

PROCEDURE TO SET-UP THE STRESSING VALUES IN THE GAUGES OR PRESURE
DIGITAL DISPLAYS OF A "PAUL" BRAND PUMP UNIT AND PRE-STRESSING JACK
(manufactured by Paul Maschinenfabrik GmbH & Co. in Germany, EEC)

Step 1: Turn on the pump unit by turning the black circular switch to the "I" position.

Step 2: Turn counter-clockwise the cylindrical knob with the final sign, marked with the letter "P", 1 or 2 complete turns (to the "-" sign that is printed on it), located in the back side of the pump unit where the gauges or digital display are located.

Step 3: Press the "final" button in the remote, until the jack's piston reaches full stroke backwards and keep pressing the button to make sure the "final" pressure gauge reading is between zero and 200 bar (0 and 2900 psi).

Step 4: If the needle of the "final" pressure gauge, or the reading in the digital display, is over this range, please do the following:

- A) Release the "final" stress button.
- B) Press the "R" button to return the piston to the front of the Jack.
- C) Once the piston is completely in front of the jack, release the "R" button.
- D) Give 1 or 2 turns counter-clockwise to the cylindrical knob "P" and repeat step 3.

Step 5: Once you read a pressure of 200 bar (2900 psi) or lower in the "final Gauge", or digital display, proceed to press again the "final" button and keep holding it after the piston of the jack has reached it's full stroke backwards.

Step 6: With the "final" stress button pressed, turn the "final" cylindrical knob "P" clockwise (to the "+" sign) until you reach the design pressure.

To determine the correct reading in the "final" gauge for the "design tension" , use the calibration protocol supplied by your local calibrator.

The original digital display from PAUL, supplied with the jack, may come in PSI or LBF. The digital display is programable to change it from PSI to LBF and vice versa.

To set the initial stressing pressure, repeat the above procedure by using the "initial" gauge or digital display, and initial pressure button in the remote. This button is located between the final stress button and the "R" button.

This initial and final gauges, or digital display setting procedure must be followed exactly step by step to get the correct elongations in the strand.

For any question about this procedure please contact us at our cellular phone numbers:
(786) 447 8990 and (786) 447 7781.

Thank you very much.
Jorge A. Hernandez