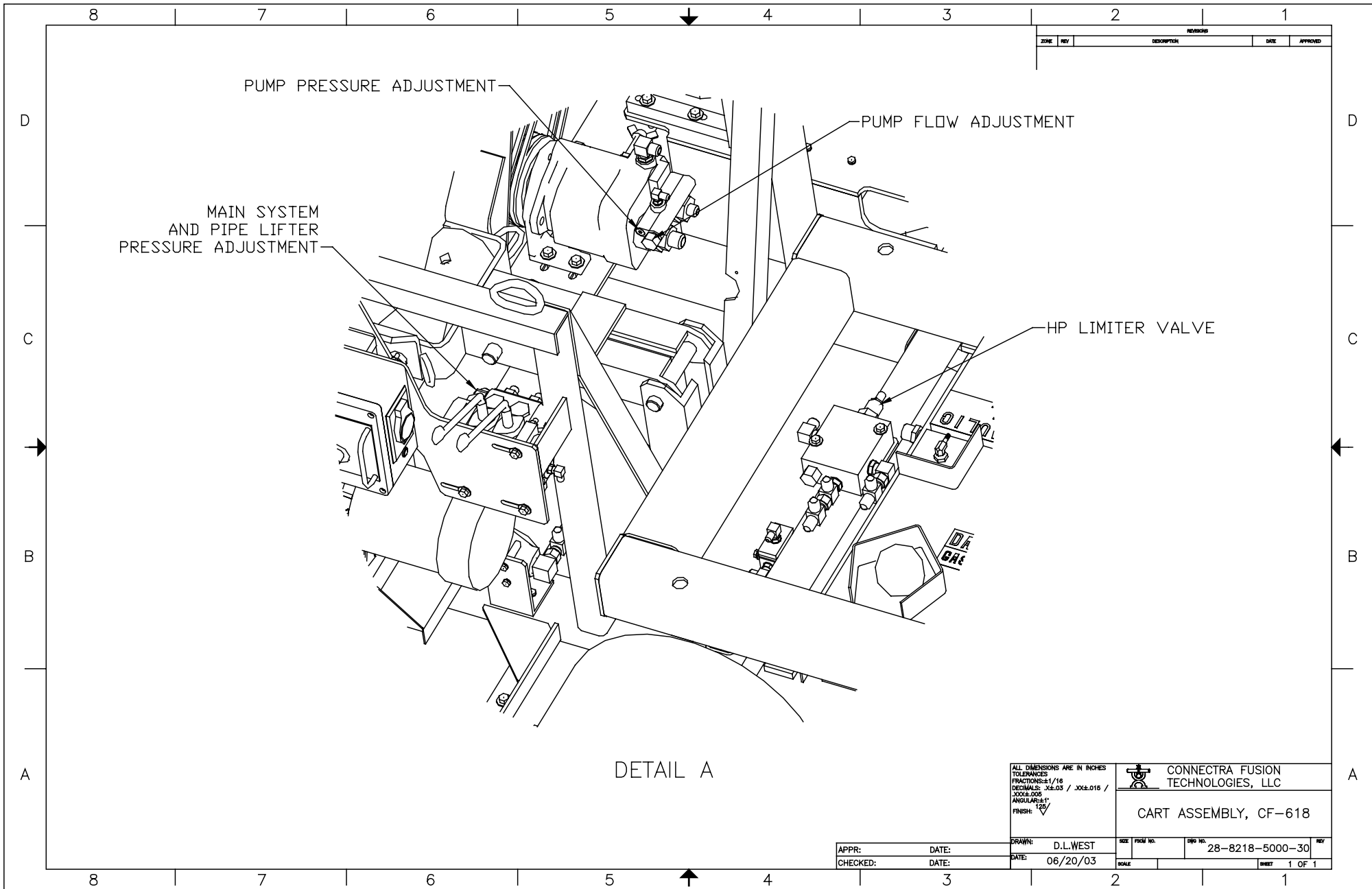


Connectra Fusion Technologies, LLC

618/620 Hydraulic Adjustments

1. Using a 3/16" allen wrench and a 3/4" wrench for the lock-nut, screw the HP Limiter Valve all the way in (clockwise), then screw out (counterclockwise) 4 1/4 revolutions and tighten the lock-nut.
2. Make sure all of the pressure adjustment valves on the manifold are set to "0" psi by adjusting them all the way out (turning counterclockwise.) This includes the Facing, Heating, and Fusion Pressure control valves along with the Drag Compensation Valve. Make sure the carriage directional valve is in the neutral position and that the Facer ON/Off Valve is in the OFF position.
3. Check the oil level in the Hydraulic Fluid reservoir.
4. Start the engine and set the speed so you have 245V showing on the voltmeter then adjust the throttle stop screw for repeatability.
5. Set the Hydraulic Pump Pressure. Using a 3/16" allen wrench remove the PUMP PRESSURE ADJUSTMENT PLUG (this will leak a small amount of hydraulic fluid during the adjustment.) Using a 1/4" allen wrench adjust the pump so that on the Hydraulic Manifold System Pressure Gauge you get a pressure setting of 500 psi. Screwing in (clockwise) will raise the pressure and screwing out (counterclockwise) will lower the pressure. Replace the PUMP PRESSURE ADJUSTMENT PLUG (check to make sure the O-Ring is undamaged.)
6. Set the Main System and Pipe Lifter Pressure Adjustment. Using a 9/16" wrench loosen the lock-nut. Using one of the valves, raise one of the pipe lifters until it is all the way up and while still holding the valve open using a 5/32" allen wrench adjust the relief valve until on the Hydraulic Manifold System Pressure Gauge you get a pressure setting of 2900 – 3000 psi. Screwing in (clockwise) will raise the pressure and screwing out (counterclockwise) will lower the pressure. You may now release the pipe lifter handle. Tighten the lock-nut.
7. Adjust the Pump Flow Adjustment. Turn on the facer and adjust in (clockwise) or out (counterclockwise) until the facer has sufficient rpm to face the pipe.



PUMP PRESSURE ADJUSTMENT

PUMP FLOW ADJUSTMENT

MAIN SYSTEM
AND PIPE LIFTER
PRESSURE ADJUSTMENT

HP LIMITER VALVE

DETAIL A

ALL DIMENSIONS ARE IN INCHES
TOLERANCES:
FRACTIONS: ±1/16
DECIMALS: .005 / .015 / .016 / .005
ANGULARS: ±1°
FINISH: 12/

CONNECTRA FUSION
TECHNOLOGIES, LLC

CART ASSEMBLY, CF-618

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