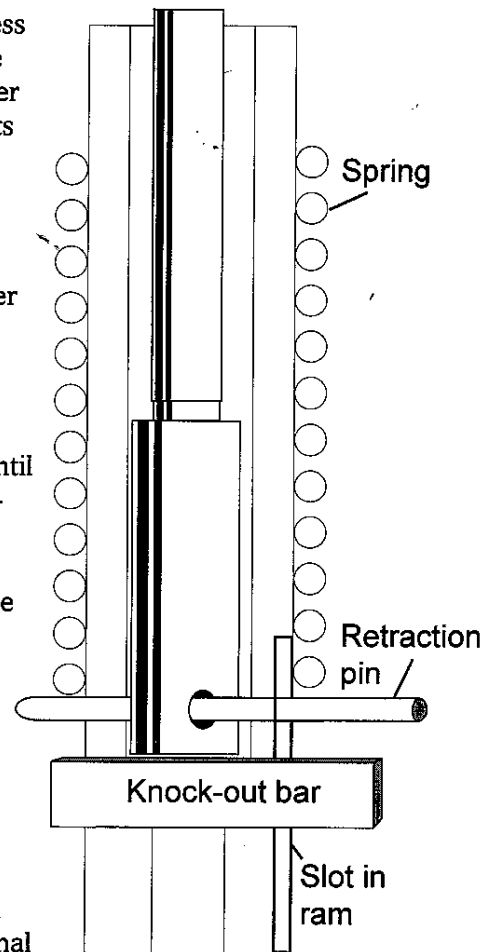
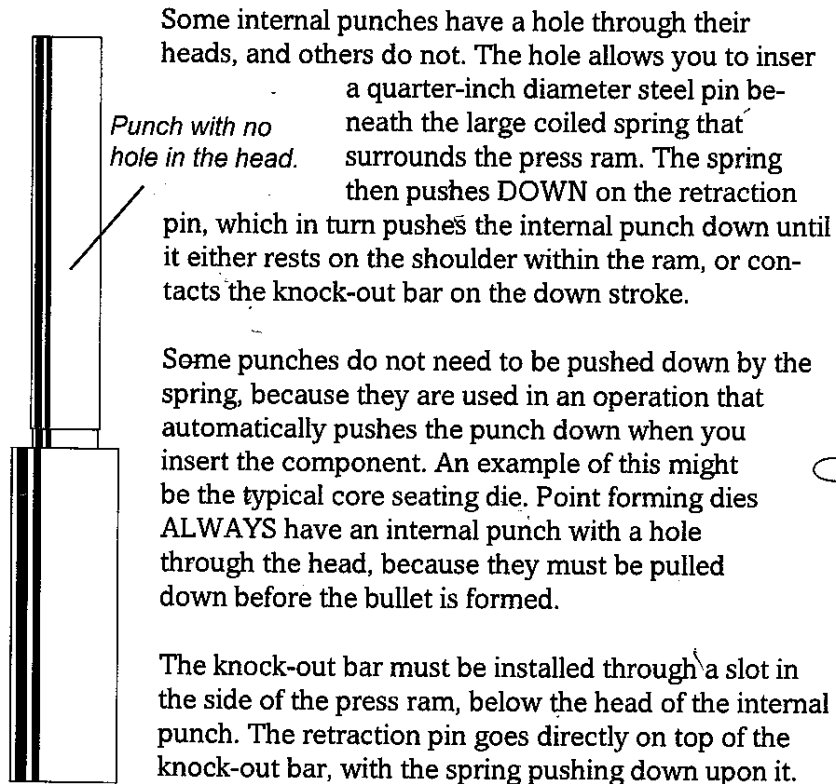


RETRACTION PIN and EJECTION BAR Installation:

Swaging dies for the CHP-1 Hydro-Press and CSP-2H Hydraulic Mega-Mite presses screw directly into the press RAM (not the press head, as with reloading dies). The long punch which fits inside the die is called the "INTERNAL" punch. It comes to rest on a shoulder inside the ram on the upward stroke. (The "EXTERNAL" punch fits into the "Floating Punch Holder", which in turn screws into the press head.)



To install the knock-out bar and the retraction pin, first put the internal punch into the ram. Then turn on the press and move the ram upward (Energize and UP buttons held down) until the spring is loose. When you can move the spring up and down by hand, put the knock-out bar through the slot in the ram below the spring. Then, align the hole in the internal punch head with the slot in the side of the ram, and push the retraction pin through the slot and the hole, below the lowest coil of the spring. Do NOT insert the pin through any adjacent spring coils!

The knock-out bar, or ejection bar, is what stops the internal punch from continuing down with the die and ram once the bar comes to rest on top of the lower press mounting plate. It stops, forcing the internal punch upward against spring pressure on the retraction pin. The lower ram position sensor must be set so that the press stops (red light on the sensor comes on) just as the punch end comes to the top of the die and pushes out the component: make sure the spring is not completely compressed or it will be ruined. There should be some space between coils even at the lowest useful position.