

Running 1" National

1. Turn on the main power and check the oil level. If it is low; fill it up to the top of the glass.
2. Make sure the air line in the back is in the **“OPEN”** position.
3. Fill up the spindle oil and open the valve slightly to allow drip. Close the valve after a couple of minutes.
4. Push **“RESET”** on the back side of the bench drawer (near the spindle oil fill.)
5. Push **“MASTER START”** on the un-coiler to turn it on.
6. Make sure the sensor for the un-coiler is in a good spot, if it's misaligned the feed and the Smog-Hog will not turn on.
7. Press **“Continue Production”** on the Brankamp. To reset the count on the Brankamp; Press #6 (Counter) -> Order -> **“Clear Counter”**. Everything else is automatic.
8. Make sure the lubricator, coolant, and all oil lines in the header and on the kickout rods are flowing.
9. Check the air lines to make sure the trim chip is being blown from the face of the 4th die.
10. **Jog/Run** buttons spin the motor, but it will not move until you press **“Clutch ON”**. To stop it press **“Clutch OFF”** and use the foot pedal.
11. When the oil gets low in the knockout area of the header, use the switch by the main power panel that says **“OIL CATCH PAN”** it will recycle oil back into the machine. When you hear the motor sucking in air, make sure to turn that switch back off.
12. The trim chip conveyor is wired backward. Forward is reverse.