

Manual

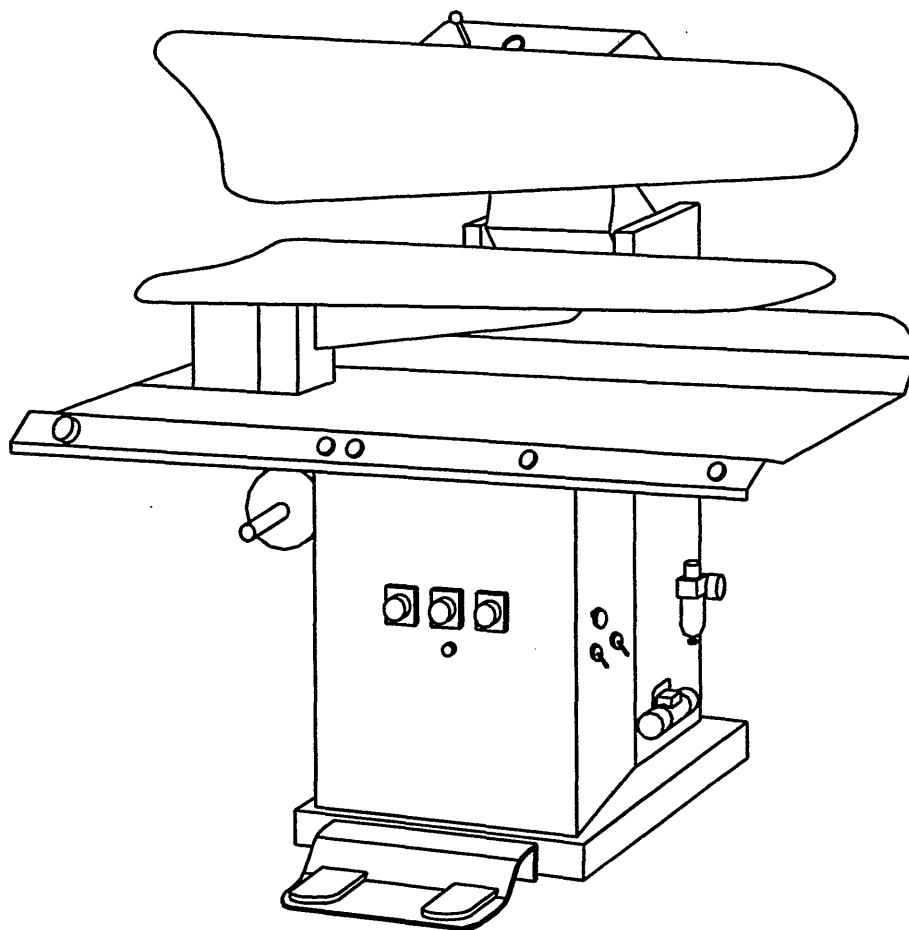
Utility press


cissell

made by

PANTEX

2000



Model: CU 19, 24, 41, 45, 47, 50, 52, 220, 226, 439, 441,
444, 446, 448, 487.

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Type :70 Air operated press, button operated.
Luchtbediende pers, knop bediend.
Luftbediente Press, Knopf-bediend.
72 Timer operated, button operated.
Timer gestuurd, knop bediend.
Zeituhr Steuerung, Knopf-bediend.
73 Air operated press, foot pedal control.
Luchtbediende pers, pedaal bediend.
Luftbediente Press, Fußpedal bedienung.

Part No. D0109 M:\HANDBOEK\CISSELL\CU\CUENG

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Enclosure A: Machine survey spare parts

Enclosure B: Air circuit

Enclosure C: Electrical circuit

3 Introduction

The presses are for the pressing of all kinds of garments and laundry. This PRESS is air-operated (type code /70 head-lever operated, type code /73 foot pedal operated) or timer controlled (type code /72).

All the numbers and capitals in this manual indicated in brackets (), refer to the numbers/capitals of the different machine drawings.

Important:

- ! Read this manual first before installation and before taking the machine into use.
- ! All the installation, repair, adjusting and maintenance activities should be carried out by experts.



The press can take a steam pressure of 6 bar maximum. A higher pressure could bring along safety risks or lead to damage to the machine. Recommended working pressure: 6 bar.



A higher compressed air pressure than 6 bar is not allowed for an higher pressure could bring along safety risks or damage the machine. Recommended working pressure: 5 bar.

- ! Take care for good survey and create enough working space around the machine.

Advice: Keep the manual somewhere near the press.

4 Technical data

Model : CU 19, 24, 41, 45, 47, 50, 52, 220, 226, 439, 441, 444, 446, 448, 487
Type : 70 Air operated presses, button operated
72 Timer operated presses, button operated
73 Air operated presses, foot pedal operated

Maximum allowed steam pressure	: 6 bar
Recommended working pressure	: 6 bar
Steam consumption (steam pressure of 6 bar)	: 12-15 kg/hour

Maximum allowed air pressure	: 6 bar
Recommended working pressure	: 5 bar
Air consumption (air pressure of 5 bar)	: 30 l/min.

Voltage (type code /72)	: 230/50/1
Power	: 0,6 A
Electrical consumption	: 125 W

Weight	CU 19, 24, 220, 226: 220 kg
	CU 41, 45, 47, 50, 52: 260 kg
	CU 439, 441, 444, 448, 487: 280 kg
Floor surface	CU 19, 24, 220, 226: 1000 x 950 mm
	CU 41, 45, 47, 50, 52: 1400 x 950 mm
	CU 439, 441, 444, 448, 487: 1400 x 950 mm

Temperature pressing shoes	covered: approx. 130 °C
	uncovered: approx. 160 °C

Sound pressure	: <70 dB(A)
(A-weighted equivalent continuous sound pressure)	

5 Installation

5.1 Transport and positioning

☞ **Mind your safety! Wear safety shoes and working gloves.**

- Leave the machine on the pallet for transport to its location.
- Avoid shakes.
- Use a lifting device for transport and for moving it into position.
- Handle the machine only by its frame.
- Take care for enough working space around the machine.
- Check the stability and fix the machine with 4 bolts (M10 x 100mm) in case of an uneven floor.

5.2 Connections

☞ **When making the connections to the machine, take utmost care to ensure that no dirt or other materials enter the lines, since this may cause the machine to malfunction.**

5.2.1 Steam

☞ **Mind your safety! Wear working gloves!**

Connection: ½" BSP

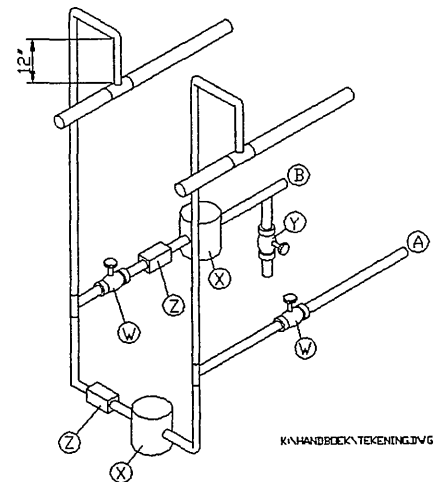
Maximum steam pressure: 9 bar.

Recommended working pressure: 6 bar

A :	Steam supply	X :	Steam trap
B :	Steam return	Y :	Blow off cock
W :	Shut off valve	Z :	Non-return valve

Instructions to connect the steam lines:

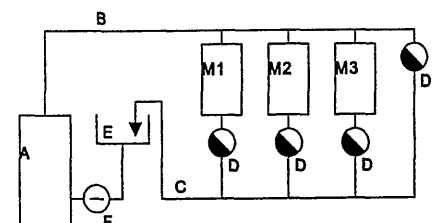
- Connect the steam lines according to illustration 1.
- Avoid condensation to enter the machine: Connect the branches of the supply and return lines in such way that they run at least 300mm upward first.
- Flush the connected steam lines with steam from the steam supply.
- Install a steam trap and non-return valve as close as possible to the connection of the machine (mark the entry and exit).
- Install a shut off valve in both supply and return lines in order to be able to shut off the machine from the steam lines, for instance for repair activities.
- To get dry steam the connection of a steam trap with non-return valve on the lowest point of the supply to the drainage (dotted line fig. 1) is recommended. Mark the marking 'entry' and 'exit'.
- Connect the machine to the steam lines.



5.2.2 Steamline systems

Open system

Mount a steamtrap (D) at the end of the steam supply line (B) and at the end of each connected machine. The condensate will be led to the watertank (E) through the condense return line (C). The condensate in the watertank will be pumped in the boiler (A) through pump (F). Disadvantage of the open system is the loss of energy and an increasing fault sensibility.



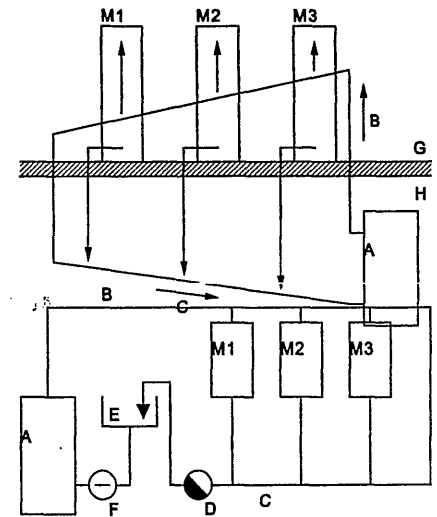
Closed system

The condensate ends up in the boiler (A) through a down going condensate return line (C). The waterlevel of the boiler (A) has to be lower than the lowest condensate output of the connected machines! There will be no loss of energy. The energy savings in regard to the open system is approximately 33%.

This system gives the lowest installation costs. When the system works well, the system will work well for years.

Half open system

This system is conform the open system. The only difference is that in this system at the end of the ringline (B,C) a steamtrap has to be mounted. This steamtrap brings the condensate in a watertank (E). The condensate in the watertank (E) will be pumped in the boiler (A) through the pump (F). In this system the waterlevel in the boiler (A) can be higher than the condensate output of the connected machines. The energy saving in regard to the open system is approximately 20%. This system will operate fault free for years.



A : Boiler	D : Steamtrap	G : Work room
B : Steam supply line	E : Watertank	H : Boiler room
C : Condensate return line	F : Pump	M : Machine

5.2.3 Compressed air

- **Attention:** Avoid dirt to enter in the compressed air line for it might damage the machine.
- Connect a 1/4" compressed air line to the air control (8) of the machine.
- **Attention:** the upper shoe will rise automatically!

☞ **Mind your safety! The compressed air can have a pressure of 6 bar maximum. A higher pressure might damage the machine. Recommended working pressure: 5 bar.**

5.2.4 Electricity



☞ **Mind your safety! Never touch cords or plugs with wet hands!**
A plug hasn't been installed at factory.

5.2.5 Vacuum

- Connect the press with a 2" gas pipe to the main vacuum line (D). The connection is on the left of the press, under the table.

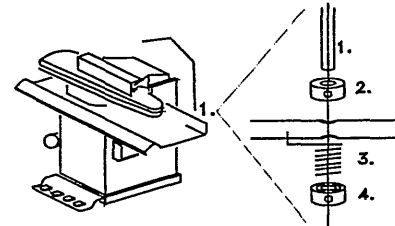
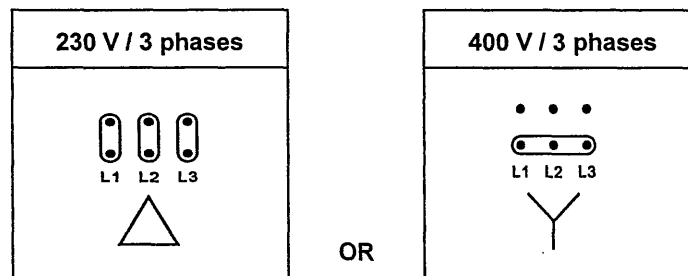


Figure 2: Support rod

5.3 Built-in vacuum (code 358)

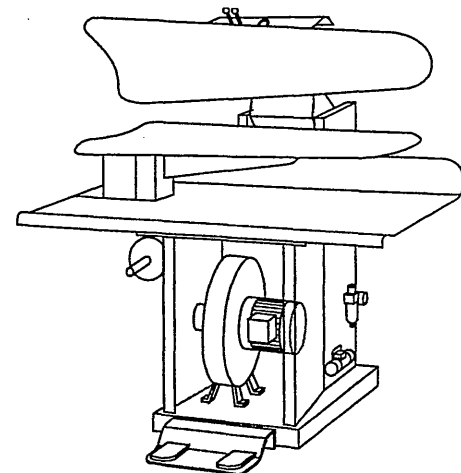
- Remove cover electrical connection of the blower (100).
- Connect the main power supply according to figure 4.



- Mount cover electrical connection of the blower.
- Mount a plug (if you want with a switch).

Check rotating direction of blower (100):

- Switch on the main power.
- Press left footpedal (11, vacuum buck) and check with the aid of a piece of paper whether or not the buck (5) is exhausted sufficiently. If not, change the electric connections L1 en L2.



5.4 Support rod

See figure 2:

- Slide adjusting ring 2. around the "support rod" 1.,
- Put the "support rod" through the hole of the pipe,
- Mount the spring 3. and the springholder in such a way that the "support rod" automatically turns back in the base position by the force of the spring after using the steam iron.
- Make sure that the steam hoses cannot come between the head and the buck.

5.5 Iron plate brace

See figure 3:

- Turn the iron plate as far as possible to the pressing shoes.
- The iron plate may not be located under the safetybar (1).
- Loosen the two bolts (A), slide brace (B) to the outside until the plate is not located under the safetybar anymore.
- Tighten the two bolts (A) again.

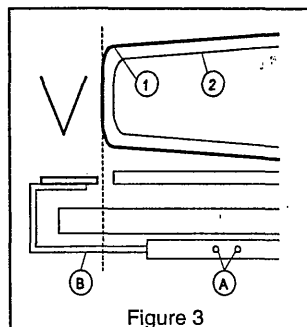


Figure 3

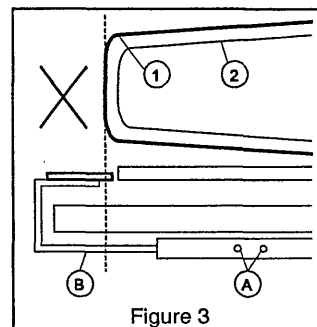


Figure 3

6 Put into operation

☞ Think of your own and other people's safety!

Create a clean, surveyable and spacious working environment.

Make sure that nobody is standing behind the machine.

☞ Check the following points daily!

- Only for steam heated machines: Check the steam pressure (maximum 6 bar, recommended working pressure 6 bar), close the blow off cock (Y, see figure 1) and open the steam shut off valves (W) completely.
- Connect an air pressure line (1/4" BSP) to the air control (8) and set the desired air pressure on the air control (maximum 6 bar, recommended air pressure 5 bar).
- Type code /72: Plug in the wall socket.
- Check the working of the Emergency Switch :
 - Operate the buttons (6), by which the press closes.
 - Touch the Switch with your hand when the press is closed.
 - The head (4) will return into its starting position IMMEDIATELY.
 - Turn the safety switch (32).
- Consult chapter 'Trouble shooting' in case of malfunctions.
- In case of leakage or defects, always call for an expert.
- Let the machine warm up for about 20 minutes.
- Ready for use.



7 How to operate

7.1 User directions

! Use the press only for the treatment of clothes.

! Preferably a compressed air pressure of 5 bar and a steam pressure of 6 bar should be used. Higher pressures may cause the machine to malfunction.(maximum compressed air pressure: 6 bar, maximum steam pressure: 6 bar).

! Maintenance and repair activities are to be executed by a qualified serviceman.



☞ Not following the instructions of this manual may lead to injury or to damage to the machine!

☞ Caution: After a while, the head (4) will get warm. The downside of the buck (5) and the steam connections at the backside of the machine are hot. Do not touch these!

7.2 User instructions:

☞ Think of your own and other people's safety!

Create a clean, surveyable and spacious working environment!

Make sure that nobody is standing behind the machine!

7.2.1 Operation functions

- Buttons (6)** (type code /70, /72)
Foot pedal (6) (type code /73)
 Closing head while buttons are operated.
 Type code /72: As long as the buttons are operated, the garment to be pressed will be steamed (only if selector switch 'automatic head steam' (7) is on).
- Selector switch 'automatic head steam' (7)**
 (type code /72)
 When the selector switch 'automatic head steam' is selected on, head steam will be given while operating the buttons (6) / foot pedal (10).
- Pressure control (12)**
 (type code /72)
 Set a pressure for the material to press.
Notice: The pressure setting can be read on manometer (14) when button 'pressing' (1) is operated.
Warning: Set a lower pressure for the pressing of delicate material and a higher pressure for thicker, less delicate material.
- Button 'pressing' (1)**
 When the head (4) is closed (the buttons (6) pressed in), the garment can be pressed by operating button 'pressing' (1). The pressure setting can be read on manometer (14). The pressure can be adjusted with lever (1) (type code /70 and /73) or with the pressure control (12) (type code /74).
 The pressing can be stopped by operating foot pedal (11).
- Lever 'head steam' (2)**
 Manual head steam for the garment as long as the lever (2) is operated.
 Type code /72: Will also work when selector switch 'automatic head steam' (7) is off.
- Foot pedal 'up-steam' (9)**
 Before pressing, if the garment is too dry, you can make the garment damp by giving up-steam.
- Foot pedal 'opening and vacuum' (11)**
 By operating this foot pedal **before** starting pressing, the buck will be sucked vacuum for better positioning of the garment.
While pressing the pressing can be stopped by operating this foot pedal: the head will come up and the buck is sucked vacuum as long as the foot pedal is operated (cooling off the garment for the tenability of the pressing quality).
- Fast/slow opening head (40)**
 (type code /72)
 You can let the head open more slowly when for instance the garment comes up with the head.



7.2.2 Tips for use

- Only press garments when they are damp.
- Short pressing duration for synthetic fibres, longer duration for cotton/linen.
- The foot switch (11) can also be used as emergency stop, because the press will open as soon as this pedal is operated.
- Advice: Take care for a maximum temperature of 35°C on the operators position at an ambient temperature of 25°C and an relatively humidity of 65%.
- Take care for sufficient ventilation.
- Take care for sufficient light on the workshop.

7.2.3 Order of operation:

☞ Consult chapter 'Trouble shooting' in case of trouble or malfunction.

Manual operation (type code /70, /73)

- Before pressing, if the garment is too dry, you can make the garment damp by giving up-steam (foot pedal 9).
- Press foot pedal (12) 'vacuum' for better positioning of the garment and keep it pressed in.
- Close head (4) by operating buttons (type code /70) or foot pedal (type code /73) (6). **Release foot pedal (11) when the head (4) is closed.**
- Start the pressing by operating button 'pressing' (1). Release buttons (type code /70) or foot pedal (type code /73) (6) after operating lever 'pressing' (1).

Warning: Set a lower pressure for the pressing of delicate material and a higher pressure for thicker, less delicate material.

- The pressing can be stopped by operating foot pedal (11). The head will go up and the buck will be sucked vacuum for as long as the foot pedal (11) is operated (cooling off the garment for the tenability of the pressing quality).
- During pressing head-steam (2) and up-steam (9) can always be given.

Advice: A steam-time longer than 5 seconds is not recommended, because too much steam can have an drying effect on the garment.

Timer controlled operation (type code /72)

- Timer steaming (46): Set the desired steam time.
Advice: A steam-time longer than 5 seconds is not recommended, because too much steam can have an drying effect on the garment.
- Timer pressing (47): Set the desired pressing time.
Advice: Short pressing duration for synthetic fibres, longer duration for cotton/linen.
- Timer vacuum (44): Set the desired vacuum time.
(cooling off the garment for the tenability of the pressing quality)
- Select automatic head steam on/off (selector switch 7) during operating buttons (6) (closing head).
- Adjust desired high pressure on the pressure controle (12).
Warning: Set a lower pressure for the pressing of delicate material and a higher pressure for thicker, less delicate material.
- Before pressing, if the garment is too dry, you can make the garment damp by giving up-steam (foot pedal 9).
- Press foot pedal (12) 'vacuum' for better positioning of the garment and keep it pressed in.
- Close head (4) by operating buttons (6). **Release foot pedal (11) when the head (4) is closed.**
Keep buttons (6) pressed in to steam the garment (only active when selector switch 'automatic head steam' is on) and to keep the head (4) closed.
Advice: A steam-time longer than 5 seconds is not recommended, because too much steam can have an drying effect on the garment.
- Start the pressing by operating button 'pressing' (1). Release buttons (6) after operating button pressing' (1).
- During pressing head-steam (2) and up-steam (9) can always be given.

8 Put out of operation

- Type code /72: Remove the plug from the wall socket.
- Remove vacuum.
- Uncouple the compressed air line.

Warning! At disconnecting the air line the filtered water will be drained out of the air control (8).

☞ **Catch the water for it might contain oil remains.**

For steam heated machines only:

- Close the steam shut off valve (W, see figure 1).
- Blow of steam by opening the blow off cock (Y).

9 Trouble shooting



Mind your safety!

If you cannot solve the problems with the aid of table below, then call for an expert.

Table: Trouble shooting

Trouble	Check / solution
The machine does not work at all.	<ol style="list-style-type: none"> 1. Is a compressed air line connected to the air control (8)? 2. Check set-up air control (8), re-adjust (5 bar) if necessary. 3. Turn the Emergency Switch to put the pressure back on the system. 4. Type code /72: Plugged-in? <p>Engineer:</p> <ol style="list-style-type: none"> 5. Check functioning air valves (32) and (33), repair or replace if necessary. 6. Check functioning air valve (34), repair or replace if necessary.
Head (4) does not close	<ol style="list-style-type: none"> 1. Head (4) only closes when buttons (type code /70) or foot pedal (type code /73) (6) is operated. 2. Is a compressed air line connected to the air-control (8)? 3. Check set-up air control (18), re-adjust (5 bar) if necessary. 4. Turn the Emergency Switch to put the pressure back on the system. <p>Engineer:</p> <ol style="list-style-type: none"> 5. Check air valve 21. 6. Check functioning Emergency Switch (3) (air valves 33) 7. Check functioning exhaust valve (28), repair or replace if necessary. 4. Check functioning air cylinder (29).
Little or no head steam during closing of head (type code /72)	<ol style="list-style-type: none"> 1. Is selector switch 'automatic head steam' (7) on? 2. Are the steam shut off cocks fully open? 3. Check the steam pressure (maximum 6 bar). <p>Engineer:</p> <ol style="list-style-type: none"> 4. Check steam valve cylinder (15), re-adjust if necessary (see chapter 'Adjustments')
Head (4) closes, but gives no high pressure after operating button (1).	<ol style="list-style-type: none"> 1. Check set-up pressure control (12) (type code /72). 2. The machine will only press if foot pedal (11) 'opening and vacuum' is released. <p>Engineer:</p> <ol style="list-style-type: none"> 3. Check air valve (25) and exhaust valve (27), repair or replace if necessary. 4. Check functioning air valve (20), repair or replace if necessary. 5. Type code /72: Check to see if there is any air pressure from fabric feel valve (12). If no air pressure or very little adjustment of air pressure, replace or repair the fabric feel valve (12).
Little or no up-steam when operating foot pedal (9).	<ol style="list-style-type: none"> 1. Are the steam shut off cocks fully open? 2. Check the steam pressure (maximum 6 bar). <p>Engineer:</p> <ol style="list-style-type: none"> 3. Check steam valve cylinder (24), re-adjust if necessary (see chapter 'Adjustments'). 4. Check functioning air valve (19).
Insufficient or no vacuum on buck (5) when operating foot pedal (11).	<ol style="list-style-type: none"> 1. Check vacuum connection (D). 2. Check covering, replace. <p>Engineer:</p> <ol style="list-style-type: none"> 3. Check vacuum-unit. 4. Check cylinder (31) and vacuum valve. 5. Check functioning air valve (20) and air flow valve (30), replace if necessary.
Head (4) closes, but does not open by foot pedal (11).	<p>Engineer:</p> <ol style="list-style-type: none"> 1. Check functioning exhaust valve (27), repair or replace if necessary. 2. Check air valve (20).

10 Maintenance and repairs

10.1 Maintenance

Mind your safety!

Before starting maintenance activities:

- Type code 72: remove the plug from the wall socket,
- Remove air line from air control (8) (Attention: The reservoir of the air control will drain automatically when disconnecting the air line. Catch the water, it may contain oil remains),
- For steam heated machines: close the steam shut off valves (W, see figure 1), blow off steam (Y).
- Let the machine cool down.

• **Air control (8)**

The air filter (8) which is incorporated in the reducing valve, cleans and dries the air supplied from the main line.

Maintenance:

- Check at regular intervals whether dirt or condensate have accumulated in the clear plastic bowl.
- **Warning! The compressed air line should be removed.**
- Clean the air filter as follows:
 - unscrew the plastic bowl;
 - empty the bowl and clean it with petrol or turpentine (never use acids or detergents);
 - screw the bowl on the valve.Make sure that the sealing ring presses evenly on its seat and the bowl is properly and firmly tightened (by hand).

• **Oil-check**

Fill up oil if necessary:

- Remove the plug,
- Fill up the oil (Type: Unavis HP22 ISO VG 22)
- Mount the plug.

• **Covering**

 Do not wash the coverings!!!

10.2 Repairs/Dismantling

Mind your safety!

Before starting repair or dismantling activities:

- Type code I72: Remove the plug from the wall socket,
- Remove air line from air control (8) (Attention: The reservoir of the air control will drain automatically when disconnecting the air line. Catch the water, it may contain oil remains),
- For steam heated machines: close the steam shut off valves (W, see figure 1), blow off steam (Y).
- Let the machine cool down.

 All repair activities are to be carried out by a qualified serviceman.

For repair activities consult addition A containing detail drawings with spare parts.

To be able to execute the repair activities, the panels mounted on the frame of the machine can be removed.

In case some parts have become defective, contact the distributor to order new parts (see table 'spare parts').

Use only original parts!


When the repairs have been completed, put the panels back into place before taking the machine into operation again.

10.3 Adjustments


 **Mind your safety!**

Before starting adjustment activities:

- Type code /72: Remove the plug from the wall socket,
- Remove air line from air control (8) (Attention: The reservoir of the air control will drain automatically when disconnecting the air line. Catch the water, it may contain oil remains),
- For steam heated machines: close the steam shut off valves (W, see figure 1), blow off steam (Y).
- Let the machine cool down.

 **All adjustment activities are to be carried out by a qualified serviceman.**

- **Steam quantity buck & head**

 **The steamvalves are hot! Do not touch them. Use working gloves.**

! Don't ever set the steam quantity to its maximum. Too much steam causes wet coverings and garments after steaming and pressing.

- **Steam quantity head (4):**
 1. Unscrew nut of steam valve (15).
 2. Set the suitable steam quantity by adjusting the bolt.
 - In = less steam
 - Out = more steamCheck the steam quantity by starting the press.
 3. Fasten the nut.
- **Steam quantity buck (5):**
 1. Remove the cover.
 2. Unscrew the nut of steam valve (24).
 3. Set the suitable steam quantity by adjusting the bolt.
 - In = less steam
 - Out = more steamCheck the steam quantity by starting the press.
 4. Fasten the nut.
 5. Mount the cover.

11 Spare parts

Order spare parts by contacting your distributor.

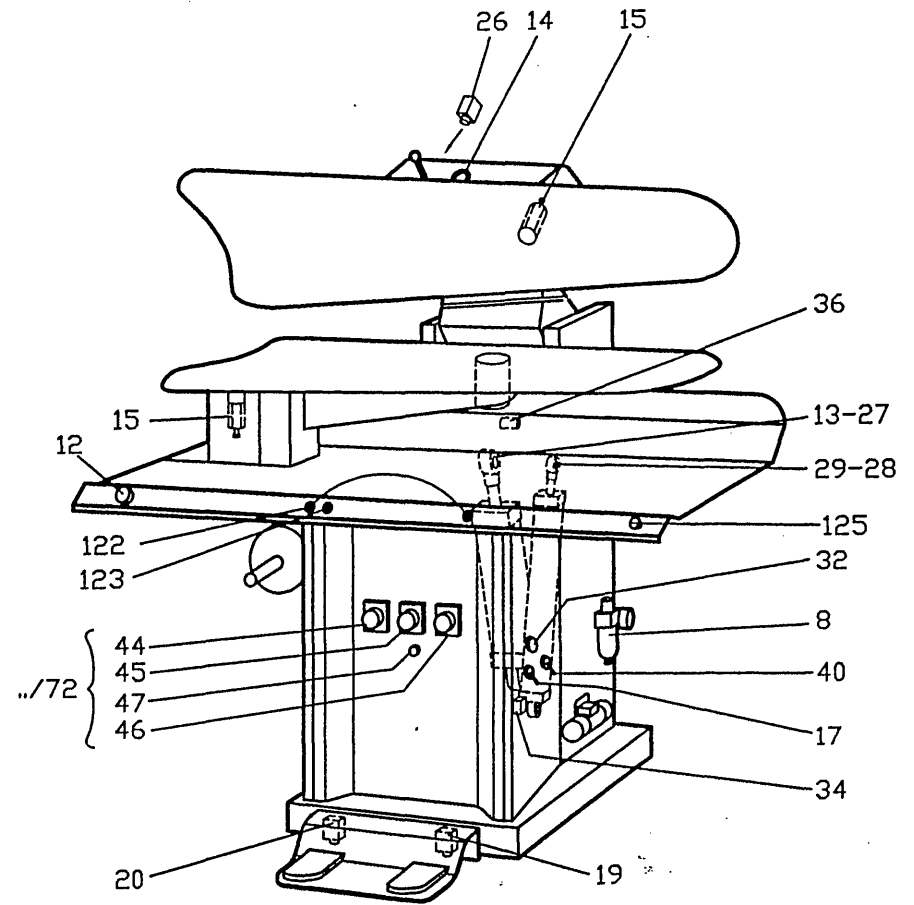
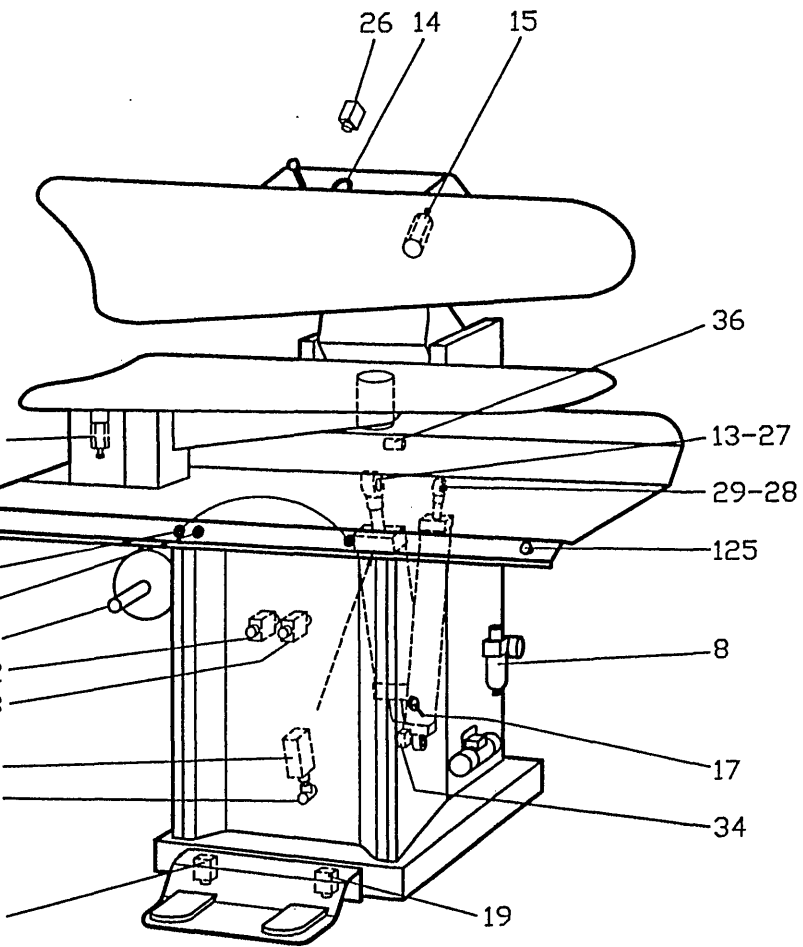
Do not use any parts but original spare parts!

Table: Spare parts

Nr.	Discription	Art.nr.	Nr.	Discription	Art.nr.	Nr.	Discription	Art.nr.
1			31	Cylinder	119077	100		
2			32			101	Valve	35232
3			33			102	Seat	15081
4			34			103	Ball stud	97402
5			35	Air valve (/72)	118541	104	Mounting plate	97403
6			36	Check valve (/72)	117106	105	Headlever	
7			37	Air valve (/72)	119284	106	Main shaft	96683
8	Air control	119277	38	Air valve (/72)	118542	107	Bearing	81058
9			39	Air valve (/72)	118542	108	Ball end	85010
10			40	Air valve (/72)	118587	109	Connecting rod	97166
11			41	Air valve (/72)	118541	110	Oil brake	115033
12	Fabric feel valve	118552	42	Shuttle valve (/72)	118592	111	Steam hose	80507
13	Cylinder CU 19,24,41,45,47 CU 50,52 CU 439,441,444,448,487	119187 119073	43	Air valve (/72)	118541	112	Check valve	80021
14	Gauge	80949	44	Timer (/72)	70828	113	Spring	50039
15	Steam valve	115609	45	Timer (/72)	70828	114	Valve	
16	Air flow valve	80846	46	Timer (/72)	70828	115	Head assy	Model nr.
17	Air valve	118587	47	Switch (/72)	70821 +70826	116	Head covering	Model nr.
18	Shuttle valve (/70/73)	118592	48			117	Buck assy	Model nr.
19	Air valve	118572	49	Solenoid valve (/72)	118602	118	Buck covering	Model nr.
20	Air valve	118572	50	Solenoid valve (/72)	118602	119		
21	Air valve (/70/73)	118572	51	Pressure switch	70749			
22	Air valve (/70/73)	118542	52	Transformer (/72)	122	Push Button black	119169
23	Air valve (/70/73)	118542	53	Fuse (/72)	70579	123	Push B. coloured	119532
24			54			124	2-Hand module	118662
25			55			125	Emergency stop	119529
26	Air valve	118572	56			126	Main valve	119155
27	Exhaust valve	110025	57			127	Valve	118542
28	Exhaust valve	110025	58	Fuse (/72)	70111	128	Check valve	113156
29	Cylinder	119072	59					
30	Air flow valve (/72)	95369	60					

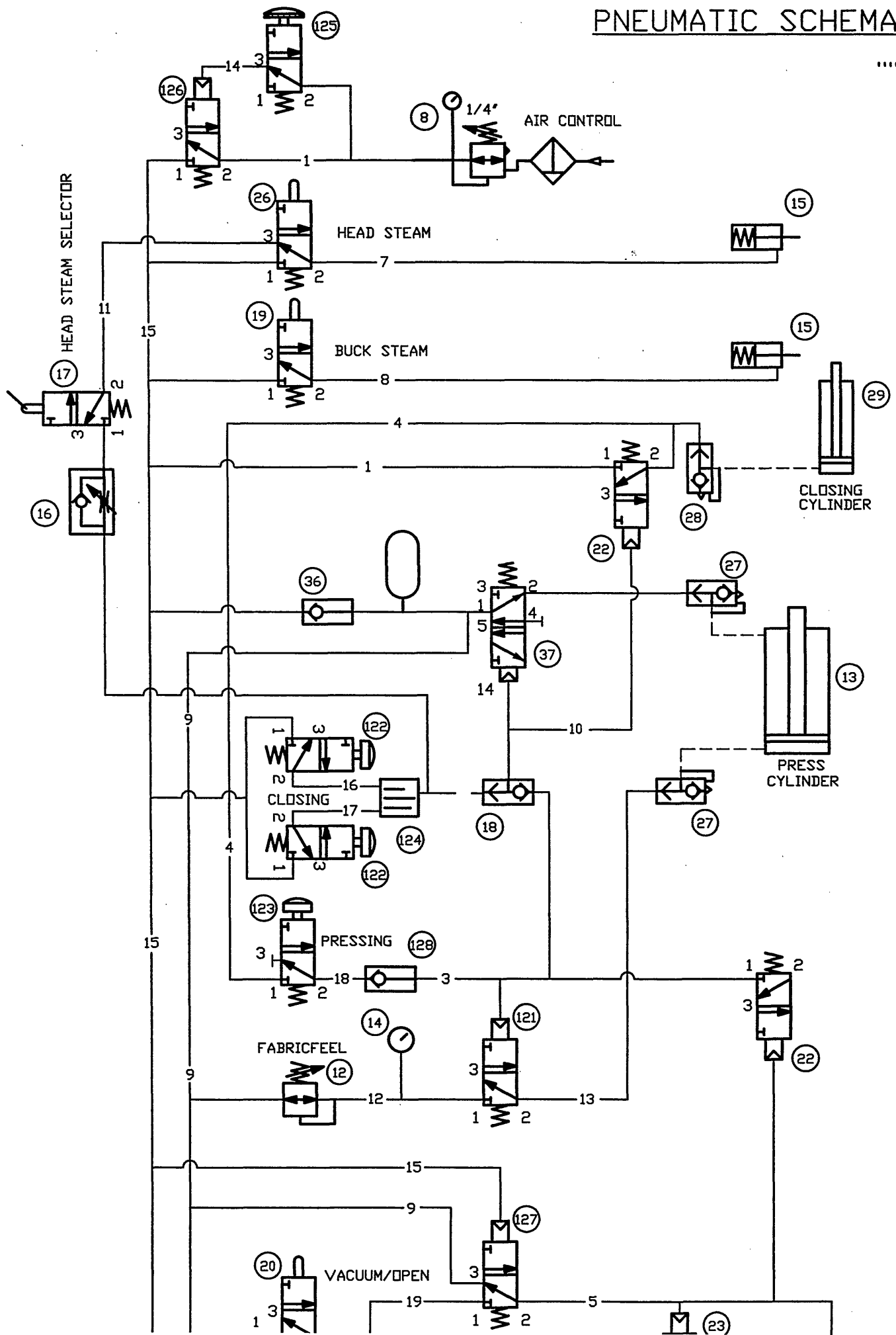
.../70

.../72 legger



PNEUMATIC SCHEMATIC

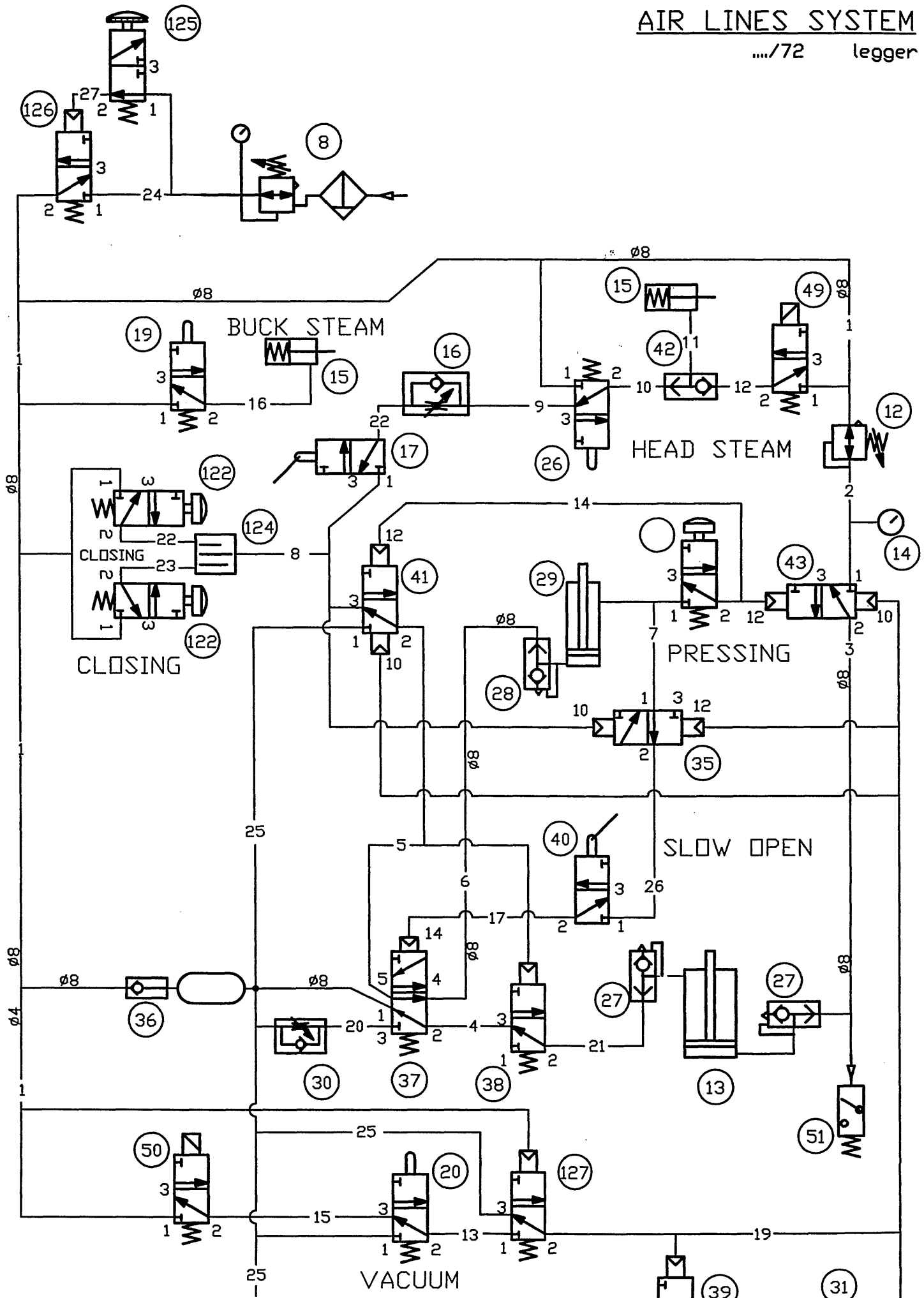
..../70



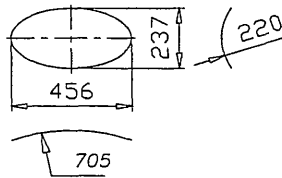
AIR LINES SYSTEM

.../72

legger

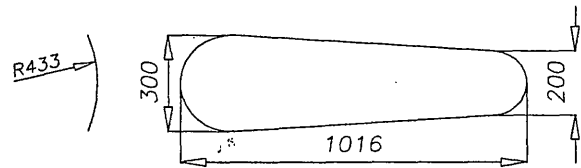


Cissel Utility



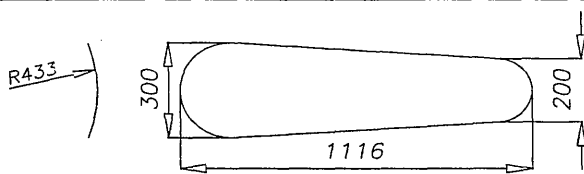
CU-19-70

Press Shoe Group:	122526
Head:	102437
Head covering:	118368
Head Insulating:	66552
Buck:	102366
Buck covering:	118367
Buck Insulating:	66553
Support covering:	119320 / 66554



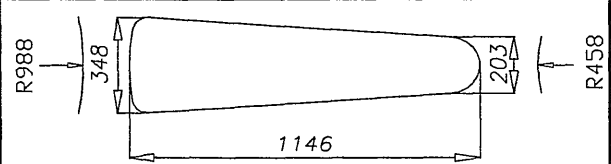
CU-41-70

Press Shoe Group:	121095
Head:	102374
Head covering:	118291
Head Insulating:	66536
Buck:	102433
Buck covering:	118290
Buck Insulating:	66537



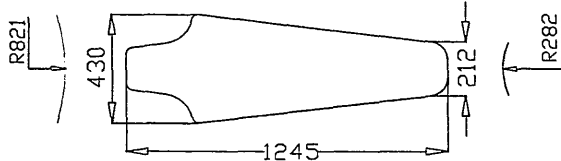
CU-45-70

Press Shoe Group:	121096
Head:	102435
Head covering:	118292
Head Insulating:	66536
Buck:	102362
Buck covering:	118291
Buck Insulating:	66537



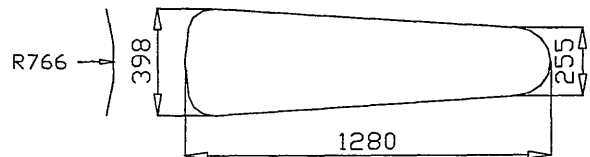
CU-47-70

Press Shoe Group:	121097
Head:	102436
Head covering:	118372
Head Insulating:	66540
Buck:	102356
Buck covering:	118371
Buck Insulating:	66541



CU-50-70

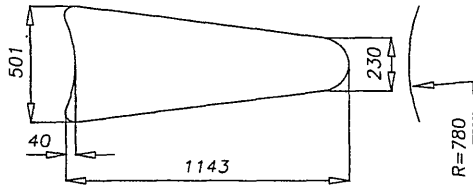
Press Shoe Group:	121090
Head:	102365
Head covering:	118345
Head Insulating:	66542
Buck:	102356
Buck covering:	118344
Buck Insulating:	66543



CU-52-70

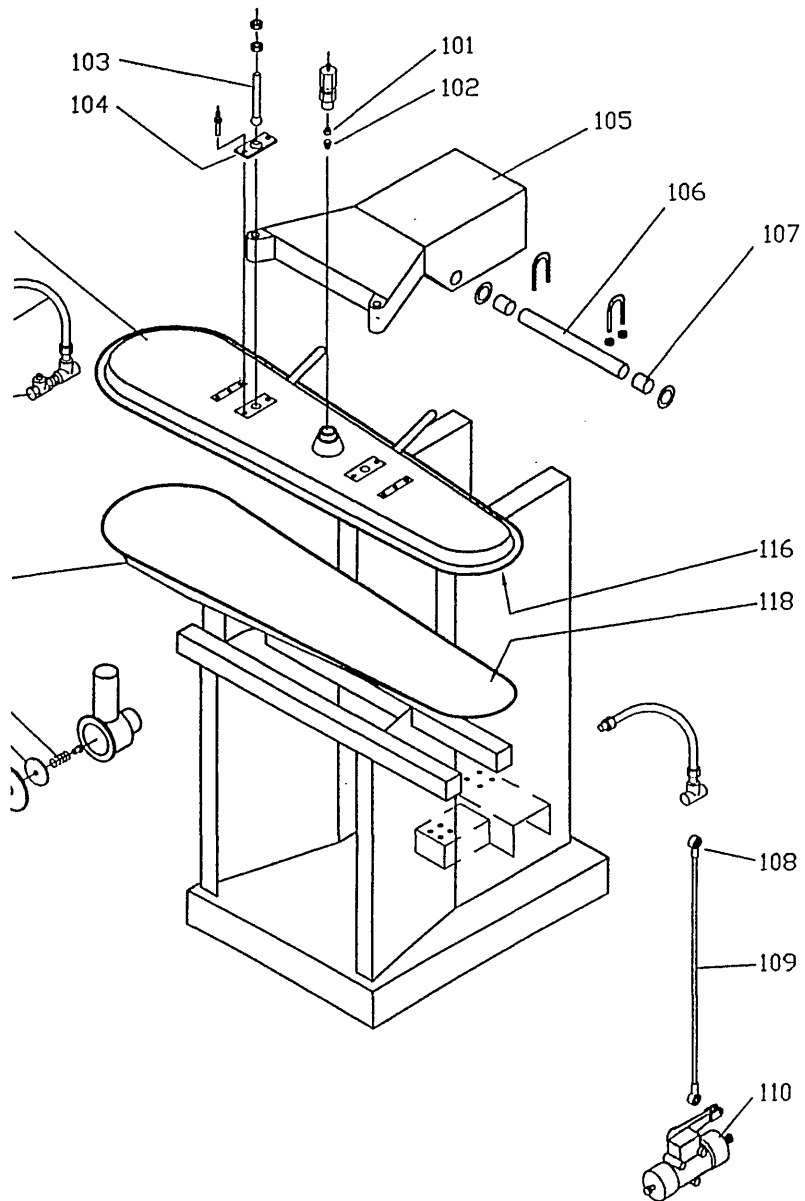
Press Shoe Group:	121099
Head:	102437
Head covering:	118347
Head Insulating:	66544
Buck:	102366
Buck covering:	118346
Buck Insulating:	66545

Cissel Utility



CU-446-72

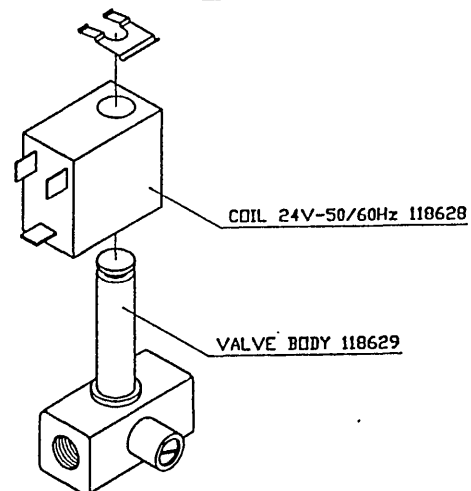
Press Shoe Group:	122525
Head:	102434
Head covering:	118728
Head Insulating:	66546
Buck:	102395
Buck covering:	118727
Buck Insulating	66547



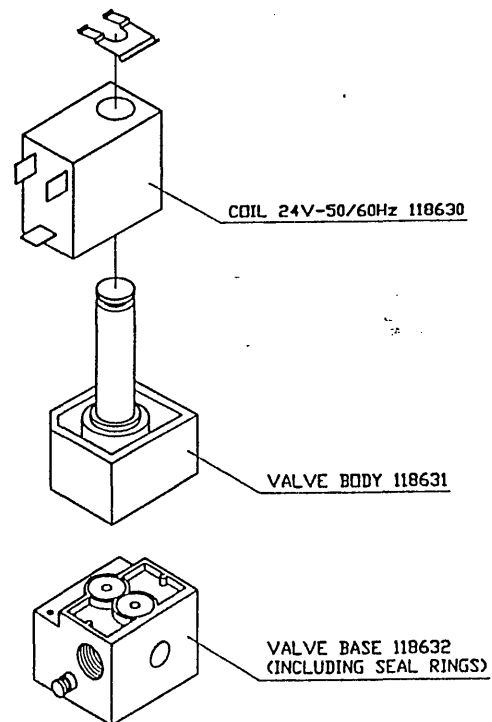
3511

SOLENOID VALVES

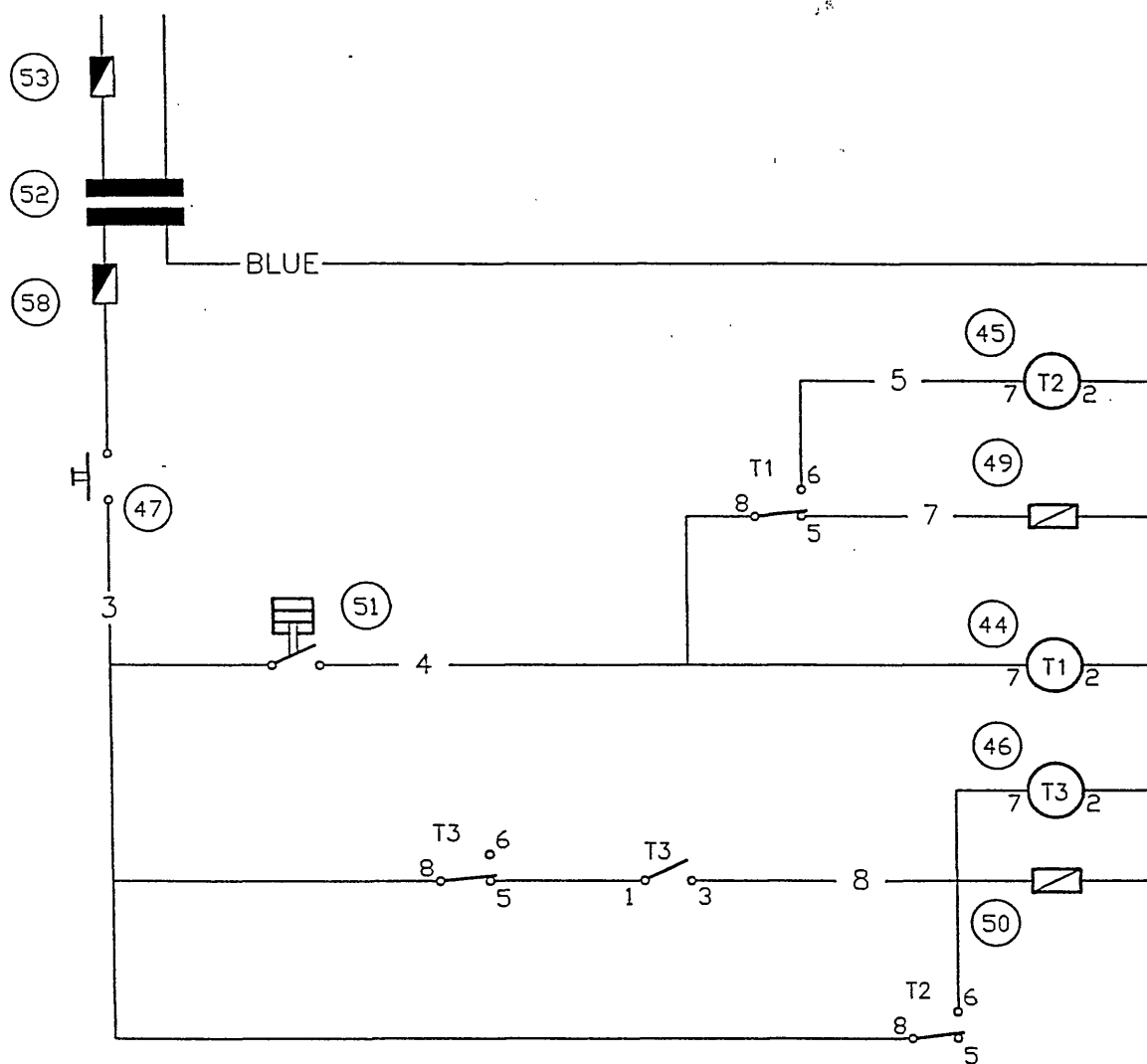
Solenoid valve complete 118544



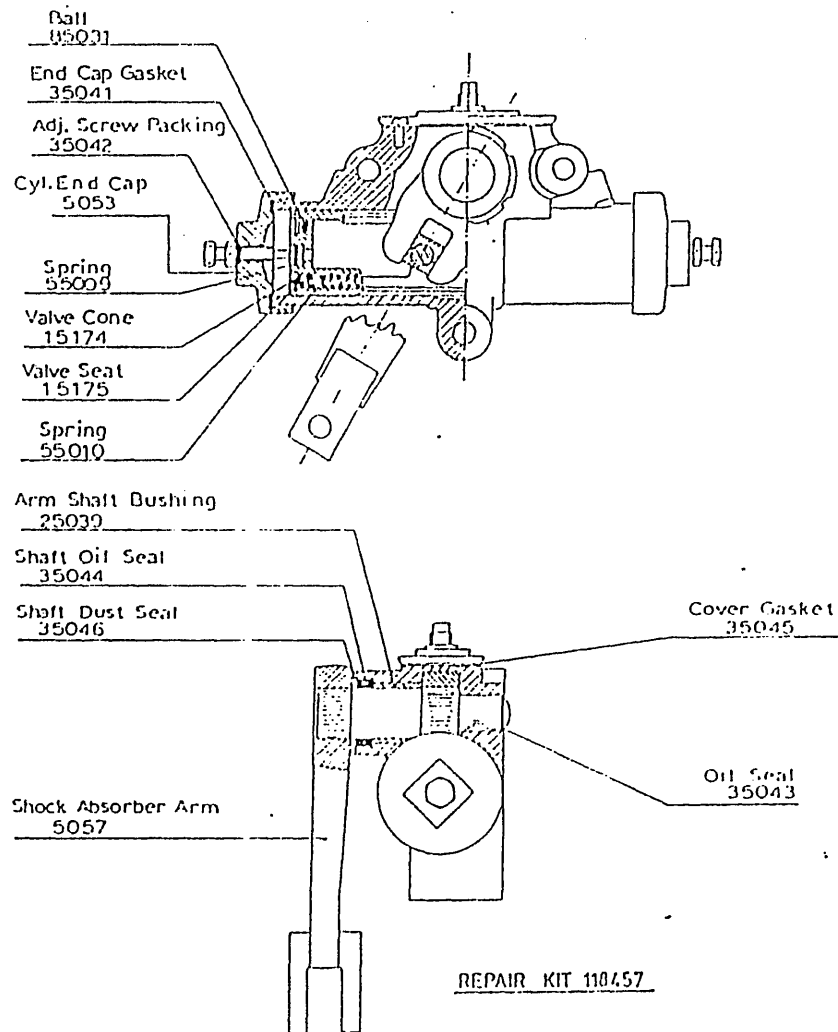
Solenoid valve complete 118602



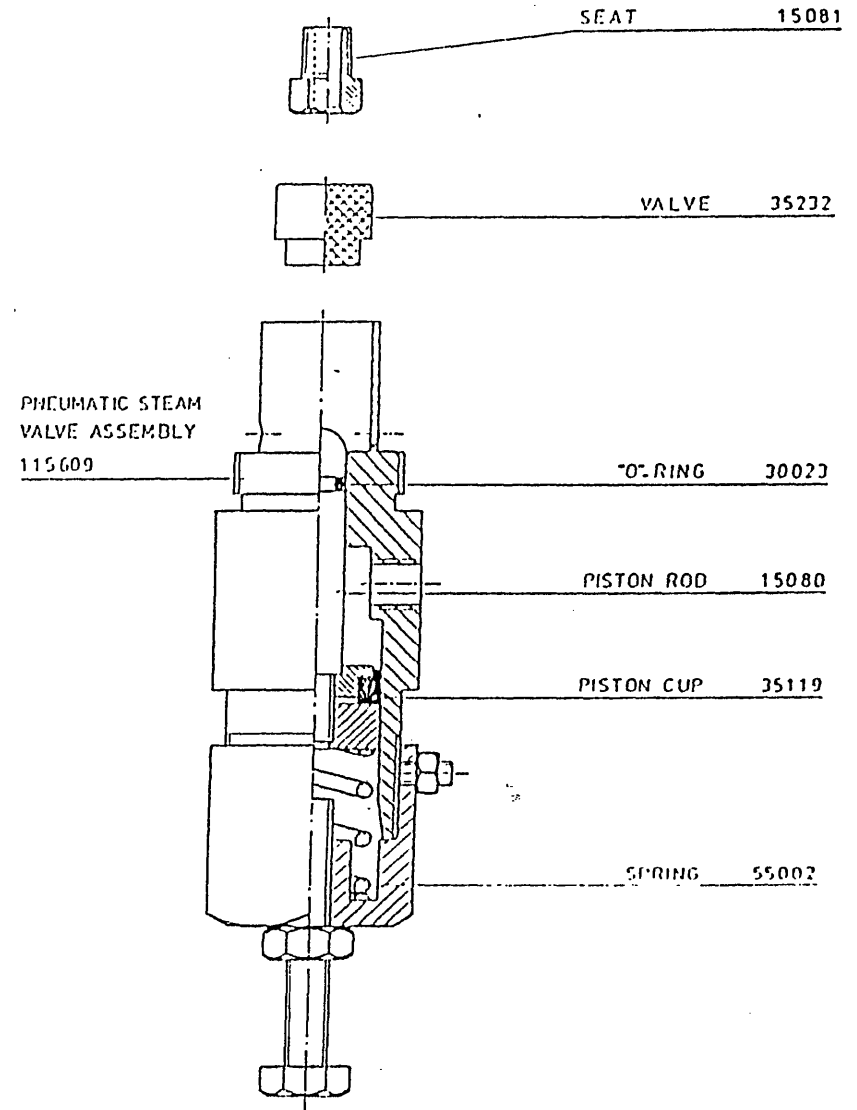
3138

WIRING DIAGRAM

HYDRAULIC CHECK ASSY 115 033



PNEUMATIC STEAM VALVE



Code 358
built on (in) vacuum
utility

