Operation Control Panel

Model YA

Operation Control Panel with User-Friendly Controls Prevents misoperation with the interlock function.

United type of operation panel and control panel. Implements a more simplistic and compact design than YP model.

YA Operation Control Panel allows for flexibility in circuit construction and interlock functions for various die change systems.

Model No. Indication

YA 1441

Circuit Constructions

We provide a serial number in accordance with die change system. Please contact us separately.

Specifications

<table>
<thead>
<tr>
<th>Model No.</th>
<th>Operation and Control Panel United Type</th>
</tr>
</thead>
<tbody>
<tr>
<td>Type</td>
<td>Key Switch 90° - 2 Notch (Stop Manually at Each Position)</td>
</tr>
<tr>
<td>Die Change Selector Switch</td>
<td>Selector Switch 90° - 2 Notch (Stop Manually at Each Position)</td>
</tr>
<tr>
<td>Each Operation Switch</td>
<td></td>
</tr>
<tr>
<td>Operating Temperature Range</td>
<td>0 ~ 50 °C</td>
</tr>
<tr>
<td>Paint Color</td>
<td>Munsell Number : SY7/1 (JEM Standard Panel Color)</td>
</tr>
</tbody>
</table>

Notes:
1. When using YA Operation Control Panel, electric remodeling on press side should be conducted by customer.
2. We provide name plate with other languages such as English. Please contact us for more information.
## Circuit Construction Examples

<table>
<thead>
<tr>
<th>Example</th>
<th>Upper Clamp</th>
<th>Lower Clamp</th>
<th>Die Lifter</th>
<th>Hydraulic Unit Circuit Symbol</th>
</tr>
</thead>
<tbody>
<tr>
<td>Example 1</td>
<td>Clamp</td>
<td>-</td>
<td>C</td>
<td>G</td>
</tr>
<tr>
<td>Example 2</td>
<td>-</td>
<td>Clamp</td>
<td>C</td>
<td>G</td>
</tr>
<tr>
<td>Example 3</td>
<td>-</td>
<td>-</td>
<td>Die Lifter</td>
<td>D</td>
</tr>
<tr>
<td>Example 4</td>
<td>Clamp</td>
<td>Clamp</td>
<td>CC</td>
<td>2G</td>
</tr>
<tr>
<td>Example 5</td>
<td>Clamp</td>
<td>Clamp</td>
<td>Die Lifter</td>
<td>CD</td>
</tr>
<tr>
<td>Example 6</td>
<td>Clamp</td>
<td>Clamp</td>
<td>Die Lifter</td>
<td>CCD</td>
</tr>
</tbody>
</table>

## External Dimensions

The above is just an example.

We can provide various circuit constructions and interlock functions to match the specifications of your die change system. Please contact us for more information.
Cautions

- Installation Notes (Cautions for Hydraulic Series)
  1) Check the fluid to use
     - Please use the appropriate fluid by referring to the Hydraulic Fluid List.
     - If hydraulic oil with viscosity grade higher than ISO-VG-32 is used, action time would be longer.
     - If using it at low temperature, action time will be longer because the viscosity of hydraulic oil becomes higher.

  2) Procedure before Piping
     - The pipeline, piping connector and fixture circuits should be cleaned by thorough flushing.
     - The dust and cutting chips in the circuit may lead to fluid leakage and malfunction.
     - Our products except some valves are not equipped with protective function to prevent dust and cutting chips going into the hydraulic system and pipeline.

  3) Applying Sealing Tape
     - Wrap with tape 1 to 2 times following the screwing direction.
     - Pieces of the sealing tape can lead to air leaks and malfunction.
     - In order to prevent a foreign substance from going into the product during piping, it should be carefully cleaned.

  4) Air Bleeding in the Hydraulic Circuit
     - If the hydraulic circuit has excessive air, the action time may become very long.
       After installing the hydraulic circuit, or if the pump run out of oil, be sure to bleed air by the following step.
       ① Reduce hydraulic supply pressure to less than 2MPa.
       ② Please loosen the cap nut of pipe fitting that is closest to clamps + RA die lifters by one full turn.
       ③ Wiggle the pipeline to loosen the outlet of pipeline fitting. The hydraulic fluid mixed with air comes out.

       ④ Tighten the cap nut after bleeding.
       ⑤ It is more effective to bleed air at the highest point inside the circuit or at the end of the circuit.

  5) Checking Looseness and Retightening
     - At the beginning of the machine installation, the bolt/nut may be tightened lightly.
       Check torque and re-tighten as required.

Hydraulic Fluid List

<table>
<thead>
<tr>
<th>ISO Viscosity Grade</th>
<th>Multi-Purpose Hydraulic Oil</th>
</tr>
</thead>
<tbody>
<tr>
<td>Maker</td>
<td>Anti-Wear Hydraulic Oil</td>
</tr>
<tr>
<td>Showa Shell Sekiyu</td>
<td>Tellus S2 M 32</td>
</tr>
<tr>
<td>Idemitsu Kosan</td>
<td>Daphne Hydraulic Fluid 32</td>
</tr>
<tr>
<td>JK Nippon Oil &amp; Energy</td>
<td>Super Hyrando 32</td>
</tr>
<tr>
<td>Cosmo Oil</td>
<td>Super Mulpus DX 32</td>
</tr>
<tr>
<td>ExxonMobil</td>
<td>Mobil DTE 24</td>
</tr>
<tr>
<td>Matsumura Oil</td>
<td>Hydol AW-32</td>
</tr>
<tr>
<td>Castrol</td>
<td>Hyspin AWS 32</td>
</tr>
</tbody>
</table>

Note: As it may be difficult to purchase the products as shown in the table from overseas, please contact the respective manufacturer.
Notes on Hydraulic Cylinder Speed Control Unit

Please pay attention to the cautions below. Design the hydraulic circuit for controlling the action speed of hydraulic cylinder. Improper circuit design may lead to malfunctions and damages. Please review the circuit design in advance.

Flow Control Circuit for Single Acting Cylinder
For spring return single acting cylinders, restricting flow during release can extremely slow down or disrupt release action. The preferred method is to control the flow during the lock action using a valve that has free-flow in the release direction. It is also preferred to provide a flow control valve at each actuator.

Accelerated clamping speed by excessive hydraulic flow to the cylinder may sustain damage. In this case add flow control to regulate flow.

Flow Control at the Release Side

Flow Control Circuit for Double Acting Cylinder
Flow control circuit for double acting cylinder should have meter-out circuits for both the lock and release sides. Meter-in control can have adverse effect by presence of air in the system.

In the case of meter-out circuit, the hydraulic circuit should be designed with the following points.
1. Single acting components should not be used in the same flow control circuit as the double acting components. The release action of the single acting cylinders may become erratic or very slow.

Refer to the following circuit when both the single acting cylinder and double acting cylinder are used together.

Separate the control circuit.

Reduce the influence of double acting cylinder control unit. However, due to the back pressure in tank line, single action cylinder is activated after double action cylinder works.

In the case of meter-out circuit, the inner circuit pressure may increase during the cylinder action because of the fluid supply. The increase of the inner circuit pressure can be prevented by reducing the supplied fluid beforehand via the flow control valve. Especially when using sequence valve or pressure switches for clamping detection. If the back pressure is more than the set pressure then the system will not work as it is designed to.
**Cautions**

**Notes on Handling**

1) It should be handled by qualified personnel.
   - The hydraulic machine / air compressor should be handled and maintained by qualified personnel.

2) Do not handle or remove the machine unless the safety protocols are ensured.
   ① The machine and equipment can only be inspected or prepared when it is confirmed that the preventive devices are in place.
   ② Before the machine is removed, make sure that the above-mentioned safety measures are in place. Shut off the air of hydraulic source and make sure no pressure exists in the hydraulic and air circuit.
   ③ After stopping the machine, do not remove until the temperature cools down.
   ④ Make sure there is no abnormality in the bolts and respective parts before restarting the machine or equipment.

3) Do not touch clamps (cylinders) while they are working. Otherwise, your hands may be injured.

4) Do not disassemble or modify.
   - If the equipment is taken apart or modified, the warranty will be voided even within the warranty period.

**Maintenance • Inspection**

1) Removal of the Machine and Shut-off of Pressure Source
   - Before the machine is removed, make sure that the above-mentioned safety measures are in place. Shut off the air of hydraulic source and make sure no pressure exists in the hydraulic and air circuit.
   - Make sure there is no abnormality in the bolts and respective parts before restarting.

2) Regularly clean the area around the equipment.
   - If it is used when the surface is contaminated with dirt, it may lead to packing seal damage, malfunctioning, fluid leakage and air leaks.

3) If disconnecting by couplers on a regular basis, air bleeding should be carried out daily to avoid air mixed in the circuit.

4) Regularly tighten bolts and pipe line, mounting bolts, nuts, circlips and cylinders to ensure proper use.

5) Make sure the hydraulic fluid has not deteriorated.

6) Make sure there is smooth action and no abnormal noise.
   - Especially when it is restarted after left unused for a long period, make sure it can be operated correctly.

7) The products should be stored in the cool and dark place without direct sunshine or moisture.

8) Please contact us for overhaul and repair.
### Warranty

1) **Warranty Period**
- The product warranty period is 18 months from shipment from our factory or 12 months from initial use, whichever is earlier.

2) **Warranty Scope**
- If the product is damaged or malfunctions during the warranty period due to faulty design, materials or workmanship, we will replace or repair the defective part at our expense.
- Defects or failures caused by the following are not covered:
  1. If the stipulated maintenance and inspection are not carried out.
  2. If the product is used while it is not suitable for use based on the operator’s judgment, resulting in defect.
  3. If it is used or handled in inappropriate way by the operator.
     (Including damage caused by the misconduct of the third party.)
  4. If the defect is caused by reasons other than our responsibility.
  5. If repair or modifications are carried out by anyone other than Kosmek, or without our approval and confirmation, it will void warranty.
  6. Other caused by natural disasters or calamities not attributable to our company.
  7. Parts or replacement expenses due to parts consumption and deterioration.
     (Such as rubber, plastic, seal material and some electric components.)

- Damages excluding from direct result of a product defect shall be excluded from the warranty.
## Sales Offices

### Sales Offices across the World

<table>
<thead>
<tr>
<th>Country</th>
<th>TEL.</th>
<th>FAX.</th>
<th>Address</th>
</tr>
</thead>
<tbody>
<tr>
<td>Japan</td>
<td>+81-78-991-5162</td>
<td>+81-78-991-8787</td>
<td>KOSMEK LTD. 1-5, 2-chome, Murotani, Nishi-ku, Kobe-city, Hyogo, Japan 651-2241</td>
</tr>
<tr>
<td>USA</td>
<td>+1-630-620-7650</td>
<td>+1-630-620-9015</td>
<td>650 Springer Drive, Lombard, IL 60148 USA</td>
</tr>
<tr>
<td>Mexico</td>
<td>+52-442-161-2347</td>
<td></td>
<td>Blvd Jurica la Campana 1040, B Colonia Punta Juriquilla Queretaro, QRO 76230 Mexico</td>
</tr>
<tr>
<td>Europe</td>
<td>+43-463-287587</td>
<td>+43-463-287587-20</td>
<td>Schlepppeplatz 2 9020 Klagenfurt am Wörthersee Austria</td>
</tr>
<tr>
<td>China</td>
<td>+86-21-54253000</td>
<td>+86-21-54253709</td>
<td>Room601, RIVERSIDE PYRAMID No.55, Lane21, Pusan Rd, Pudong Shanghai 200125, China</td>
</tr>
<tr>
<td>India</td>
<td>+91-9880561699</td>
<td></td>
<td>F 203, Level-2, First Floor, Prestige Center Point, Cunningham Road, Bangalore -560052 India</td>
</tr>
<tr>
<td>Thailand</td>
<td>+66-2-300-5132</td>
<td>+66-2-300-5133</td>
<td>67 Soi 58, RAMA 9 Rd., Suanluang, Suanluang, Bangkok 10250, Thailand</td>
</tr>
<tr>
<td>Taiwan</td>
<td>+886-2-82261860</td>
<td>+886-2-82261890</td>
<td>16F-4, No.2, Jian Ba Rd, Zhonghe District, New Taipei City Taiwan 23511</td>
</tr>
<tr>
<td>Full Life Trading Co., Ltd.</td>
<td></td>
<td></td>
<td>台湾新北市中和区建八路2号16F-4（遠東世紀廣場）</td>
</tr>
<tr>
<td>Philippines</td>
<td>+63-2-310-7286</td>
<td>+63-2-310-7286</td>
<td>Victoria Wave Special Economic Zone Mt. Apo Building, Brgy. 186, North Caloocan City, Metro Manila, Philippines 1427</td>
</tr>
<tr>
<td>G.E.T. Inc., Phil.</td>
<td></td>
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### Sales Offices in Japan

<table>
<thead>
<tr>
<th>Office</th>
<th>TEL.</th>
<th>FAX.</th>
<th>Address</th>
</tr>
</thead>
<tbody>
<tr>
<td>Osaka Sales Office</td>
<td>078-991-5162</td>
<td>078-991-8787</td>
<td>関西本社 〒651-2241 兵庫県神戸市垂水区堂谷2丁目1番5号</td>
</tr>
<tr>
<td>Tokyo Sales Office</td>
<td>048-652-8839</td>
<td>048-652-8828</td>
<td>東京営業本部 〒331-0815 埼玉県さいたま市北区大成町4丁目81番地</td>
</tr>
<tr>
<td>Nagoya Sales Office</td>
<td>0566-74-8778</td>
<td>0566-74-8808</td>
<td>名古屋営業本部 〒446-0076 愛知県安城市安城市2丁目10番地</td>
</tr>
<tr>
<td>Fukuoka Sales Office</td>
<td>092-433-0424</td>
<td>092-433-0426</td>
<td>佐賀営業本部 〒812-0006 福岡県福岡市博多区上妻田1丁目8-10-101</td>
</tr>
</tbody>
</table>

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Overseas Affiliates and Sales Offices

Distributors

Asia Detailed Map

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