

Model 98 Operation Guide

Installation

- **Mounting:** Mounting holes are located in the mounting bracket, and the use of 1/4-20 socket head cap screws with lock washers is required. The Model 98 markers require a sturdy, level platform for mounting. For optimum power, the marker should be mounted so that the stamp face is 2 1/8" to 2 3/8" away from the part to be marked for a 2 1/2" stroke model.
- **Air Requirements:** Model 98 is air powered for the forward motion, and the return motion is spring controlled. CMT recommends a 1/2" minimum shop airline. Maximum operating pressure of 100 psi, minimum operating pressure of 20 psi. Please note that the airline length between the valve and marker should not exceed 3'. The marker has one 1/2" NPT air port. Air will naturally escape when the marker is in the forward position.
- **Adjustments:** Increase air pressure to mark deeper. Decrease air pressure to mark lighter. *To regulate marking pressure, adjust FRL (Filter/Regulator/Lubricator unit). Sold separately.*

Maintenance

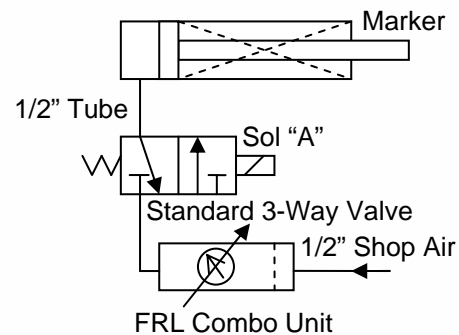
Shut off all air and electrical power prior to performing any and all maintenance.

- **Lubrication:** Add 10W "light" industrial hydraulic oil to lubricator bowl and adjust oil flow to approximately 1 drop for every 30-50 cycles.
- **Air Filter:** Check and clean /change as required. The frequency of cleaning/changing is dependent on environment and plant air system. Do not allow excess water to fill filter bowl.

Pneumatic Controls

- **Electrical Sequence for Spring Return Valve:** To advance marker, energize solenoid "A". To return marker and reset, de-energize solenoid "A" after part is marked. Spring in marker returns ram after pressure is exhausted.
- **Note:** For most efficient operation, electrical signal energizing solenoid "A" should be very short, approximately .06 to .10 seconds.

Suggested Pneumatic Control Diagram



Removal of front cap voids warranty.

Model 98 Parts List

