

Required Tools:

1. #2 Phillips Screwdriver
2. #1 Phillips Screwdriver



CAUTION: Detach power cord before proceeding



Remove 4x #6 x 1/2" Screws from control housing using #2 Phillips Screwdriver



Remove 2x #4-40 x 1" Screws from Controller Housing using #1 Phillips Screwdriver

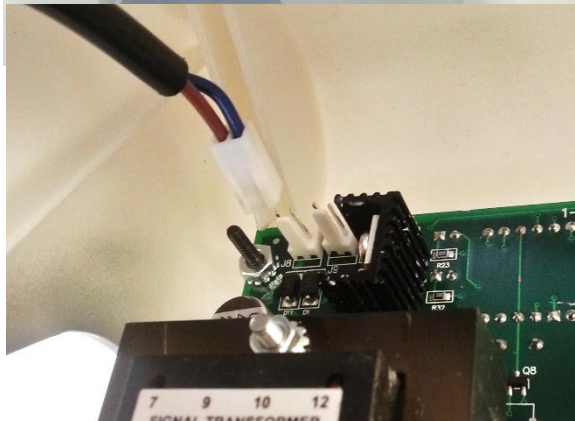
NOTE: #4-40 Nuts on back side can be removed without a wrench due to integral toothed lock-washer



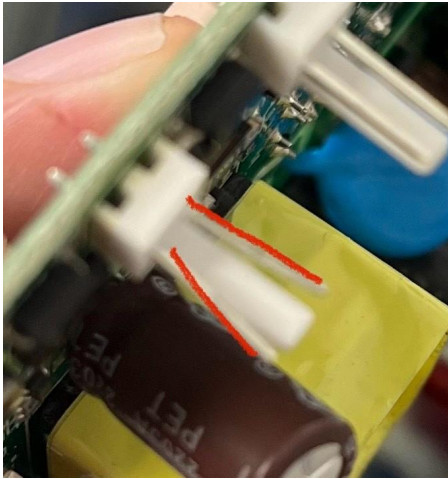
Lift off top half of Controller Housing and remove 2x #6 x 1/2" Screws from Controller Bracket using #2 Phillips Screwdriver



Fully remove top half of Controller Housing and set aside



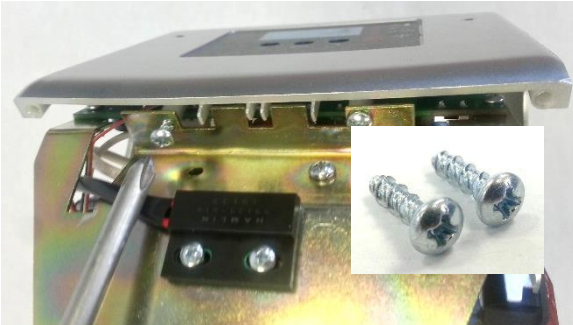
Unplug Electromagnet from Controller port P2 (newer models) or EM1 (older models)



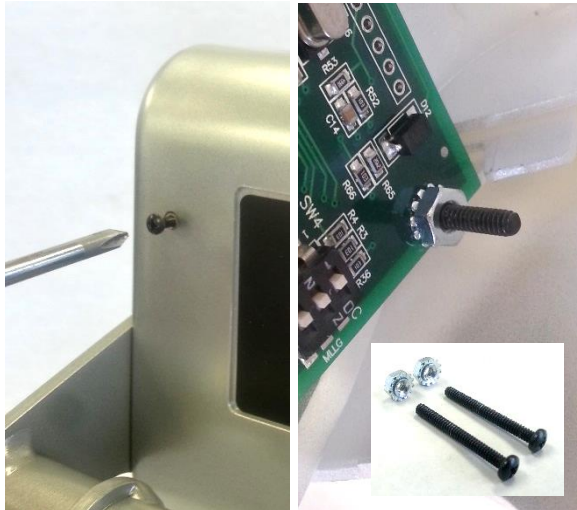
Spread the pins to reflect what is shown, similar to a V shape.



Plug Electromagnet wires into Controller port P2 (newer models) or EM1 (older models)



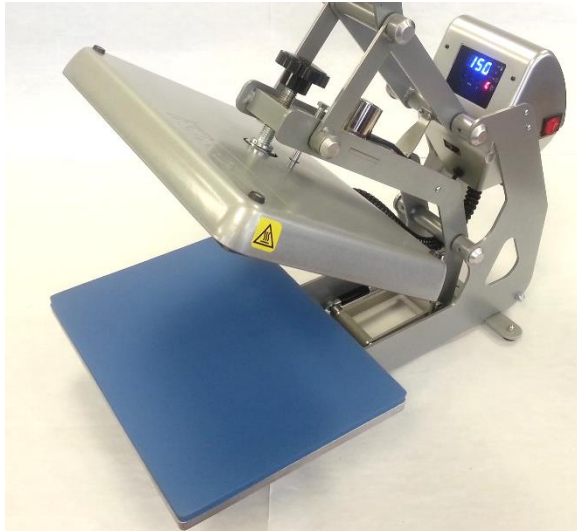
Attach Controller to top half of Controller Housing by screwing in 2x #6 x 1/2" Screws using #2 Phillips Screwdriver



Install 2x #4-40 x 1" Screws and Nuts with Lock Washer using #1 Phillips Screwdriver to secure new Controller to top half of Controller Housing



Install top half of Controller Housing and secure by screwing in 4x #6 x 1/2" Screws using #2 Phillips Screwdriver



Plug in press and turn ON to verify proper operation