

Cylinder Information

Model A-6024 1-3/4" Bore x 3" Stroke—Single End 604
(Repair Kit 1-3/4" Bore—Single End) 20828

Model A-6019 1-3/4" Bore x 3" Stroke—Double End 603
(Repair Kit 1-3/4" Bore—Double End) 20348



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SERVICE MANUAL

SERIAL# _____



Janesville Tool &
Manufacturing, Inc.

A-6000 SERIES

A-6019
A-6024

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Model: A-6024

Model: *A-6019

Safety Instructions

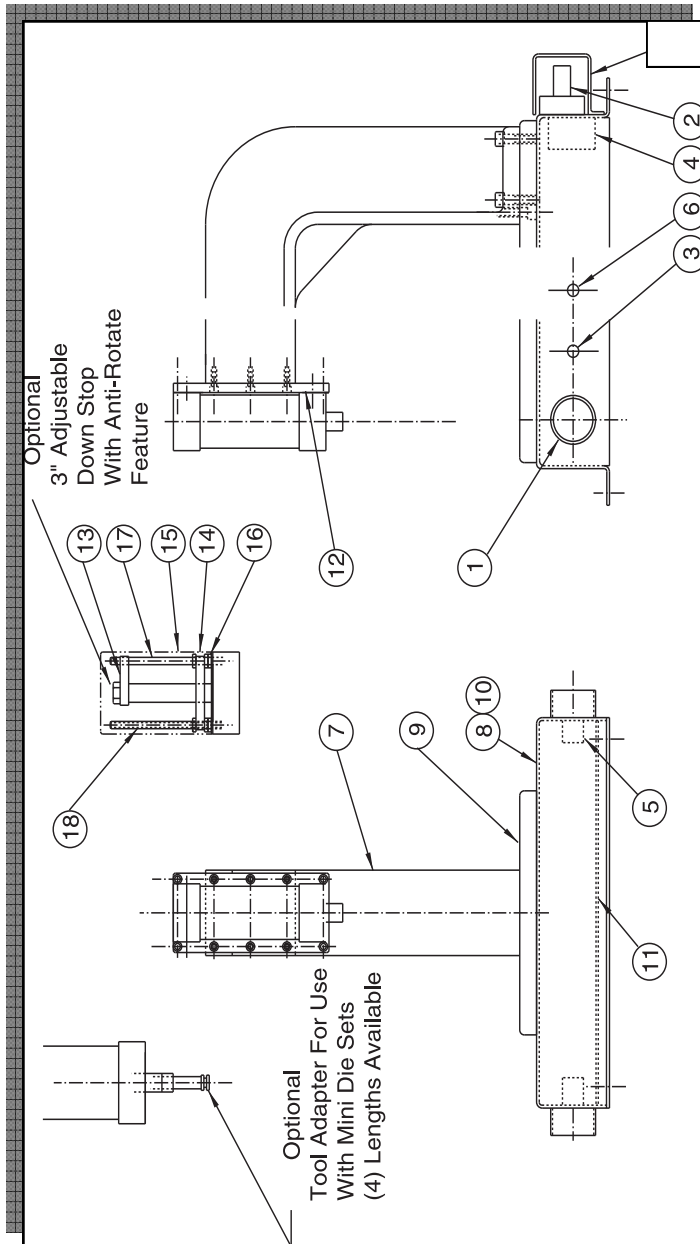
Read All Instructions Carefully

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-6019 & A-6024 A-6000 Series Parts List

ITEM	REQ'D	NAME	PART NO.
1	2	Push Button	503
2	1	Valve	511
	1	Valve Mounting Plate	3000-66
3	1	Fuse	515
4	1	Control Module	540
5	2	Contact, Push Button	545
6	1	On/Off Switch	560
7	1	Frame	6000-01
8	1	Control Box (PB)	6000-04
9	1	Plate	6000-05
10	1	Control Box (OT)	6000-06
11	1	Bottom Cover	6000-07
12	1	Cyl. Mtg. Plate	6000-10
13	1	Anti-Rotate 1-3/4 Bore	1000-06
14	1	Stop Plate 1-3/4 Bore	1000-07
15	1	Bottom Guard 1-3/4 Bore	1000-14
16	1	Bottom Guard 1-3/4 Bore	1000-10
17	1	Anti-Rotate Stud	3000-09
18	2	Threaded Rod	3000-26

A-6000 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.)

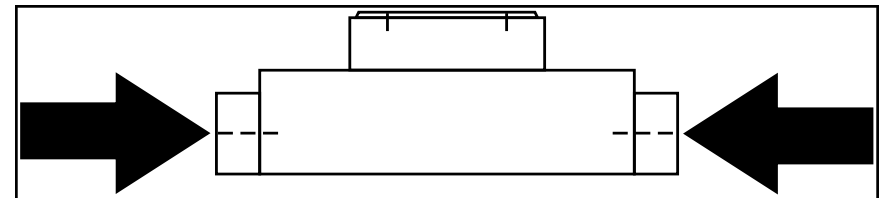
CONTROL MODULE – The life expectancy for the control module (#540) is ten million cycles. Replacing the module on a yearly basis will ensure production reliability and avoid costly downtime.

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.

