**Press Specifications: Woven**

# Back Gauge

* .054 and Below
  + Double fold at 311/16 -hook at 315/16
* .072 to .120
  + 313/16
* .148 to .225
  + 37/8
* .243
  + 315/16
* .312 to .500
  + 41/8
* .625 & .750
  + 41/4

# Settings

* High
  + 1.7 (lower) to 1.5 (higher)
* Slow
  + .148 and below
    - 4
  + .162 & up
    - 3.5 (.312 can be at 4 if < 80” long & 60” wide)
* Bend
  + Below .072
    - 4.4
  + .072 to .120
    - 4.35
  + .148
    - 4.3
  + .162 & .177
    - 4.275
  + .192 & .225
    - 4.25
  + .234 & up
    - 4.22
  + U-Hooks:
    - 6.2
    - Flex-Mat: 4.55 for the double fold

**\*\*\* FOR U-HOOKS, SEE HOOKING CHART FOR BACK GAUGE MEASUREMENTS \*\*\***

**\*\*\* GENERALLY, 2” BG + TICKNESS OF WIRE (6-HOOKS) \*\*\***

**SH-1 Specifications: Woven**

# Finger Length

* 5” Shrouds
  + .120 & below
    - No fingers
  + .148
    - 2 ¼ to 2 ¾
* 6” Shrouds
  + .162 to .243
    - 2 ¾ + opening
* 7” Shrouds
  + .312 & .362
    - 3” + opening
* 9” Shrouds
  + 4.5” + opening
* 1 Hooks
  + .500 & up
    - Opening + 1”
* U-Hooks
  + 6” + opening

\*Generally, use shorter fingers if math puts you within 3/16 of maximum due to bowing.

**\*\*\* FOR ALL OTHER SPECIFICATIONS, SEE HOOKING CHART \*\*\***

**SH-2 Specifications: Flex-Mat**

# Finger Length

* Single Folds:
  + Green tables
  + .105 wire diameter & larger
  + Move back gauge to forward position
    - Double check 21/4 length
* Double Folds
  + Blue tables
  + .092 wire diameter & smaller
  + Move back gauge to back position
    - Double check 23/4 length

\*\*\* **ALWAYS MAKE SURE TO USE PROPER BLADE SPACING – SEE CHART ON SIDE \*\*\***

**DF-1 Procedures**

# Startup & Operation

At the beginning of each shift:

* Operator performs startup procedure
* Assistant operator stocks shroud rack

Startup

1. Check die bolts under RAM for tightening
2. Check all 3 position sensors (strings) for breaks/wear
3. Make sure all tools are present on shadow-board
   * If any are missing, inform the supervisor
4. Turn on machine
5. Move top switch into Manual Mode (right position)
6. Move bottom switch into Hold Down Up
7. Move RAM level with the die/table to check alignment
   * E-Stop in place and inspect on both sides
   * Call maintenance if X-axis or Y-axis need re-alignment
8. Make sure values are displayed under X-axis & Y-axis
   * If any are at 0.000 when aligned with die, call maintenance

Operation

1. Move top switch back into Automatic Mode (left position)
2. Load appropriate setting
   * 02REG: .105 & larger wire diameter
   * 03DUB: .092 & smaller wire diameter
3. With both operator and assistant operator watching movement:
   * Home & cycle machine with one hand on magnetic E-Stop **twice**
4. If motion is safe after second cycle, begin operation
5. If RAM appears it will hit something, E-stop and repeat Step 3
6. Repeat each time settings are changed.

**\*\*\*ALWAYS WATCH FOLD WITH HAND ON E-STOP TO ENSURE USUAL OPERATION\*\*\***