

## FORGE PRESSURE SWITCH CALIBRATION

The forge pressure switch calibration should be checked periodically to ensure accuracy. The forge pressure switch and trip screw are located on the lever mount block and lever respectively, and are accessed by removing machine's the top cover.

- 1) Remove the left cover from the front of the machine.
- 2) Enter into the SETUP mode.
- 3) Set the timing for around 0.150".
- 4) JOG the cam from weld start until the cam follower is lined up with the cam's timing mark.
  - a) If the machine beeps during step 4 then the forge pressure switch calibration is very early. Proceed to step 7.
  - b) Otherwise proceed to step 5.
- 5) JOG the cam SLOWLY, by quickly tapping the ADVANCE button, from the timing mark toward the drop-off until the machine beeps, then stop immediately.
- 6) The cam follower should be lined up with the cam about 1/16" above the drop-off right when the machine beeps.  
(See Cam Diagram)
  - a) If the forge pressure is calibrated, proceed to step 10.
  - b) Otherwise proceed to step 7.
- 7) Remove the top cover from the machine, if it is not already.
- 8) Adjust the trip position, if necessary, by turning the trip screw.
  - a) CW causes the forge pressure to trip sooner.
  - b) CCW causes the forge pressure to trip later.
- 9) Recheck the calibration from step 4.
- 10) Make sure the trip screw lock nut is tight. If it is not, tighten it, then recheck the calibration from step 4.
- 11) Replace the top cover on the machine.
- 12) Replace the left cover on the front of machine.
- 13) Exit out of SETUP mode.
- 14) The forge pressure switch is now calibrated.

