumatic circuit diagrams

MP-CB (CE) used with MP termination press:



8. Pneumatic circuit diagrams

MP-CB (CE) used with a MP cover fitment press or a YA tool.



9. Parts list

Parts List For MP-CB (CE) Press Control Unit

| Item | Description | Part Number | Quantity | Control box location |
|------|----------------------------------|-------------|----------|---|
| 1. | Gauge 10bar 40mm panel mount | 4K8-10P | 1 | Front panel |
| 2. | Male connector 6mm – 1/8 | KQH06-U01 | 4 | Valve / dump valve connections |
| 3. | Bulkhead union 4mm tube | KQE04-00 | 3 | Rear panel connections |
| 4. | Bulkhead female 4mm-Rc1/8 | KQE04-01 | 2 | Rear panel / pressure gauge |
| 5. | Branch tee 6mm – 1/8 | KQT06-U01 | 1 | Pressure distribution / footswitch outlet |
| 6. | Union tee 6mm tube | KQT06-00 | 1 | Pressure distribution rear panel |
| 7. | Stem reducer 4mm-6mm | KQR04-06 | 2 | Valve and pressure distribution tee |
| 8. | Stem reducer 6mm-8mm | KQR06-08 | 2 | Rear of press, cylinder connections |
| 9. | Stem reducer 4mm-8mm | KQR04-08 | 1 | Output return from on footswitch |
| 10. | Stem plug 8mm | KQP-08 | 1 | Unused output on footswitch |
| 11. | Male run tee 6mm-uni1/8 | KQY06-U01 | 1 | Valve main cylinder connection tee |
| 12. | Straight union 4mm tube | KQH04-00 | 2 | Carriage sensor on base of press |
| 13. | Impulse generator 0-30 s | 81-507-720 | 1 | Inside case |
| 14. | Single sub base (din rail mount) | 81-532-104 | 1 | Inside case |
| 15. | 1/8 silencer | AN103-01 | 3 | Main valve and dump valve |
| 16. | Bulkhead union 6mm tube | KQE06-00 | 2 | Press connections – rear panel |
| 17. | Pilot spring valve (5/2) | SYA5120-01 | 1 | Main valve inside case |
| 18. | Plug in ‘or’ gate | 81-540-001 | 1 | On rear panel connections inside case |
| 19. | Push button mushroom | VM-30AR | 1 | Top panel |
| 20. | 3/2 plunger actuated valve | VM430-01-00 | 1 | Fitted to part 19 above |
| 21. | Regulator | AR20-F02 | 1 | Top panel |
| 22. | Nut | AR20P-260S | 1 | Regulator fixing nut |
| 23. | Bulkhead Union 6mm/1/4 | KQE06-02 | 1 | Main air inlet |
| 24. | ¼ Quick disconnect coupling | AC21CF02 | 1 | Rear panel |
| 25. | ¼ Quick disconnect coupling | ACA2593 | 1 | Supply hose to control box |
| 26. | ¼ Hose fitting | 25802 | 1 | Supply hose to control box |
| 27. | Case | 338-1087 | 1 | ----- |
| 28. | Emergency stop legend plate | K2-P550-4 | 1 | Top of case |
| 29. | Male connector 8mm – ¼ | KQH08-U02 | 1 | Footswitch supply connector |
| 30. | Reducer elbow 4mm – 8mm | KQL04-08 | 1 | Footswitch supply connection |
| 31. | Male connector 6mm – ¼ | KQH06-U02 | 2 | Pressure regulator connections |
| 32. | Male elbow 4mm – M5 | KQL04-M5 | 1 | Valve connection |
| 33. | Male elbow 4mm – 1/8 | KQL04-01S | 1 | Pressure gauge outlet on regulator |
| 34. | Counter | 0731 101 | 1 | Front panel |
| 35. | Microswitch | 321-600 | 1 | Inside case |