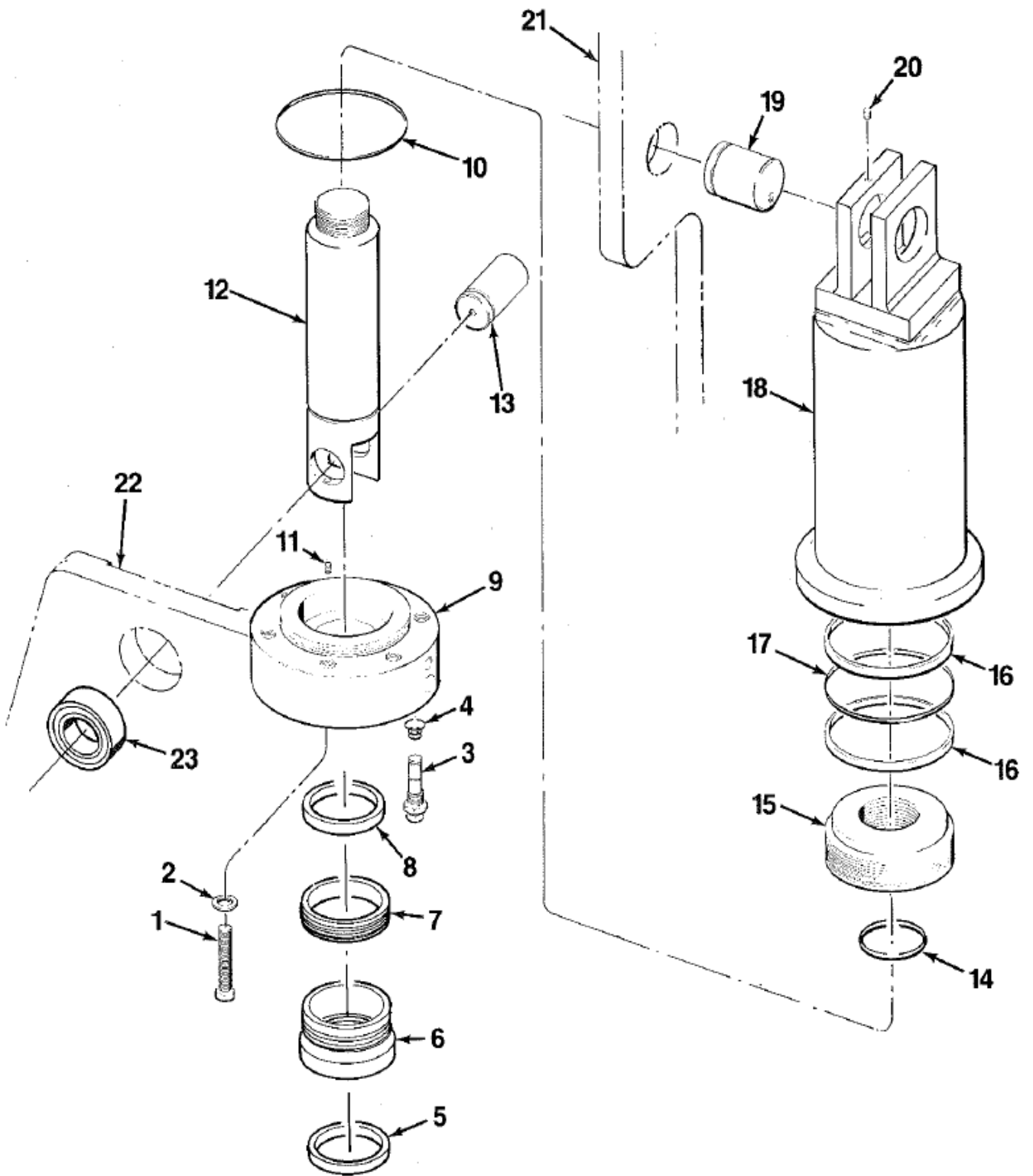


FRAME

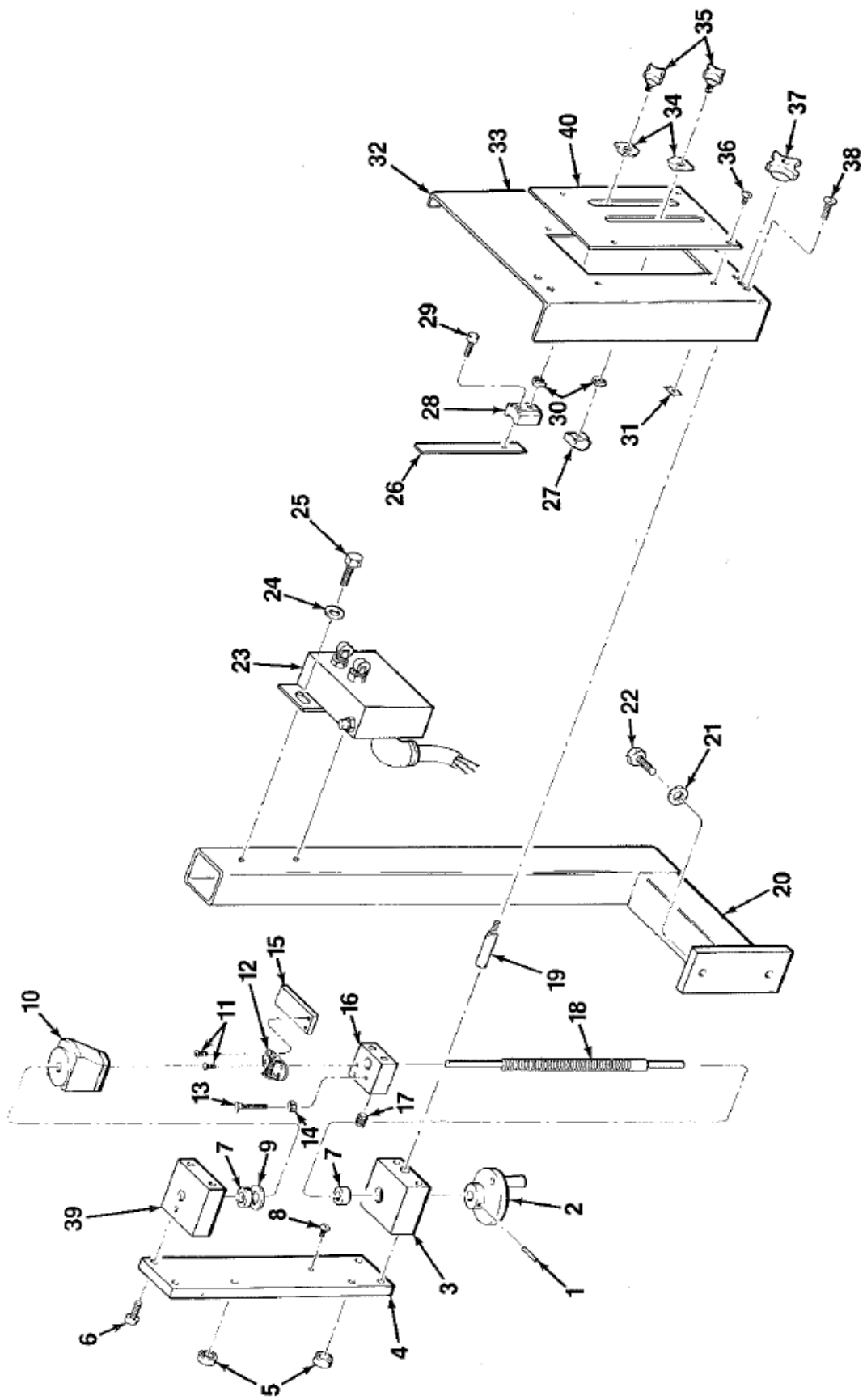
- | | |
|------------------------|--------------------------|
| 1. Screw | 20. Limit Switch Bracket |
| 2. Gib Plate Spacer | 21. Nut |
| 3. Gib Mounting Plate | 22. Threaded Stud |
| 4. Shim | 23. Adjusting Block |
| 5. Gib Liner | 24. Socket Head Screw |
| 6. L.H. Gib | 25. Hex Head Screw |
| 7. Screw | 26. Pivot Block Retainer |
| 8. Socket Head Screw | 27. Pivot Block |
| 9. Socket Head Screw | 28. Pivot Shoe |
| 10. Hydraulic Cylinder | 29. R.H. Gib |
| 11. Frame | 30. Gib Mounting Plate |
| 12. Reservoir Cover | 31. Gib Plate Spacer |
| 13. Manifold Assembly | 32. Ram |
| 14. Shroud | 33. Spring |
| 15. Pressure Gage | 34. Clamp Bar |
| 16. Socket Head Screw | 35. Bushing |
| 17. Microswitch | 36. Washer |
| 18. Hex Head Screw | 37. Hex Head Screw |
| 19. Washer | 38. Screw |



CYLINDER

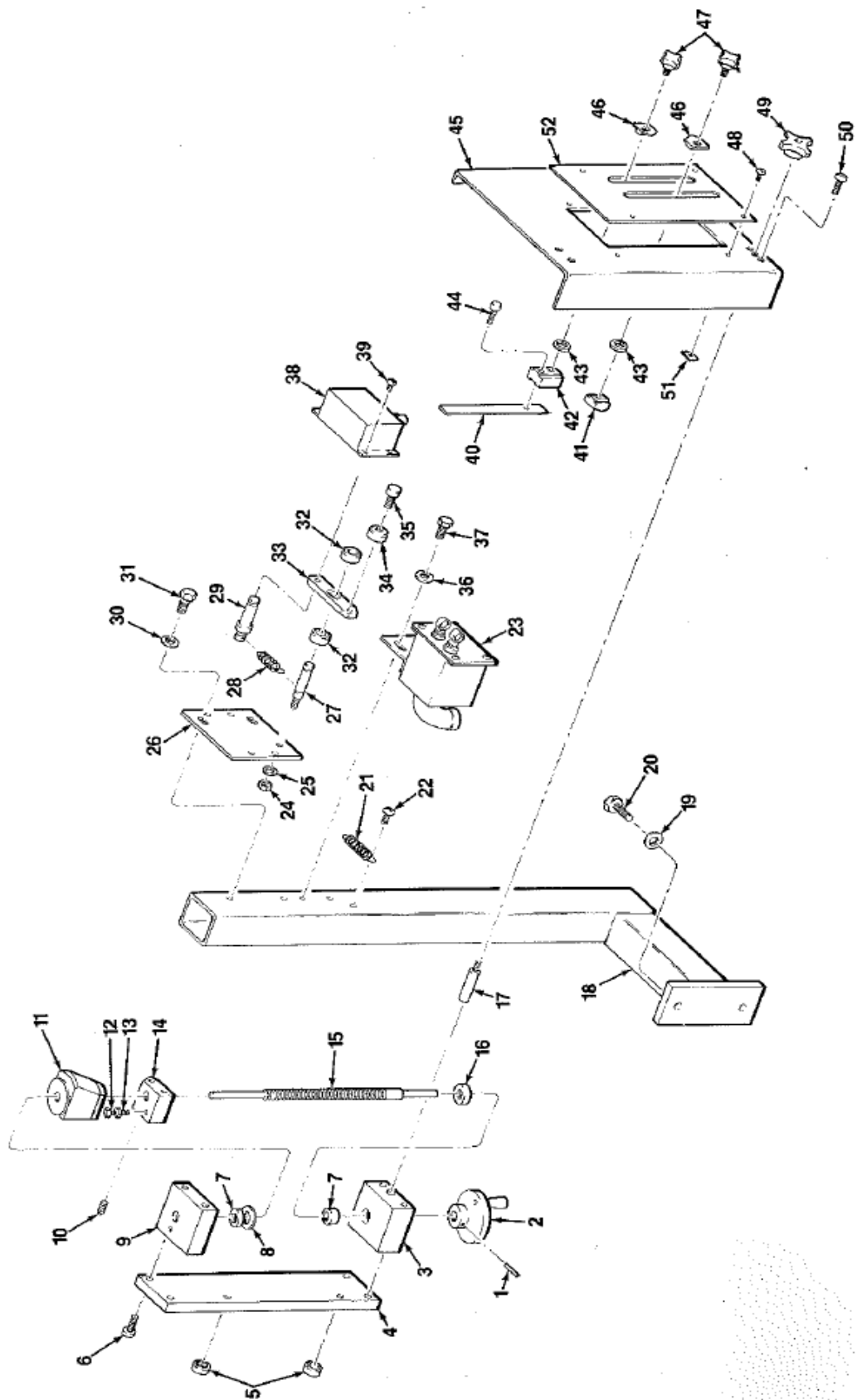
- | | |
|-----------------------------------|---------------------------|
| 1. Hex Head Bolt | 13. Ram Clevis Pin |
| 2. Flat Washer | 14. O-Ring |
| 3. Counterbalance Valve L.H. only | 15. Piston |
| 4. O-Ring Set L.H. only | 16. Bearings |
| 5. Wiper Ring | 17. Piston Seal |
| 6. Packing Nut | 18. Body Assembly |
| 7. Vee Packing | 19. Cylinder Mounting Pin |
| 8. Rod Bearing | 20. Set Screw |
| 9. Head Flange | 21. Housing |
| 10. O-Ring | 22. Ram |
| 11. Set Screw | 23. Spherical Bearing |
| 12. Rod Assembly | |

Specify L.H. or R.H. cylinder when ordering parts



STROKE & SPEED CONTROL - STYLE "A"

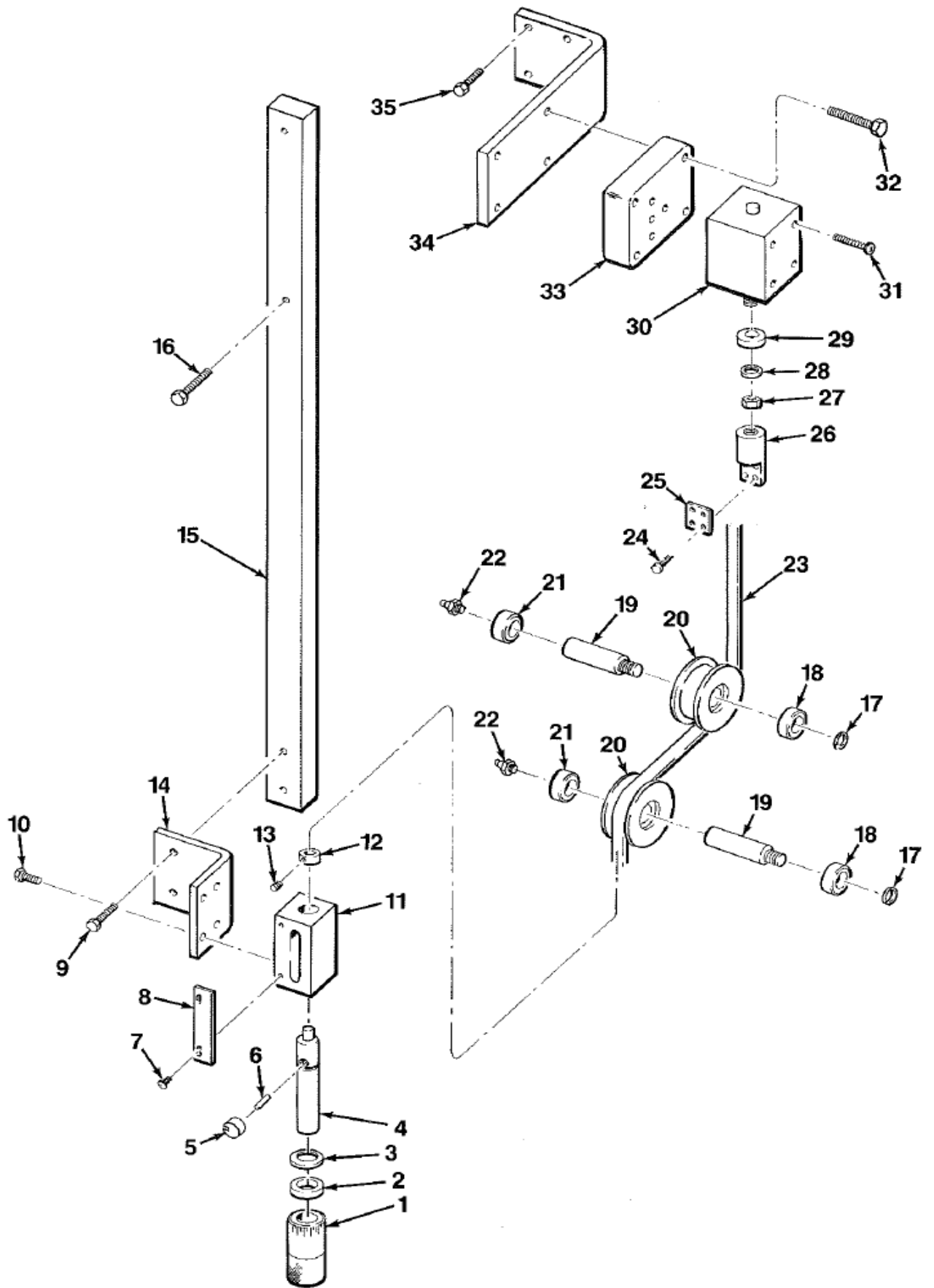
1. Roll Pin
2. Handle Wheel
3. Shaft Mounting Block - Lower
4. Limits Assembly Mounting Plate
5. Collar
6. Socket Head Screw
7. Bearing
8. Socket Head Screw
9. Retaining Ring
10. Indicator
11. Button Head Screw
12. Spring Hinge
13. Hex Head Capscrew
14. Hex Nut
15. Breakaway Plate
16. Bottom Stop Block
17. Ball Plunger
18. Bottom Stop Adjusting Screw
19. Clamp Bolt
20. Switch Enclosure Mounting Support
21. Washer
22. Hex Head Screw
23. Limit Switch Assembly
24. Washer
25. Hex Head Screw
26. Speed Change Cam
27. Top Stop
28. Speed Change Block
29. Socket Head Capscrew
30. Spring Washer
31. Cage Nut
32. Limits Assembly Guard
33. Cover Plate
34. Pointer
35. Handknob
36. Button Head Capscrew
37. Handknob
38. Button Head Capscrew
39. Shaft Mount Block - Upper
40. Cover Plate



STROKE & SPEED CONTROL - STYLE "B"

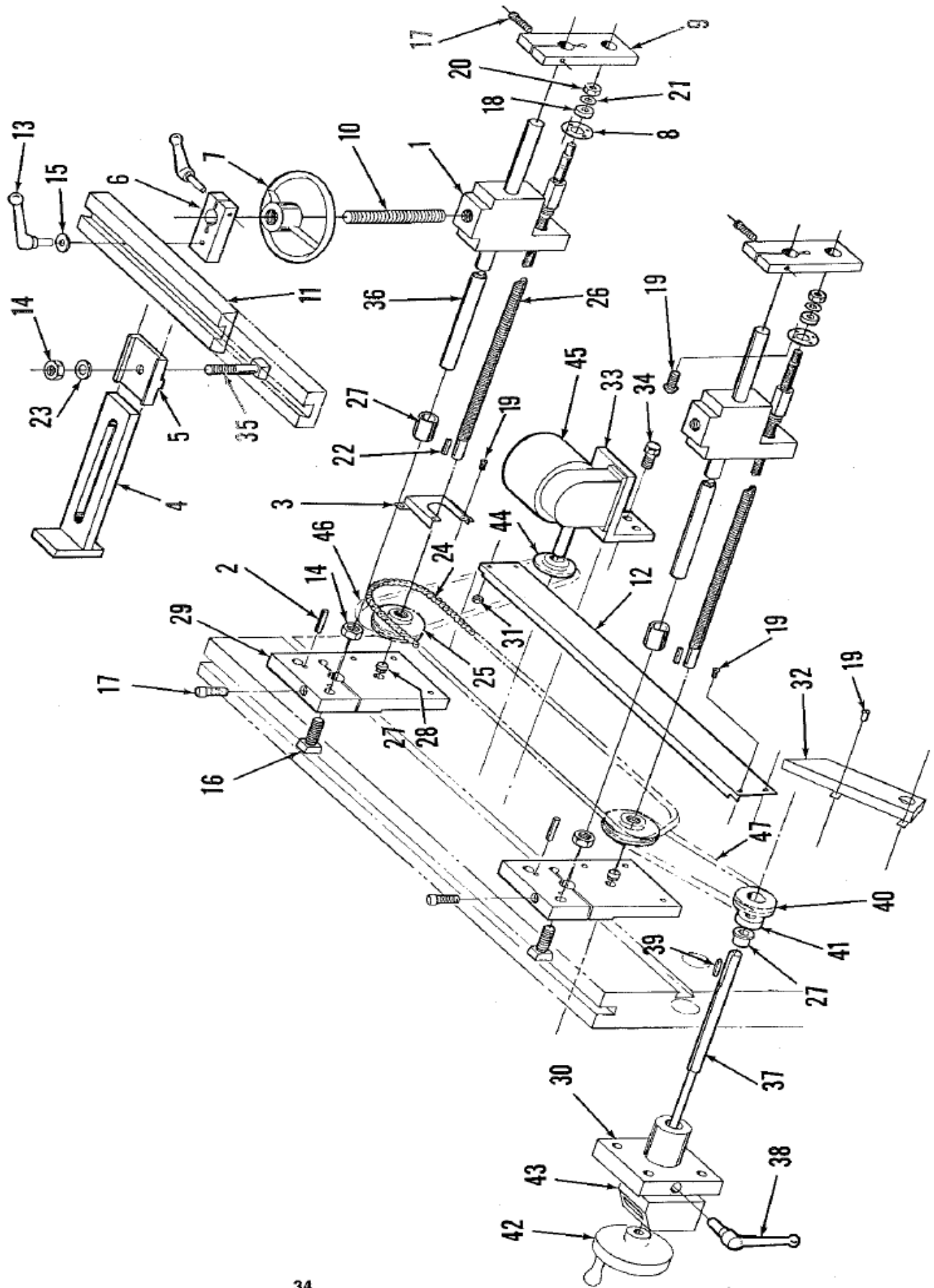
- | | |
|-----------------------------------|---------------------------|
| 1. Roll Pin | 27. Pivot Pin |
| 2. Handle Wheel | 28. Spring |
| 3. Shaft Mounting Bracket - Lower | 29. Switch Actuating Pin |
| 4. Limits Assembly Mounting Plate | 30. Washer |
| 5. Spacer | 31. Hex Head Screw |
| 6. Socket Head Screw | 32. Collar |
| 7. Bearing | 33. Breakaway Lever |
| 8. Retaining Ring | 34. Bearing |
| 9. Shaft Mounting Block - Upper | 35. Socket Head Capscrew |
| 10. Ball Plunger | 36. Washer |
| 11. Indicator | 37. Hex Head Screw |
| 12. Hex Head Screw | 38. Bottom Stop |
| 13. Nut | 39. Button Head Screw |
| 14. Bottom Stop | 40. Speed Change Cam |
| 15. Bottom Stop Adjusting Screw | 41. Top Stop |
| 16. Threaded Collar | 42. Speed Change Block |
| 17. Clamp Bolt | 43. Spring Washer |
| 18. Bed Reference Bracket | 44. Socket Head Capscrew |
| * 19. Washer | 45. Limits Assembly Guard |
| 20. Hex Head Screw | 46. Pointer |
| * 21. Spring | 47. Handwheel |
| * 22. Button Head Screw | 48. Button Head Capscrew |
| 23. Top Stop Assembly | 49. Handwheel |
| 24. Nut | 50. Button Head Capscrew |
| 25. Washer | 51. Cage Nut |
| 26. Limit Switch Mounting Plate | 52. Cover Plate |

* Purchase together



RAM LEVEL CONTROL

1. Adjusting Knob
2. Bearing
3. Bearing Washer
4. Tape Adjustment Screw
5. Indicator
6. Roll Pin
7. Button Head Screw
8. Scale
9. Hex Head Screw
10. Hex Head Screw
11. Screw Housing
12. Tape Locking Collar
13. Set Screw
14. Tilt Adjustment Bracket
15. Tilt Adjustment Bracket Support
16. Hex Head Screw
17. Lockwasher
18. Collar
19. Pulley Shaft
20. Pulley
21. Collar
22. Grease Fitting
23. Tape
24. Hex Head Capscrew
25. Tape Clamp
26. Tape Holder
27. Nut
28. Washer
29. Servo Cushion
30. Servo Valve
31. Socket Head Screw
32. Hex Head Screw
33. Sub Plate
34. Servo Mounting Bracket
35. Hex Head Capscrew

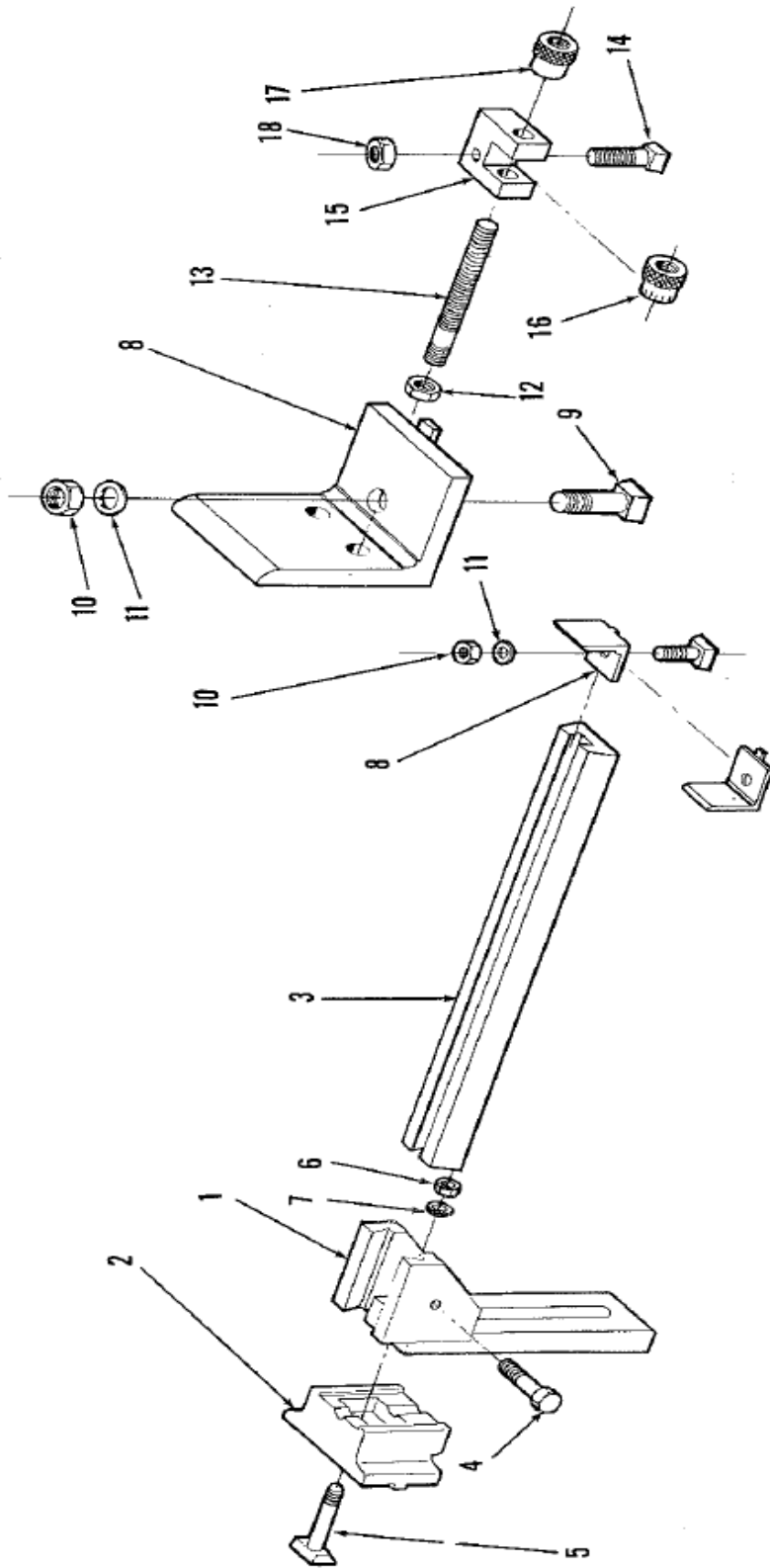


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FRONT OPERATED, PARALLEL ADJUSTED BACK GAGE

- | | |
|---|--|
| <ol style="list-style-type: none"> 1. Carriage 2. Support Plate 3. L.H. Chain Guard 4. Finger 5. Finger Support 6. Finger Rest Support Plate 7. Hand Wheel 8. Brg. Retainer 9. Rear Stop Plate 10. Elevating Screw 11. Backgage Finger Rest 12. Center Chain Guard 13. Stud Type Handle 14. Hex Nut 15. Washer 16. "V" Bolt 17. Socket Hd. Screw 18. Bearing 19. Butt Hd. Capscrew 20. Locknut 21. Lockwasher 22. Key 23. Washer | <ol style="list-style-type: none"> 24. Chain 25. Sprocket 26. Ballscrew & Nut Assembly 27. Olite Brg. 28. Snap Ring 29. Roll Pins 30. Indicator Cartridge 31. Weld Nut 32. Drive Chain Guard 33. Motor Support 34. Hex Hd. Bolt 35. Special Dovetail Bolt 36. Guide Bar 37. Adjusting Shaft 38. Clamp Bolt & Handle 39. Key 40. Sprocket 41. Collar 42. Handle Wheel 43. Cartridge 44. Sprocket 45. Gear Motor 46. Chain 47. Chain |
| <p>MANUALLY OPERATED ONLY</p> <ol style="list-style-type: none"> 38. Clamp Bolt & Handle 42. Handle Wheel | <p>POWER OPERATED ONLY</p> <ol style="list-style-type: none"> 33. Motor Support 34. Hex Hd. Bolt 44. Sprocket 45. Gear Motor |

HEAVY DUTY, UNIVERSAL GAGE BRACKET, & GAGING STOP

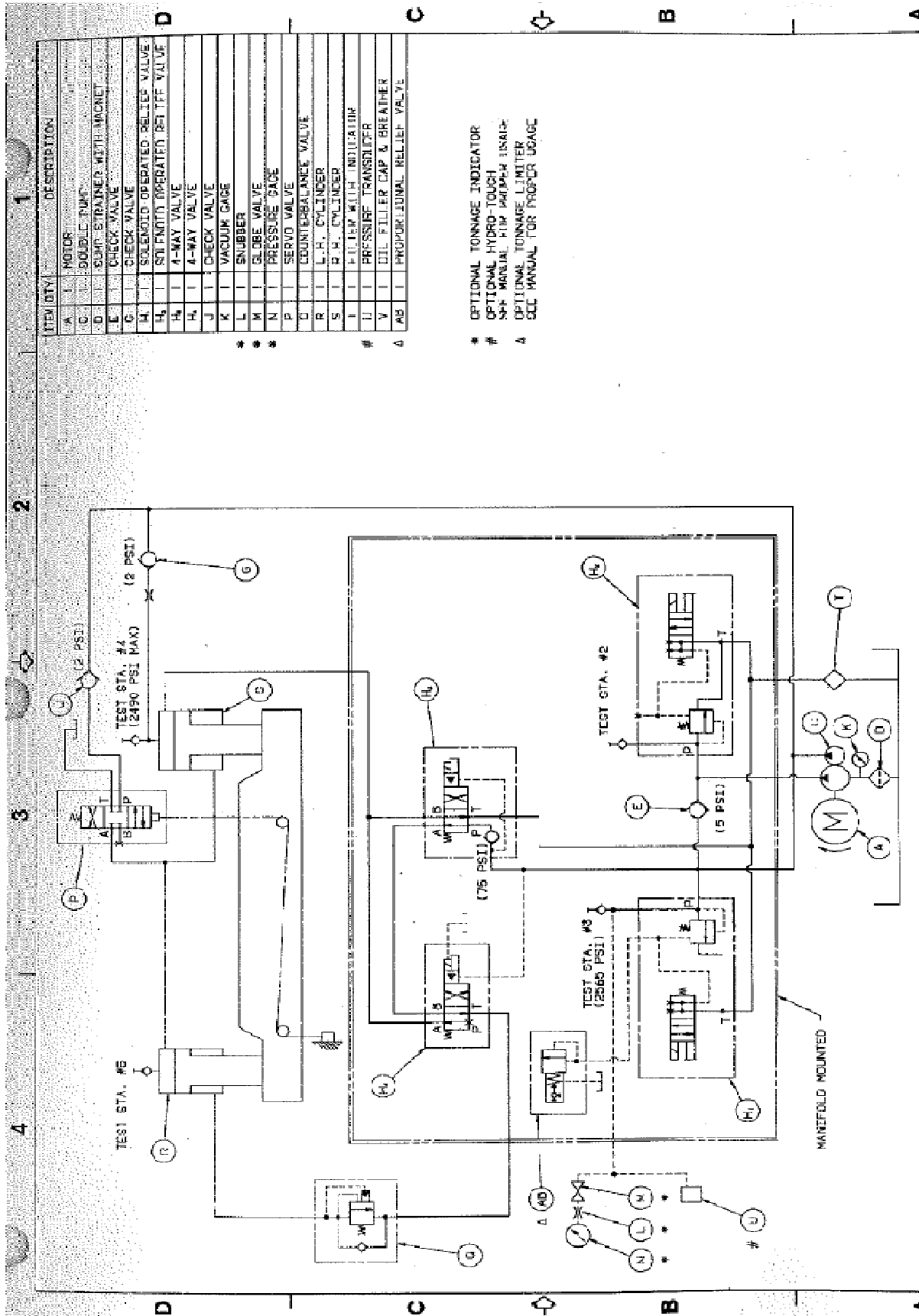


- 1. Back Gage Post
- 2. Base — Back Gage
- 3. Back Gage Slide
- 4. Hex Hd. Bolt
- 5. Tee Bolt
- 6. Hex Nut
- 12. Hex Nut
- 13. Stud
- 14. "V" Bolt
- 15. Micrometer Support

- 7. Washer
- 8. Gage Stop
- 9. "V" Head Bolt
- 10. Hex Nut
- 11. Washer

MICROMETER ADJUSTMENT

- 16. Micrometer Nut
- 17. Locking Nut
- 18. Hex Nut



VALUES ENTERED SPECIFIED		MODEL NO. 1B-95-4-9 PRESS BRAKE
TOLENANCE	DATE	TITLE HYDRAULIC CIRCUIT DRAWING
DESIGNER	DRAWN BY	
CHECKED BY	DATE	
DATE		
NO.	DATE	DATE
NO.	DATE	DATE
NO.	DATE	DATE

OPERATION	SPEED (IN/MIN)	WORKING PRESSURE (TONS)	SOLENOID - ENERGIZED - DE-ENERGIZED			
			H ₁	H ₂	H ₃	H ₄
TOILE			-	-	-	-
RAPID ADVANCE	107		-	-	-	-
ANTI-BACKBEND	16	2450 PSI	-	-	-	-
DECOMPRESSION			-	-	-	-
RAPID RETURN	157		-	-	-	-

NIAGARA
 MEMBER OF THE SCHULER GROUP