

# SERVICE MANUAL

## Cylinder Information

SERIAL# \_\_\_\_\_

Model A-5310	2 Stage 3" Stroke Single End	618
Model A-5302	2 Stage 3" Stroke Double End	617
Model A-5461	3 Stage 3" Stoke Single End	620
Model A-5453	3 Stage 3" Stoke Double End	619
Model A-5612	4 Stage 3" Stroke Single End	622
Model A-5604	4 Stage 3" Stroke Double End	621



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Janesville Tool &  
Manufacturing, Inc.

## A-5000 SERIES

A-5310  
A-5302  
A-5461  
A-5453  
A-5612  
A-5604

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Model: A-5310  
A-5461, A-5612

Model: \*A-5302,  
\*A-5453, \*A-5604

## Safety Instructions

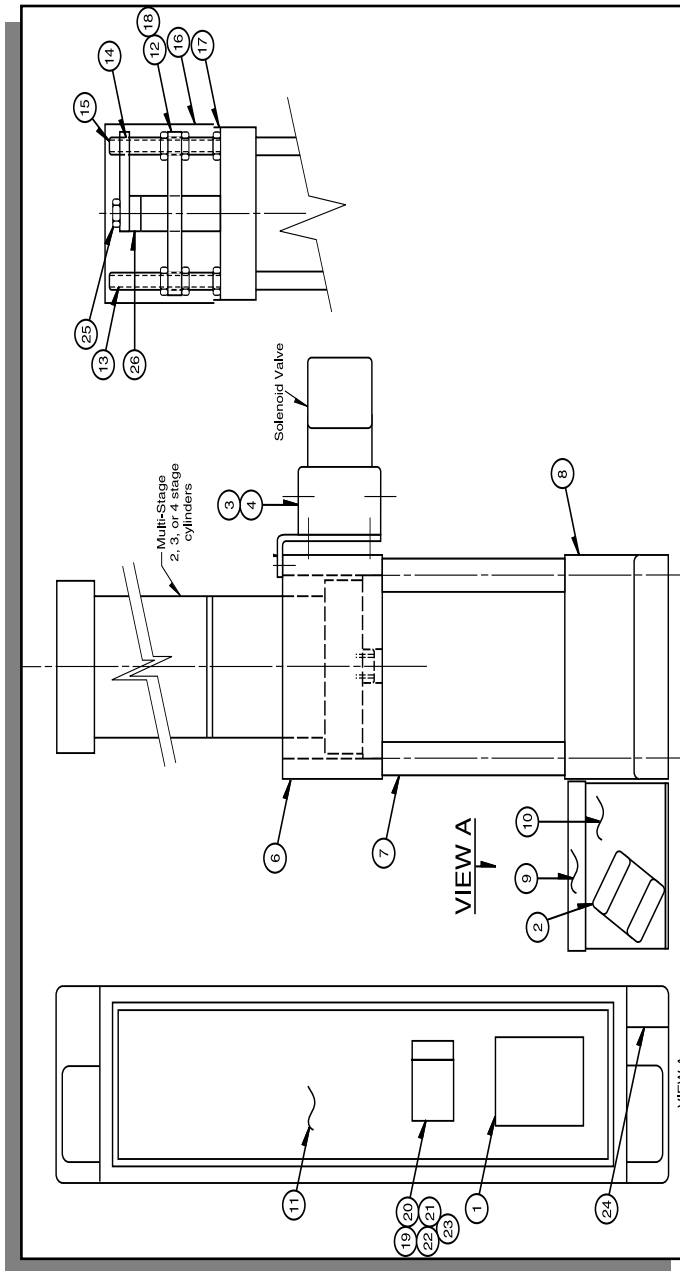
### Read All Instructions Carefully

1. **DO NOT OPERATE PRESS WITH GUARDS REMOVED.**  
**ALL SAFETY DEVICES MUST BE INSTALLED AND OPERABLE.**
2. **ADDITIONAL GUARDING IS REQUIRED FOR SPECIAL TOOLING.**
3. **DISCONNECT PRESS** when not in use, before servicing, and when changing accessories, such as down stops and tooling.
4. **WEAR SAFETY GLASSES WHILE OPERATING PRESS.**
5. **GUARD AGAINST ELECTRIC SHOCK.** Do not use in damp locations.
6. **DRESS PROPERLY.** Do not wear loose fitting clothing or jewelry that could get caught in moving parts.
7. **KEEP HANDS AWAY.** Never reach near moving parts.
8. **DO NOT OPERATE PRESS OVER 80 PSI.** Excess pressure may cause damage or injury.
9. **DO NOT OPERATE PRESS OVER LABELED VOLTAGE.**
10. **WATCH FOR DAMAGED PARTS.** If press is damaged during operation, examine the damaged part carefully to insure that it will operate properly. If in doubt, replace the damaged part. Check for alignment of moving parts, binding of moving parts, mounting and any other conditions that may affect its operation.

## Model A-5310, A-5302, A-5461, A-5453, A-5612, A-5604

ITEM	REQ'D	NAME	PART NO.
1	1	Control Module	540
2	2	Push Button	525
3	1	Valve 2 Stage Cylinders	511
4	1	Valve 3 and 4 Stage Cylinders	546
6	1	Top	5012-47
7	4	Post	5000-40
8	1	Base	5012-48
9	1	Control Box Cover	4000-27
10	1	Control Box	4000-26
11	1	Inner Panel	4000-28
12	1	Stop Plate 2 Stage Cylinders	3000-07
	1	Stop Plate 3 and 4 Stage Cylinders	4000-30
13	2	Threaded Rod	3000-27
14	1	Anti-Rotate	3000-10
15	1	Anti-Rotate Stud	3000-08
16	1	Upper Guard	3000-35
17	1	Bottom Guard	3000-23
18	1	Valve 3 and 4 Stage Cylinders	546
19	1	Fuse	531
20	1	Fuse Clip	529
21	1	End Anchor	527
22	1	End Barrier	528
23	1	Terminal Holding Strip	530
24	1	On/Off Switch	560
25	1	Special Bolt	N/A
26	1	Rod Spacer	N/A

## A-5000 Series Parts List



## Safety Instructions Continued...

**11. KEEP WORK AREA CLEAN.** Cluttered areas and benches invite injuries.

**12. STAY ALERT.** Watch what you are doing. Use common sense.

### MAINTENANCE GUIDELINES

Thanks to its unique design, this press requires virtually no maintenance. Clean, dry air is required for operation.

(Lubricated air may be used, but must be used for the life of the press.)

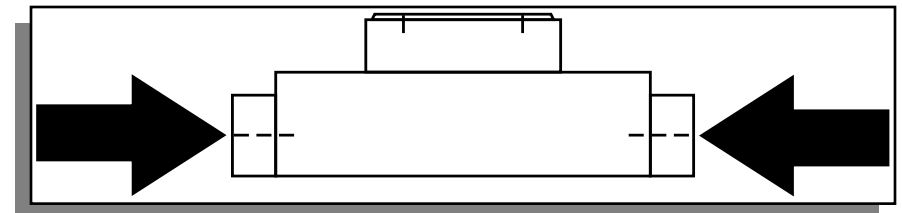
**CONTROL MODULE** – The life expectancy for the control module (#540) is ten million cycles. Replacing the module on a yearly basis will ensure production reliability and avoid costly downtime.

### FLOW CONTROLS

To alter the ram descent speed on your JT&M Press, adjust the screw marked B Located on the valve at the rear of the press. To alter the ram ascent speed, adjust screw A. (The ram retraction speed has been preset by the factory.) Rotate the screws clockwise to decrease the speed of the ram.

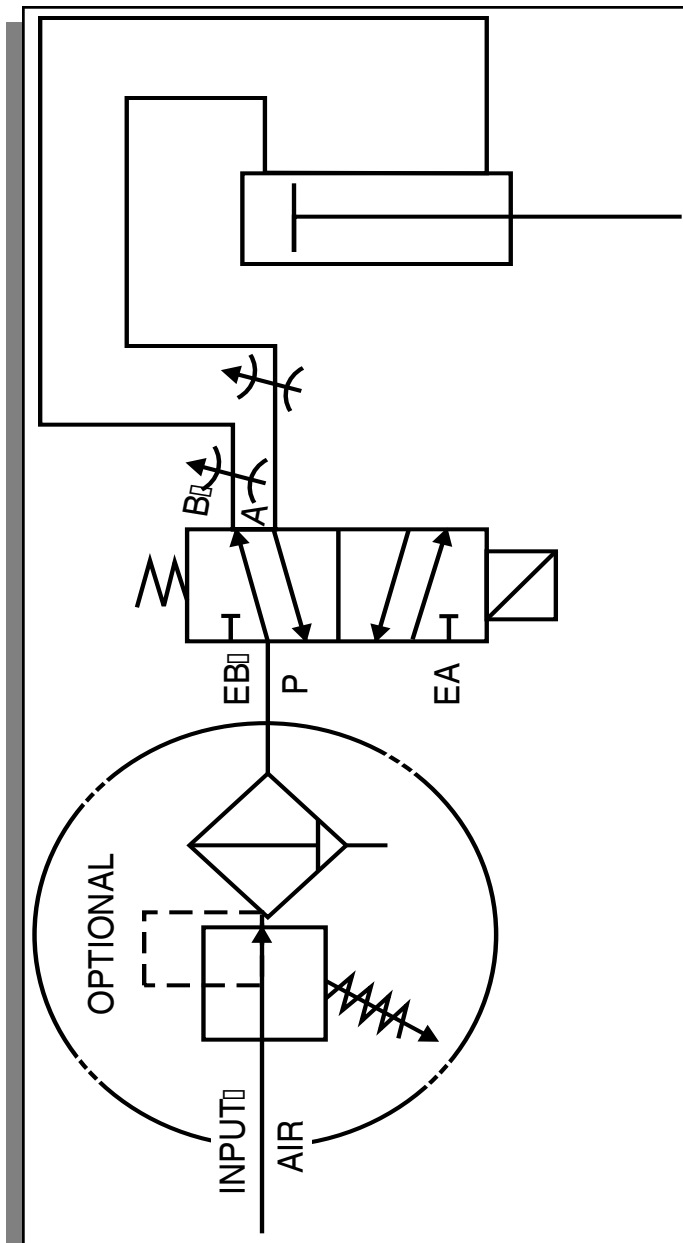
### PRESS OPERATION

To operate press, push palm buttons in at the same time. Hold the palm buttons in until the down stroke is completed.



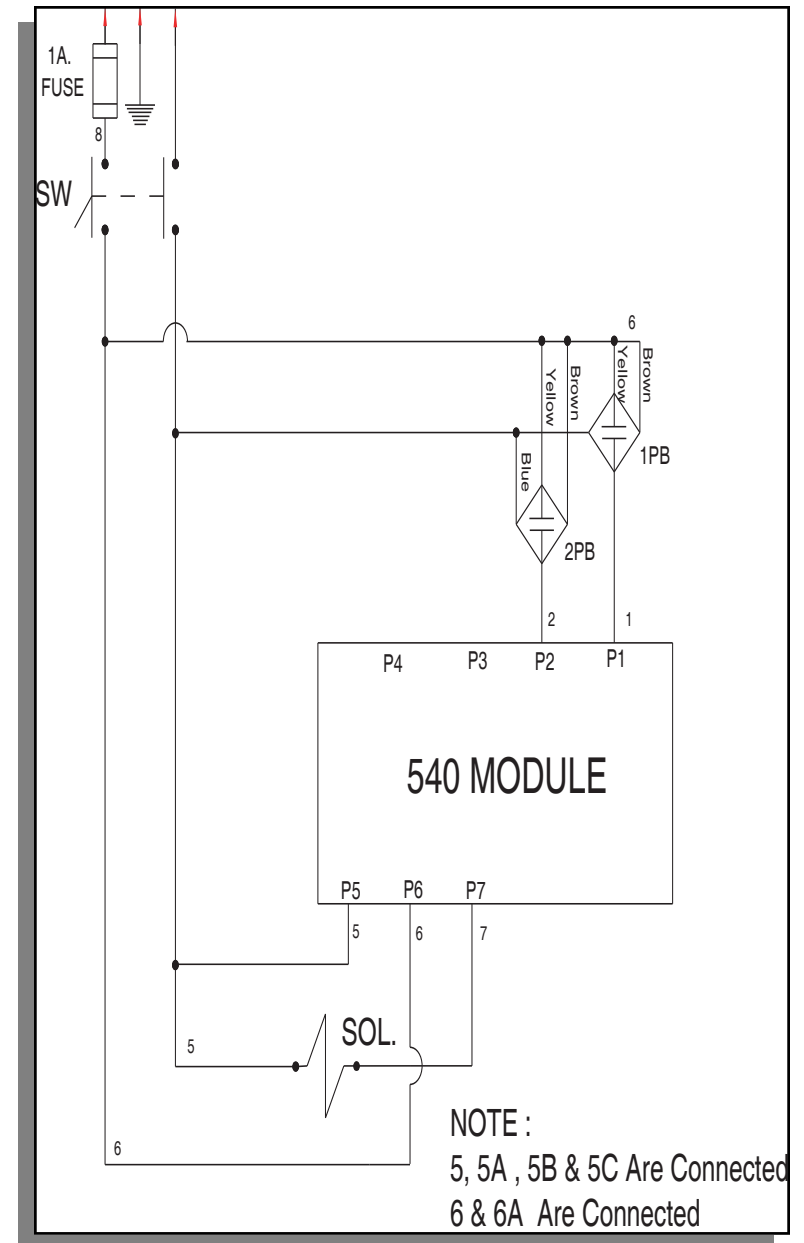
**Please Write Serial No. On Front Cover.**

## Pneumatic Schematic



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## Electrical Schematic



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