



# Castle TSM-21

## Air Pressure Regulator, Setting

21.90

The Pressure Regulator determines Drill Feed Rate, clamping pressure, and overall speed of the machine. The factory setting is approximately 75 PSI. and should be checked periodically or when machine performance becomes rough or too slow. Cycles that are too slow can burn bits and cause drill bit separation at the shank. Cycles that are too fast can cause drill bits to break or to cut over-sized holes.

NOTE: It's extremely important that a minimum 85 PSI be provided from your compressor. Operating pressure can be especially affected by other machines that share the same air line as your TSM-21.

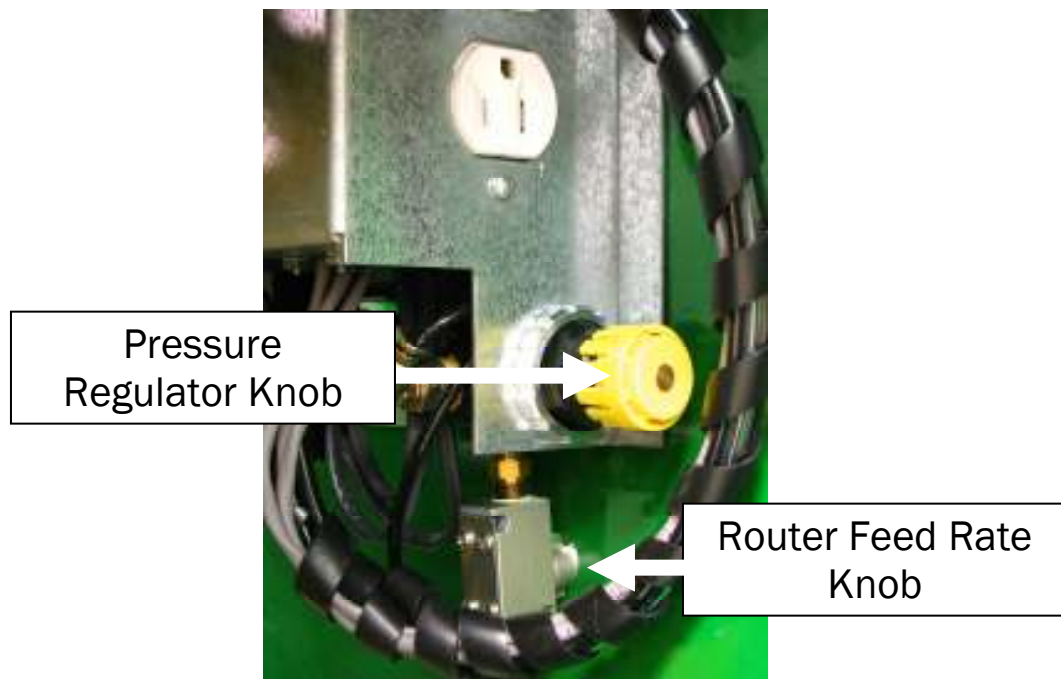


Figure 32

To reset the Air Pressure Regulator:

1. Open the rear door and locate the Pressure Regulator mounted to the Control Box. **See fig. 32.**
2. Pull out the Click-collar on the Regulator knob to unlock it.
3. Turn the knob fully counter-clockwise until it stops
4. Use a marker pen to make a reference point on the knob then turn it 6 full clockwise rotations. This process will set the pressure to approximately 75 PSI.
5. Cut test pockets and adjust slightly more or less than 6 turns until the appropriate operational speed is reached. **NEVER EXCEED 7 FULL ROTATIONS.**
6. Push in the click-collar on the Regulator knob to lock it.

**NOTE:** If the Pressure Regulator has been adjusted, the Router Feed Rate may need re-adjustment after the Pressure Regulator setting has been finalized. **See Procedure 21.32**

Castle, Inc. 1364 N. McDowell Blvd. PO Box 750236. Petaluma CA 94975  
(800) 282-8338 Fax (707) 765-0953 [www.castleusa.com](http://www.castleusa.com)