

Cole-Parmer®

XP-400 X-Press®

Hydraulic Pellet Press for Spectroscopy Applications

Quick Start Guide

For 115V (04577-46) and 230V (04577-47)



For Product Information



How To Operate XP-400 X-PRESS®

- Do not place the XP-400 X-Press® on it's side (oil may leak). The unit should be operated on a flat, hard, stable benchtop due to the weight (approx 145 lbs).
- Connect the powercord to the AC Inlet located at the back of unit. Power On the XP-400 X-Press®.
- Upon start-up, the home screen will display, and the START and STOP buttons will flash. After a few seconds, INITIALIZING... will briefly be displayed at the bottom of the screen, indicating that initialization is in progress. When STANDBY is displayed at the bottom, the press is ready for operation.
- The touch screen on front of the XP-400 X-Press is used to program the press.
- Lift the safety door and place a loaded Die onto the platen/piston and tighten down the adjustment screw. Close the safety door.

- **PRESSURE** displays the piston force, from 0 to 35 tons, with a resolution of one ton. During a run, the pressure will increase from zero to the set tonnage and will gradually fall to zero as pressure is released at the end of a run. A minimum pressure of 10 tons is recommended.
- **DWELL** shows the time for which the maximum pressure will be maintained at the top of the cycle and is adjustable in increments of 15 seconds. During a run, "DWELL" will be displayed at bottom of the screen and the dwell time will count down in 1 second increments. The minimum dwell time is 0 and the maximum is 10 minutes.
- **RELEASE** indicates the time during which the system pressure will be bled to zero during an automatic cycle. The word "RELEASE" will be displayed at bottom of the screen and will count down in 1 second increments during a run. Release is adjustable in 15 second increments. The minimum release time is 15 seconds and the maximum is 10 minutes.
- The Plus (+) and Minus (-) buttons are used to increase or decrease the settings shown in the PRESSURE, DWELL, and RELEASE fields. First press the button (e.g. Pressure) to activate field then use the plus or minus buttons to enter desired settings.
- **STANDBY** indicates that the press is in automatic mode. To operate in manual mode, touch the AUTO/MANUAL button. MANUAL will be displayed at the bottom of the screen.
- **MANUAL** is used when the operator prefers to run the press manually rather than automatically. When operating in manual mode, all other fields are inactive and cannot be adjusted. To switch from manual to automatic mode, touch the AUTO/MANUAL field. STANDBY will be displayed.

Changing the Run Parameters

To operate in Manual Mode refer to section 7.4 of the manual. To start a run press the Start button. To abort the program, touch the STOP button. For maximum consistency in pressure, it is not recommended that the XP-400 X-Press be operated below 10 tons.

The X-Press is shipped with an initial set of default values: 20 tons pressure, 30 seconds dwell, and 30 seconds release. These will remain the default values until the settings are changed.

- Step 1.** To change the pressure setting, touch the PRESSURE button on the display screen. Press the plus button (+) to increase pressure by 5 ton increments or press the minus (-) button to decrease by 5 ton increments. Maximum pressure is 35 tons. The new settings will be saved once the press is operated at these settings. When the X-Press is turned off, it will revert to the last saved settings upon start-up.
- Step 2.** To change the dwell setting, touch the DWELL button on the display screen. Press the plus button (+) to increase the dwell time in 5 second increments or press the minus (-) button to decrease time in 5 second increments. Maximum dwell time is 10.00 min. The new settings will be saved once the press is operated at these settings. When the X-Press is turned off, it will revert to the last saved settings upon start-up.
- Step 3.** To change the release setting, touch the RELEASE button on the display screen. Press the plus button (+) to increase the release time in 5 second increments or press the minus (-) button to decrease the run time in 5 second increments. Maximum release time is 10.00 min. The new settings will be saved once the press is operated at these settings. When the X-Press is turned off, it will revert to the last saved settings upon start-up.
- Step 4.** Lift the safety door, place a loaded Die onto the platen/piston and tighten down the adjustment screw. Close the safety door and press the START button to begin a programmed run.
- Step 5.** At the end of a run, or when the red STOP button is pressed, the unit will “beep “and both the START and STOP buttons will flash. The controls will reset to the beginning of a new cycle and the message at the bottom of the page will return to “STANDBY”. The door can be opened and the die removed at this point.



Our Application Specialists at Cole-Parmer are here to help with advice on accessories and grinding protocols.

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