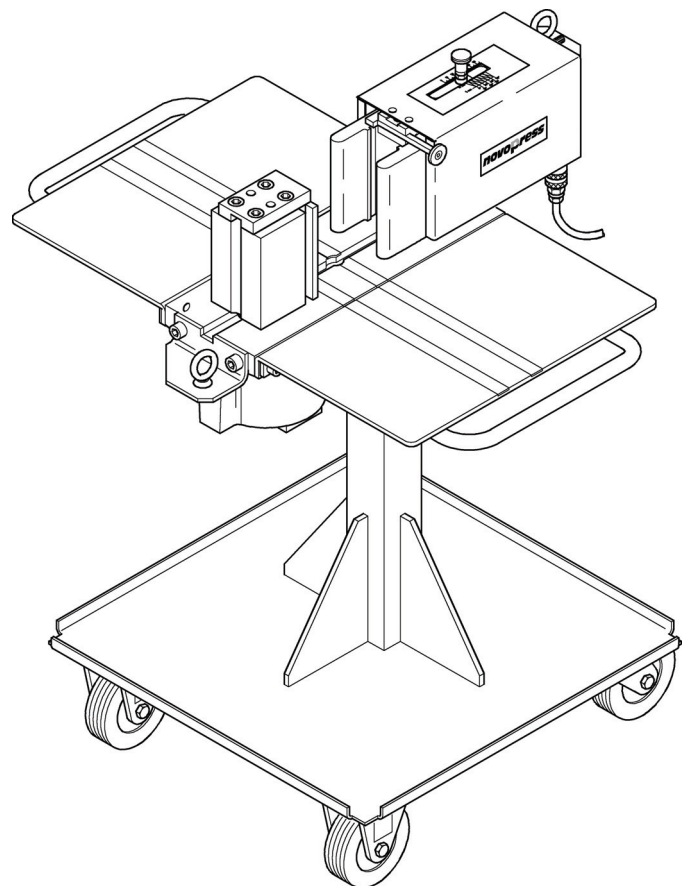
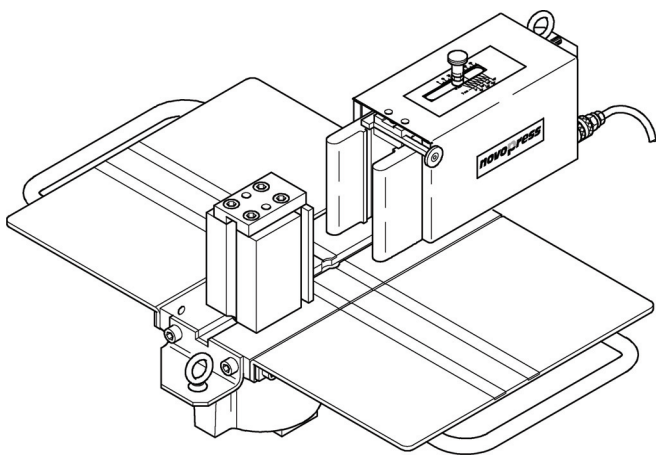


# Repair Instructions for

# **novopress**

## SLB 125



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## GENERAL SAFETY REGULATIONS

### Read all safety regulations and instructions!

1. Keep the place of work clean.  
Disorderly work-places and work-benches invite accidents.  
Ensure that lighting is good.
2. Keep children away.  
Do not allow unauthorised persons to touch the device or the cable.  
Keep unauthorised persons away from your place of work.
3. Wear suitable working clothing.  
Do not wear any wide clothes nor jewellery - they may get caught up in moving parts.  
When working in the open it is recommended that you wear rubber gloves and non-slip footwear. Wear a hair- net if you have long hair.
4. Always be alert.  
Only use a device after having been instructed in its operation.  
Concentrate on your work. Proceed sensibly.  
Do not use the device when you are distracted.
5. Do not lean too far forward. Avoid abnormal stance.  
Make sure that you have a secure standing position, and maintain balance at all times.
6. Leave safety devices where they belong.
7. Hand tools may not be installed as fixtures.
8. Repair and maintenance.  
Have repairs and maintenance work carried out in an authorised NOVOPRESS specialist workshop.  
Only use original and identical NOVOPRESS spare parts.  
We reject all responsibility and liability for work carried out by third- party personnel.

## SAFETY INSTRUCTIONS FOR HYDRAULIC EQUIPMENT

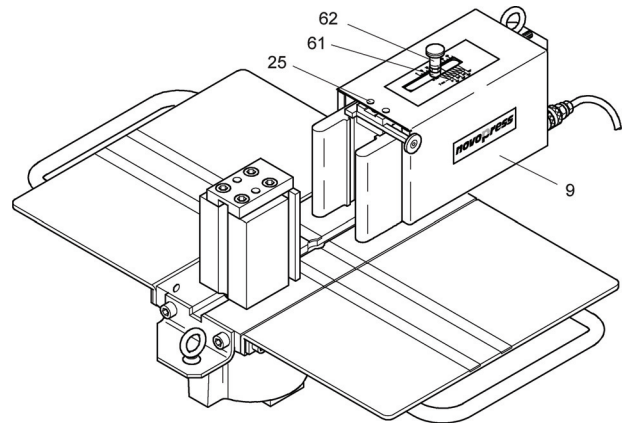
1. Please read the operating instructions.  
Acquaint yourself with the hydraulic equipment.
2. Provide the equipment with the necessary care.  
Always keep the equipment in operational condition.  
Cleanness is an essential requirement for good and safe working.
3. Switch off the electric power supply to the hydraulic equipment,
  - when the equipment is not in use
  - when maintenance work is to be carried out.
4. Avoid unintentional switching - on.  
Keep hands and feet away from the switch when the equipment is not being used.
5. Do not use the equipment in a manner in contravention of the instructions.  
Never carry the equipment by the pipe or pull on the pipe.  
Protect the piping from heat, oil, sharp edges and high levels of weight strain.
6. Use only piping, fittings and accessories which have been designed for the operating pressure of the hydraulic unit.  
**BURSTING PRESSURE OR TEST PRESSURE IS NOT OPERATING PRESSURE!**  
Avoid squashing or bending of the piping.  
Piping must not be painted over.
7. Replace the hydraulic piping
  - when cracks, squashed or bent points are to be seen
  - when blistering is established
  - when hydraulic fluid escapes
  - when pipe fittings are damaged
  - when discolouration is established on the outer layer, e.g. due to the influence of solvents.
8. The hydraulic fluid used in the system is kerosene-based.  
This requires particular care and attention.
  - Avoid continuous contact with the skin
  - ensure that the hydraulic fluid does not get into the eyes or mouth.Hydraulic pipes have to be replaced after 5 years of usage, despite of the circumstance that no damages should be remarkable.
9. The equipment must not be operated, if it has leaks and there is a danger of hydraulic fluid coming into contact with persons, open fire, heating equipment, electric cabling, ground water, foods and other substances which are intended for human consumption.
10. Hydraulic units with petrol engines
  - must not be operated in closed rooms, due to the **DANGER OF INTOXICATION!**
  - do not pour in petrol while the motor is running or in the vicinity of open fire. **DANGER OF EXPLOSION!**

**WARNING!**

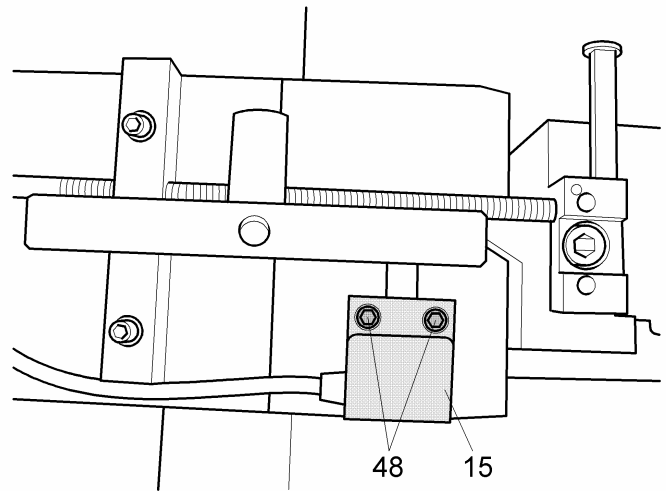
**Before beginning any maintenance or repair work, disconnect the hydraulic unit.**

**1. Changing the limit switch**

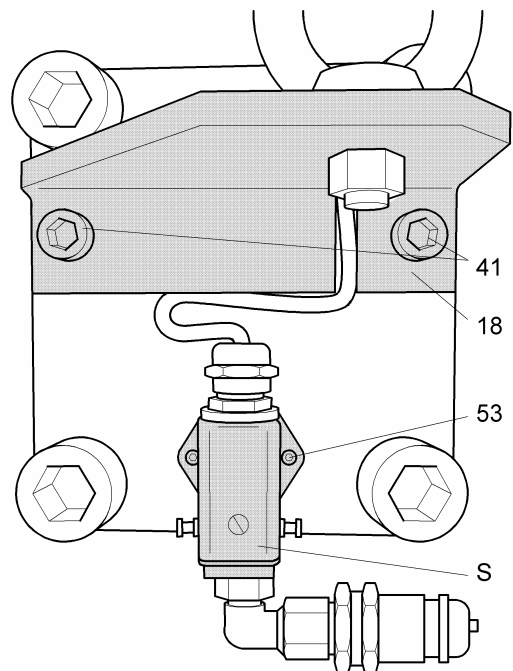
- 1.1. Unscrew indexing bolt (62) and remove it together with spacer bush (61).
- 1.2. Unscrew bolts (25).
- 1.3. Remove cover (9).



- 1.4. Unscrew bolts (48).
- 1.5. Remove limit switch (15) and place it on the workplate.



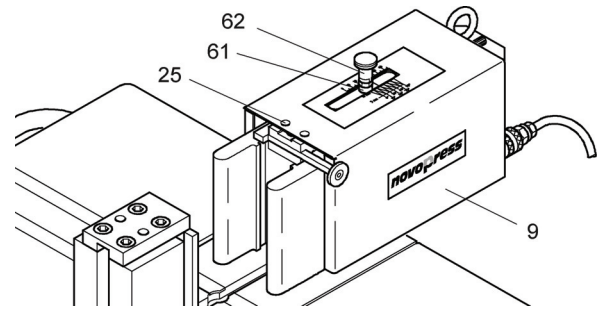
- 1.6. If present:  
Unscrew 2 bolts (41).
- 1.7. If present:  
Set aside angled plate (18).
- 1.8. Unscrew 2 bolts (53).
- 1.9. Remove socket housing (S).
- 1.10. Reassemble in reverse order.



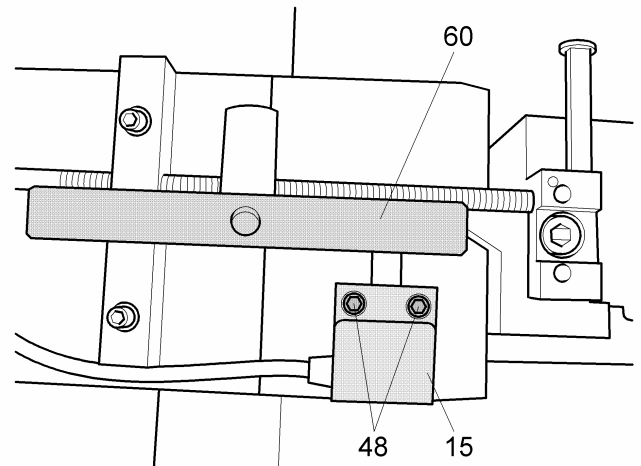
## 2. Replacing the cylinder

### Disassembly

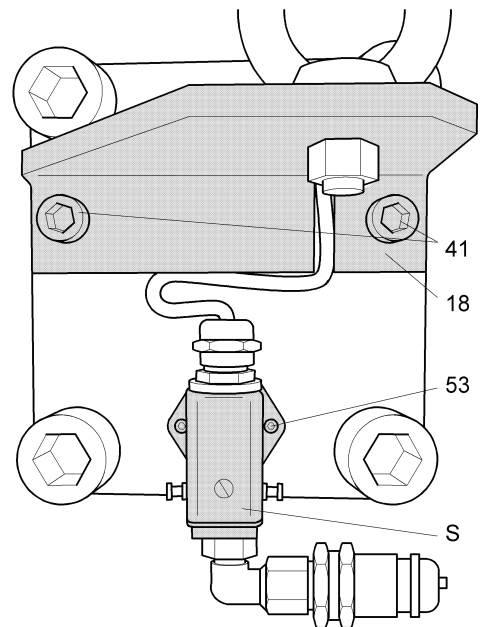
- 2.1. Unscrew indexing bolt (62) and remove it together with spacer bush (61).
- 2.2. Unscrew bolts (25).
- 2.3. Remove cover (9).



- 2.4. Remove stroke adjustment plate (60).
- 2.5. Unscrew bolts (48).
- 2.6. Remove limit switch (15) and place it on the workplate.



- 2.7. If present:  
Unscrew 2 bolts (41).
- 2.8. If present:  
Remove angled plate (18).
- 2.9. Unscrew 2 bolts (53).
- 2.10. Remove socket housing (S).



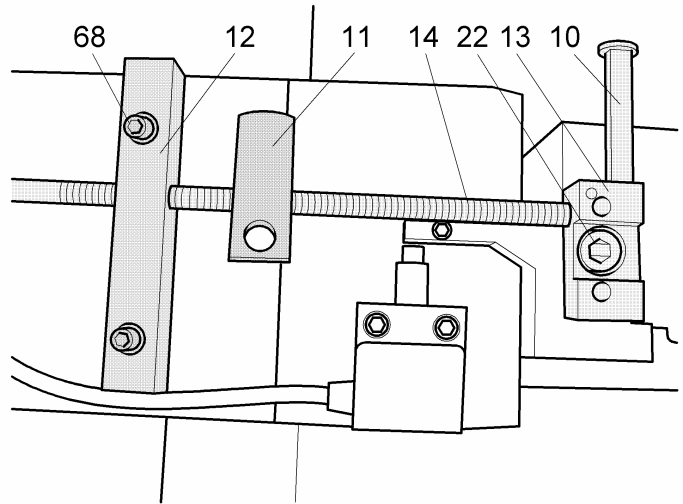
2.11. Unscrew bolts (68).

**Note**

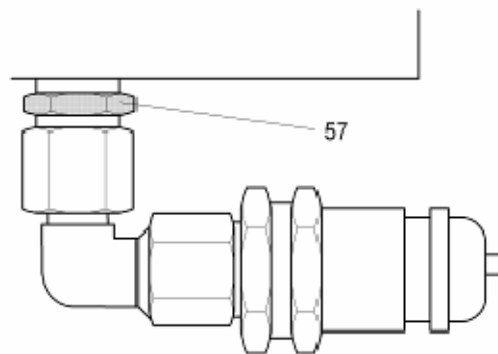
Do not adjust the nuts.

2.12. Unscrew bolt (22).

2.13. Remove the unit comprising spindle bearing block (13), spindle (14), spindle guide (12) and switch valve (10) in such a way as to ensure that the spindle does not become bent.



2.14. Unscrew pipe connector (57) from the cylinder.



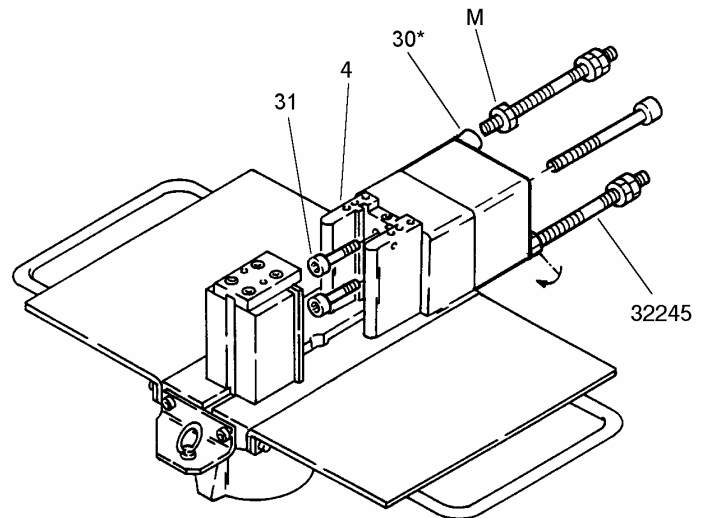
2.15. Unscrew bolts (31) and remove pressure piece (4).

2.16. Unscrew bolts (30\*) diagonally.

2.17. In place of the bolts (30\*), screw in the assembly bolts (accessory no. 32245) as illustrated and tighten them.

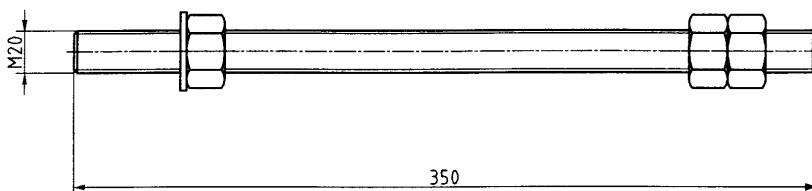
2.18. Screw loose nuts (M) onto the cylinder by hand.

2.19. Unscrew the 2 remaining bolts (30).



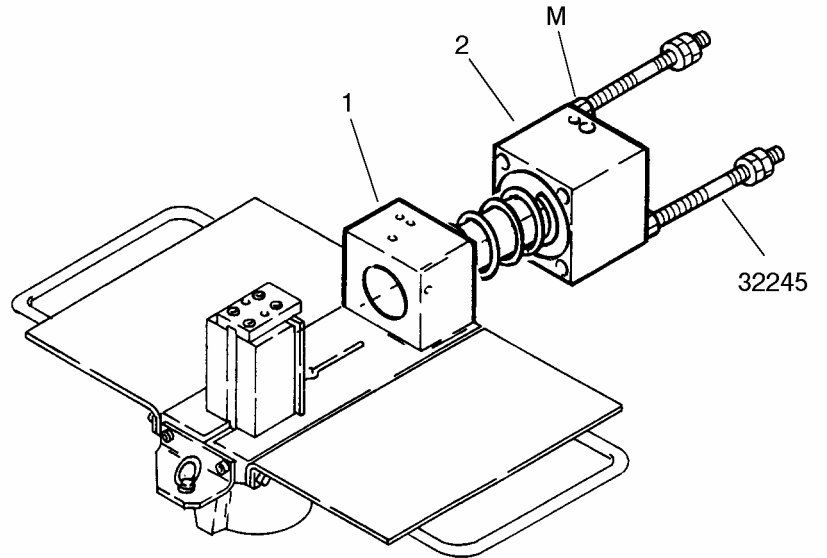
Accessory no. 32245

Screw the nuts against each other (fully tighten)



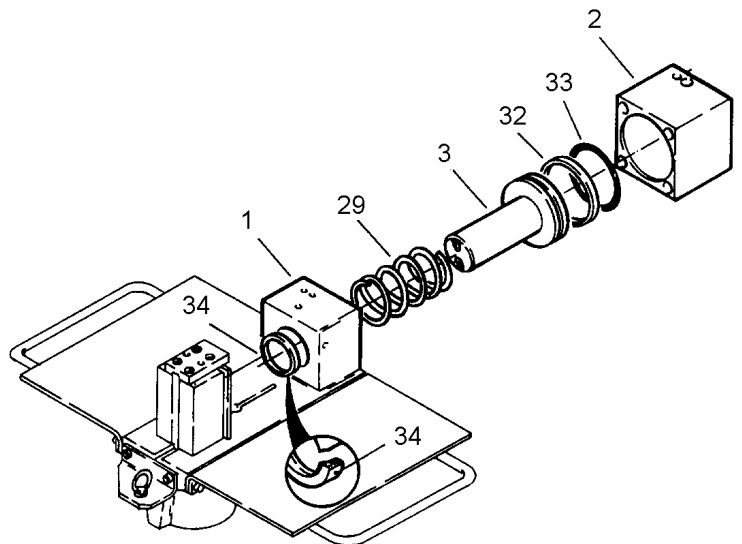
2.20. Unscrew loose nuts (M) step by step from the assembly bolts on alternating sides until the return spring is not tensioned.

2.21. Unscrew assembly bolts (32245).



2.22. Remove cylinder (2), piston (3) and return spring (29).

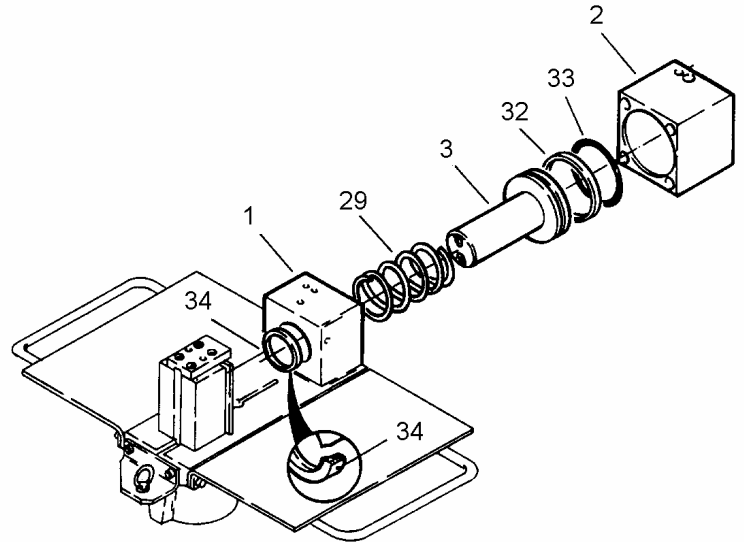
2.23. Wearing parts - replace O-ring (33), bearing ring (32) and scraper (34) if required.



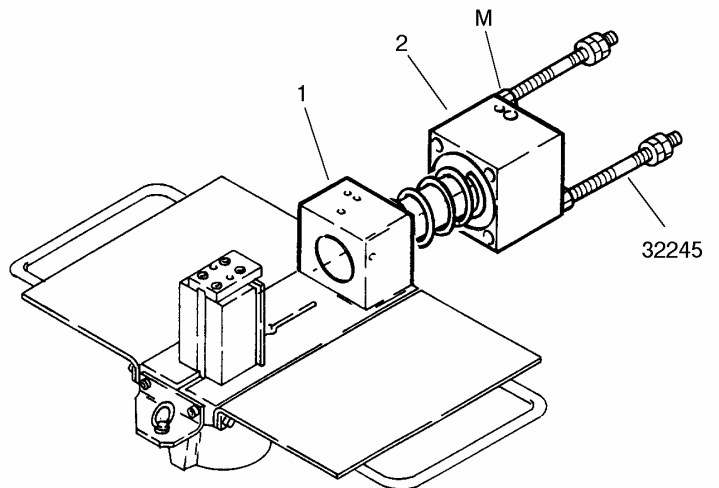


## Assembly

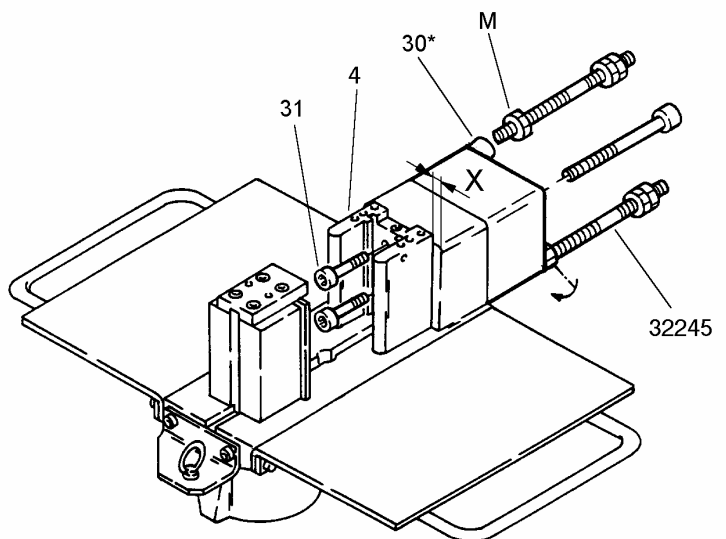
- 2.1. Place bearing ring (32) and O-ring (33) on piston (3).
- 2.2. Insert piston (3) in cylinder (2).
- 2.3. Push return spring (29) onto the piston rod.
- 2.4. Insert scraper (34) into plate (1).



- 2.5. Insert cylinder (2) with the components assembled into plate (1).
- 2.6. Screw assembly bolts (32245) diagonally through cylinder (2) into plate (1) and tighten them.
- 2.7. Using loose nuts (M), gradually (1/4 turns) draw cylinder (2) onto plate (1).
- 2.8. Screw in 2 bolts (30) and tighten them.
- 2.9. Unscrew assembly bolts (32245).
- 2.10. Screw in the remaining 2 bolts (30\*) and tighten them.
- 2.11. Initiate a test stroke to check that the device functions correctly.

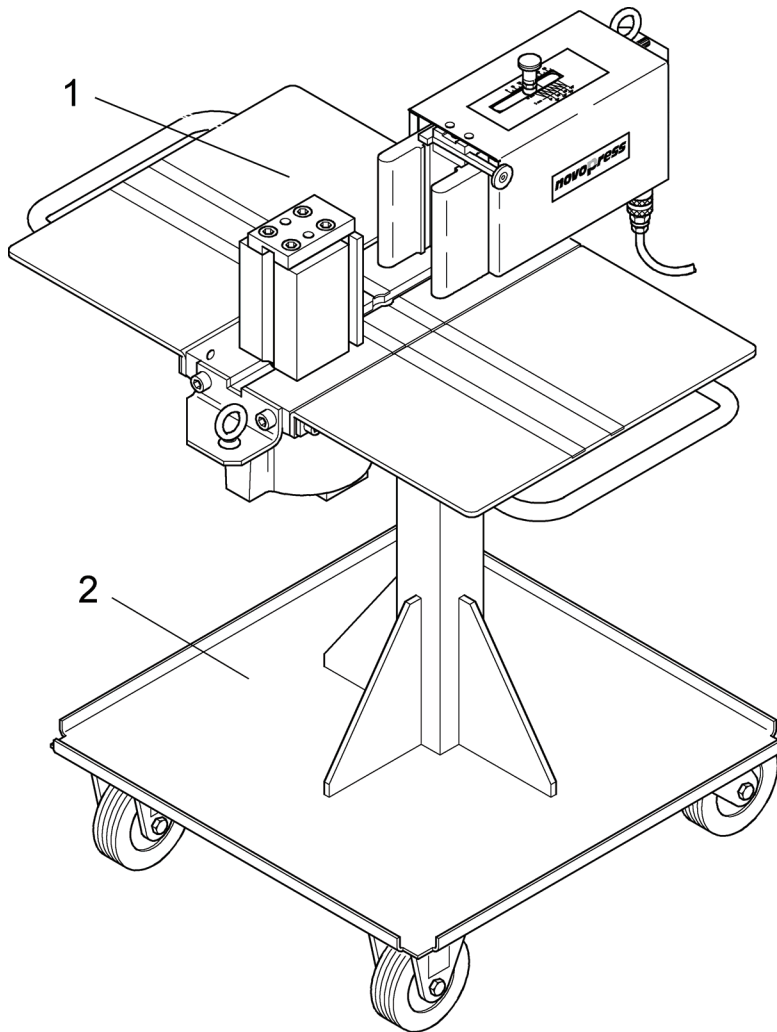


- 2.12. Insert bolts (31) into piston (3) without pressure piece (4).
- 2.13. Bolts (31) must be positioned vertically to the plate (check using a set square).
- 2.14. Unscrew bolts (31), position pressure piece (4) and attach it loosely to piston (3) using bolts (31). Align the pressure piece with table (1) so as to ensure that distance X is the same on both sides of the pressure piece.
- 2.15. Tighten bolts (31).
- 2.16. Finish assembly in reverse order.



**40070 SLB125 basic unit with carriage**

Item	Description	Ord. no.	Qty.
1	SLB 125 basic unit	40200	1
2	SLB 125 carriage assy.	40390	1



**40200 SLB 125 basic unit**

Item	Country code	Description	Ord. no.	Qty.
1		Table	30769	1
2		Cylinder	39696	1
3		Piston	31029	1
4		Pressure piece	39697	1
5		Tool retainer	31032	1
6		Cutting bar	31033	2
7		Pressure plate	31034	1
8		Anti-twist device	31035	1
9		Cover	39624	1
10		Switch valve	39625	1
11		Switching block	39628	1
12		Spindle guide	39627	1
13		Spindle bearing block	39626	1
14		Adjusting spindle	39629	1
15		Limit switch assy.	40138	1
16		Identification plate	39692	1
17		Stroke angle scale	40353	1
20		Carrying handle	31334	2
21		Coupling plug	3659	1
22		Cheese-head screw M10x40	16787	1
25		Countersunk screw M5x10	11197	2
26		Cheese-head screw M5x20	11010	2
29		Pressure spring	30378	1
30		Cheese-head screw M20x160	12131	4
31		Cheese-head screw M16x30	13982	2
32		Bearing ring	13979	1
33		O-ring	13980	1
34		Scraper	13229	1
35		Cheese-head screw M8x16	11313	4
37		Cheese-head screw M10x25	11248	10
39		Straight pin	12751	2
40		Cheese-head screw M6x12	11259	8
43		Straight pin	14223	1
44		Support plate, right	37525	1
45		Support plate, left	37526	1
47		Measuring tape	13377	4
46	45	Measuring tape	14058	4
48		Cheese-head screw M5x25	11323	2

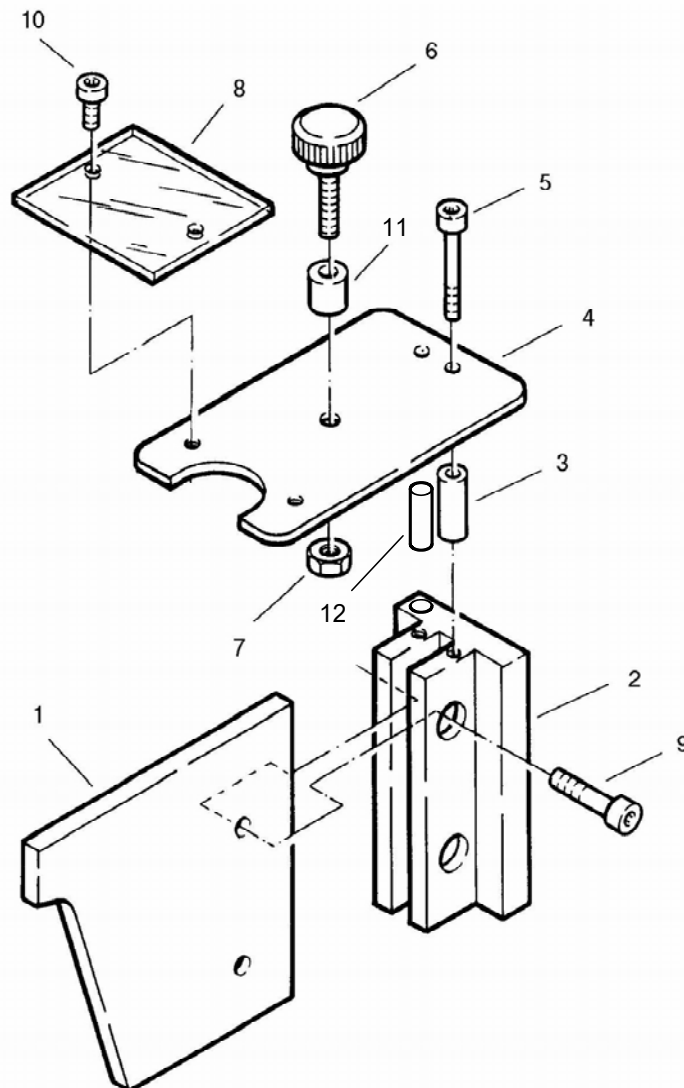
Item	Country code	Description	Ord. no.	Qty.
50		Washer	11203	5
51		Countersunk screw M4x10	11070	1
52		Novopress plate	33316	1
53		Cheese-head screw M3x8	12377	2
55		Base	40339	1
56		Cheese-head screw M10x12	11686	2
57		Straight pipe connector	13376	1
58		Adjustable angled coupling	13414	1
59		Union nut	1725	1
60		Stroke adjustment plate	40456	1
61		Spacer bush	40457	1
62		Indexing bolt	14127	1
66		Clamping sleeve	11977	2
67		Straight pin	11137	1
68		Cheese-head screw M5x35	11142	2
69		Nut M5	11065	2





### 31242 Cutting tool

Item	Description	Ord. no.	Qty.
1	Blade	31039	1
2	Blade bracket	31041	1
3	Sleeve	31307	2
4	Guard plate	31049	1
5	Cheese-head screw M5x50	12143	2
6	Knurled screw M8x25	14138	1
7	Hexagonal nut M8	11367	1
8	Protective glass	31323	1
9	Cheese-head screw M8x20	11094	2
10	Cheese-head screw M5x10	12350	2
11	Sleeve	31593	1
12	Straight pin	16206	1

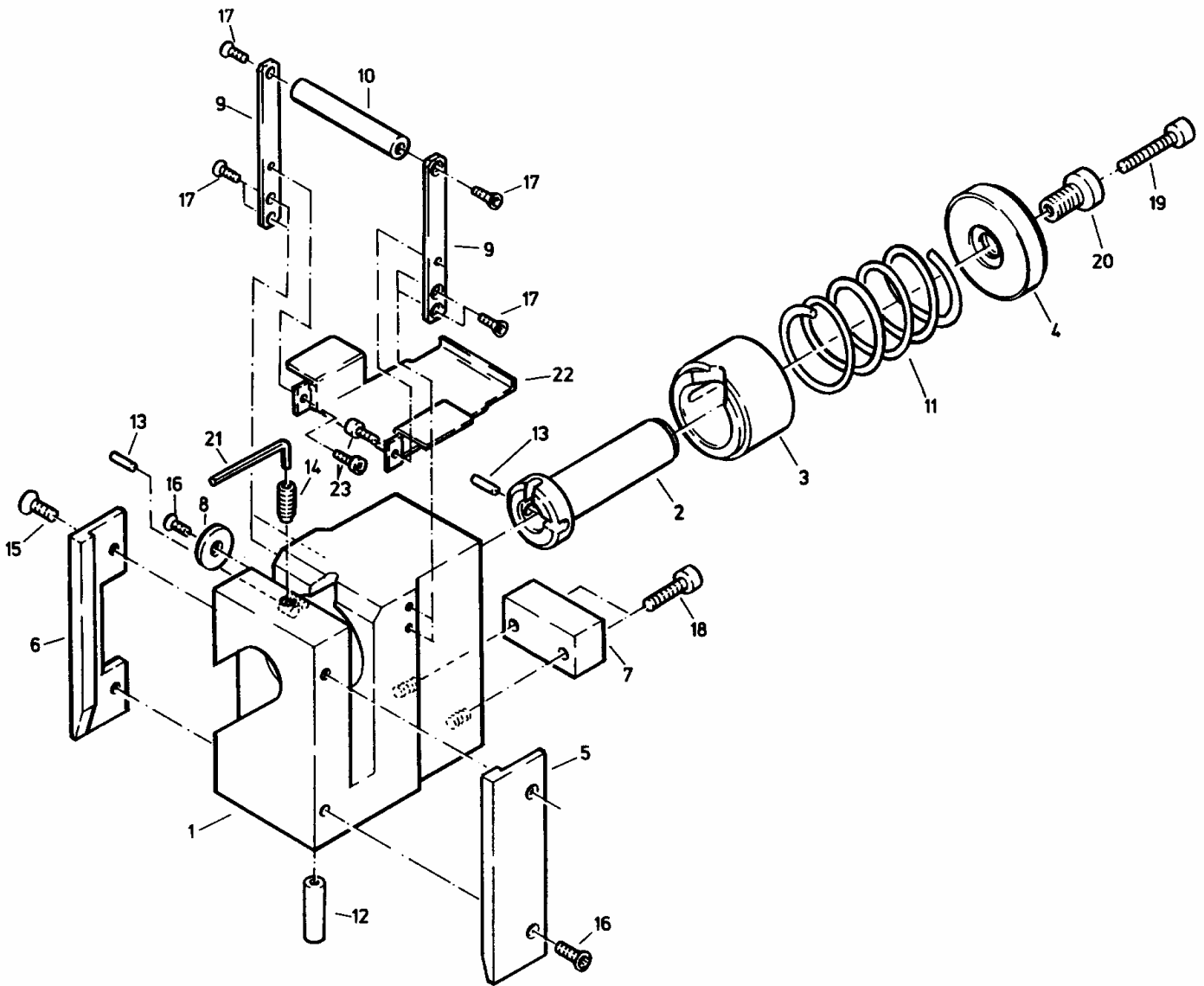


**30980 Hole puncher**

<b>Item</b>	<b>Description</b>	<b>Order no.</b>	<b>Qty.</b>
1	Body	30971	1
2	Piston	30973	1
3	Scraper	30974	1
4	Retractor washer	30975	1
5	Bracket, right	30972	1
6	Bracket, left	31122	1
7	Spacer block	30977	1
8	Cover disc	30978	1
9	Handle piece	31289	2
10	Handle	31291	1
11	Spring system, yellow	13926	1
12	Straight pin 10m6x30	14072	1
13	Straight pin 6m6x12	13150	1
14	Grub screw M8x12	14128	2
15	Countersunk screw M6x10	11044	4
16	Countersunk screw M5x8	12608	1
17	Countersunk screw M5x10	11197	6
18	Cheese-head screw M6x20	11009	2
19	Tool screw assy.	31480	1
20	Fastening bolt M12x20	31456	1
21	Hexagon socket spanner A/F 4	11769	1
22	Guard plate	31597	1
23	Cheese-head screw M4x6	14174	2

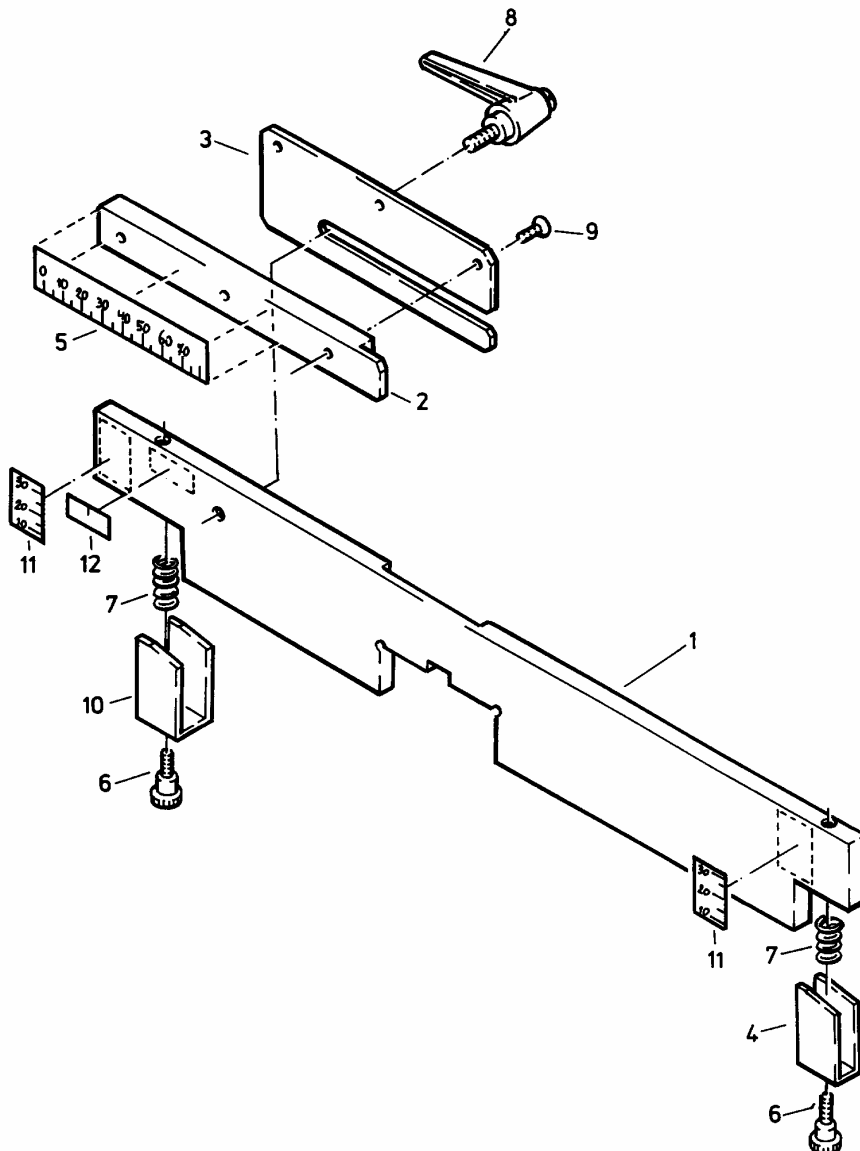


## 30980 Hole puncher



### 31890 Adjustable hole template

Item	Description	Order no.	Qty.
1	Guide rail	31891	1
2	Slide	31892	1
3	Guide plate	31893	1
4	Adjusting plate	31894	1
5	Scale	31071	1
6	Knurled screw	14260	2
7	Pressure spring	14261	2
8	Clamping lever	14262	1
9	Countersunk screw	11197	3
10	Adjusting plate	31912	1
11	Scale	31965	2
12	Scoring plate	31981	1

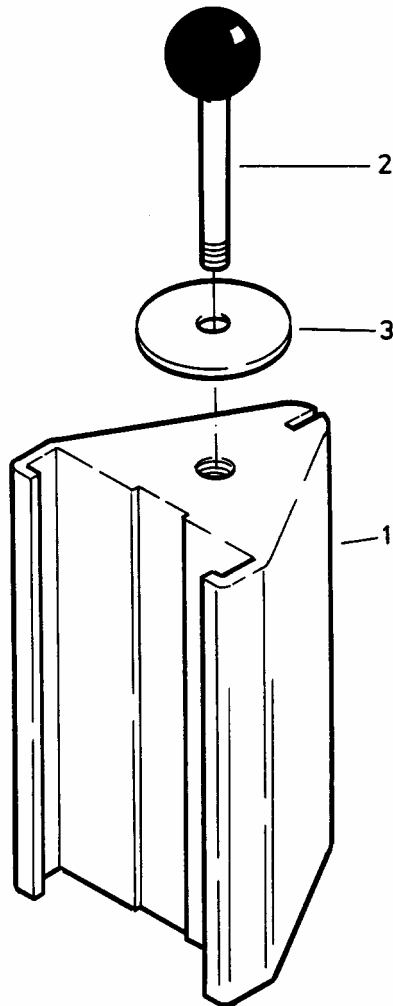


**31243 R 10 bending tool**

Item	Description	Ord. no.	Qty.
1	Bending mandrel	31038	1
2	Handle shaft	14197	1
3	Protective disc	31619	1

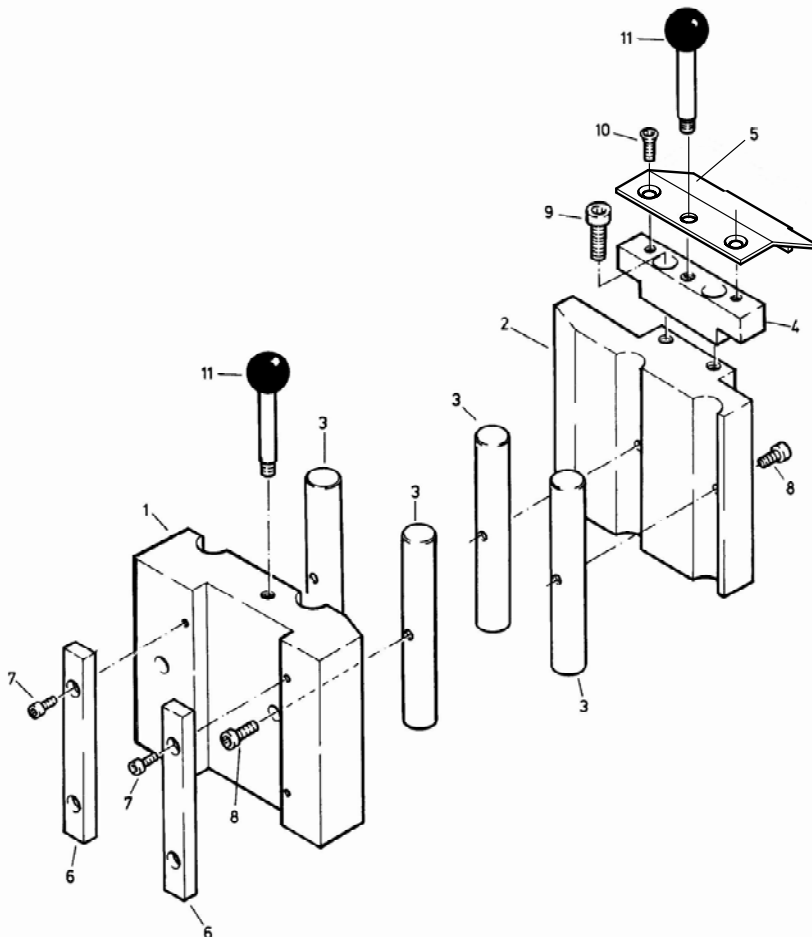
**31732 R 6 bending tool**

Item	Description	Ord. no.	Qty.
1	R6 bending mandrel	31747	1
2	Handle shaft	14197	1
3	Protective disc	31619	1



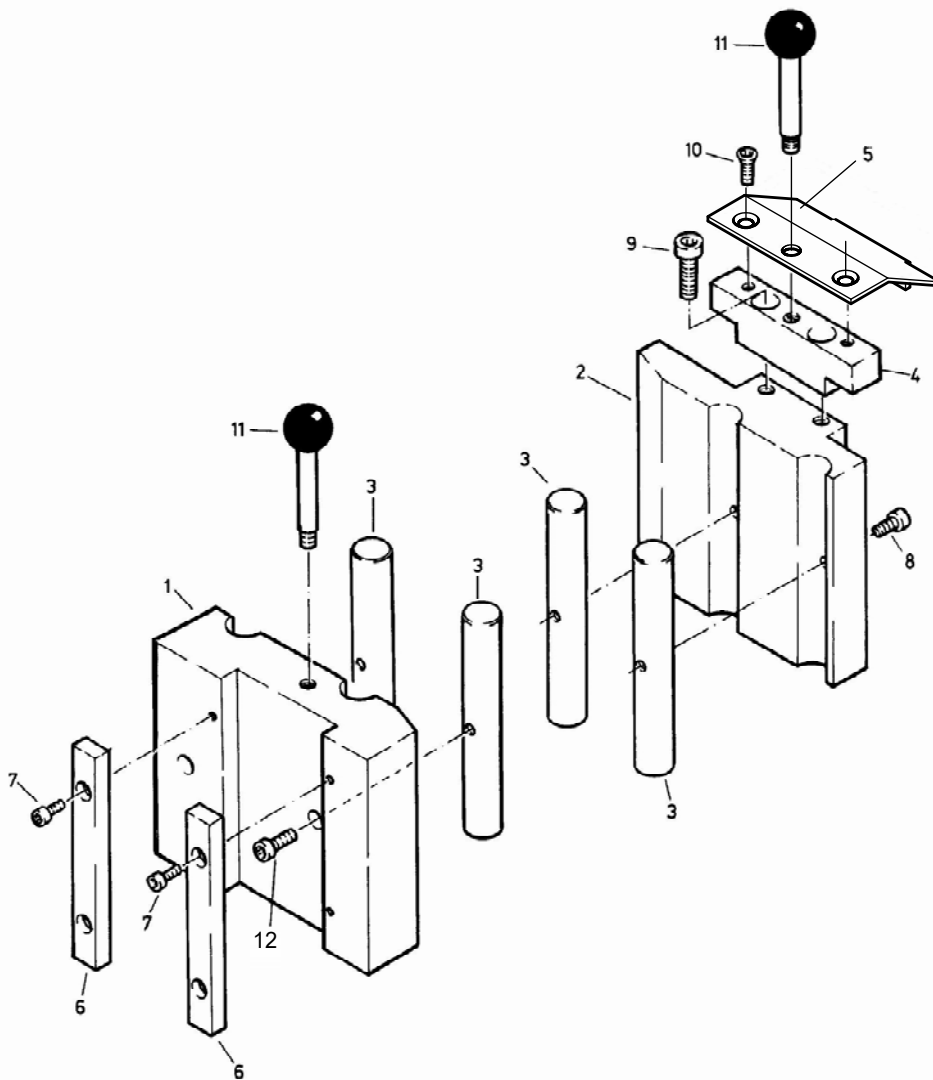
### 31425 Step bending tool, small

Item	Description	Ord. no.	Qty.
1	Step bending pressure piece 1	31423	1
2	Step bending pressure piece 2	31424	1
3	Step bending radius	31327	4
4	Stop bridge	31774	1
5	Retractor	40326	1
6	Guide bars	31339	2
7	Cheese-head screw M5x10	11081	4
8	Cheese-head screw M5x20	11010	4
9	Cheese-head screw M8x30	12590	2
10	Countersunk screw M6x12	11647	2
11	Handle shaft M8	14197	2



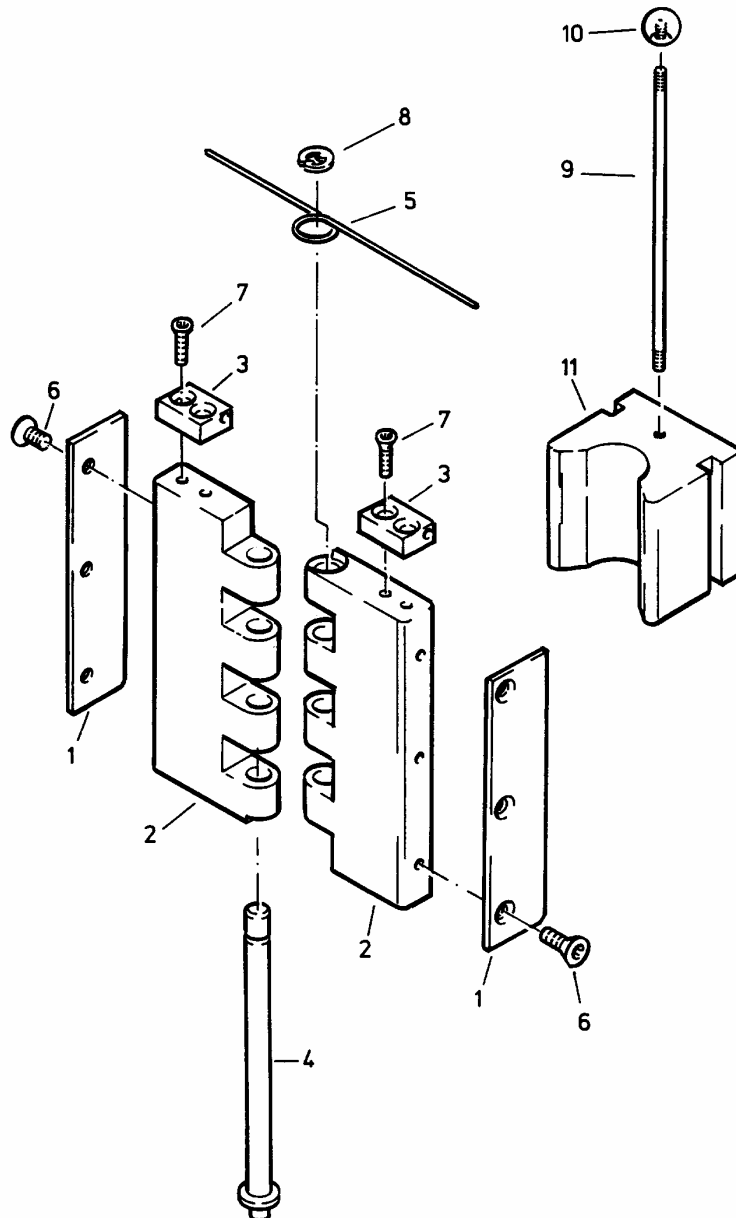
### 31646 Step bending tool, large

Item	Description	Ord. no.	Qty.
1	Step bending pressure piece 1	31338	1
2	Step bending pressure piece 2	31647	1
3	Step bending radius	2643	4
4	Stop bridge	31774	1
5	Retractor	40326	1
6	Guide bar	31339	2
7	Cheese-head screw M5x10	11081	4
8	Cheese-head screw M6x12	11259	2
9	Cheese-head screw M8x30	12590	2
10	Countersunk screw M6x10	11044	2
11	Handle shaft M8	14197	2
12	Cheese-head screw M6x30	12184	2



### 31636 Hinge bending tool

Item	Description	Ord. no.	Qty.
1	Spacer plate	31913	2
2	Hinge half	31914	2
3	Spring retainer	31915	2
4	Bolt	31916	1
5	Spiral spring	14210	1
6	Countersunk screw M5x10	11197	6
7	Countersunk screw M5x16	12755	4
8	Circlip	11644	1
9	Threaded rod	31653	1
10	Ball head	11243	1
11	Stop	31641	1





Repairs / service

**novopress**

**NELCO**

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