



SERVICE MANUAL

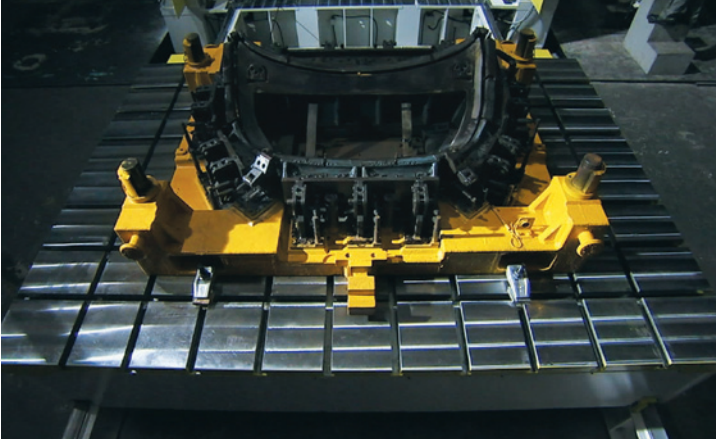
# 180° Reversing Type Spotting Press

[www.prosperous.com.tw](http://www.prosperous.com.tw)



## Frequently Asked Questions

- 1.No pressure
- 2.The bolster can't be moved out
- 3.The slide can't be moved down
- 4.The reversing plate can't be reversed out
- 5.Reversing plate is detached with reversing hook
- 6.Monthly maintenance



## **2.The Bolster Can't Be Moved out**

2-1.Push button error

2-2.E-stop button is pressed and does not release

2-3.Moving bolster rail is blocked by an unknown object

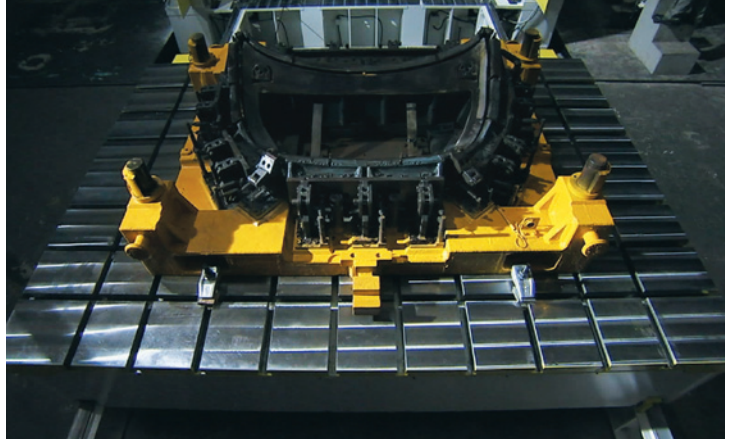
2-4.The limit switch of moving bolster rail has been activated

2-5.Safety bar limit switch not activated

2-6.Anti-slip mechanisms are not locked

2-7.Moving bolster cable rewinder is broken or cable is cut

2-8.Slide is not located at the top of the stroke



## **2.The Bolster Can't Be Moved out**

2-9.The moving bolster is not raised

2-10.The bolster system pressure is insufficient

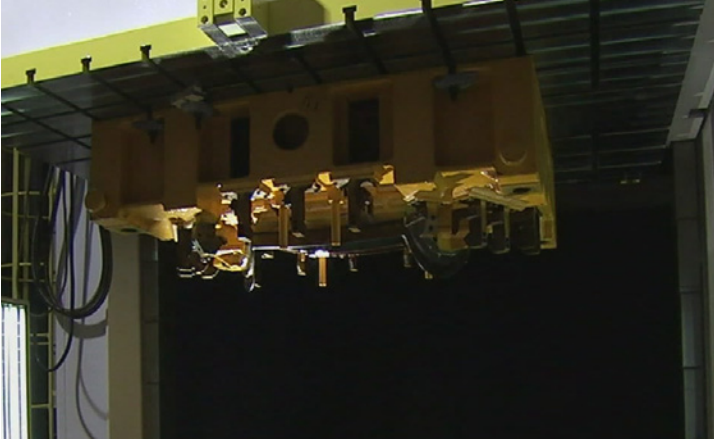
2-11.The cushion is not at the down limit position

2-12.Slide reversing plate position limit switch not activated

2-13.Slide reversing lock pin is not fully in place

2-14.The moving bolster motor is out of order

2-15.The moving bolster gear box is damaged



## **3.The Slide Can't Be Moved down**

3-1.Push button error

3-2.Safety bar limit switch not activated

3-3.Safety fence is not closed

3-4.Check all E-stop buttons

3-5.Safety bar limit switch not activated

3-6.Anti-slip mechanisms are not locked

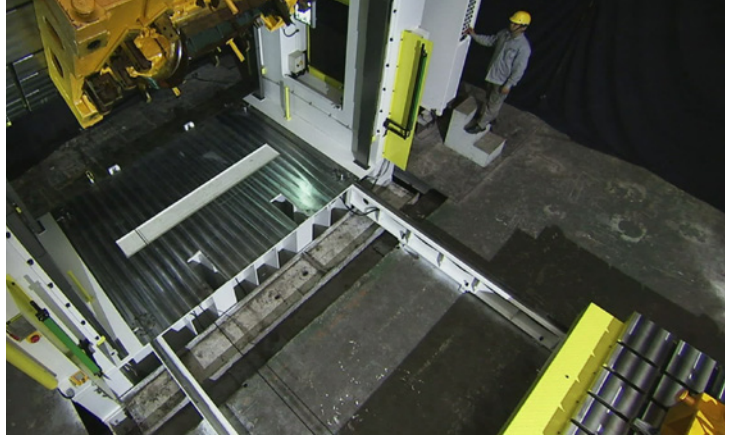
3-7.Check safety light curtain (if equipped)

3-8.The bolster is not clamped

3-9.The slide reversing plate is not correctly positioned (if equipped)

3-10.Direction valve not working

3-11.No pump pressure



## **4.The Slide Reversing Plate Can't Be Reversed out**

4-1.Push button error

4-2.Safety bar limit switch not activated

4-3.Safety fence is not closed

4-4.Check all E-stop buttons

4-5.Safety bar limit switch not activated

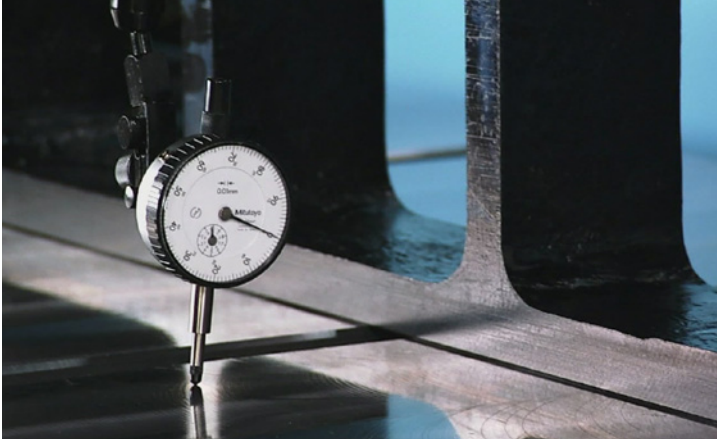
4-6.The bolster is not clamped

4-7.The moving bolster not moved to the rear limit switch

4-8.Slide is not located at the top of stroke

4-9.Lock pins of anti-slip mechanisms are not locked

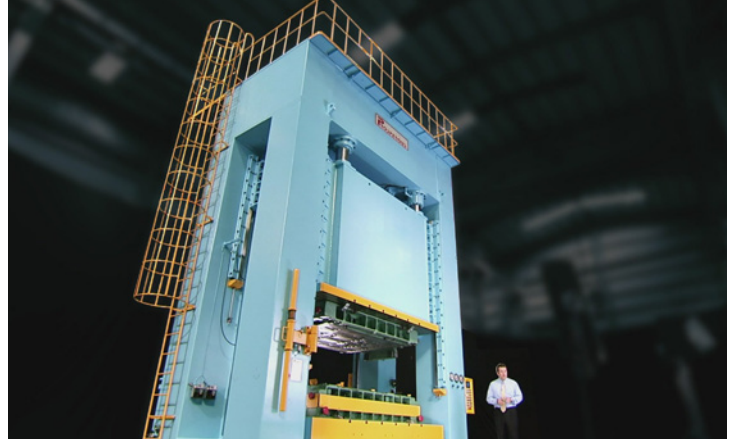
4-10.Simple hydraulic circuit check



## **5.Reversing plate is detached with reversing hook**

5-1.Reversing plate is detached with reversing hook





## 6.Monthly maintenance

6-1.Checking all bolts

6-2.Checking lubrication oil

6-3.Empty all lubrication oil tray

6-4.Check all tubes and hoses if any oil leakage by visually and hand touch

6-5.Touch pistons to find oil leaking or scratch

6-6.To check the hydraulic oil is enough or not

6-7.To check all tubes and hoses for oil leaking

6-8.Oil temperature must less than 55 degrees

6-9. Cleaning machine surface

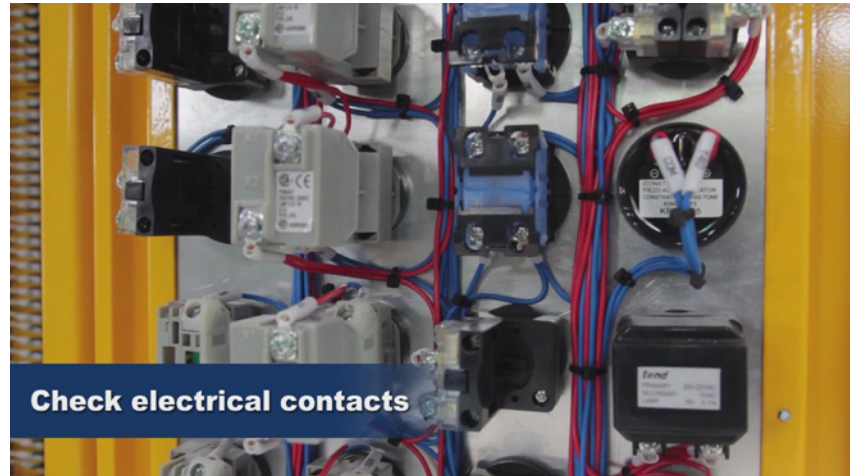
6- 10 . Electric box cleaning and check

6- 11 . Oil filter cleaning



## 2-1 Push button error

### ■ 2-1-1. Electric Circuit



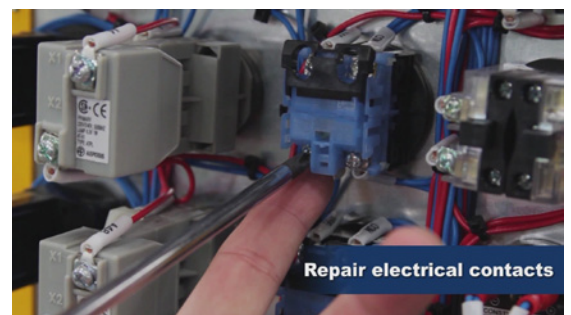
Check electrical contacts

#### **Solution:**

- A. Check electrical circuit contacts.
- B. If any are loose, fasten them.
- C. If any contacts are broken, replace them.



Loose electrical contacts



Repair electrical contacts

## 2-1 Push button error

### ■ 2-1-2. Wiring(cable) problem



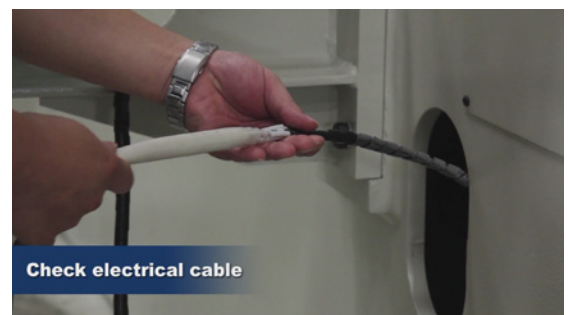
Check cable rewinder

#### **Solution:**

- A. Check cable rewinder.
- B. Check electrical cable.



Check cable rewinder



Check electrical cable

**FAQ** 2. The bolster can't be moved out

## 2-2 E-stop button is pressed and does not release

### **Solution:**

Check all E-stop buttons and ensure they are not pressed.



Check all emergency stop buttons and release them

**FAQ** 2. The bolster can't be moved out

## 2-3 **Moving bolster rail is blocked by an unknown object**

**Solution:**

Remove the object.



Remove any unknown objects

**FAQ** 2. The bolster can't be moved out

## 2-4 The limit switch of moving bolster rail has been activated

### **Solution:**

Remove the object.



Remove any objects that are in contact with the limit switch

## 2-5 Safety bar limit switch not activated

### **Solution:**

Check safety bar activates the limit switch and insert the lock pin.



Check safety bar is in contact with limit switch



Insert safety bar lock pin

- **If this still can't be solved, check the limit switch is not broken.**
  - **If it's not broken, keep checking for other problems.**
  - **If broken, replace limit switch with a new one.**



**FAQ** 2. The bolster can't be moved out

## 2-6 Anti-slip mechanisms are not locked

### **Solution:**

Press the slide up button to raise slide to top of the stroke. Then ensure anti-slip mechanisms are securely locked.



Manually raise the slide and lock mechanisms



## 2-7 Moving bolster cable rewriter is broken or cable is cut

**Solution:**

- A. Replace the cable rewriter.
- B. Replace the cable.



Check cable rewriter



Check electrical cable

**FAQ** 2. The bolster can't be moved out

## 2-8 Slide is not located at the top of the stroke

### **Solution:**

Press the slide up button to raise the slide to the top of the stroke.



Press the slide up button to raise the slide to the top of the stroke

## 2-9 The moving bolster is not raised

### Possible Problems:

- A. No pressure
- B. Push button error



Manually increase pressure

**FAQ** 2. The bolster can't be moved out

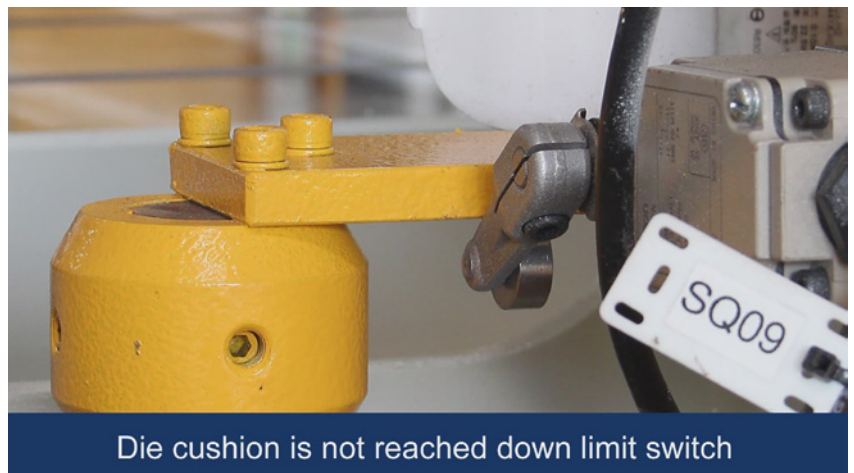
## 2-10 Bolster system pressure is insufficient

---

## 2-11 The cushion is not at the down limit position

### **Solution:**

The cushion is not at the down limit position.



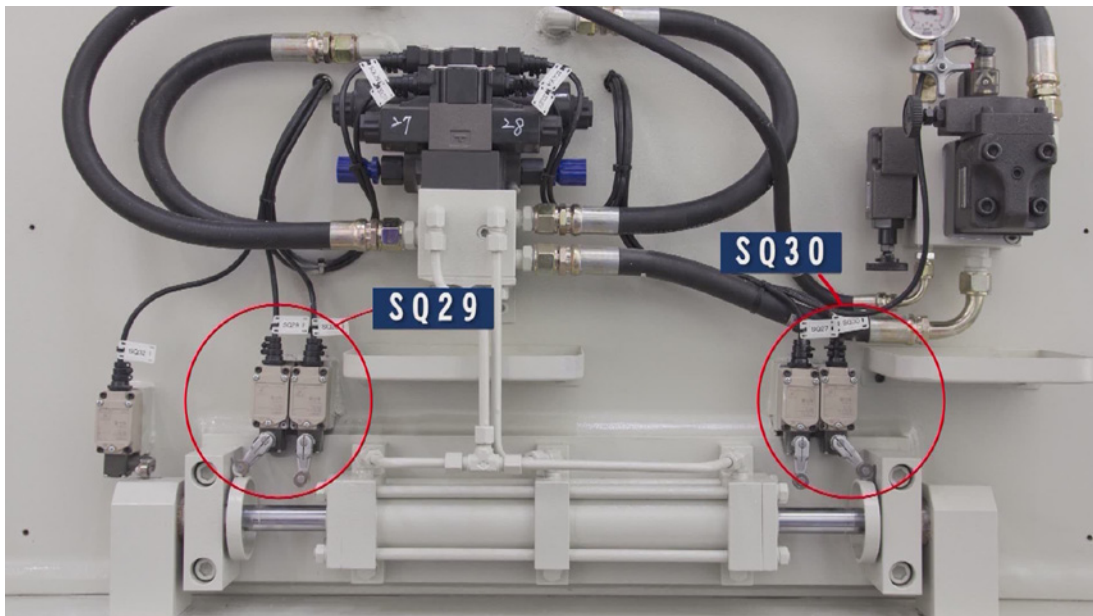
The cushion is not at the down limit position

**FAQ** 2. The bolster can't be moved out

## 2-12 Slide reversing plate position limit switch not activated

### Solution:

- A. Check that the weight of the mold does not exceed the design limit.
- B. Check the limit switches - SQ29 & SQ30.



Check the limit switches - SQ29 & SQ30

**FAQ** 2. The bolster can't be moved out

## 2-13 Slide reversing lock pin is not fully in place

---

**Solution:**

- A. Check that the weight of the mold does not exceed the design limit.
- B. Check the limit switches - SQ29 & SQ30.

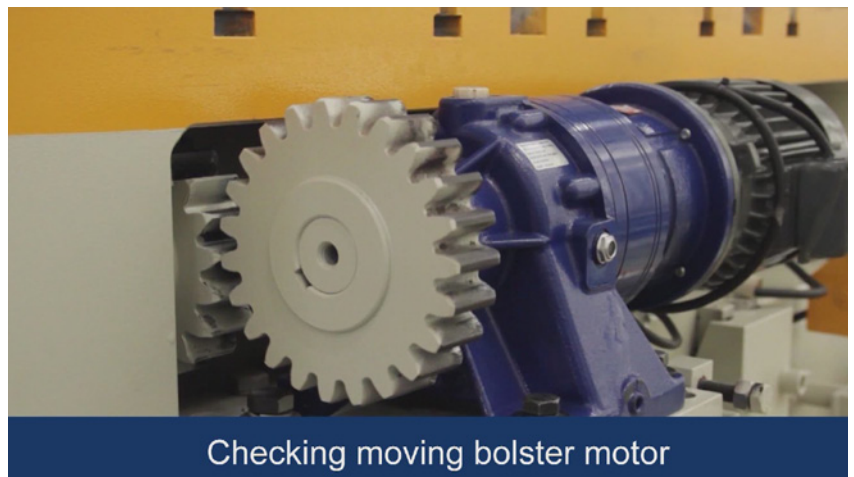


**FAQ** 2. The bolster can't be moved out

## 2-14 The moving bolster motor is out of order

### **Solution:**

If bolster motor is broken, replace it with a new one.



Checking moving bolster motor

The moving bolster motor is out of order

**FAQ** 2. The bolster can't be moved out

## 2-15 Moving bolster gear box damaged

---

## 3-1 Push button error

### ■ 3-1-1.

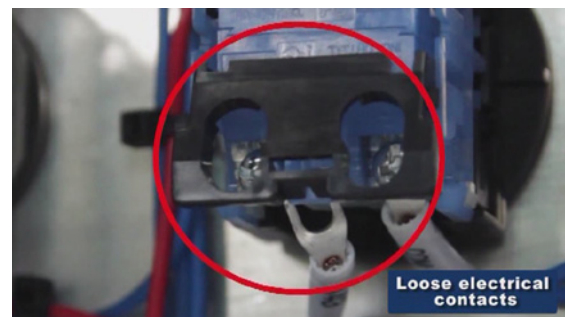
#### Checking electric poing



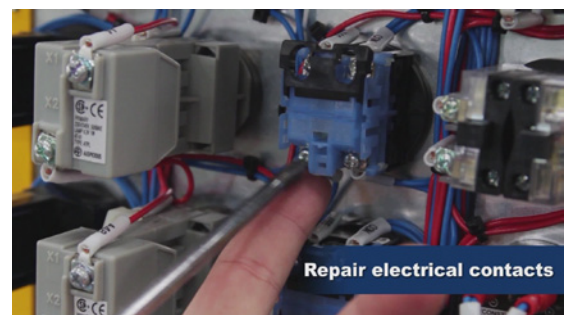
Checking electric poing

#### **Solution:**

- A. Checking electric point.
- B. Checking the button wiring(cable).
- C. If the wiring is ok, please replace a new button.



Checking electric point



Checking the button wiring(cable)

## 3-1 Push button error

### ■ 3-1-2. Bolster cable problem



Bolster cable problem

#### **Solution:**

- A. Checking the cable rewriter.
- B. Checking the cable.



Checking the cable rewriter



Check electrical cable

**FAQ** 3. The slide can't be moved down

## 3-2 Safety bar limit switch not activated

### Solution:

Checking two safety bars, make it close to the limit switch and hang the lock pin on.



Check safety bar is in contact with limit switch



Insert safety bar lock pin

- **If the problem still can't be solved, keep checking other points.**

**FAQ** 3. The slide can't be moved down

### 3-3 Safety fence is not closed

**Solution:**

Checking safety fence is closed or not.



Checking safety fence is closed or not



Checking safety fence is closed or not

- **If the problem still can't be solved, keep checking other points.**



**FAQ** 3. The slide can't be moved down

## 3-4 Check all E-stop buttons

### Solution:

Checking every E-stop button.



Checking every E-stop button



**FAQ** 3. The slide can't be moved down

## 3-5 Safety bar limit switch not activated

### Solution:

Safety bar  
limit switch not  
activated.



Check safety bar is in contact with  
limit switch



Insert safety bar lock pin

- **Problem not solved, please check limit switch.**
  - **Limit switch OK! Please check follow other item.**
  - **Limit switch NG! Change a new the same limit switch .**

**FAQ** 3. The slide can't be moved down

## 3-6 Anti-slip mechanisms are not locked

### Solution:

- A. Checking the air units.
- B. Checking the air pressure.



Checking the air units



Checking the air pressure

## 3-7 Check safety light curtain (if equipped)

### ■ 3-7-1. Lighting



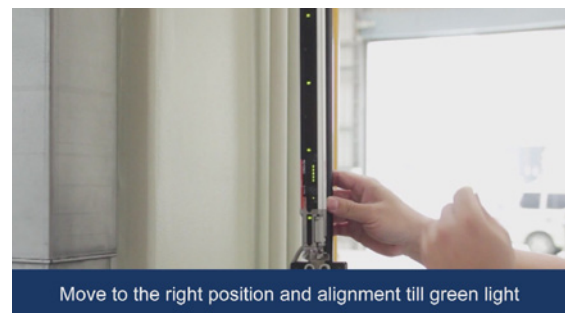
Two light curtains on position but not alignment

#### **Solution:**

It means the wiring(cable) is normal, and if you see the red light flashing, please correct position till see the green light.



Two light curtains on position but not alignment



Move to the right position and alignment till green light

■ **If the problem still can't be solved, keep checking other points.**

## 3-7 Check safety light curtain (if equipped)

---

### ■ 3-7-2. No lighting

It means wiring or cable has some problem, please check the wiring or cable first.

---

#### **Solution:**

A. If the wiring or cable is normal, it means light curtain is out of order, you can bypass this and use this machine temporarily.

A-1. The user to buy one set of the same light curtain.

A-2. Buy one set of new light curtain from Hsin Lien Hseng.

B. If the wiring or cable is un-normal.

B-1. Checking wiring and cable.

- **If the light curtain still no lighting after wiring and cable checking, it means the light curtain is out of order, you can bypass this and use this machine temporarily.**

**A-1. The user to buy one set of the same light curtain.**

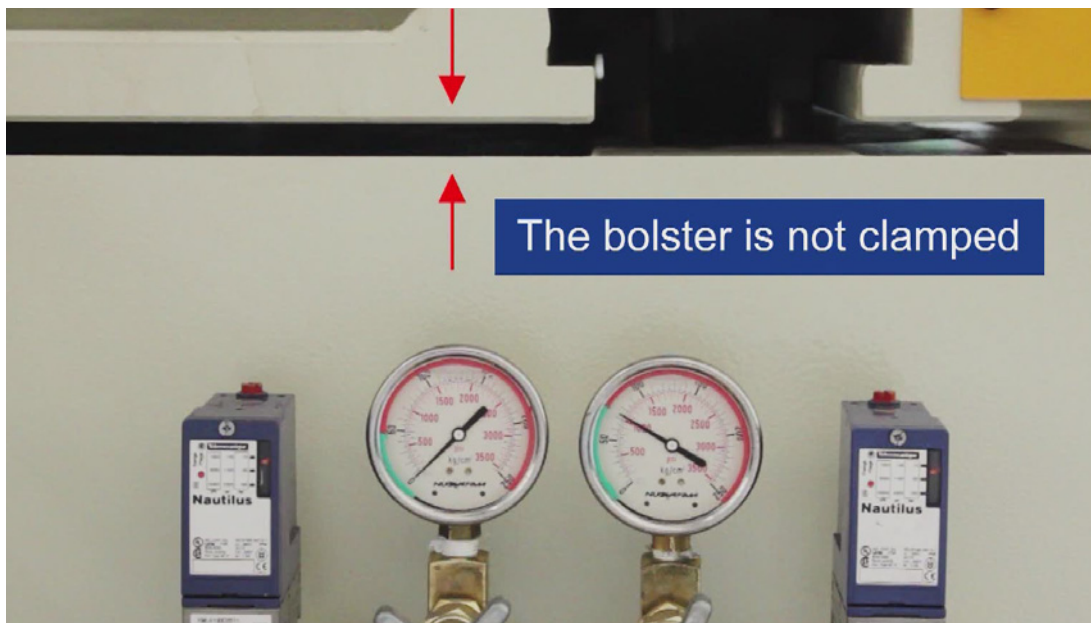
**A-2. Buy one set of new light curtain from Hsin Lien Hseng.**

**FAQ** 3. The slide can't be moved down

## 3-8 The bolster is not clamped

**Solution:**

Checking the oil circuit.



The bolster is not clamped



Switch to "CLAMP"

- If the problem still can't be solved, please contact Hsin Lien Hsheng



**FAQ** 3. The slide can't be moved down

## 3-9 The slide reversing plate is not correctly positioned (if equipped)

### ■ 3-9-1. The mold weight over the machine original design

**Solution:**

Status :Please use a lighter mold.

### ■ 3-9-2. The mode weight doesn't over the machine original design

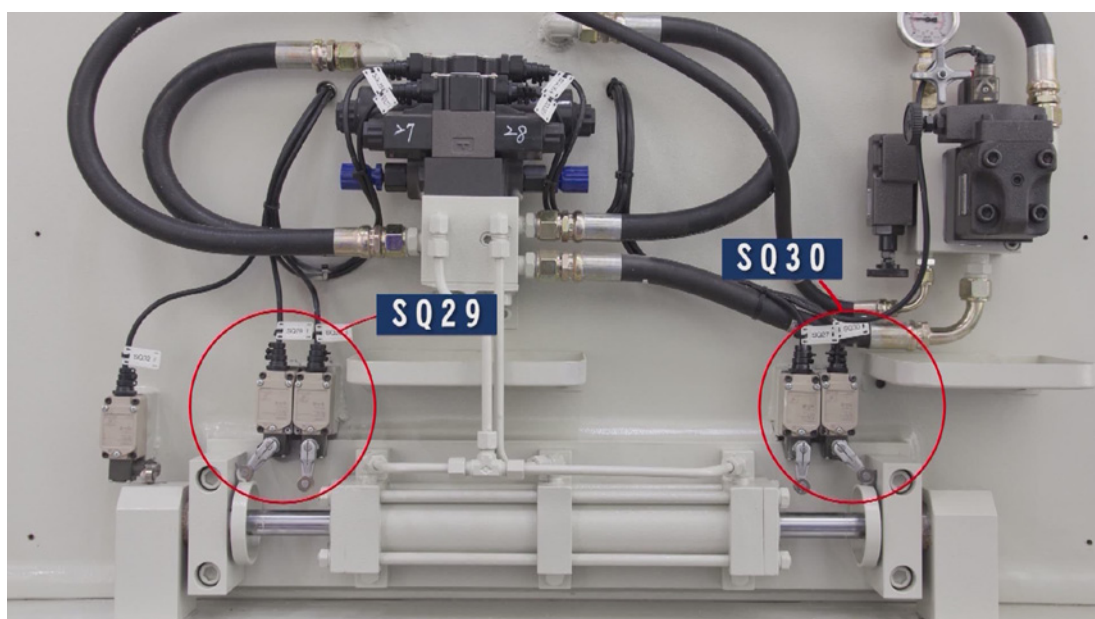
**Solution: Status**

Status :Oil circuit adjustment.

### ■ 3-9-3. The reversing plate is back to the original position, but the lock pins are not locked.

**Solution: Status**

Status :Please check the limit switch.



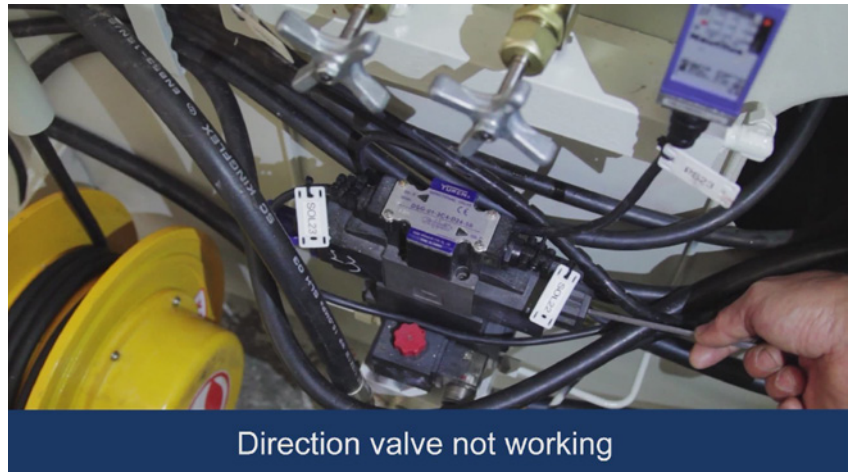
Check the limit switches - SQ29 & SQ30

**FAQ** 3. The slide can't be moved down

## 3-10 Direction valve not working

### **Solution:**

Status: Direction valve check manually.



Direction valve not working



**FAQ** 3. The slide can't be moved down

## 3-11 No pump pressure

---

**FAQ** 4. The slide reversing plate can't be reversed out

## 4-1 Push button error

### ■ 4-1-1.

#### Checking electric poing



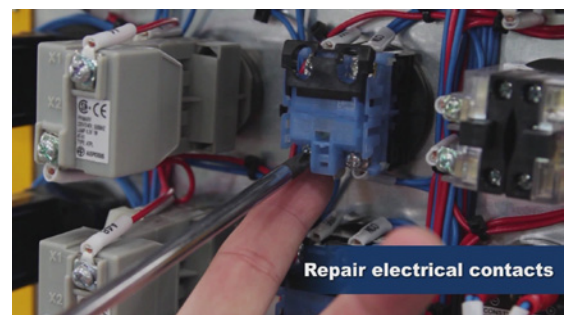
Checking electric poing

#### **Solution:**

- A. Checking electric point.
- B. Checking the button wiring(cable).
- C. If the wiring is ok, please replace a new button.



Checking electric point



Checking the button wiring(cable)

**FAQ** 4. The slide reversing plate can't be reversed out

## 4-1 Push button error

### ■ 4-1-2. Bolster cable problem



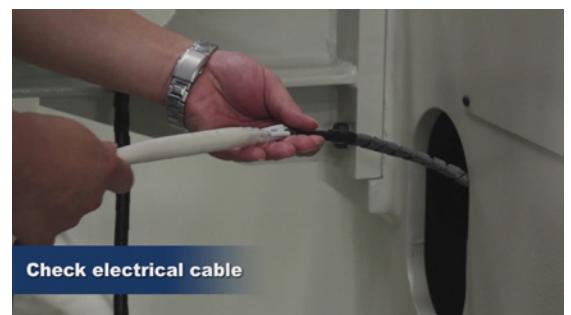
Check cable rewriter

#### **Solution:**

- A. Checking the cable rewriter.
- B. Checking the cable.



Checking the cable rewriter



Checking the cable

**FAQ** 4. The slide reversing plate can't be reversed out

## 4-2 Safety bar limit switch not activated

### **Solution:**

Checking two safety bars, make it close to the limit switch and hang the lock pin on.



Check safety bar is in contact with limit switch



Insert safety bar lock pin

- **If the problem still can't be solved, keep checking other points.**

**FAQ** 4. The slide reversing plate can't be reversed out

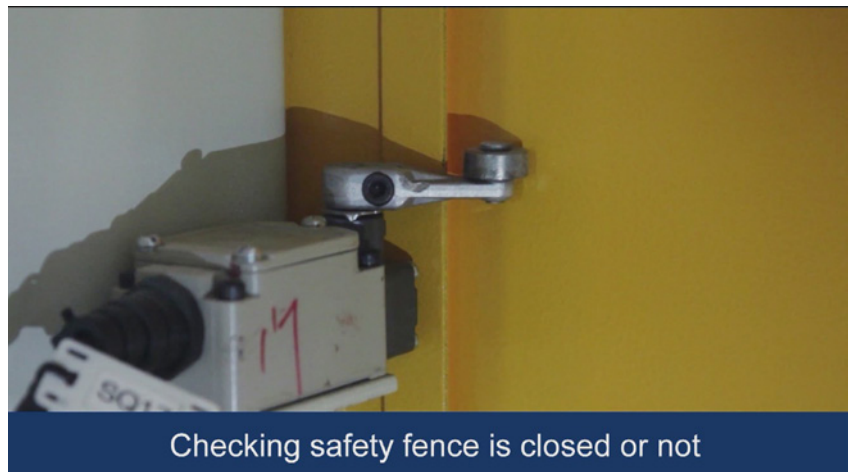
## 4-3 Safety fence is not closed

### Solution:

Checking safety fence is closed or not.



Checking safety fence is closed or not



Checking safety fence is closed or not

- **If the problem still can't be solved, keep checking other points.**

**FAQ** 4. The slide reversing plate can't be reversed out

## 4-4 Check all E-stop buttons

### Solution:

Checking every E-stop button.



Checking every E-stop button.



**FAQ** 4. The slide reversing plate can't be reversed out

## 4-5 Safety bar limit switch not activated

### Solution:

Checking two safety bars, make it close to the limit switch and hang the lock pin on.



Check safety bar is in contact with limit switch



Insert safety bar lock pin

- **Problem not solved, please check limit switch.**
  - **Limit switch OK! Please check follow other item.**
  - **Limit switch NG! Change a new the same limit switch.**

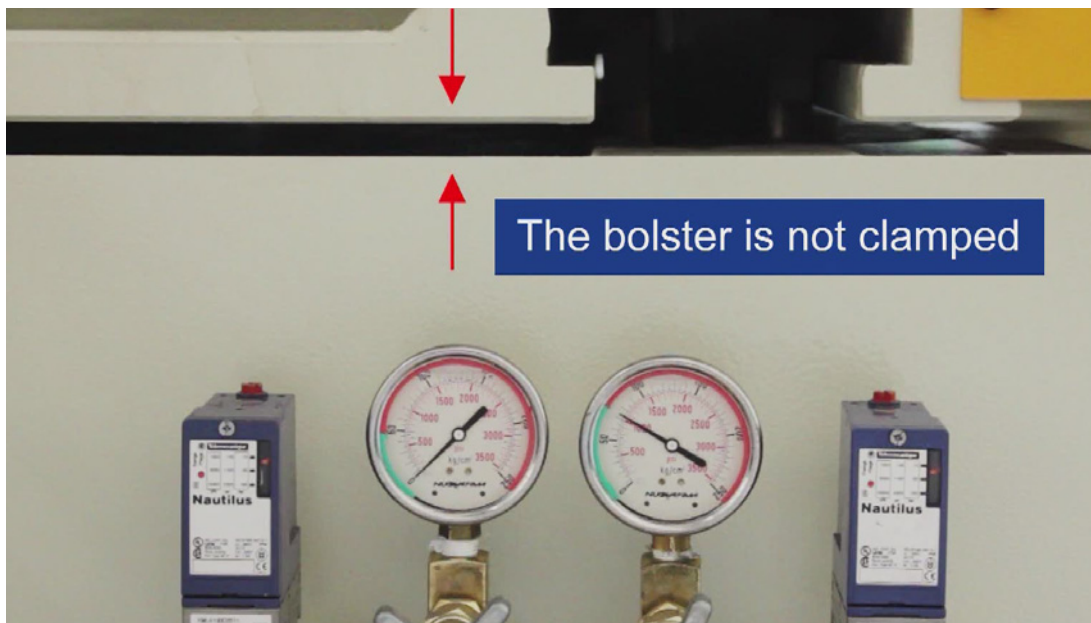


**FAQ** 4. The slide reversing plate can't be reversed out

## 4-6 The bolster is not clamped

### Solution:

The bolster is not clamped. Switch to "CLAMP".



The bolster is not clamped



Switch to "CLAMP"

- If the problem still can't be solved, please contact Hsin Lien Hsheng

**FAQ** 4. The slide reversing plate can't be reversed out

## 4-7 The moving bolster not moved to the rear limit switch

### **Solution:**

The moving bolster not moved to the rear limit switch.



The moving bolster not moved to the rear limit switch

**FAQ** 4. The slide reversing plate can't be reversed out

## 4-8 Slide is not located at the top of stroke

### **Solution:**

Slide is not located at the top of stroke.



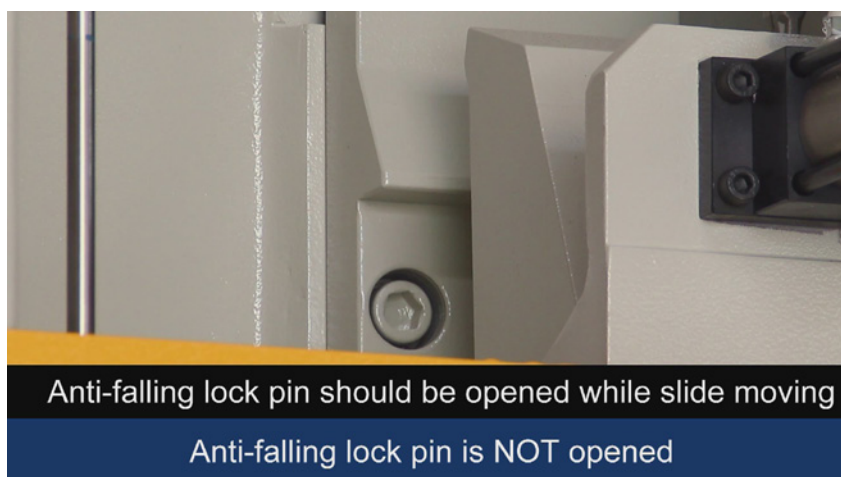
Slide is not located at the top of stroke

**FAQ** 4. The slide reversing plate can't be reversed out

## 4-9 Lock pins of anti-slip mechanisms are not locked

### **Solution:**

Anti-falling lock pin should be opened while slide moving.



Anti-falling lock pin should be opened while slide moving

**FAQ** 4. The slide reversing plate can't be reversed out

## 4-10 Simple hydraulic circuit check

---

**Solution:**

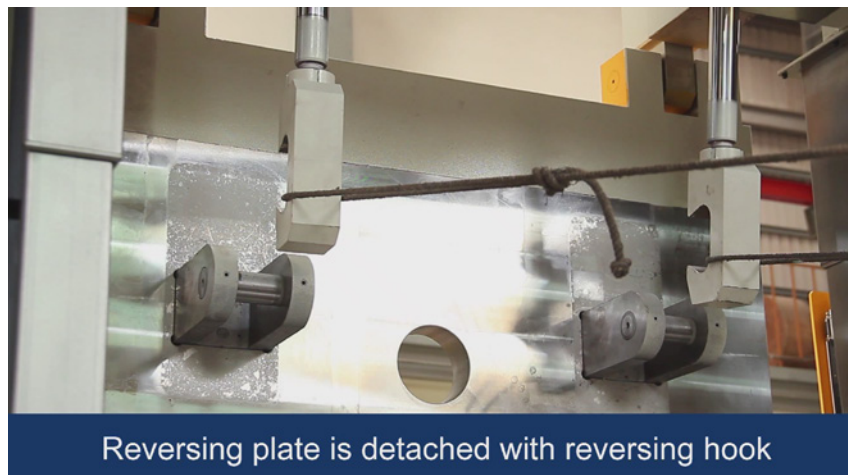
Simple hydraulic circuit check.

**FAQ** 5. Reversing plate is detached with reversing hook

## 5-1 Reversing plate is detached with reversing hook

### **Solution:**

Turn the reversing plate switch push button to "RETURN" and press it down.

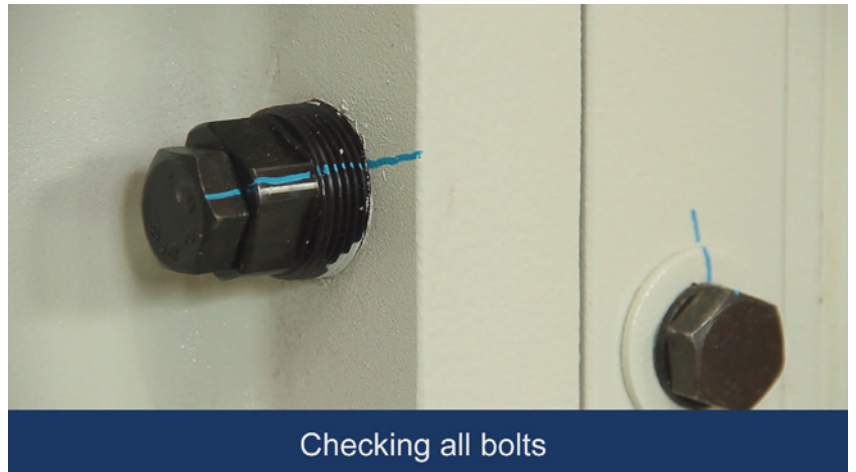


Turn the reversing plate switch push button to "RETURN" and press it down

## 6-1 Checking all bolts

**Solution:**

Checking all bolts.



Checking all bolts



## 6-2 Checking lubrication oil

**Solution:**

Checking  
lubrication oil.

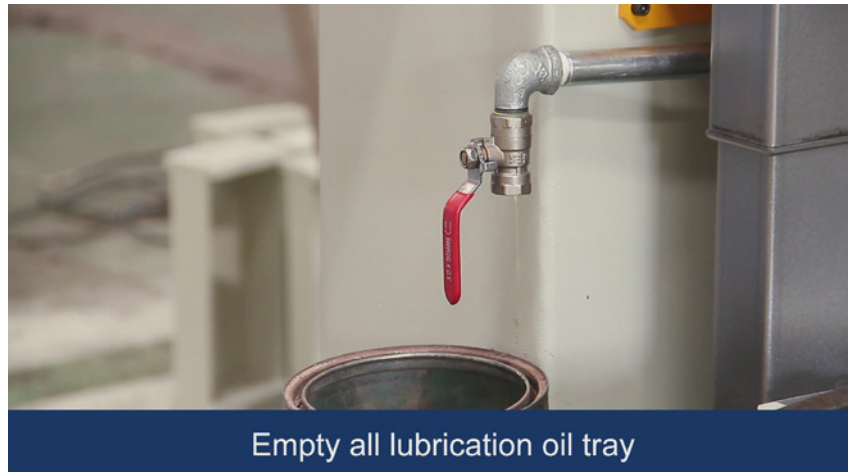


Checking lubrication oil

## 6-3 Empty all lubrication oil tray

**Solution:**

Empty all lubrication oil tray.



Empty all lubrication oil tray

## 6-4 **Check all tubes and hoses if any oil leakage by visually and hand touch**

### **Solution:**

Check all tubes and hoses if any oil leakage by visually and hand touch.

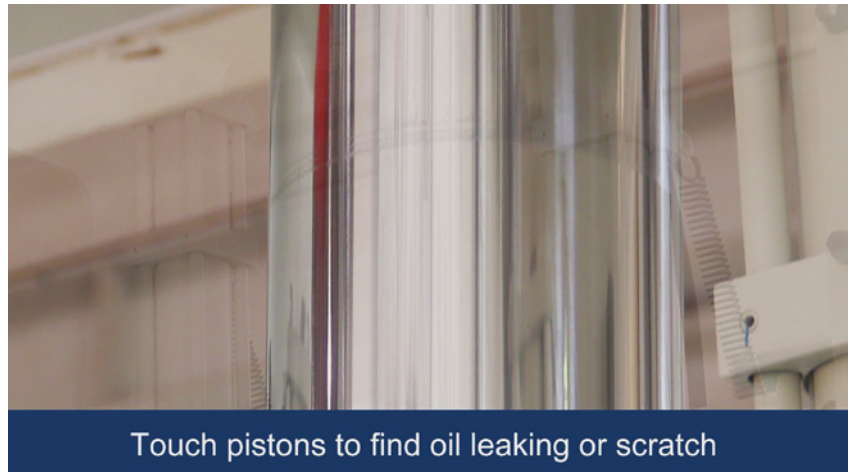


Check all tubes and hoses if any oil leakage by visually and hand touch

## 6-5 Touch pistons to find oil leaking or scratch

**Solution:**

Touch pistons to find oil leaking or scratch.

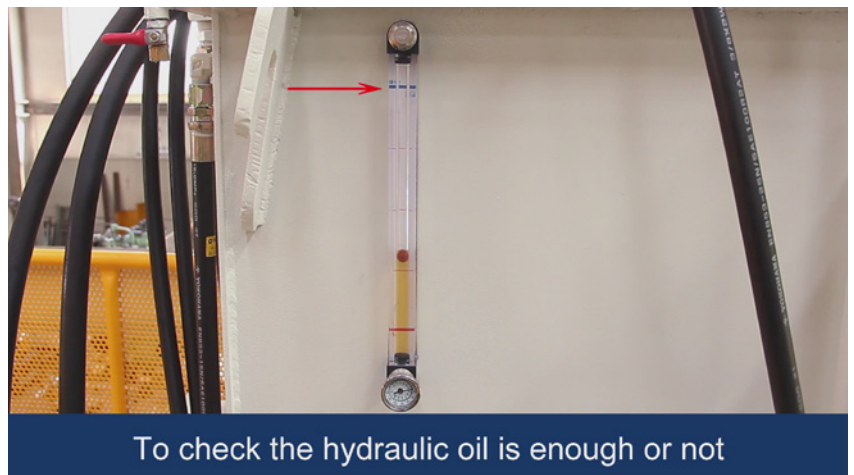


Touch pistons to find oil leaking or scratch

## 6-6 To check the hydraulic oil is enough or not

**Solution:**

To check the hydraulic oil is enough or not.



To check the hydraulic oil is enough or not

## 6-7 To check all tubes and hoses for oil leaking

### **Solution:**

To check all tubes and hoses for oil leaking.

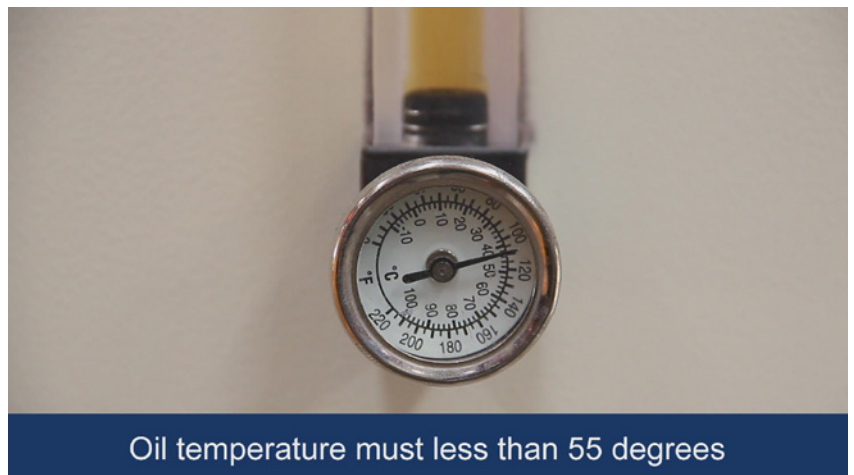


To check all tubes and hoses for oil leaking

## 6-8 Oil temperature must less than 55 degrees

### **Solution:**

Oil temperature must less than 55 degrees.



Oil temperature must less than 55 degrees



## 6-9 Cleaning machine surface

**Solution:**

Cleaning machine surface.

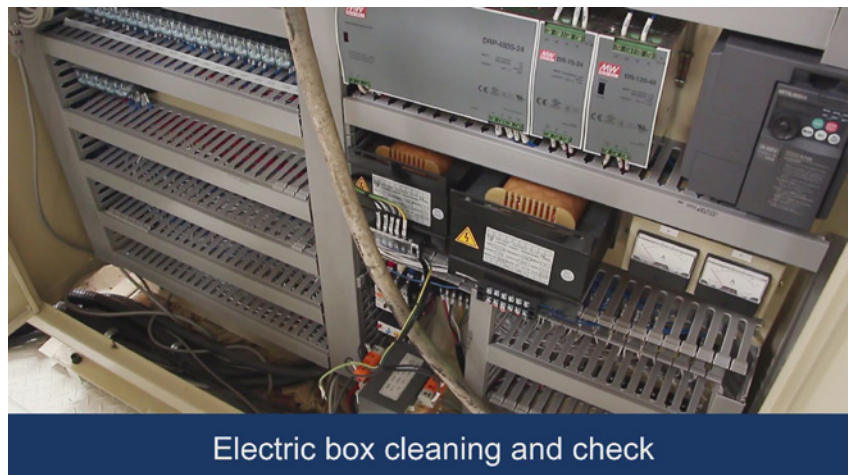


Cleaning machine surface

## 6-10 Electric box cleaning and check

### **Solution:**

Electric box cleaning and check.



Electric box cleaning and check

## 6-11 Oil filter cleaning

### Possible Problems:

Empty oil inside → Filter cleaning → Magnetic bar cleaning  
→ Assemble O-ring → Wrapping with tape



Oil filter cleaning



## HSIN LIEN SHENG MACHINERY CO., LTD.

No. 33, Rd. 36, Industrial Area, Taichung, Taiwan  
T +886-4-2350-4050    E [hlsmltd@seed.net.tw](mailto:hlsmltd@seed.net.tw)  
F +886-4-2350-4118    W [www.prosperous.com.tw](http://www.prosperous.com.tw)



Handwritten signature or mark below the QR code.

ISO 9001  
BUREAU VERITAS  
Certification



17-0000



## HSIN LIEN SHENG MACHINERY CO., LTD.

No. 33, Rd. 36, Industrial Area, Taichung, Taiwan

T +886-4-2350-4050    E [hlsmltd@seed.net.tw](mailto:hlsmltd@seed.net.tw)

F +886-4-2350-4118    W [www.prosperous.com.tw](http://www.prosperous.com.tw)



Handwritten signature or mark below the QR code.

ISO 9001  
BUREAU VERITAS  
Certification



17-0000