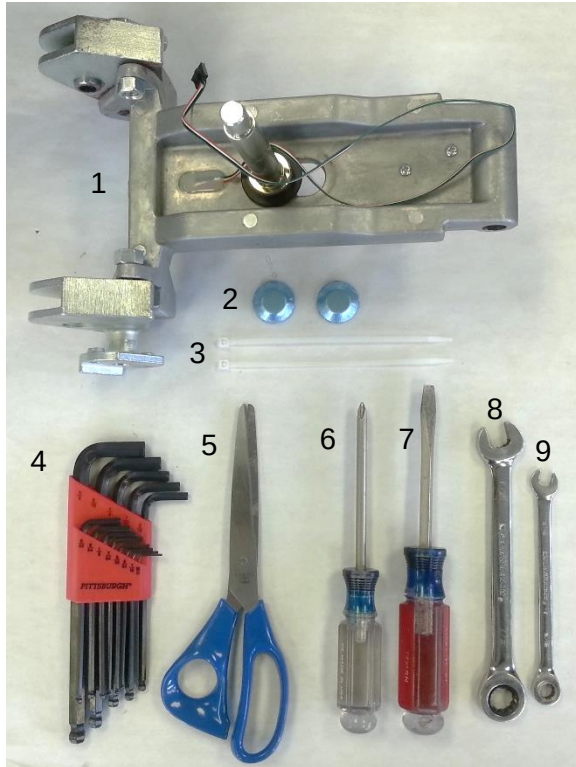


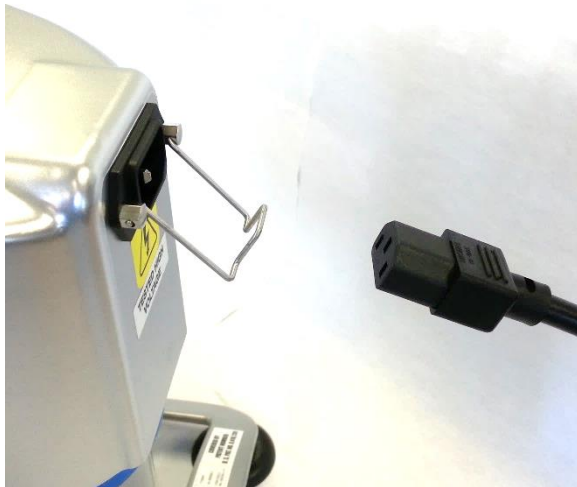


Included Parts:

1. Adjustment Casting Assembly
2. Hub Caps
3. Zip Ties

Required Tools:

4. Allen Wrenches (3/32" & 9/64")
5. Scissors
6. #2 Phillips Screwdriver
7. Flathead Screwdriver
8. 1/2" Combination Wrench
9. 5/16" Combination Wrench



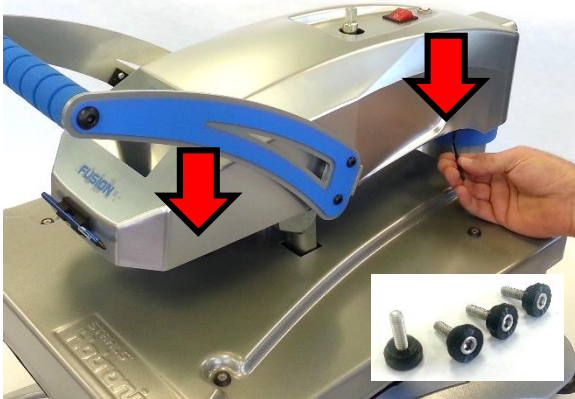
CAUTION: Detach power cord before proceeding



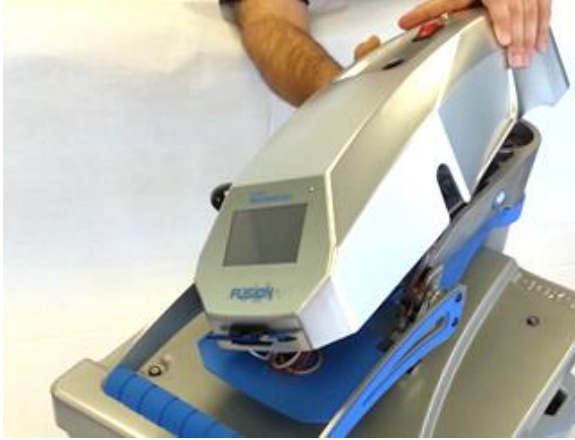
Lower heater but do not lock into place, such that it rests gently on lower platen



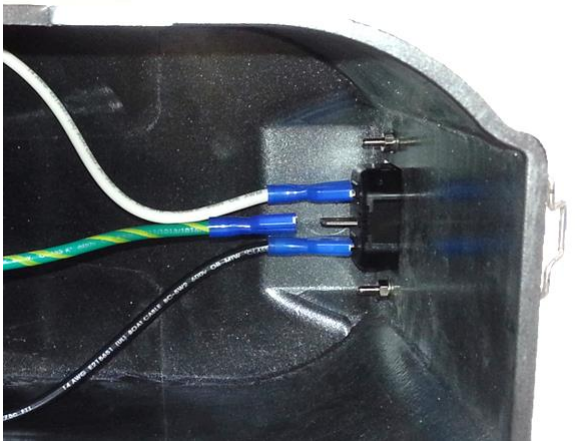
Loosen set screw in shaft of pressure adjustment knob and remove knob



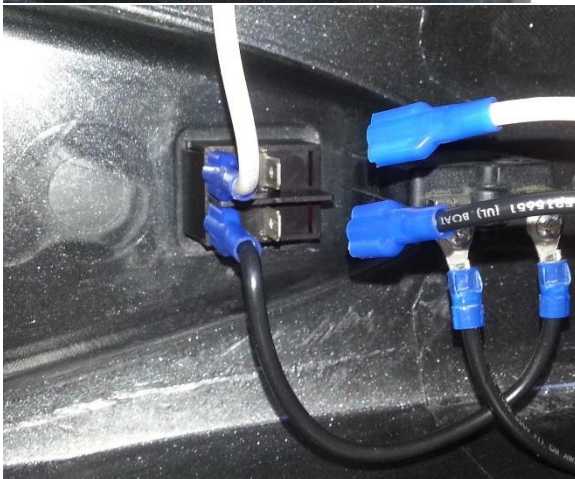
Remove 4 #8-32 x 1/2" Thumb Screws (right 2 shown) from underside of control housing using 9/32" Allen Wrench



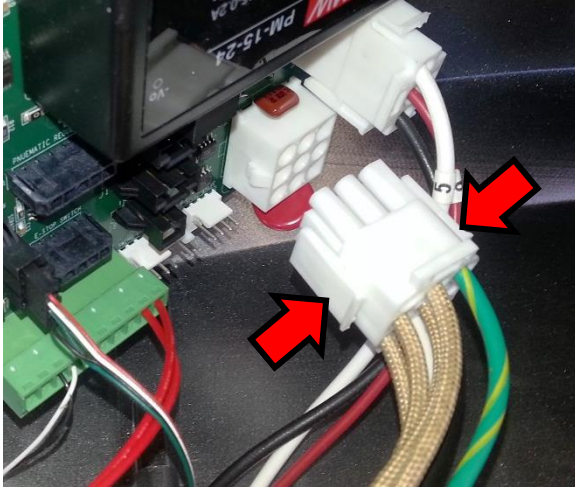
Lift off control housing and lay it gently on left side of press



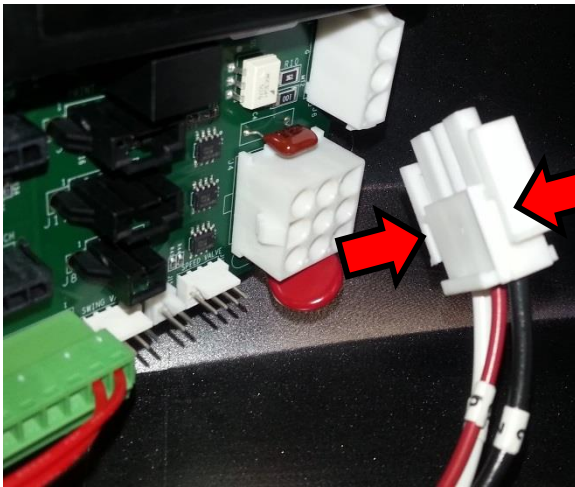
Unplug ground wire (green with yellow stripe) from IEC inlet at rear of housing



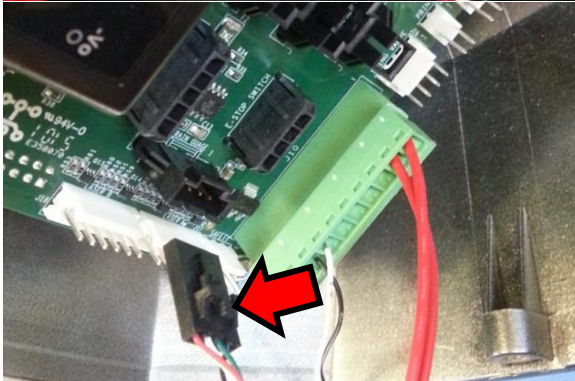
Unplug Black & White wires from Power Switch as shown to disconnect from Controller



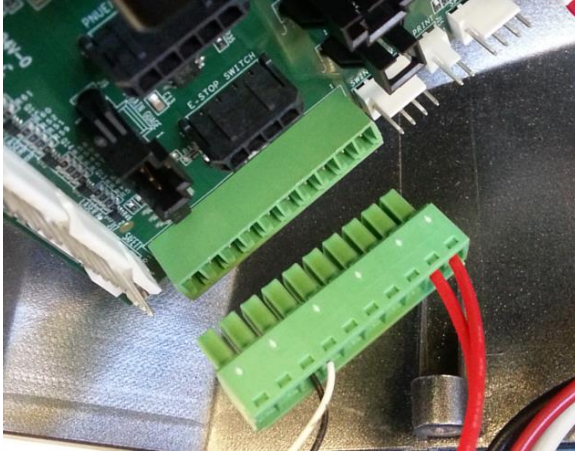
Unplug 9-pin connector from Controller by squeezing sides to release locking clips



Unplug 3-pin TRIAC connector from Controller by squeezing sides to release locking clips



Unplug 4-pin Strain Gauge connector from Controller by depressing locking clip

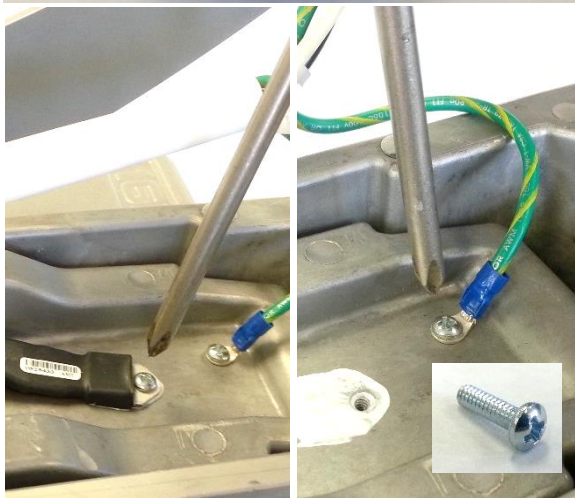


Unplug 10-pin I/O connector from Controller

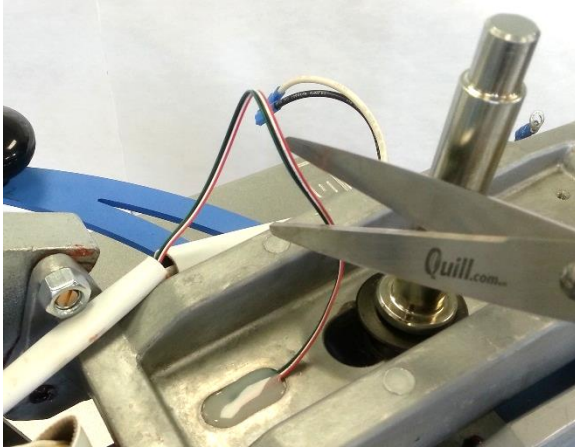
NOTE: Version 2 and prior Controllers use 25-pin D-sub connector



Remove control housing and set aside

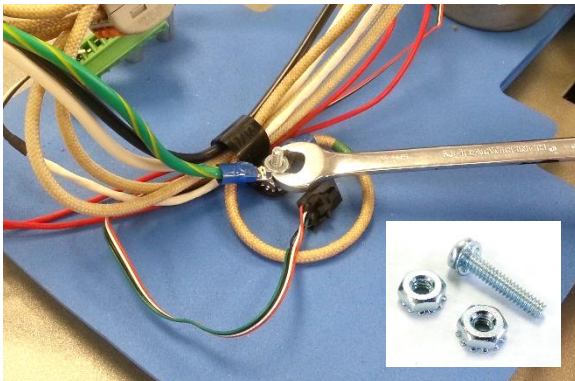


Remove TRIAC and ground wire from casting by unscrewing 2 x #6-32 x 1/2" screws using #2 Phillips Screwdriver

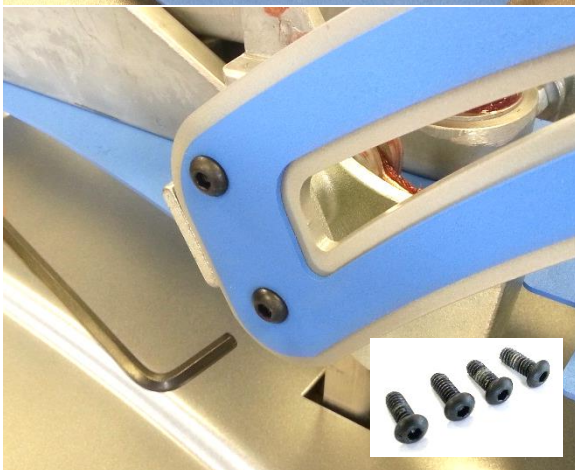


Cut Strain Gauge wires using Scissors

NOTE: Leave at least 1.5" of wire on 25-pin connector for Controller V3.7 or below

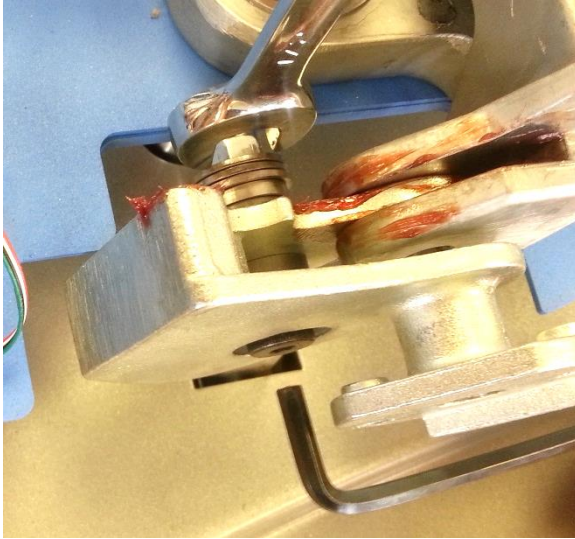


Loosen #6-32 x 1" screw using 5/16" Combination Wrench and remove cut Strain Gauge wires from sheathe and clamp, then re-tighten screw

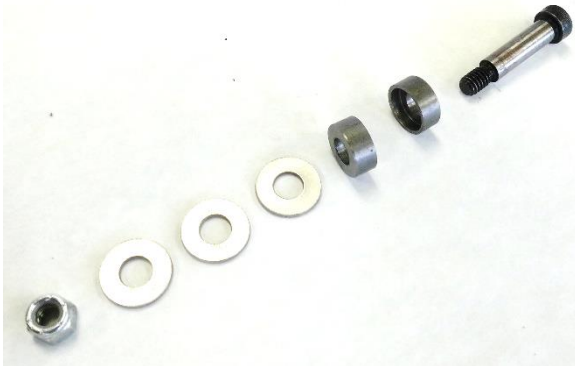


Remove handles by unscrewing 4x 1/4"-20 x 5/8" bolts from handles using 5/32" Allen Wrench

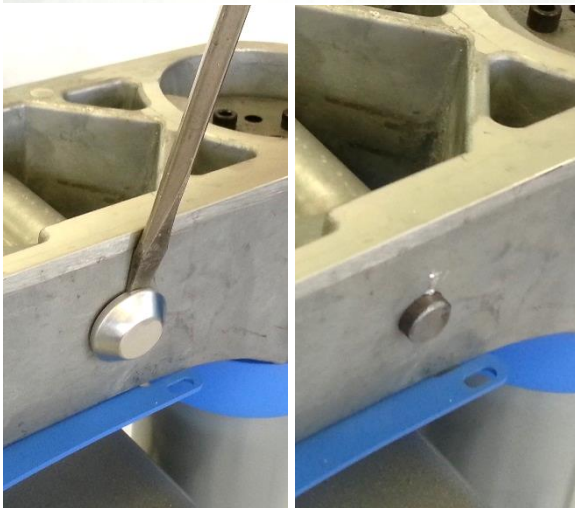
NOTE: Avoid dropping handles to prevent damage to painted surfaces below



Remove shoulder bolts using 3/16" Allen Wrench and 1/2" Combination Wrench



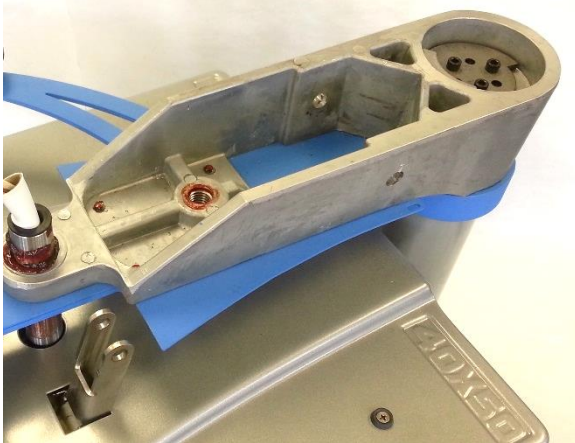
Group Shoulder Bolt hardware together to avoid re-assembly issues, noting order



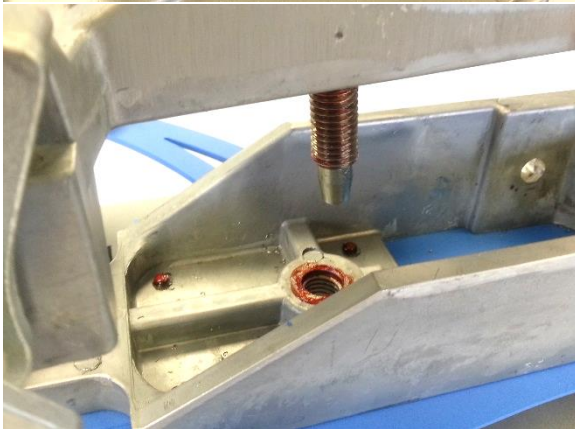
Remove one Hub Cap by prying with Flathead Screwdriver



Remove rear pin and unthread Pressure Adjustment Spindle completely



Remove old Adjustment Casting and discard



Place replacement Adjustment Casting into press and thread in Adjustment Spindle

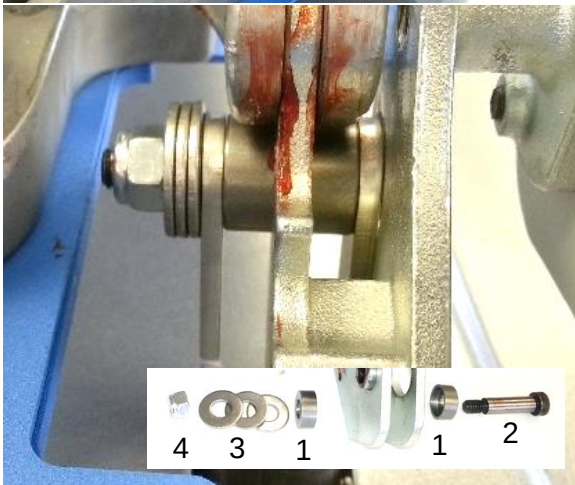


Re-insert existing rear pin



Attach provided Hub Cap to rear pin and squeeze to secure

NOTE: A clamp or vise may make this easier

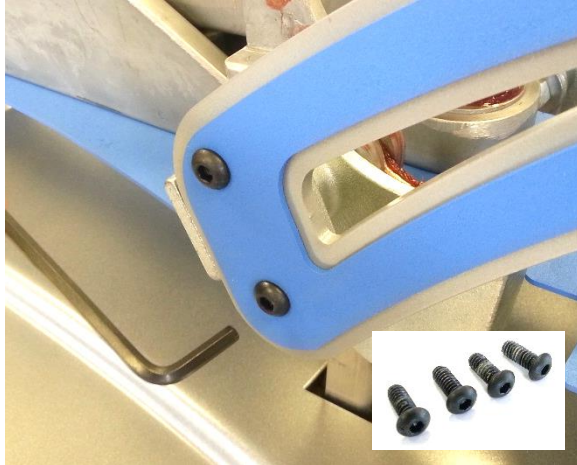


Attach pressure link on each side as shown:

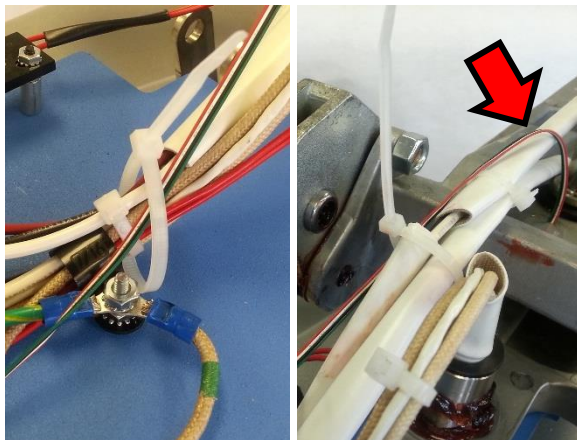
1. Bearing housings onto link bearing
2. Shoulder Screw
3. 3 washers per side
4. Locknuts

Tighten completely using 3/16" Allen Wrench and 1/2" Combination Wrench

NOTE: After tightening, shoulder bolt should spin with only moderate resistance; if not, loosen and line washers up properly, then re-tighten



Attach handles by screwing in 4x 1/4"-20 x 5/8" bolts using 5/32" Allen Wrench



Install 2 Zip Ties to secure Strain Gauge cable, being sure to leave slack in cable as shown to allow for motion of adjustment casting



Install ground wire and TRIAC flat side down using provided #6-32 x 1/2" screws

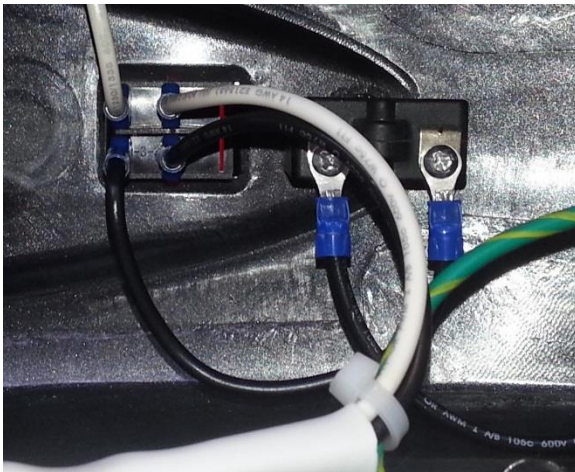
NOTE: orient TRIAC to direct wires around adjustment spindle and towards front of press as shown



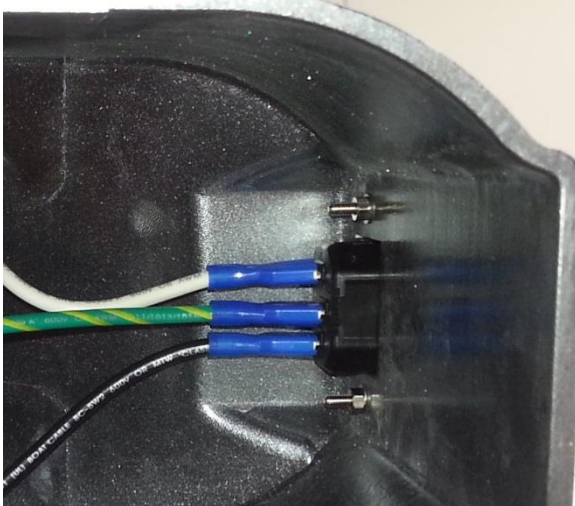
Plug connectors into Controller as shown:

1. 9-pin connector
2. 3-pin TRIAC connector
3. 4-pin Strain Gauge connector
4. 10-pin I/O connector

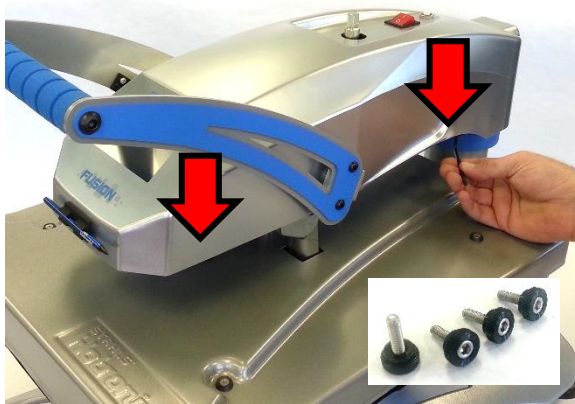
NOTE: For Version 2 and prior models,
connect 25-pin D-sub adapter.



Plug in White & Black wires into ON/OFF
switch on opposite sides of the divider as
shown to connect to Controller



Plug Green wire with Yellow band into IEC
outlet to connect to grounding circuit



Replace housing onto press and insert 4 #8-32 x 1/2" Thumb Screws (right 2 shown), tightening with 9/32" Allen Wrench



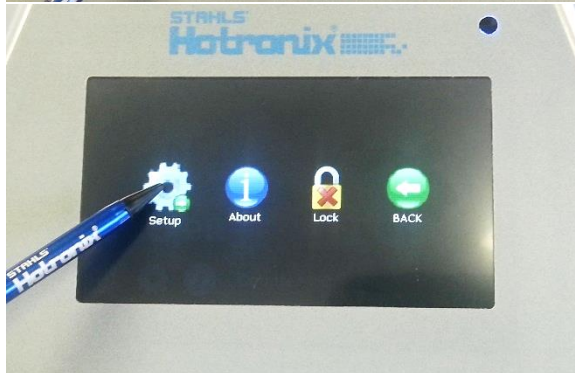
Replace Pressure Adjustment Knob, aligning set screw with flat of shaft and tightening with 3/32" Allen Wrench



Raise handle into open position, plug in press and turn ON to verify proper operation



Press "GEAR" icon



Press "SET UP"



Type in password: JAGUAR2 (JAGUAR on older models) and press "ENTER"

NOTE: do not use this password for anything besides this temperature calibration or warranty is void



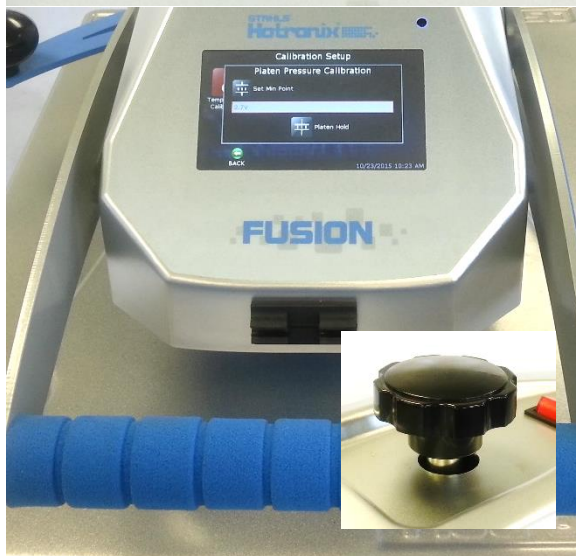
Press "CALIBRATION"



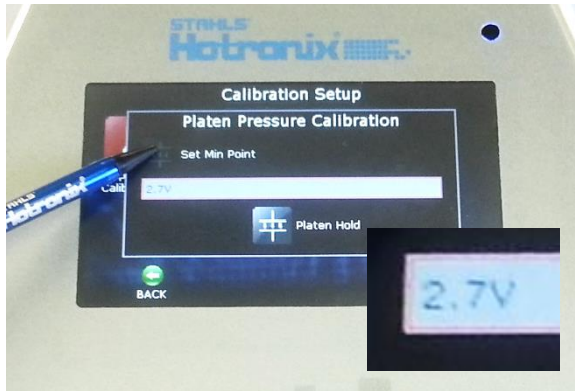
Press "PLATEN PRESSURE CALIBRATION"



Press "CALIBRATE" and wait for the Controller to dial into 2.5V and display the "SET MIN POINT" button at left



Open press and adjust the Pressure Adjustment Knob until the voltage reads 2.7V when locked down



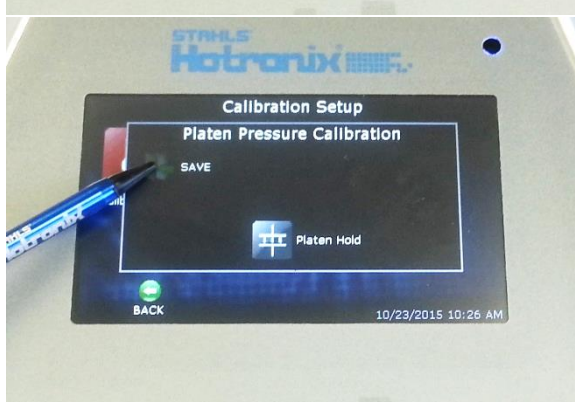
While press is locked down at 2.7V, press
"SET MIN POINT"



Open press and adjust the Pressure
Adjustment Knob until the voltage reads
either 3.1V or 3.2V when locked down



While press is locked down at 3.1V or 3.2V,
press "SET MAX POINT"



Press "SAVE" to save calibration, then
"BACK" repeatedly to return to main
operation screen