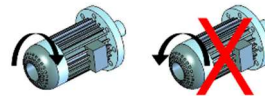


Quick Start Up Guide for HPA-P Manual Press Brakes

1. Read the User Manual
2. Anchor and level machine
3. Confirm voltage requirements
4. Remove hydraulics cover
5. Check/fill hydraulic fluid
6. Connect to power – See sticker on cabinet door
7. Turn on Power Switch
8. Press Start button
9. Confirm electrical phases



- a. Confirm motor direction matches arrow
If rotation is incorrect, swap L1 and L2

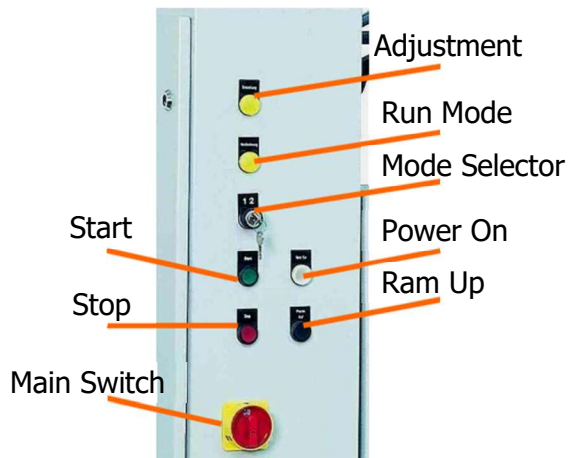
10. Replace hydraulics cover

11. Adjust/confirm stroke of ram

- a. Adjustment mode allows the Ram Up and Ram Down buttons to be used to assist with stroke adjustment

- b. Run mode disables these buttons

12. Press both Hand Control Buttons simultaneously to run



Stroke Adjustment

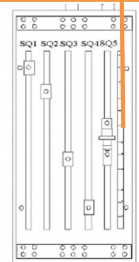
SQ1 – Top safety limit DO NOT CHANGE

SQ4 – Bottom safety limit DO NOT CHANGE

SQ2 – Top limit for ram

SQ5 – Bottom limit for ram

SQ3 – Speed change point from Advance to Working



Troubleshooting: