



- Holomatic®
- Special Machines
- Programmable Holomatic®
- Multiple Spindle Heads

PROCEDURE FOR BLEEDING AIR FROM MODEL J2 & A2 HOLOMATICS

(USING 21085-00 AUTOMATIC OIL FILLER ASSEMBLY)

The first item to check is to determine if air is in the hydraulic system and if there is air present, how bad is it.

This step is very helpful, but not mandatory. Reduce the air supply to the Holomatic with the air regulator to the minimum required to cycle the unit. Normally 10 PSI Advance and 30/40 PSI Retract.

Rotate the advance cam bar to zero rapid position, full clockwise so that the rapid control lever is not depressing the plunger. If in doubt, remove the lever arm.

If a retract feed control is installed on the unit then the retract feed valve **must be full open** and the rapid cam bar rotated to full counter clockwise, holding the **retract rapid valve full open**.

Turn the advance feed valve to minimum open position. Close completely with fingers, **DO NOT FORCE**, as the valve may be damaged.

Cycle the Holomatic, shift the directional valve and observe the distance the piston travels. A system that has no air in it will allow the piston to jump forward about 1/16 to 1/4 inch. The greater distance the piston jumps forward on this cycle, the more air in the system. Note: Retracting the piston then cycling it again immediately one (1) or more times will reduce the amount of jump that you will observe. This does not mean that there is less air in the system, only that you have compressed the air bubble into a smaller mass. The air bubble will expand and blow air and oil out the filler bowl or will be noted when it passes through the feed valve as a jumping motion.

Open the socket head cap screw located on top of the automatic filler valve, (Ref. Bulletin 21085-00) (2) two to (4) four turns. This is a bypass to allow air to escape from the hydraulic system. Rotate the positive stop to allow a full stroke, IE. 2 in., 6 in., etc. This is required so that air that is trapped in front of the quill piston may be ejected. Open the advance feed valve (4) four turns for a slow feed. After bubbles have stopped, **close cap screw**.

Cycle the unit and hold the cycle poppet or button so that the unit does not retract when it reaches the end of the stroke. Open the cap screw. When air is in the system it will be ejected out the oil bowl at this time. Do not allow the oil bowl to go empty, stop the cycle by reducing air pressure and refill. After the bubbles have stopped or are very few and small, **close cap screw**, retract the unit, open cap screw, wait to see if you get any bubbles, then repeat. Keep repeating this procedure until no more air bubbles may be seen. Note: Very small bubbles may come out in a stream and are hard to get rid of, these are caused by too fast a feed.

If after 15 to 20 minutes of repeating this procedure a large amount of bubbles are still observed, then there is a good chance a re-sealing job is required.