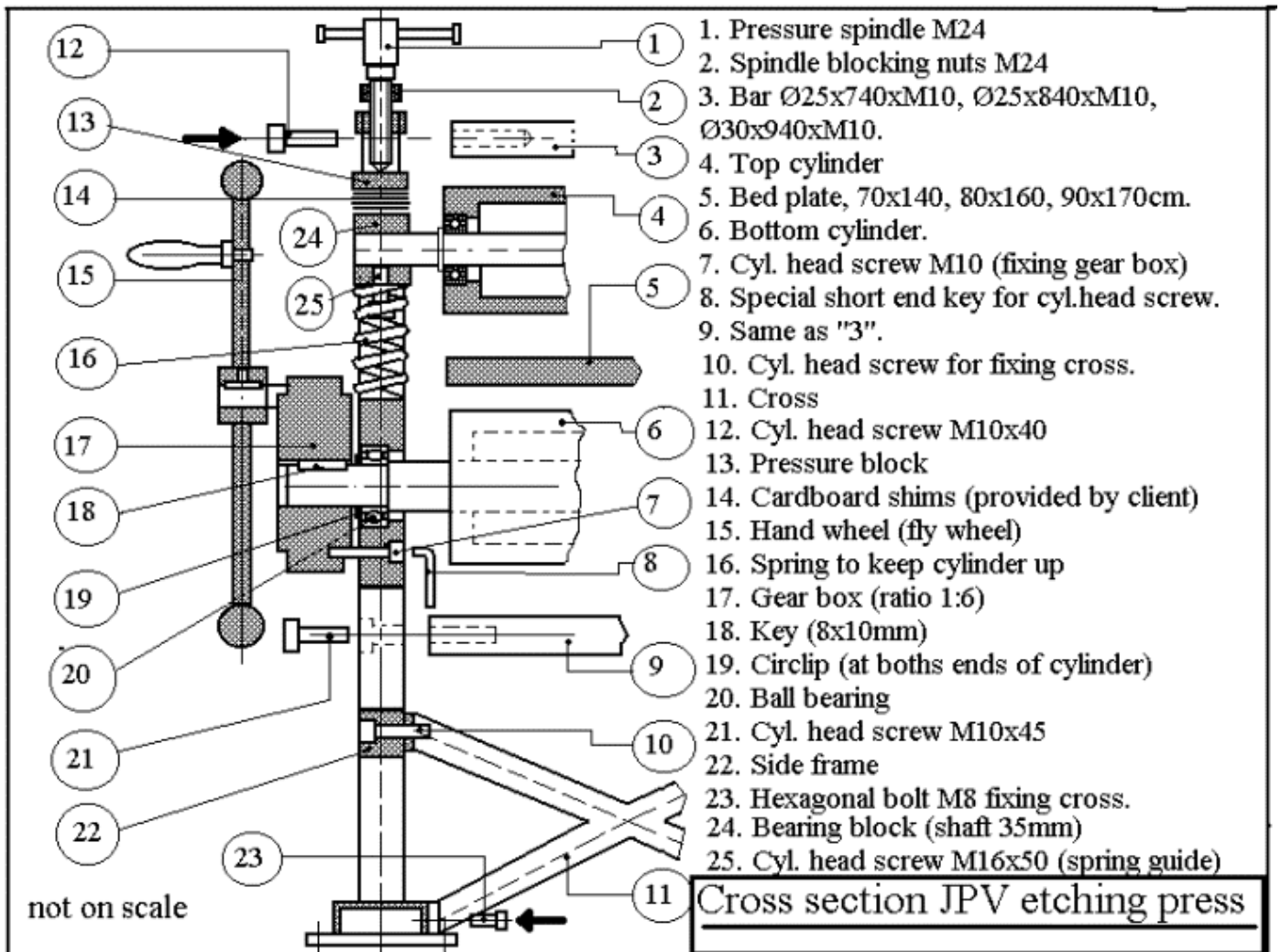




## Setting up your JPV Series Press

### Included:

- 1 gear box. Hollow shaft 35mm, (1.4") solid shaft 24mm, (0.9") gearing 1:6.
- 1 bed of very hard synthetic material. Size; JPV-70 70x140cm (28"x55"), JPV-80 80x150cm (31"x63") and JPV-90 90x170cm (35"x67"). These beds are fitted with two bars of hard wood to prevent the bed from falling out the press.
- 2 springs, diam. 3,7cm (1.5") length 11cm (4.3"). These springs keep the top cylinder up. This is very convenient for relief printing.
- 1 side frame, fitted with holes for the gear box.
- 1 side frame without holes for the gear box.
- 4 guide "strips" to be fixed to the side frames to keep the bed in place.
- 2 pressure blocks, to be placed directly under the spindles. They are designed to distribute the pressure over the cardboard pile.
- 2 cylinder head screws M16x50. They serve as guides for springs, and to keep the shaft of the upper cylinder in place.
- 2 bearing blocks for the upper cylinder.
- 1 upper cylinder.
- 1 cross to fix between the two side frames.
- 1 lower cylinder
- 8 plastic white rollers to guide the bed of the press vertically.
- 4 bars to carry the white rollers. (Bar size, JPV-70 round 20mm (0.8") length 740mm (29") M8, JPV-80 round 20mm (0.8") length 840mm (33") M8, JPV-90 round 20mm (0.8") length 940mm (37") M8.)
- 4 bars to meet the distance between the side frames. (Bar size, JPV-70 round 25mm (1") length 740mm (29")M10, JPV-80 round 25mm (1") length 840mm (33") M10, JPV-90 round 30mm (1.2") length 940mm (37") M10)
- 1 hand wheel. (hole 24mm (0.9"))
- 2 pressure spindles M24.
- 4 hex. nuts M24. Put these on the spindles, to be able to fix and hold a certain position of the spindle.
- 8 cyl.head screws ins.hex.M8x20 for the round bars with plastic rollers.
- 12 cyl.head screws ins.hex.M10x40. Eight for fixing the round bars (those without plastic rollers) to the side frames and four for fixing the gear box.
- 1 adjustment screw M8x16 ins.hex. for fixing the handwheel.
- 8 hex.bolts M8x16 for fixing the guide strips on the side frames.
- 8 washers M8 for fixing the guide strips on the side frames.
- 4 hex.bolts M8x20 for fixing the lower ends of the cross to the side frames.
- 16 circlips (19mm/0.8")for securing the plastic rollers on the round bars between the frames.
- 2 circlips (34mm) for securing the lower cylinder on both ends.
- 1 key 8x7x32mm for connecting the hand wheel to the gear box.
- 1 key 10x8x36 mm for connecting the gear box to the lower cylinder.
- 4 plastic black plugs to close the tube ends of the side frames
- 1 turn handle for the hand wheel.

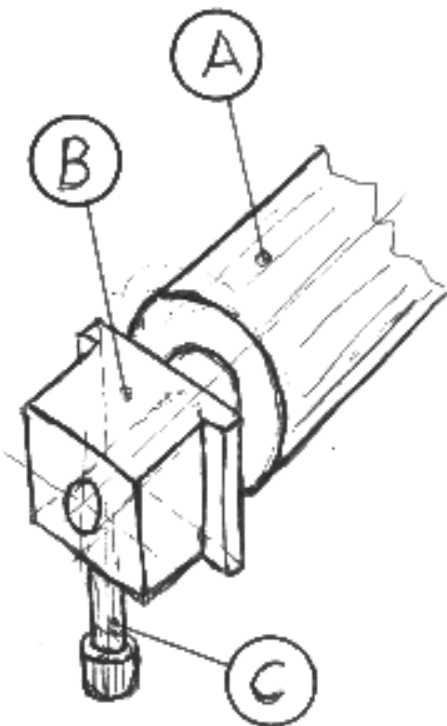


## Assembly:

1. Connect the two cylinders with a good rope. To determine what is what; the lower cylinder has a fixed shaft. The shaft of the upper cylinder can turn.
2. Glide the bearing blocks over the shaft as the picture shows. The M16 hole must point downwards. Fix the spring guide (M16x50 cyl.head screw), but do not tighten it. It must be possible to glide the bearing block over the shaft.
3. Hoist the two cylinders to the right level. When the cylinders are hanging more or less in the right position, check this by placing a side frame next to them, the hole in the side frames with the ball bearings in them must be at the same height as the shaft of the lower cylinder. Now put some grease on the shafts of the lower cylinder.
4. Place the four cyl.head screws M10x40 (for fixing of gearing) in the side frame.
5. Try to glide this side frame over the long shaft of the lower cylinder. Do not force this. If the frame is in the right position it will enter easily. At the same time, check if the bearing block (with spring guide pointing downwards) enters also correctly into the side frame. Leave a few mm free; do not slide the frame until the end. You will need some space afterwards to put the parts between the frames in place.
6. Glide now the other side frame in the same way over the shaft.
7. Place first the four bigger round bars between the frames with screws M10x40. Do not tighten these until you put all parts between the frames.
8. Release the cylinders from the rope, and take the rope off the cylinders.
9. Place the smaller round bars, with the plastic rollers, now between the frames. (with cyl.head screws M8x20) the screws are fitted in slotted holes. This is done to give a possibility of adjusting the height of the plastic rollers. If the plastic rollers are not yet fitted on the round bars, do it now. Secure each plastic roller with a circlip at each side. Each roller should be about 20 cm (8") from each end of the bar.
10. Place the cross between the frames. Fix them at the upper side with cyl.head screws M8x40, and at the lower side with hex.bolts M8x20. The cross is assembled by welding in a jig. In spite of this, there may still remain some tension in the cross. Keep this in mind while placing the cross. Do not tighten any screws yet.
11. Start now tightening the screws M10x40 very firmly. Do not force anything, and switch from one side to another while tightening the screws.
12. Now tighten the screws and bolts of the cross.
13. Bring the two circlips (19) in place to secure the lower roller.
14. Bring the key (18) 10x8mm in place, and the gearing system. Use the special key for tightening the cyl.head screws M10x40. This special key you can find fixed with tape to the hand wheel. With this special key, you can enter between the side of the lower cylinder and the side frame. Tighten the screws in the gearing firmly.
15. Bring some rope again on the middle of the upper cylinder. Hoist the upper cylinder with the tackle about 20 cm (8"). Now you can determine the place where the bearing blocks must be fixed on the shaft of the upper cylinder. Now tighten the screws/spring guides M16x50 (25).
16. Now you can also bring the two springs in place. If necessary hoist the top cylinder a bit more to facilitate the entering of the springs.
17. Let the upper cylinder go down slowly, until it rests on the springs.
18. Cut some cardboard if you want some "flexibility" on the upper roller. Make shims of it and put in into place. Put the pressure block on top of it.
19. Put some grease on the spindles, bring the hex. nuts M24 in place, and turn the spindles into the side frames.
20. Now remove the protective layer of plastic from the cylinders. Use a very sharp knife for this, AND CUT ONLY IN THE PLASTIC SURFACE, otherwise you might damage the cylinders. Clean them with solvent and let them dry.
21. Now bring now the bed into place, and adjust it. Attach the bed guides to both sides of the frame with hex.bolts M8x16 and washers. These guides must be fixed in such a way that they guide the bed in a

straight line through the press. Do not block the bed with them. The bed needs 1mm (0.04") play on each side.

22. Now adjust the bars with the plastic rollers. Adjust them to such a height that will allow the bed to pivot atop the lower cylinder. This pivoting action, caused by the difference in height between the lower roller and the plastic rollers, can be minimum and is solely to ensure continues contact between the bed and the cylinder.
23. Bring the plastic plugs into place in the ends of the tubes of the side frames.
24. Mount the wheel on the gearing system and fasten the handle onto the wheel.



A= upper cylinder  
B= bearing block  
C= cyl.head screw M1 6x50  
(spring guide and securing  
of shaft upper cylinder)

Bearing block and upper cylinder of JPV  
etching presses.