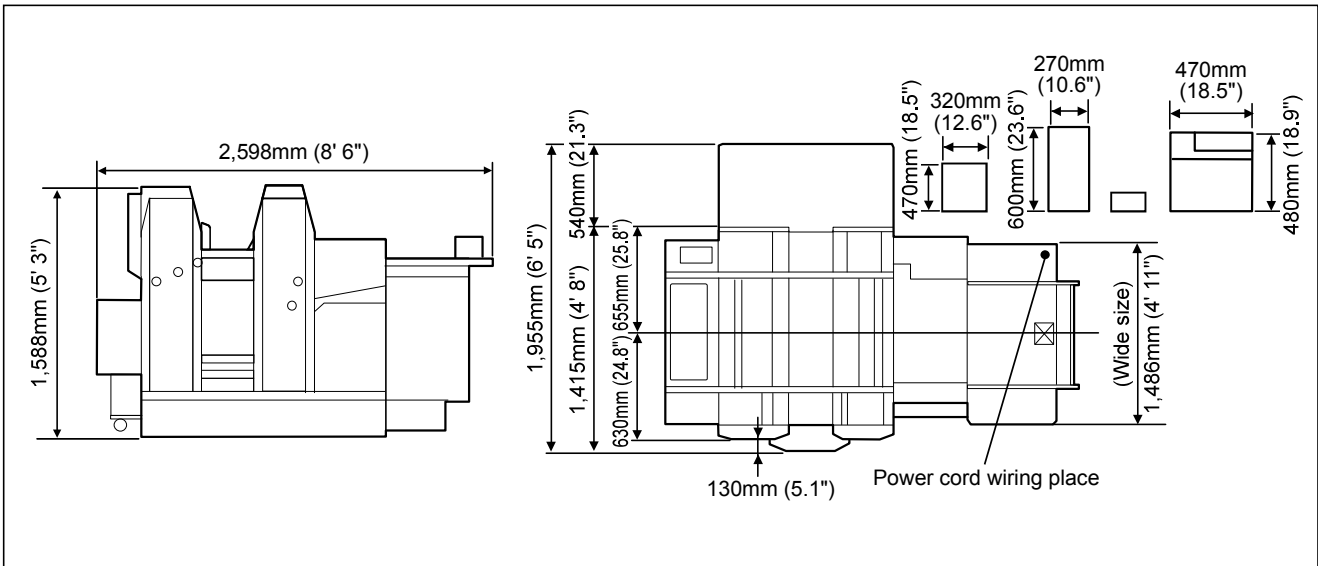


1-1 Checking the installation space

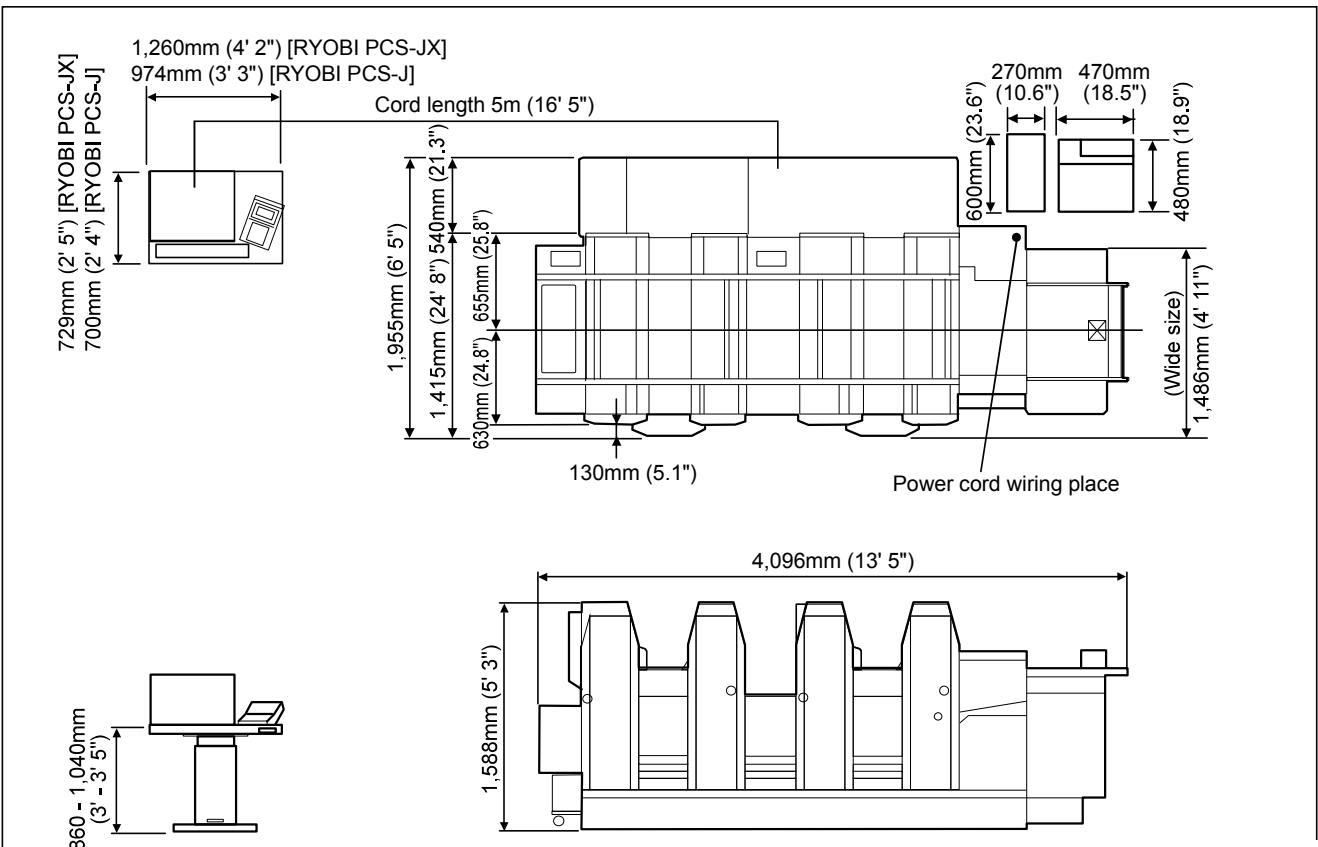
A. Installation space

- The press dimensions are shown below.
- There should be enough space between the wall and press to allow operation and maintenance.
- Check the entrance of the room that the press will be installed in.

RYOBI 522GE • Press dimensions



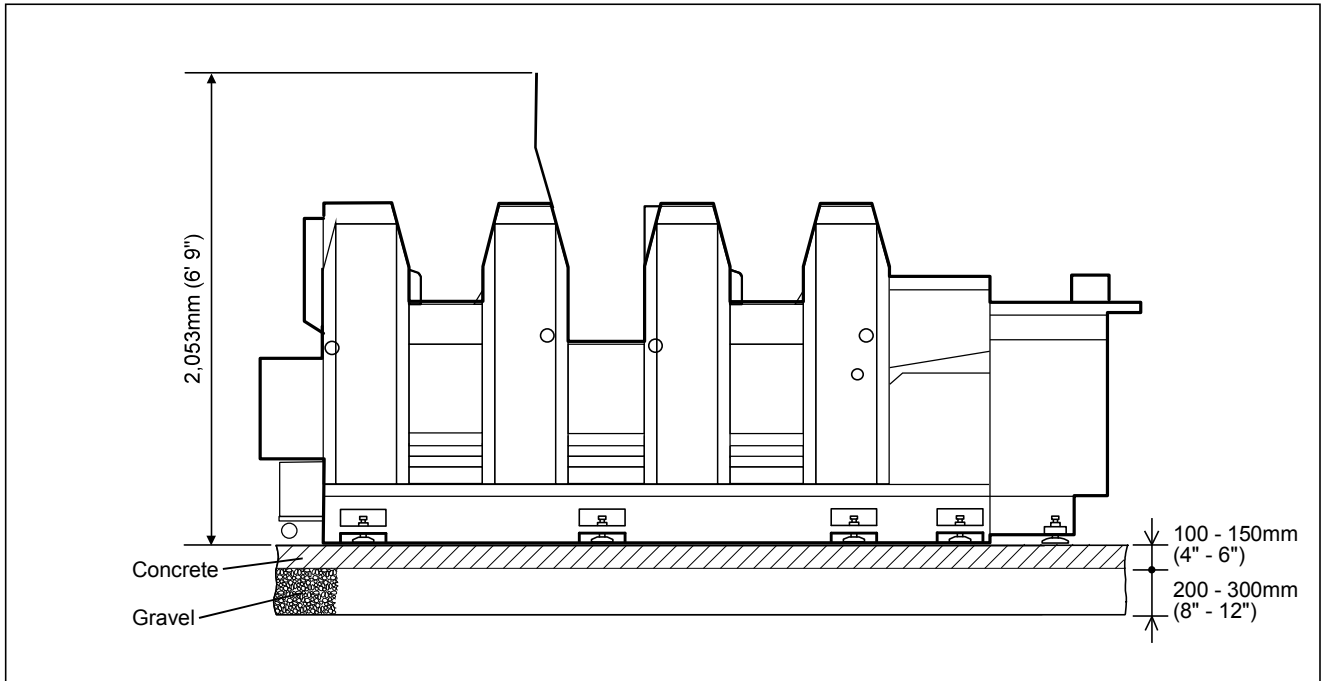
RYOBI 524GE • Press dimensions



This illustration shows the RYOBI PCS-J.

B. Press installation place

The foundation construction should be done by a specialist.



(Note)

1. The load capacity of the floor has to be determined considering the jack up bolt position and the point weight on each bolt. So please consult a contractor who has this specialized knowledge.
(Reference : Load capacity per 1m² is over 1,200kg. / Load capacity per square feet is over 246 lbs.)
2. The floor should be level.
3. The ceiling height should be over 2,500mm (8' 2").

C. Necessary tools when carrying the press

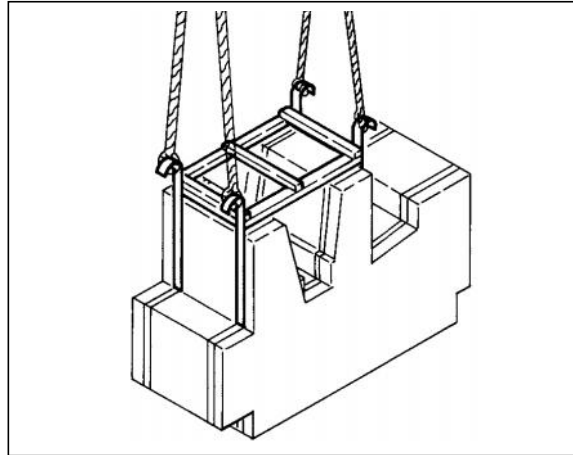
Allen wrench	14mm
Wrench	19mm, 24mm
Pipe (Round pole)	Ø50mm (Outer diameter) x 1,700mm (Length)
Jack	More than 2, each with a capacity of 2 tons
Others	Delivery tools (Hydraulic pallet truck) Level (0.02mm/m)

1-2 Carrying procedures

A. Lifting procedures

● RYOBI 522GE

Lifting gauge set No. 5522 J 010



(Reference)

Mounting the lifting gauge



1) Remove the grip.



2) Remove the 2nd unit safety cover dampers.



3) Mount the 4 hooks at the 1st unit and 2nd unit.
At this time, place packing (cardboard or rubber) between the frame and hook.



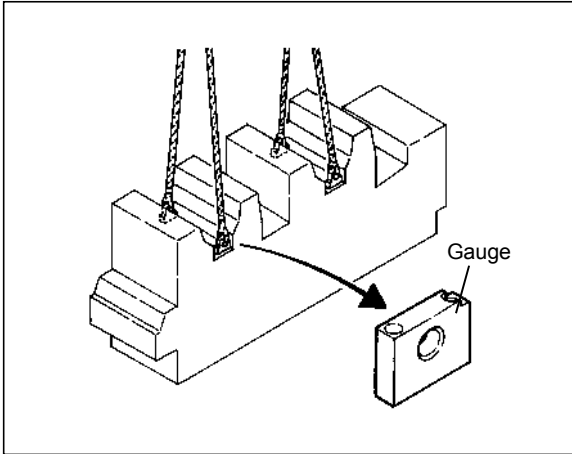
4) Mount the 2 stays between the hooks at the 1st unit and 2nd unit.



5) Mount the 2 stays between the hooks at the operation side and non operation side.

● RYOBİ 524GE

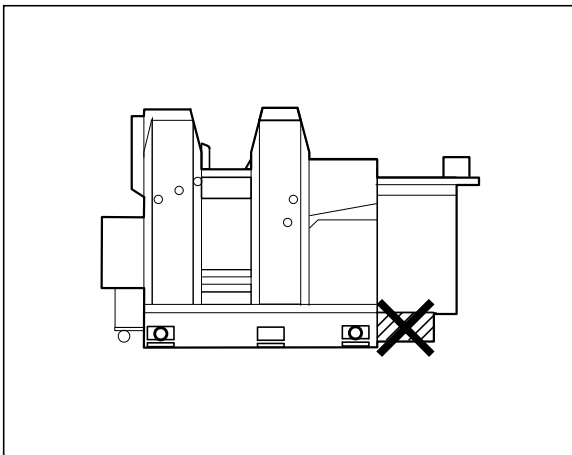
Lifting gauge set No. 6524 J 010



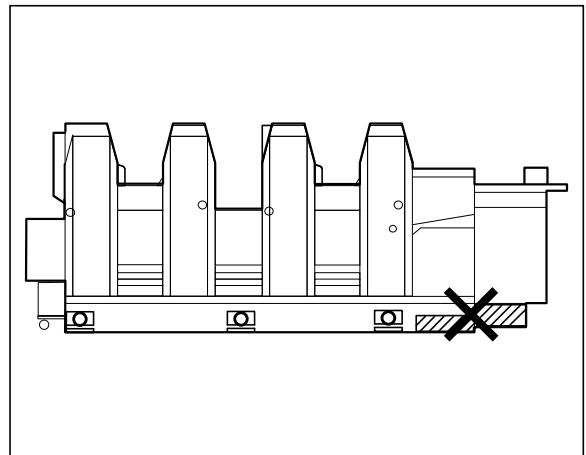
Mount the 4 gauges on the press using the bolts and lift it using the wires.

B. Jacking up

RYOBİ 522GE



RYOBİ 524GE



Pass the round poles through the bed frame holes and jack up the round poles.

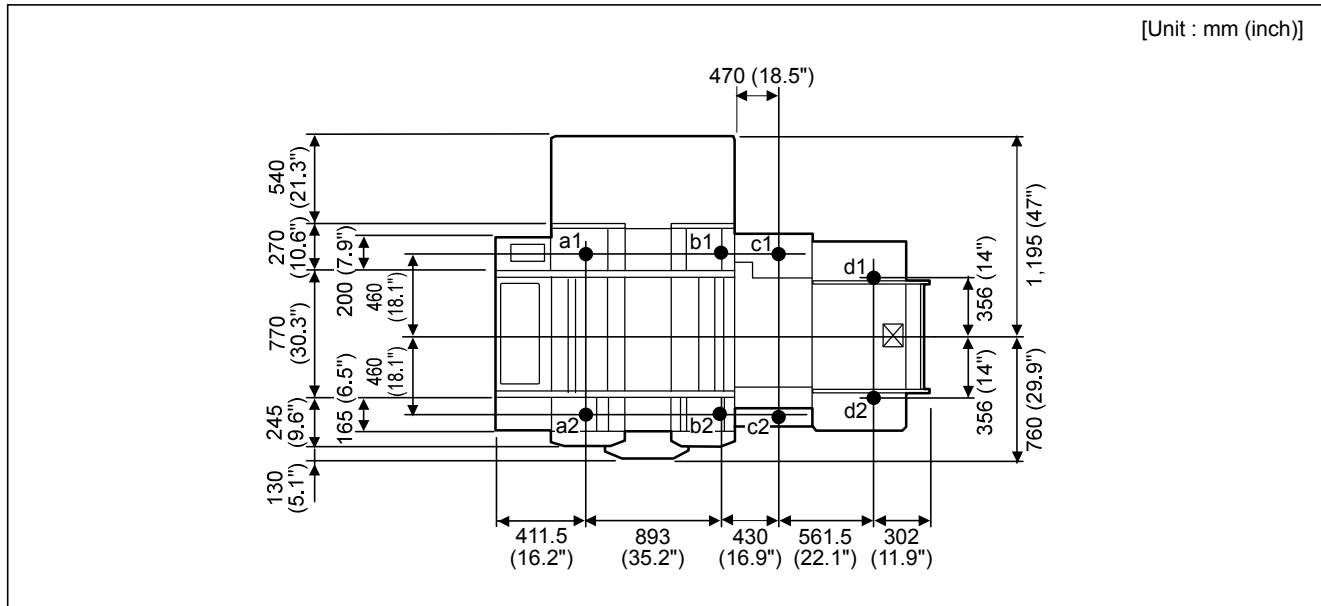
(Notice)

1. When jacking it up, be sure never to jack up the part of the feeder side shown with the diagonal line part in the illustration.
2. Be careful that the whole press is kept in balance.

(Reference)

Jack up bolt position and point weight (● mark : The jack up bolt position)

RYOBI 522GE



Point weight

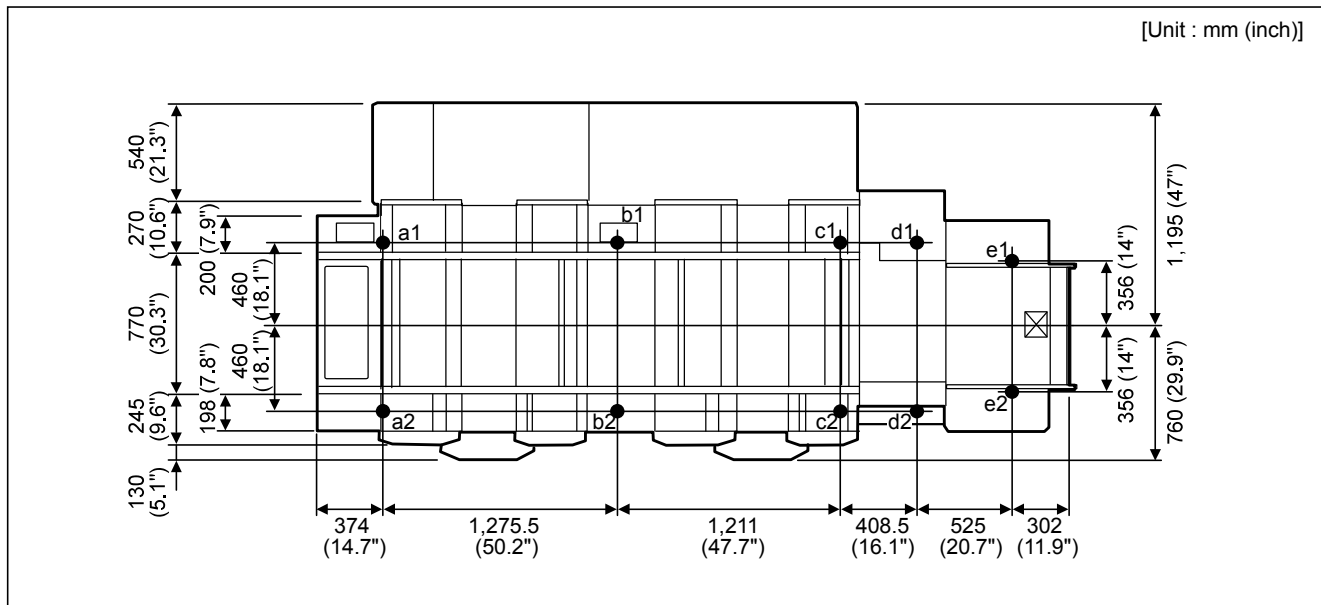
a1	a2	b1	b2	c1	c2	d1	d2	Total
525	525	525	525	525	525	100	100	3,350

(Unit : kg)

a1	a2	b1	b2	c1	c2	d1	d2	Total
1,157	1,157	1,157	1,157	1,157	1,157	220	220	7,382

(Unit : lbs.)

RYOBI 524GE



Point weight

a1	a2	b1	b2	c1	c2	d1	d2	e1	e2	Total
828.8	828.8	828.8	828.8	828.8	828.8	828.8	828.8	100	100	6,830

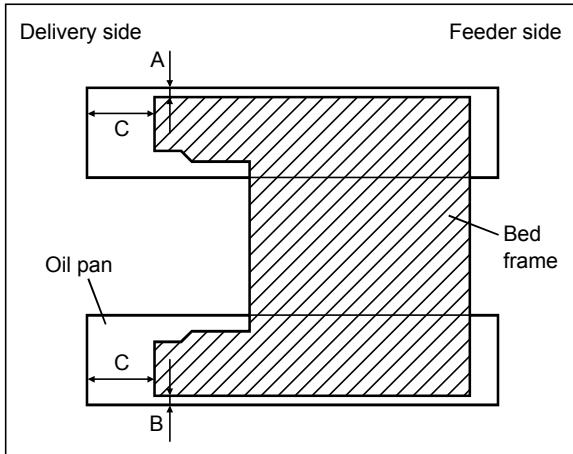
(Unit : kg)

a1	a2	b1	b2	c1	c2	d1	d2	e1	e2	Total
1,827	1,827	1,827	1,827	1,827	1,827	1,827	1,827	220	220	15,056

(Unit : lbs)

C. When setting the oil pan

The jack bases are put in and the press should be installed.



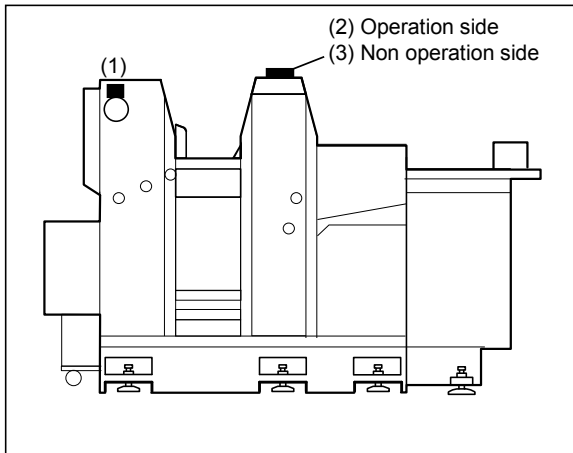
Model	A	B	C
RYOBI 522GE	60mm (2.4")	60mm (2.4")	100mm (3.9")
RYOBI 524GE	50mm (2")	50mm (2")	40mm (1.6")

1-3 Press leveling

A. Leveling accuracy measuring places

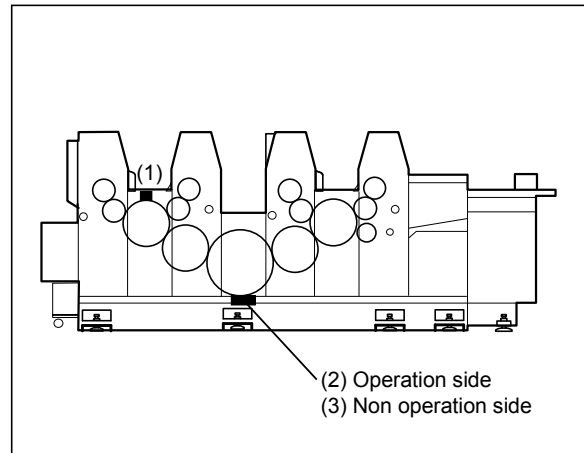
The level that is used should have an accuracy of 0.02mm per one meter.
Check the press leveling accuracy at the 3 places shown in the illustration.

RYOBI 522GE



On the 2nd unit ink fountain roller.....(1)
On the 1st unit ink frame(2), (3)

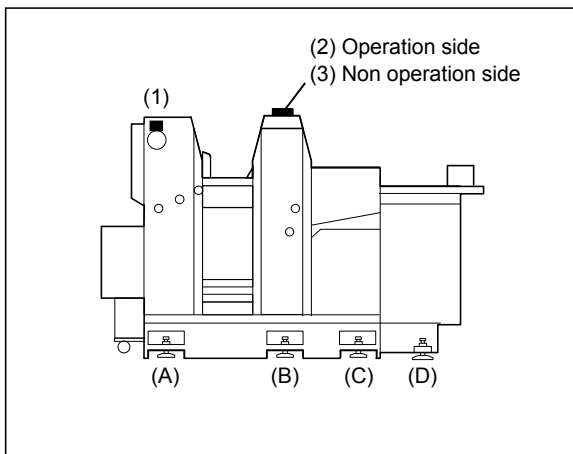
RYOBI 524GE



On the 2nd unit impression cylinder(1)
On the bed frame.....(2), (3)

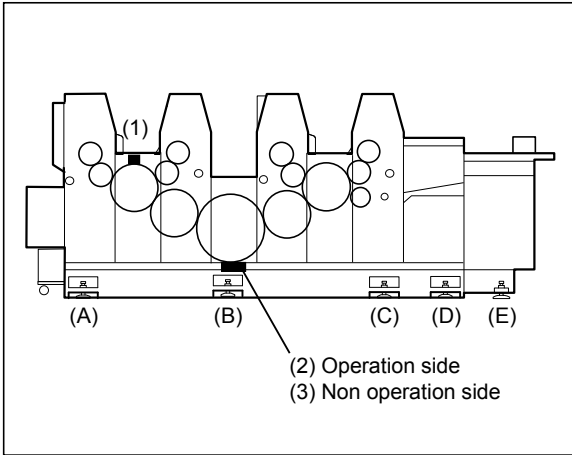
B. Adjustment procedures

RYOBI 522GE



- 1) Adjust the level of (1), (2), and (3) using the 6 adjustment bolts (A), (B), and (C).
- 2) Adjust so that the load is equal on the 2 adjustment bolts (D). At this time, be careful not to change the level of the press section.

RYOBI 524GE



- 1) Adjust the level of (1), (2), and (3) using the 6 adjustment bolts (A), (B), and (C).
- 2) Adjust so that the load is equal on the 4 adjustment bolts (D) and (E). At this time, be careful not to change the level of the press section.

(Note)

1. Any oil and foreign particles must be wiped off from the surface where the level is to be positioned.
2. After adjusting the level, apply the anti-corrosion oil on the level setting position (bed).
3. If the level accuracy of the press is not adjusted correctly, there is a possibility that the poor cylinder ON and OFF or vibration may result.

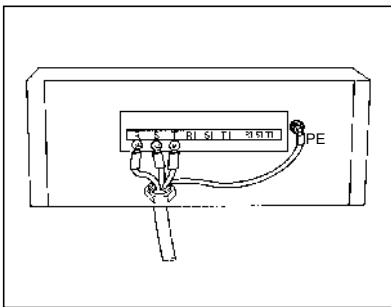
1-4 Press wiring

A. Power source wiring

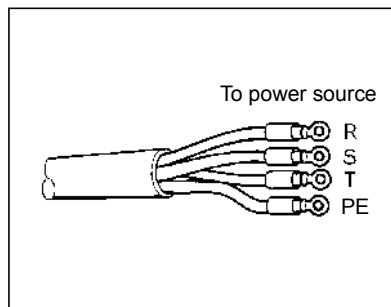
These presses require a power source shown in the table below. Prepare a power cord. Ground the press properly using the ground wire.

	RYOBI 522GE	RYOBI 524GE
Power supply	3 phase, 200V, 27A	3 phase, 200V, 47A
Power consumption	7.5kW (27,000kJ, 6,450kcal, 25,590BTU)	13.5kW (48,600kJ, 11,600kcal, 42,060BTU)
Cross sectional area of power cord	Over 5.5mm ²	Over 14mm ²
Power cord length	Less than 10m	Less than 10m

B. Wiring procedures

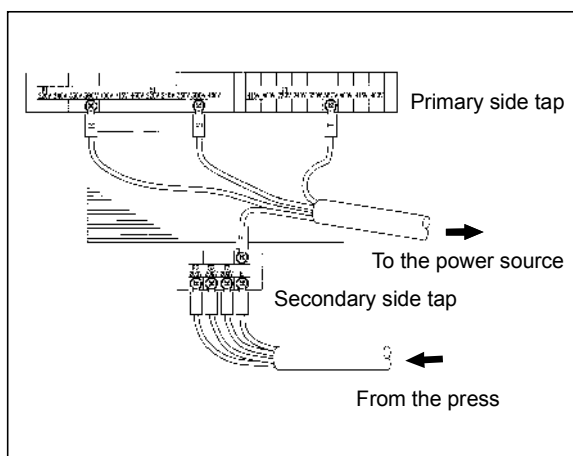


- 1) Connect the power wires to the terminal base (R, S, T, and PE) in the power box.
Fix the power cord to the box using the bushing.



- 2) Connect the power wires to the power source.

[Press with a transformer only] Transformer



(Reference)

When using a transformer, connect the transformer so that it is between the power source and press.

Wires to the power source : Primary side tap in the transformer

Wires from the press : Secondary side tap in the transformer (200V)

(Note)

Check that the connection of the wires (primary side tap) to the power source matches the voltage of the power source.