

MOLD PRESS

Operator Manual — how to run the machine

Read this page before using the machine. The press plate is heavy and moves on its own during an automatic cycle. Keep hands, tools and cloths out of the frame whenever the machine is powered on.

What this machine does

The press lowers a plate onto the tray, holds it down for a few seconds, then lifts the plate away in a series of small up-and-down movements before returning to the top. You can also drive the plate up and down by hand using the joystick.

There are two ways to run it:

- **Manual mode** — you hold the joystick and the plate moves while you hold it.
- **Automatic cycle** — you tap the button once and the machine runs a full press and release on its own.

The parts you need to know

Part	Where it is	What it does
Joystick	On top of the electronics box	Push up or down to move the plate by hand. Push left or right to change the number of release movements. Press the knob down to start or cancel a cycle, or hold it to reset.
Top limit switch	At the top of the frame	Tells the machine the plate has reached the top. This is the machine's reference point. It stops all upward movement.
Bottom limit switch	At the bottom of the travel	Tells the machine the plate has reached full press depth. This switch sets how deep the press goes.
Driver box	Outside the machine frame	Powers the motor. It gets warm in normal use. Keep it clear and uncovered.
Power supply	Wall plug into the driver box	Main power. Unplug it to stop everything immediately.

The bottom switch sets the press depth. If the press needs to go deeper or shallower, the switch bracket has to be moved. Do not try to change the depth by holding the joystick down during a cycle.

Starting the machine

1. Check the frame is clear. No hands, tools, cloths or trays sitting where the plate travels.
2. Check the plate and rods are clean and free of build-up.
3. Plug in the power supply.
4. The plate will begin moving **slowly upward** on its own. This is normal. It is looking for the top limit switch.
5. When it reaches the top switch it stops, backs off slightly, and is ready to use.

The machine always does this at power-up. It cannot run an automatic cycle until it has found the top switch, because that is the point it measures everything else from.

If the plate is **already touching the top switch** when you power on, it will first move down a short distance to come off the switch, then go back up to find it properly. This is normal.

Controls at a glance

Control	What happens
Joystick UP	Plate moves up while you hold it. Stops when you let go.
Joystick DOWN	Plate moves down while you hold it. Stops when you let go.
Push further	The plate moves faster. A small push is a slow, fine movement.
Joystick RIGHT	Adds one release movement to the automatic cycle.
Joystick LEFT	Removes one release movement from the automatic cycle.
Tap the knob	Starts an automatic cycle. Tapping again during a cycle cancels it.
Hold the knob 4 seconds	RESET. The machine stops and goes back to find the top switch.

Up and down are not the same speed. The plate goes down faster than it comes up, because lifting it takes more effort from the motor. This is intentional.

Manual mode

Push the joystick up or down and the plate follows. It speeds up smoothly rather than jumping, so for fine positioning give it a small push and be patient.

- Let go and the plate slows to a stop on its own.
- The **top switch will stop** upward movement, even in manual mode.
- The **bottom switch does not stop** manual movement. Going down is your responsibility. Watch the plate and do not run it into the bottom of its travel.

Manual down has no automatic stop. Only push the joystick down as far as you can watch it. If you are unsure, let go.

Running an automatic cycle

Tap the joystick knob once. The machine then does the following without you:

Stage	What you will see
1. Press down	The plate travels down quickly until it reaches the bottom limit switch, then stops.
2. Hold	The plate stays pressed down for about 5 seconds. Nothing appears to happen. This is normal, let it finish.
3. First release	The plate lifts a larger amount, comes straight back down, and pauses while pressed.
4. Further releases	The plate does the same movement but a smaller lift, repeated as many times as the count is set to.
5. Return	The plate travels slowly back up until it reaches the top switch. The cycle is complete and the machine is ready for the next one.

The first release lift is deliberately bigger than the rest. The later ones are smaller and are there to help the plate separate cleanly.

Setting the number of release movements

With the machine sitting idle, push the joystick **right** to add one, or **left** to remove one. Return the joystick to the middle each time — one push is one change. Holding it to the side does not keep adding.

The count can be set from 0 to 10 and stays where you set it until you change it or power off. More releases takes longer but helps if the plate is not separating cleanly.

Stopping a cycle early

Tap the knob again, or push the joystick up or down. The cycle stops and the plate returns to the top on its own. It will not stay pressed down.

Resetting the machine

Hold the joystick knob down for 4 seconds. Use this any time something does not look right — the plate is somewhere unexpected, a cycle behaved oddly, or you are simply not sure what state the machine is in.

On reset the machine stops whatever it was doing and travels slowly up to find the top switch again, exactly as it does at power-up. It is always safe to reset.

When in doubt, reset. It costs less than a minute and puts the machine back into a known, safe position.

If the machine stops and reports a problem

The machine will stop by itself and switch the motor off if something does not add up. Nothing is broken by this happening — it is the machine protecting itself. The two situations are below.

What happened	What it usually means	What to do
It could not find the top switch	Something is blocking the plate, or the top switch or its wiring has come loose.	Clear anything blocking the plate. Check the top switch is still firmly mounted and its wire is connected. Then reset.
It could not reach the bottom switch	The bottom switch or its wiring has come loose, or something stopped the plate on the way down.	Check nothing is in the way. Check the bottom switch is mounted and connected. Then reset.

After a fault, hold the knob for 4 seconds to reset. If the same fault comes back a second time, stop using the machine and report it rather than repeatedly resetting.

Everyday troubleshooting

You notice	Try this
Plate does not move at all	Check the power supply is plugged in and the driver box is on. If the machine has been sitting idle, the motor switches itself off to stay cool — it will wake up as soon as you move the joystick.
Plate moves but very slowly upward	This is normal. Up is slower than down by design, and the return to the top switch is deliberately slow.
Motor is buzzing but nothing moves	Stop and unplug. Do not keep trying. Report it.
Driver box is hot to the touch	Warm is normal. Too hot to hold is not. Make sure nothing is covering it and it has open air around it. If it stays that hot, stop and report it.
Product is not separating cleanly	Increase the number of release movements with the joystick right, and run another cycle.
Something sounds or looks wrong	Reset. If it happens again, unplug and report it.

Safety rules

- **Never reach into the frame while the machine is powered on.** An automatic cycle can start moving without warning.
- The plate is heavy. Treat the space under it as a crush hazard at all times.
- Wear the PPE required for this area, including hairnet, closed-toe shoes and goggles.
- Do not clean, wipe or adjust anything while the machine is plugged in.
- Do not disable, move or tape over either limit switch. They are what keeps the plate inside its safe travel.
- Do not put anything on top of the driver box or wrap it. It needs open air to stay cool.
- If anything is unexpected, unplug first and ask second.

To stop the machine immediately at any time, unplug the power supply. This is the fastest and most certain way to stop all movement.

Shutting down

1. Wait until any cycle has finished and the plate is back at the top.
2. Unplug the power supply.
3. Clean down the machine according to the cleaning procedure for this area.
4. Leave the plate at the top of its travel, not resting down on the tray.

Daily check before first use

- Frame is clear of tools, cloths and loose parts.
- Plate and guide rods are clean.
- Both limit switches are firmly mounted and their wires are connected.
- Driver box is uncovered and has air around it.
- Cables are not trapped, stretched or in the path of the plate.
- At power-up, the plate travels up and finds the top switch normally.

This manual covers operation only. Adjusting press depth, speeds, or anything inside the electronics box is not an operator task — report it instead.