

Procedure for testing the integrity of the Festo and Numatics valve stacks:

1. Disconnect the Injection Cylinder Clevis from the Injection Lever; let the Injection Cylinder lean back clear of the Injection lever as shown in the picture.



Injection Cylinder

2. Configure the machine to normal run conditions, i.e.: Control in run, Injection enabled.
3. Press the red E-Stop button on either the Operator Station or on the Swing Pendant, this will exhaust all air in the machine.



4. Observe if there is any advance of the Injection Cylinder Rod.
5. Disengage the E-Stop and press the Control On button, repeat steps 2 to 4 a number of times to be sure there is no movement of the Injection Cylinder Rod.
6. If movement is detected please see the appropriate procedure for repairing the type of valve stack present in you machine (enclosed).

Procedure to replace the Isolation Discs in a Numatics Valve Stack:

1. Switch the Machine's Main Electrical Disconnect to the off position.



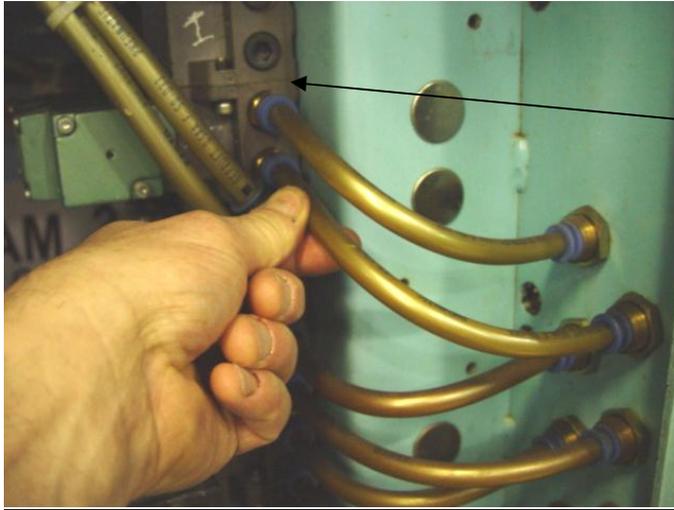
Main Electrical Disconnect

2. Close the Machine's Main Shut Off Air Valve and, if possible, disconnect the compressed air source to the machine.



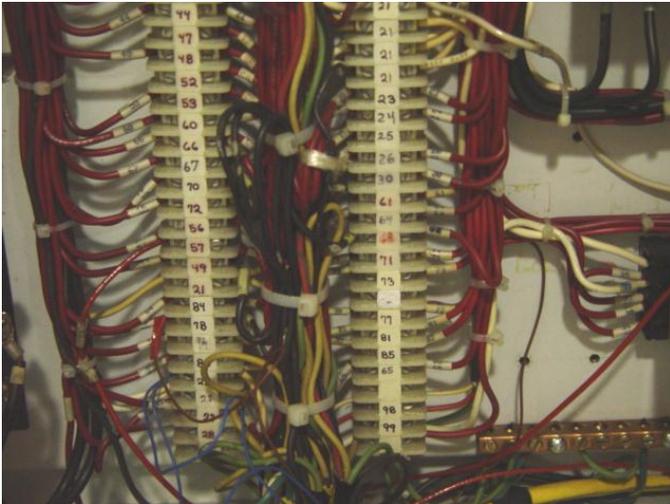
Main Shut Off Air Valve

3. Disconnect all of the air lines that are attached to the Numatics Valve Stack. Make a diagram or take pictures to make reconnecting easier.

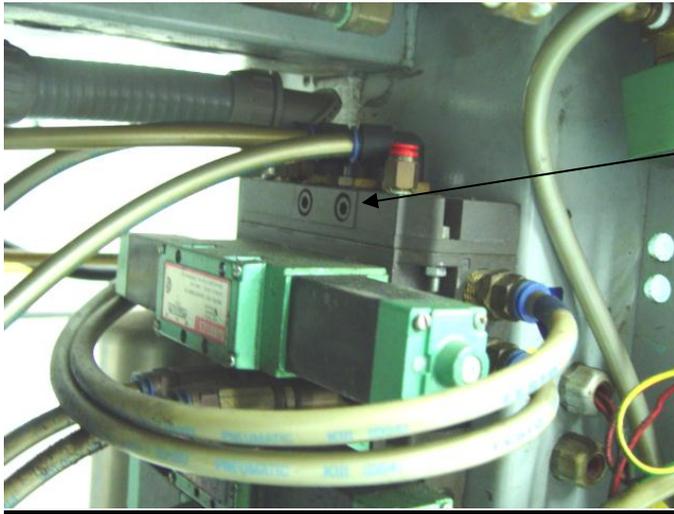


Valve Stack

4. Locate the electrical supply and signal wires to the valve stack and disconnect from the terminal blocks in the machine Electrical Cabinet. Check the wire numbers are in place on the wires.

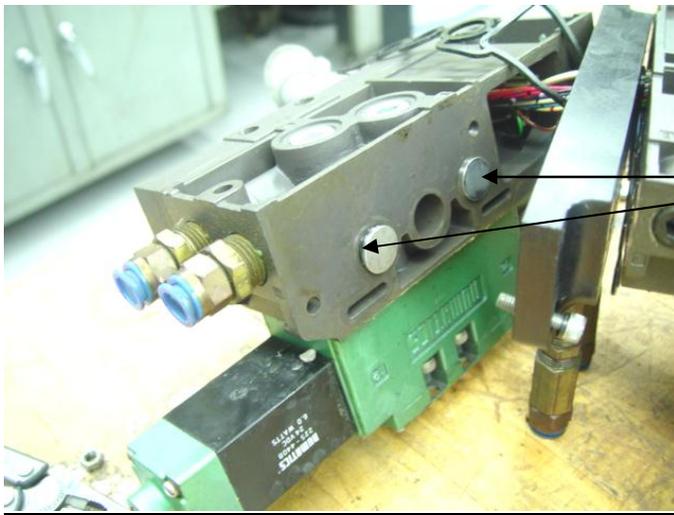


5. Remove the 4 socket head cap screws that mount the valve stack to the machine frame, there are 2 screws on the top and 2 on the bottom of the stack.



Mounting Screws

6. Remove the valve stack and place it on a work bench.
7. Separate the valve stack at the position just below the Injection Valve.
8. Locate the Isolation Discs in the valve sub base and replace as necessary.



Isolation Discs

9. Reassemble the valve stack and replace in machine frame, reconnect air lines and electrical connections.
10. Connect air supply to machine and turn the main electrical switch to on.
11. Perform the **'Procedure for testing the integrity of valve stack'** to ensure the repair was successful.

Procedure to replace the Festo Sub-Base with a Festo Sub-Base equipped with a Blanking Plate in the Exhaust Port.

1. Switch the Machine's Main Electrical Disconnect to the off position.



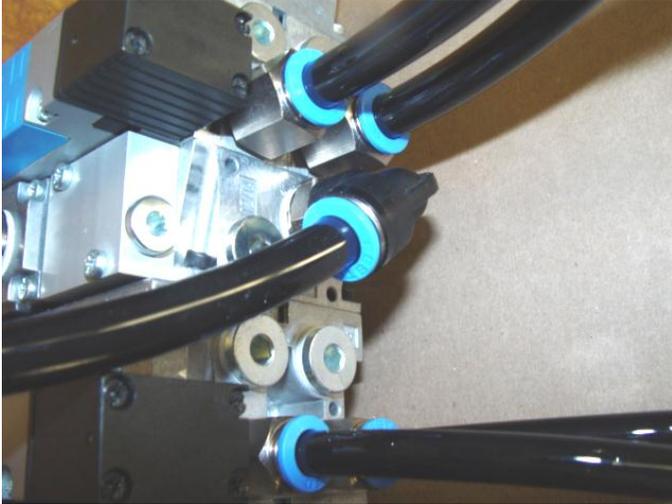
Main Electrical Disconnect

2. Close the Machine's Main Air Valve and, if possible, disconnect the compressed air source to the machine.

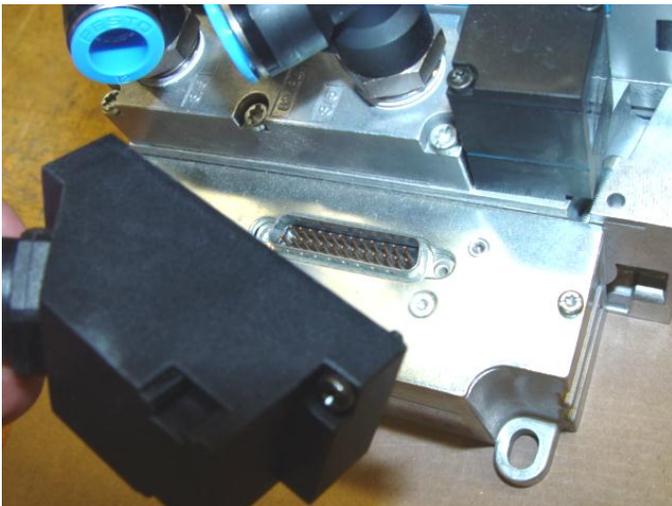


Main Shut Off Air Valve

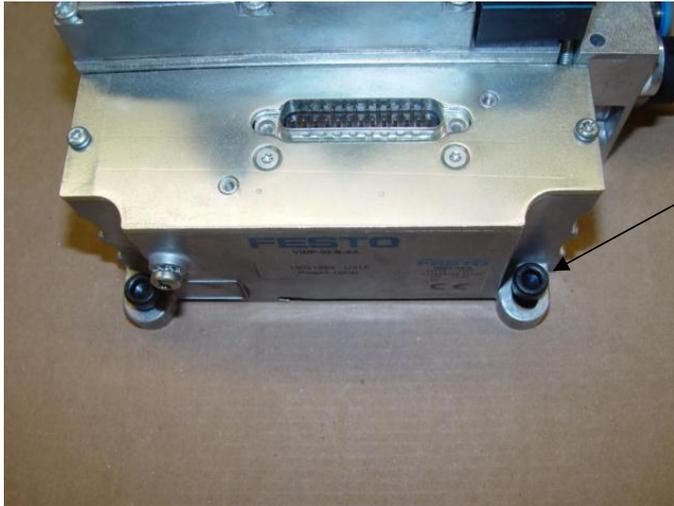
3. Disconnect all of the air lines that are attached to the Festo Valve Stack. Make a diagram or take pictures to make reconnecting easier.



4. Disconnect the electrical connector from the bottom of the valve stack.

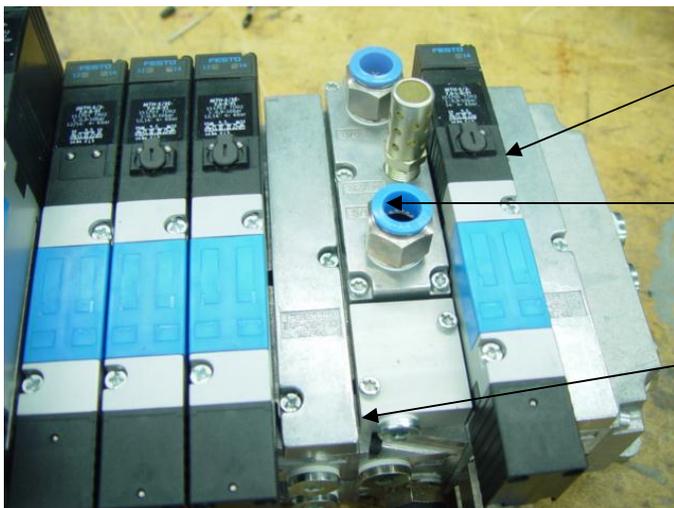


5. Remove the 4 socket head cap screws that mount the valve stack to the machine frame.



Mounting Screws

6. Remove the valve stack and place it on a work bench.
7. Remove the sub-base at the position just below the Injection Valve Exhaust Ports.

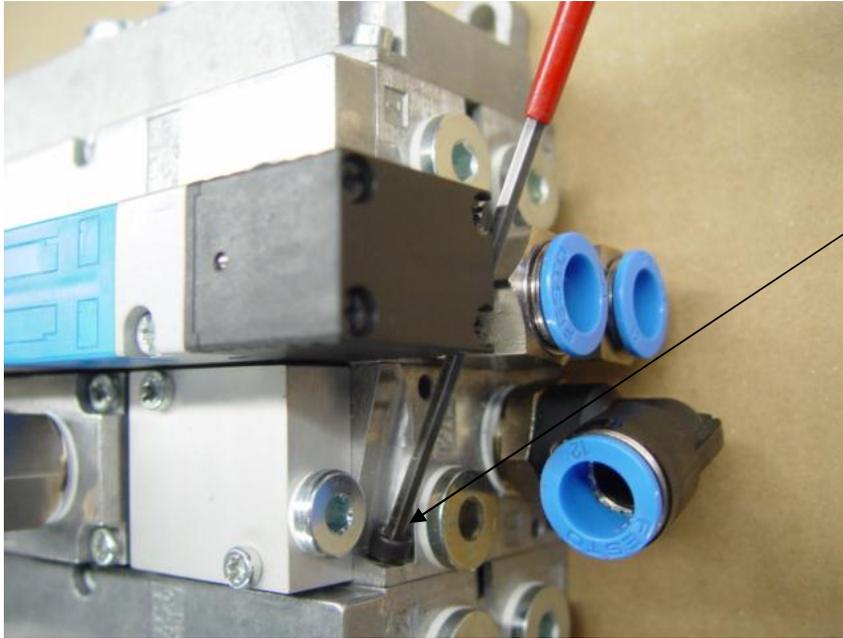


Injection Valve

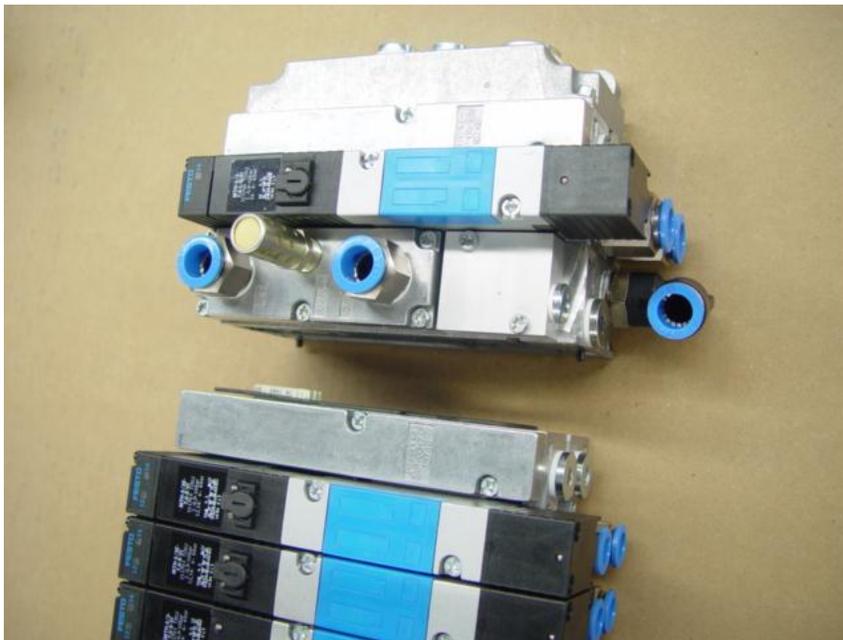
Exhaust Ports

Separate Here

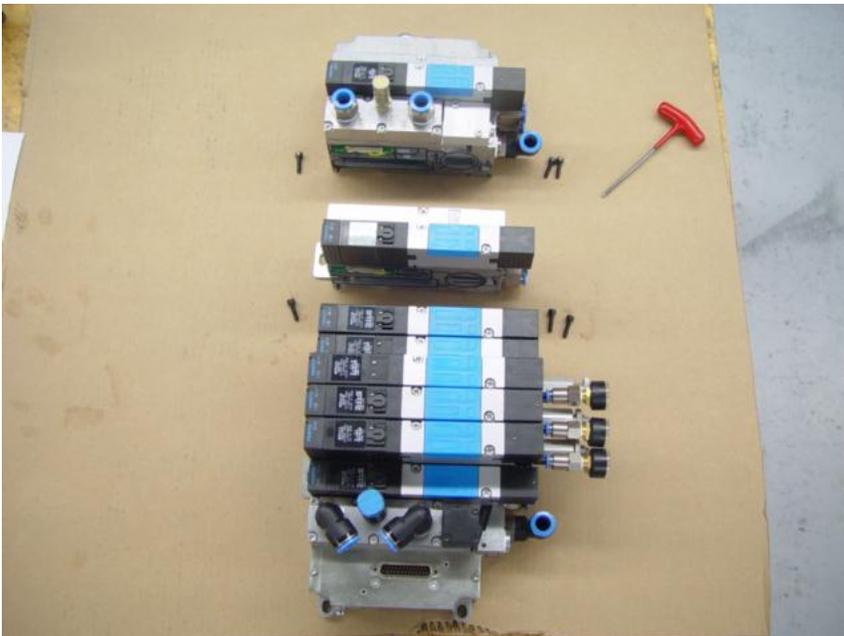
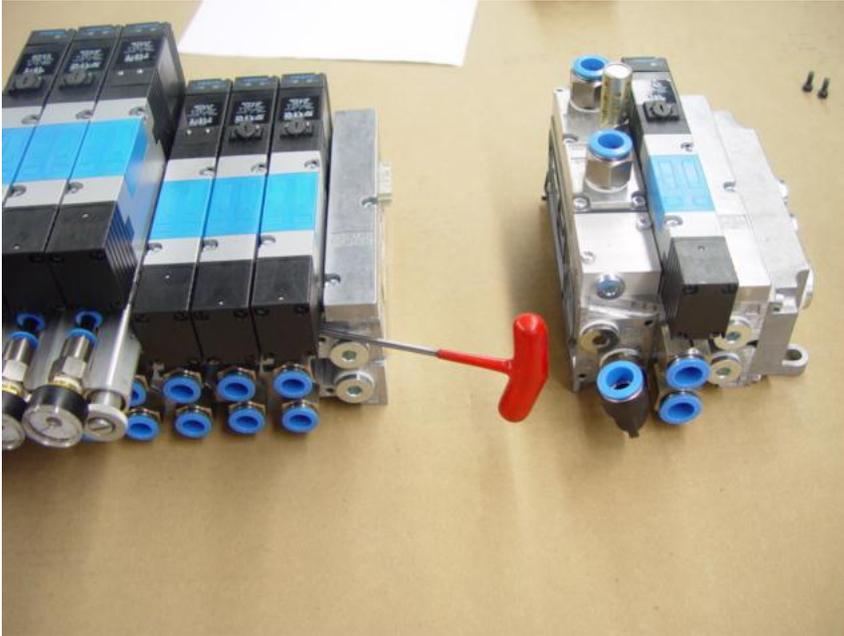
8. Remove the 3 socket head cap screws that hold the sub-bases together.



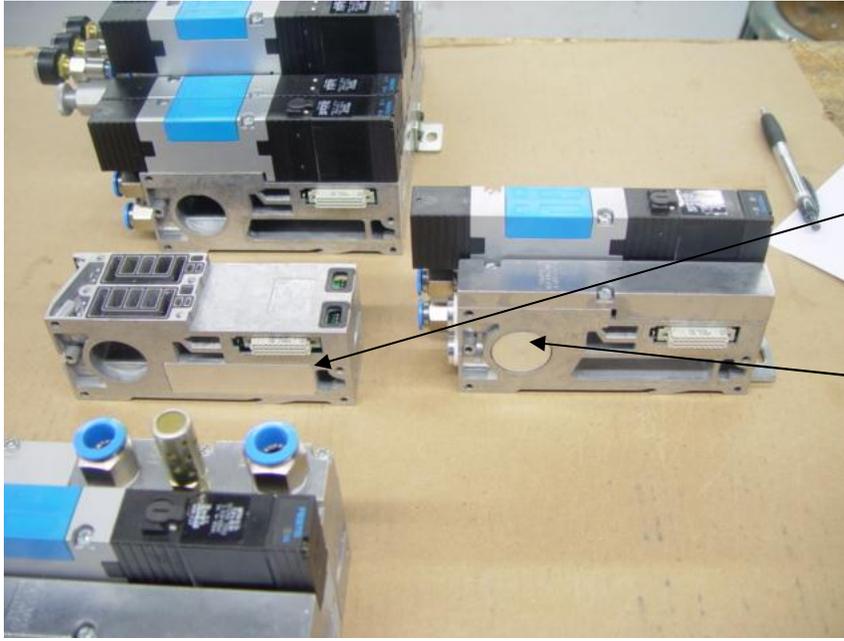
Socket head cap screw



9. Remove the 3 socket head cap screws from the next section of sub-base; this is the sub-base you will be replacing.



10. Place the new sub-base with the Exhaust Blanking Plate in the position of the sub-base you have just removed. Transfer the round Pressure Blanking Plate from the sub-base just removed to the new sub-base you are installing.



Exhaust Blanking Plate

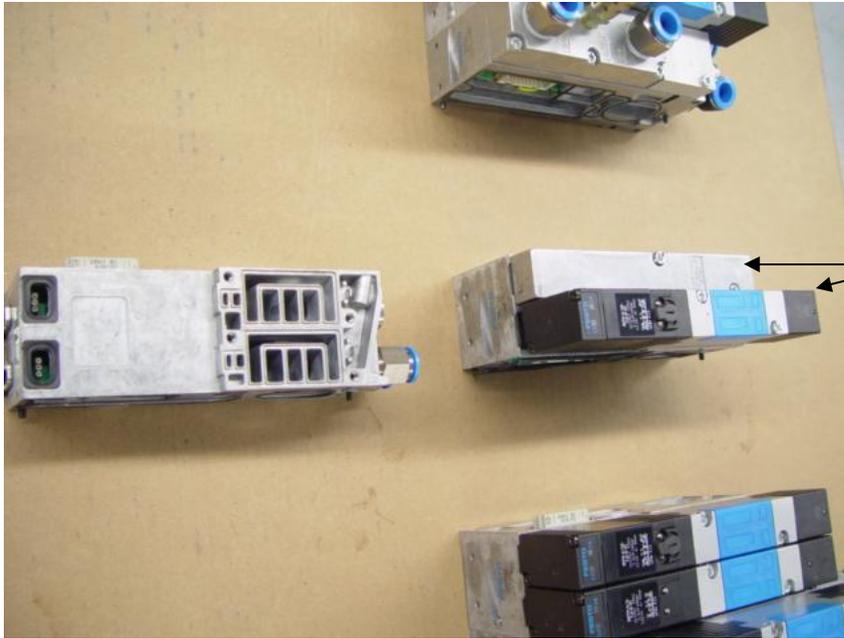
Round Pressure Blanking Plate

11. Transfer the valve and the cover plate from the sub-base you have just removed and install it on the sub-base with the new Exhaust Blanking Plate.



Cover Plate

Valve



Valve and Cover Plate installed on sub-base with Exhaust Blanking Plate

12. Re-assemble the valve stack and replace in machine, reconnect the air lines and electrical connections.
13. Connect air supply to machine and turn the main electrical switch to ON
14. Perform the **Procedure for testing the integrity of the valve stack** to ensure the repair was successful.

