



Connectra Fusion Technologies, LLC

28EP Hydraulic Adjustments

1. Rotate the SYSTEM PRESSURE CONTROL, DRAG PRESSURE CONTROL, FUSION PRESSURE CONTROL, HEATER PRESSURE CONTROL and the FACER PRESSURE CONTROL knobs counter-clockwise all the way out.
2. Set the PRESSURE SELECTOR to the FACING position.
3. Set the DRAG-OPERATOR SELECTOR to the OPERATE position.
4. Turn the FACER CONTROL to the up (OFF) position.
5. Turn the hydraulic power unit on.
6. Adjust the SYSTEM PRESSURE CONTROL knob clockwise until there is 1000 psi showing on the SYSTEM PRESSURE GAUGE and tighten the jam nut to lock the adjustment.
7. Open the FACER CONTROL slowly to purge the air from the system. Turn the FACER CONTROL counter-clockwise to turn on. The facer should rotate clockwise if viewed from the motor side.
8. With the facer in the on position the system pressure should be less than 700 psi.
9. Move the DIRECTIONAL CONTROL lever to the left and turn the FACER PRESSURE CONTROL knob clockwise to increase the carriage pressure until the carriage begins to move and run the carriage back and forth until it reaches the end of travel several times to purge the system of any air that may be trapped in the system.
10. Disconnect the hydraulic hoses to the facer motor. Remove the pump adjustment cap using a 1" wrench. With the FACER CONTROL in the on position adjust the pump using a straight bladed screwdriver until the SYSTEM PRESSURE GAUGE has a reading of 1900 psi. Adjust the pump adjustment clockwise to raise the pressure and counter-clockwise to lower the pressure. Replace the pump adjustment cap.
11. The 28EP hydraulic system should now be ready.
12. It is normal for the facer to slow or even stop when the carriage is being moved until the pipe contacts the facer plates.

