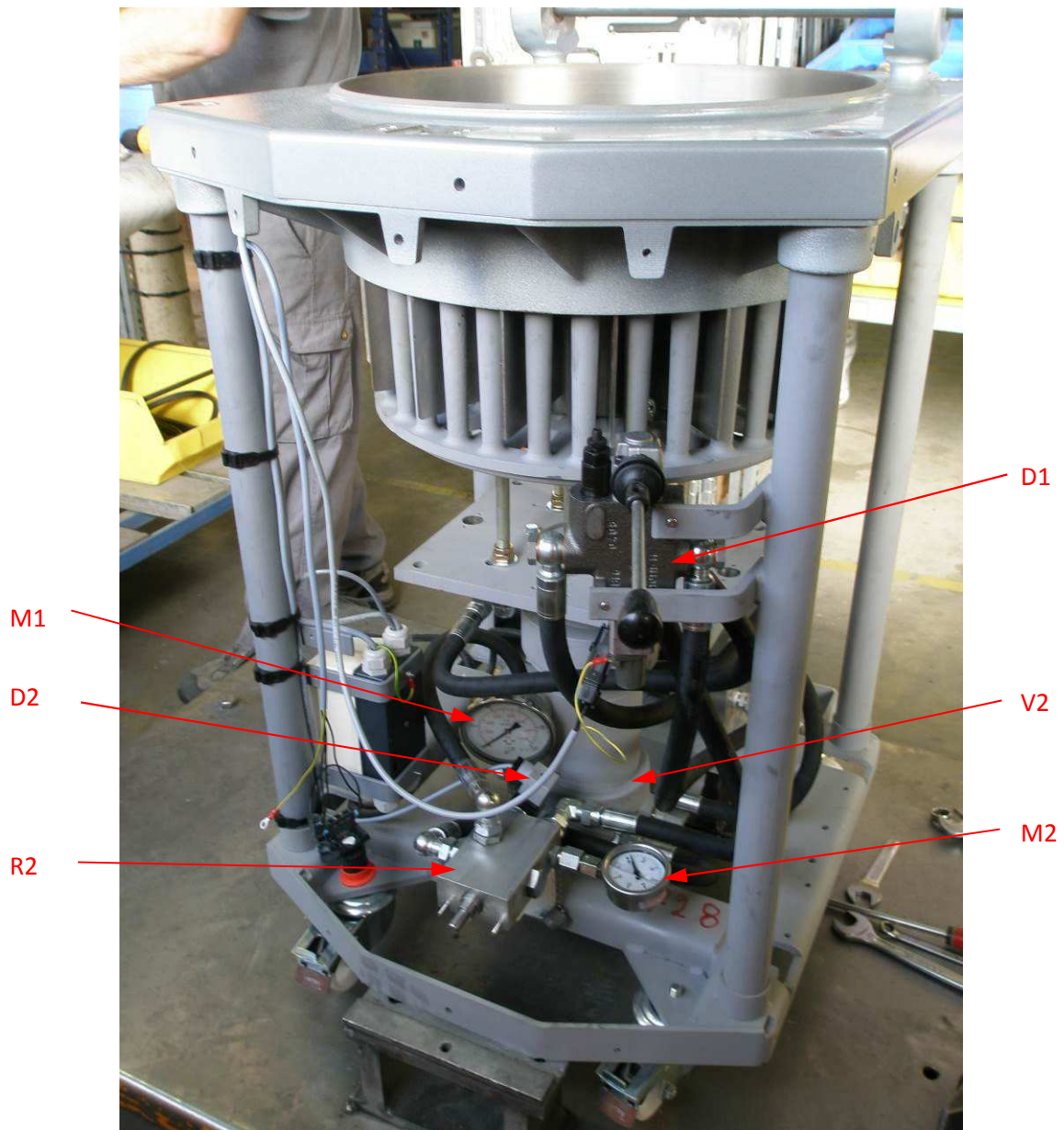
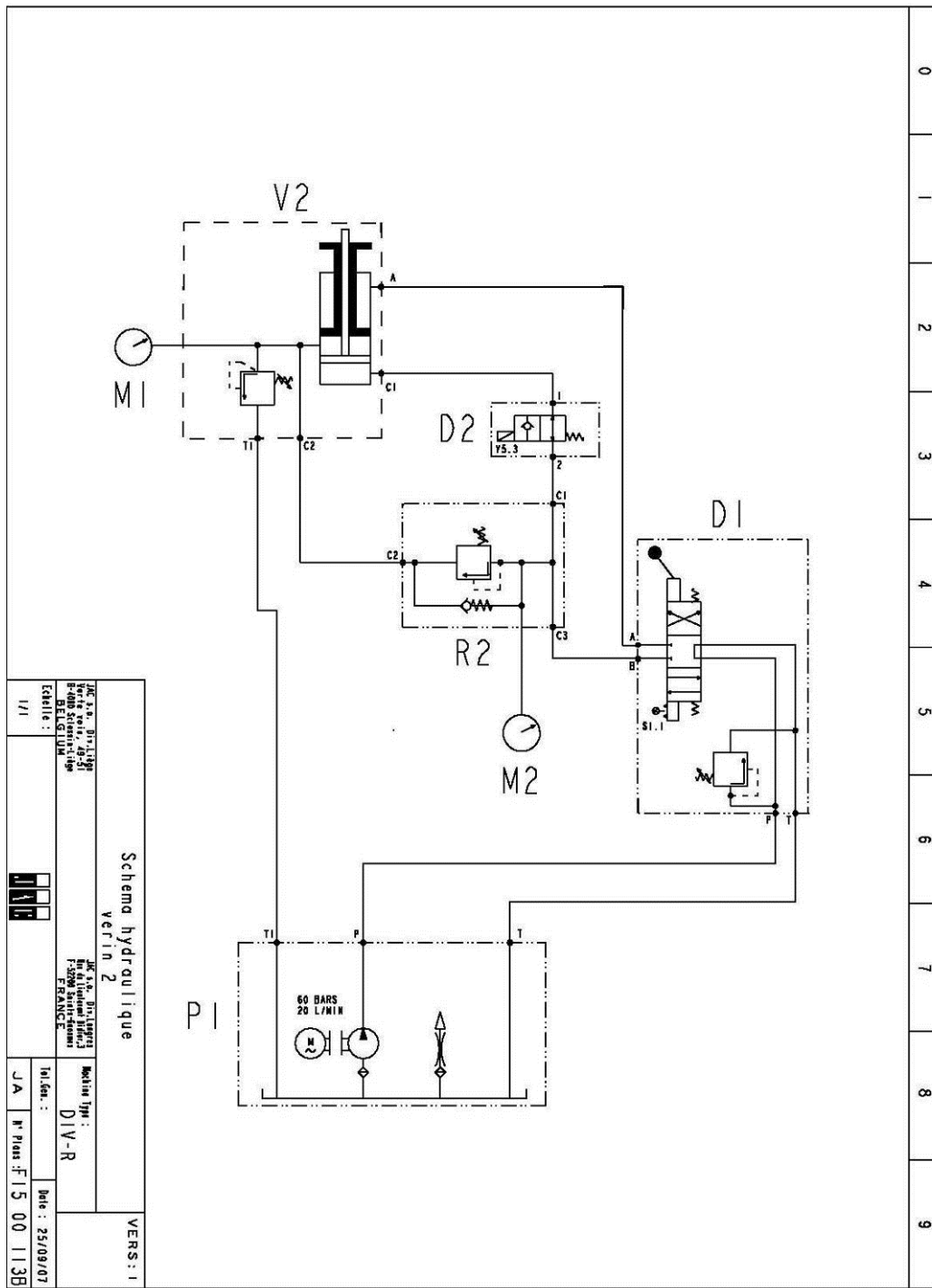


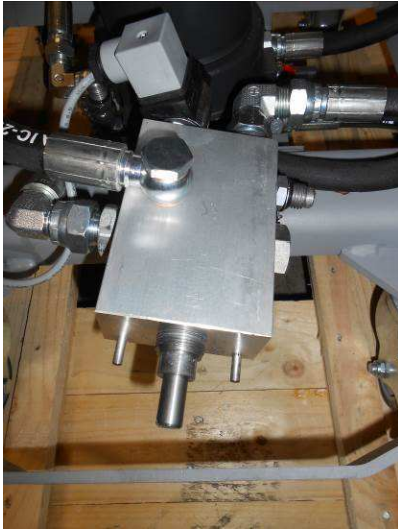
1. Div and Div-R cylinder 2 layout.



2. Div and Div-R cylinder 2 hydraulic diagram.



3. Slacken pressure setting screw **R2** as well as cylinder **V2** setting screw



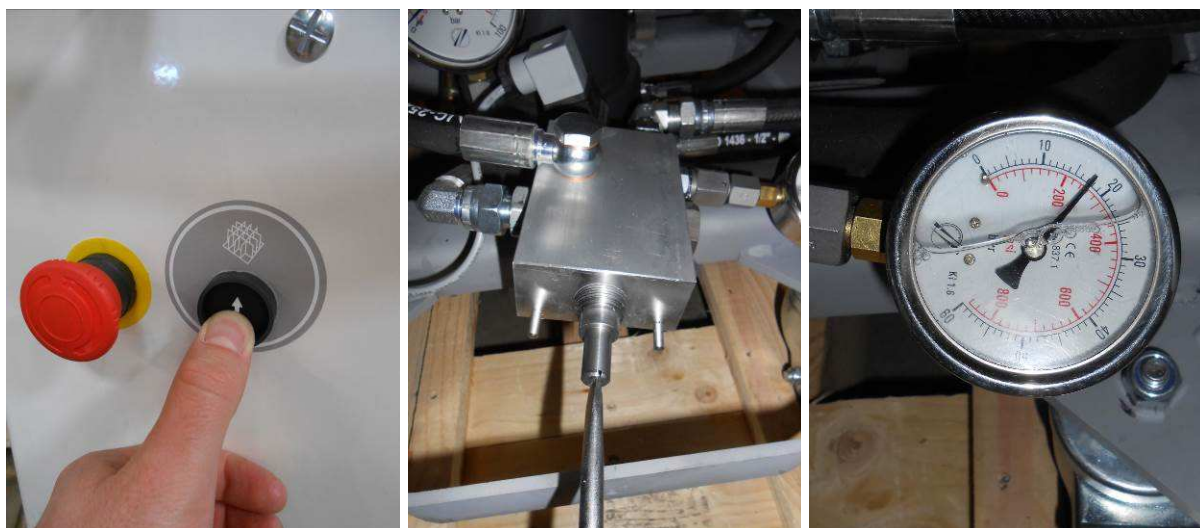
4. Raise the cylinder to its fullest extent and keep the pressure applied. Tighten cylinder **V2** setting screw until the pressure reaches **50 bars** on pressure gauge **M1** (if the pressure does not reach 50 bars, retighten cylinder **V2** setting screw until the pressure varies again then tighten the relief valve screw on control valve **D1** by one turn. The pressure should then reach 50 bars.)



5. With cylinder **V2** in the raised position and under pressure, slacken the relief valve screw on control valve **D1** until the pressure reads **44 bars** on pressure gauge **M1** then tighten the relief valve locknut on control valve **D1**.



6. Tighten pressure setting screw **R2** until the pressure reaches **18-20 bars** on pressure gauge **M2**. This pressure reading is to be taken while and only while the knives are being raised.



7. With cylinder **V2** in the raised position and under pressure, slacken cylinder **V2** setting screw until the pressure reaches **38-40 bars** on pressure gauge **M1**.



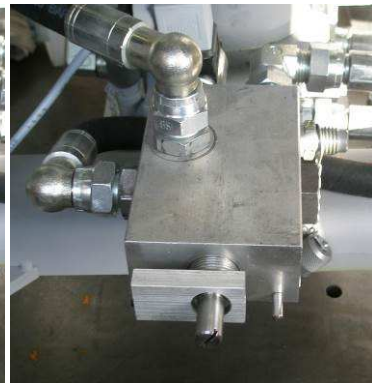
8. Fit the stops as shown in the photos.



Machine with and without pressure setting.



Machine without pressure setting.



Machine with pressure setting.

9. Check:

For machines without pressure setting:

- With cylinder **V2** in the raised position and under pressure, read **38-40 bars** on pressure gauge **M1**.
- With cylinder **V2** in the lowered position and knives moving upwards, read **18-20 bars** on pressure gauge **M2**.
- Cylinder **V2** raising and lowering times (full stroke) must be approximately equal to 3 seconds.

For machines with pressure setting:

- With cylinder **V2** in the raised position and under pressure, read the following on pressure gauge **M1**:
 - Minimum setting position: **38-40 bars**.
 - Maximum setting position: **34-36 bars**.
- With cylinder **V2** in the lowered position and knives moving upwards, read the following on pressure gauge **M2**:
 - Minimum setting position: **18-20 bars**.
 - Maximum setting position: **30-32 bars**.
- Cylinder **V2** raising and lowering times (full stroke) must be approximately equal to 3 seconds.



Pressure gauge **M2** must always read at least 2 bars (with the cylinder in the raised position and maximum setting position) more than the reading on pressure gauge **M1** (with the cylinder in the raised position and maximum setting position).