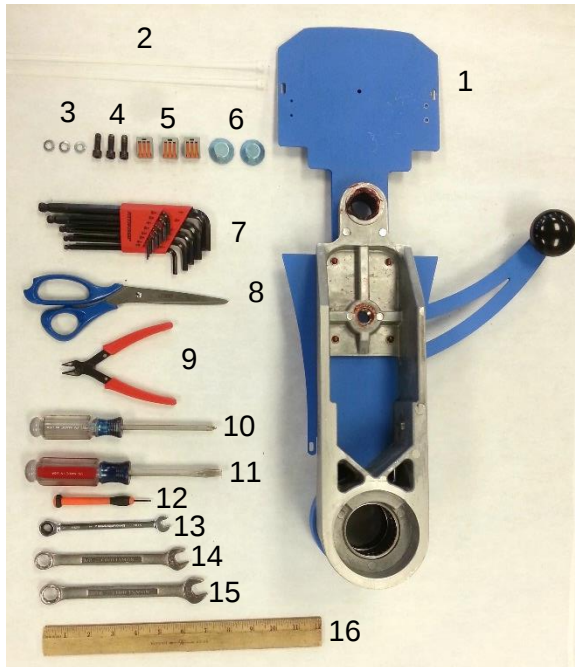


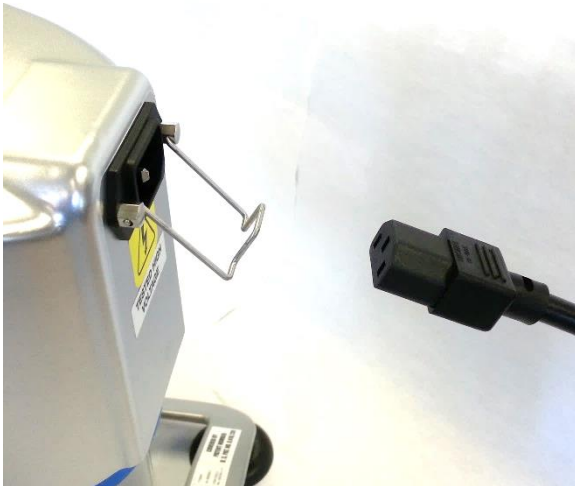


Included Parts:

1. Upper Casting
2. Zip Ties (x2)
3. 1/4" Lock-Washers
4. 1/4"-28 x 3/4" Bolts
5. Lever Nuts
6. Hub Caps (x2)

Required Tools:

7. Allen Wrenches
(3/32", 9/64", 5/32", 3/16")
8. Scissors
9. Wire Cutters
10. #2 Phillips Screwdriver
11. Flathead Screwdriver
12. 2mm Precision Flathead Screwdriver
13. 5/16" Combination Wrench
14. 1/2" Combination Wrench
15. 9/16" Combination Wrench
16. Ruler
17. Permanent Marker



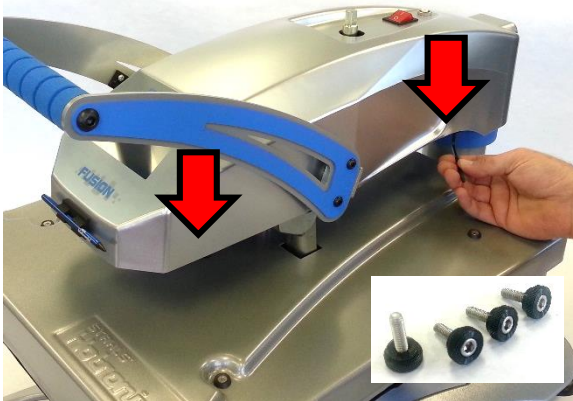
CAUTION: Detach power cord before proceeding



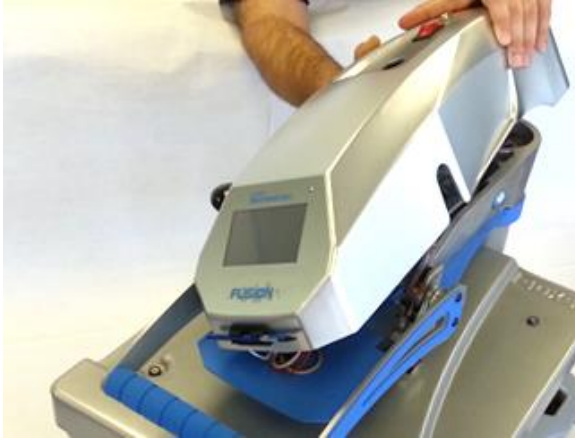
Lower heater but do not lock into place, such that it rests gently on lower platen



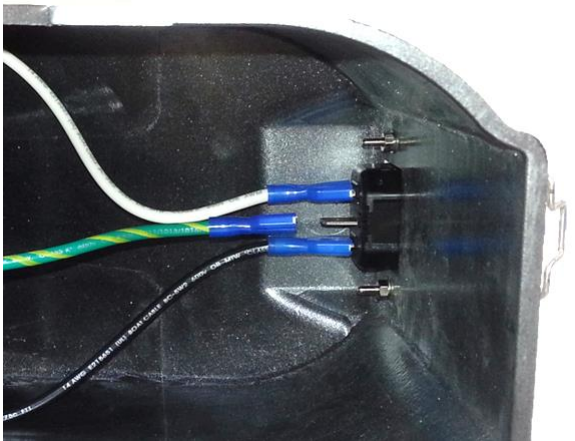
Loosen set screw in shaft of pressure adjustment knob using 3/32" Allen Wrench and remove knob



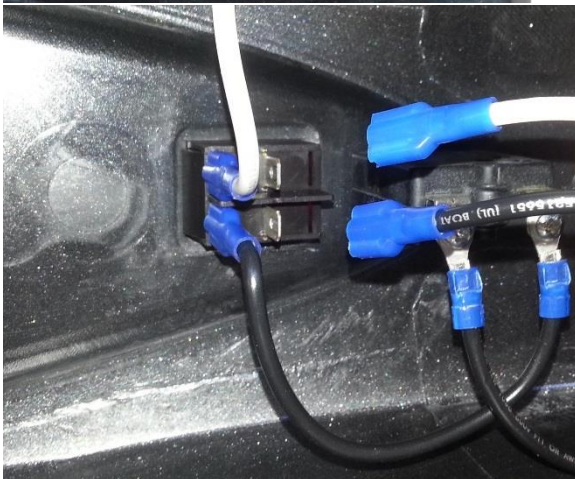
Remove 4 #8-32 x 1/2" Thumb Screws (right 2 shown) from underside of control housing using 9/32" Allen Wrench



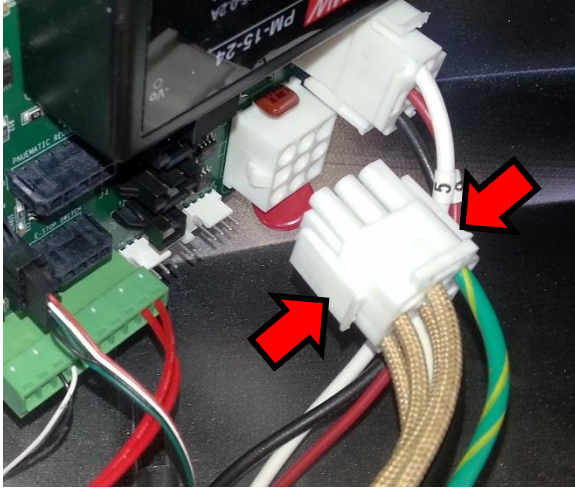
Lift off control housing and lay it gently on left side of press



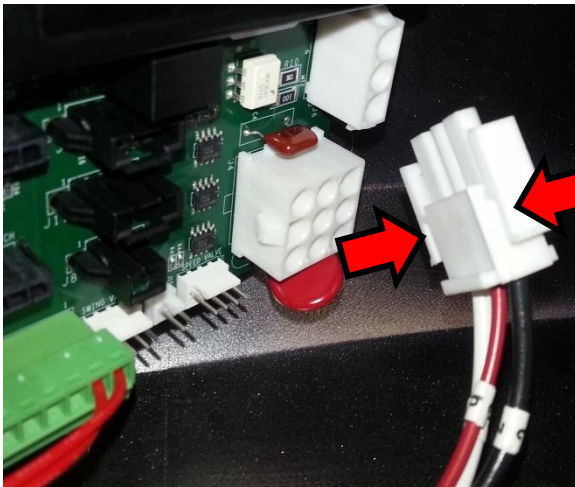
Unplug ground wire (green with yellow stripe) from IEC inlet at rear of housing



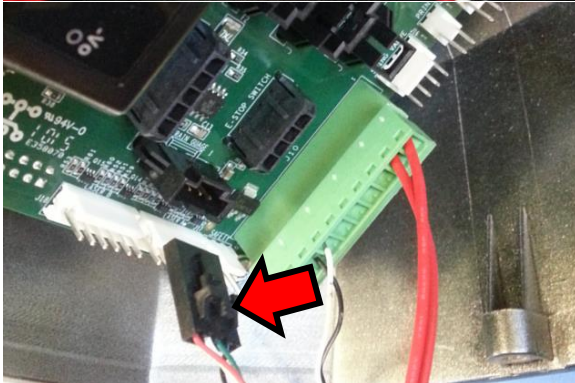
Unplug Black & White wires from Power Switch as shown to disconnect from Controller



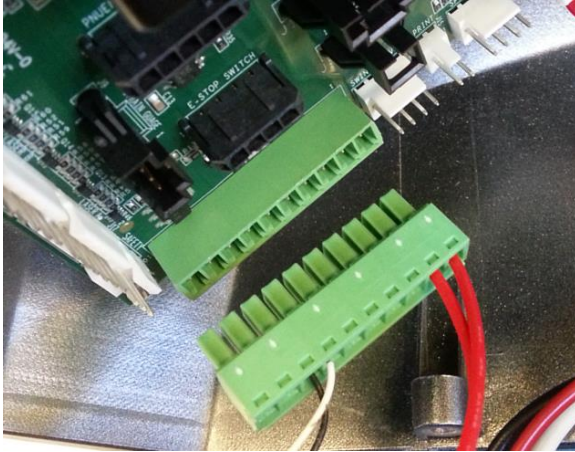
Unplug 9-pin connector from Controller by squeezing sides to release locking clips



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

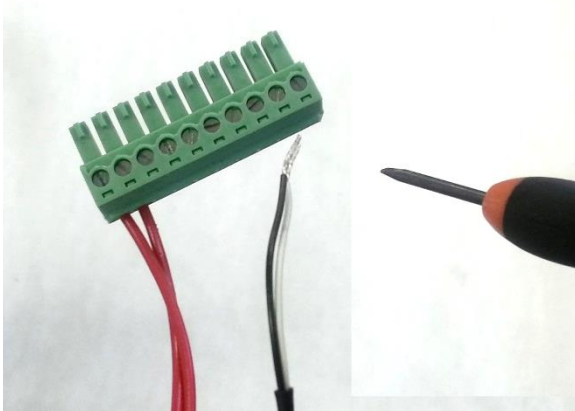


Unplug 4-pin Strain Gauge connector from Controller by depressing locking clip



Unplug 10-pin I/O connector from Controller

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



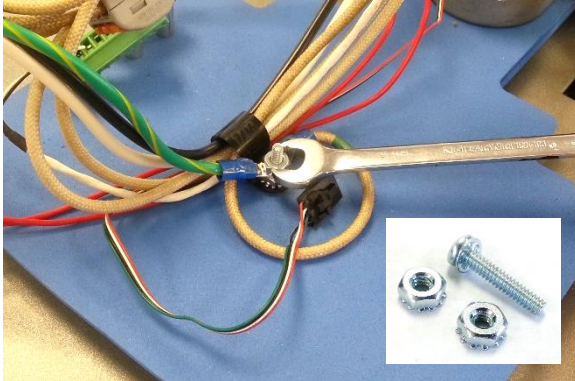
Remove old Temperature Probe wires from 10-pin I/O connector positions 7 & 8 using 2mm Precision Flathead Screwdriver

NOTE: Wire colors are interchangeable as polarity does not matter

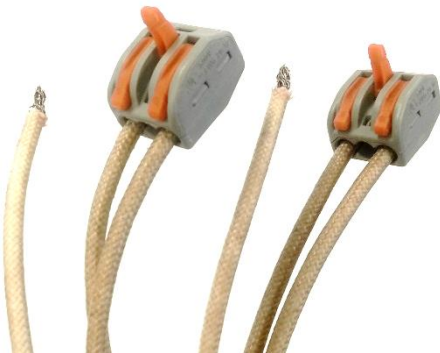
NOTE: older models use a 25-pin D-Sub connector, pins 1 & 14



Remove control housing and set aside

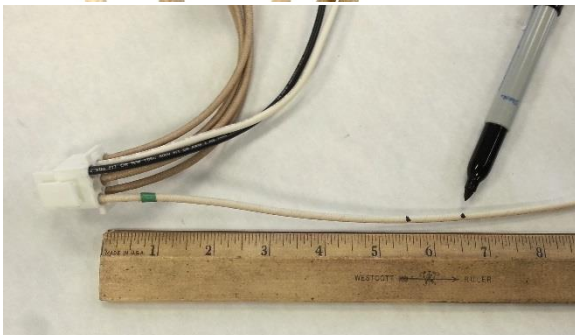


Remove #6-32 x 1" screw and 2x #6-32 Nuts using 5/16" Combination Wrench and remove black plastic Cable Clamp from Upper Casting



Remove 2 braided cloth Heater Wires from Lever Nuts

NOTE: If your press does not use Lever Nuts, see next 2 steps



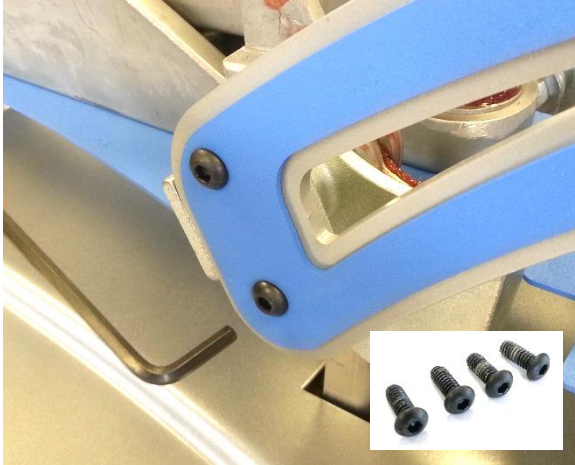
NOTE: If your press already uses Lever Nuts, this step can be skipped

Locate ground wire by identifying green band on braided cloth Heater Wire or green wire with yellow stripe, and mark with Permanent Marker 5-1/2" and 6-1/2" from 9-pin Connector



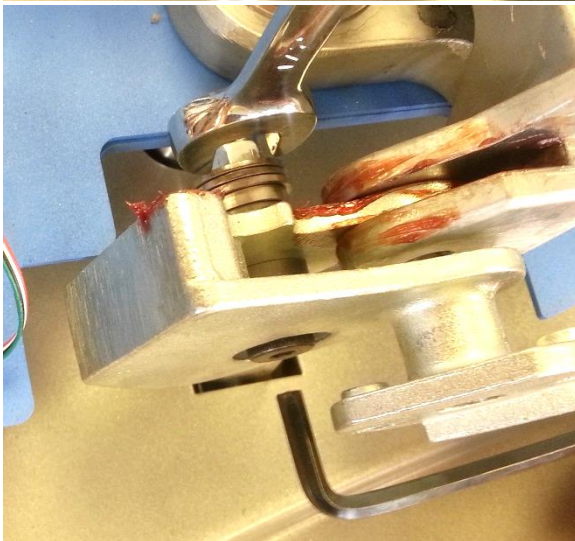
NOTE: If your press already uses Lever Nuts, this step can be skipped

Cut 3 braided cloth Heater Wires, including ground wire, 6" from 9-pin Connector using Wire Cutters, such that your marked ground wire can be identified on both loose wire ends.

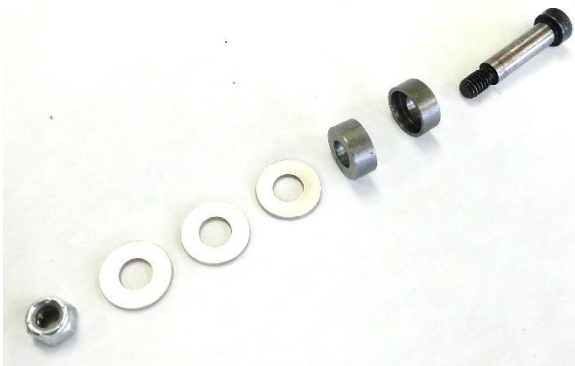


Remove handles by unscrewing
4x 1/4"-20 x 5/8" bolts from handles using
5/32" Allen Wrench

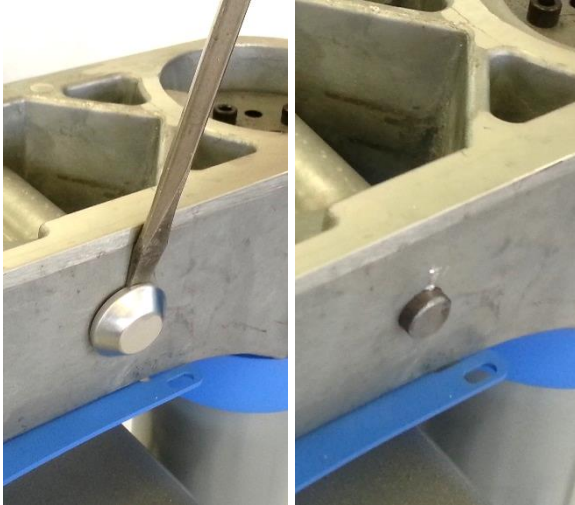
NOTE: Avoid dropping handles to prevent
damage to painted surfaces below



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



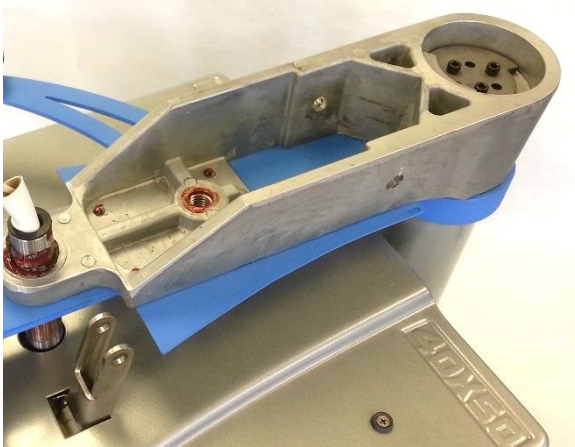
Group Shoulder Bolt hardware together to
avoid re-assembly issues, noting order



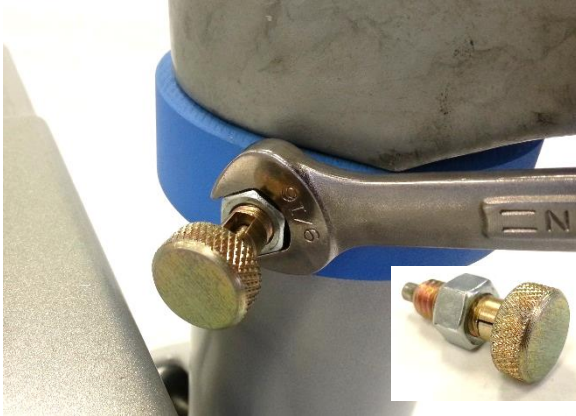
Remove one Hub Cap by prying with Flathead Screwdriver



Remove rear pin and unthread Pressure Adjustment Spindle completely



Remove Adjustment Casting with wiring and set aside



Unthread Hand-Retractable Plunger from blue collar using 9/16" Combination Wrench and set aside



Unscrew three 1/4"-28 x 3/4" Screws and 1/4" Lock Washers (if present) from Stop Plate using 3/16" Allen Wrench



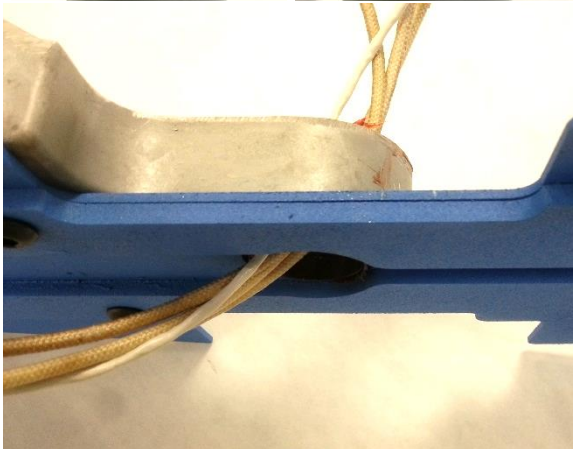
Remove Stop Plate and set aside



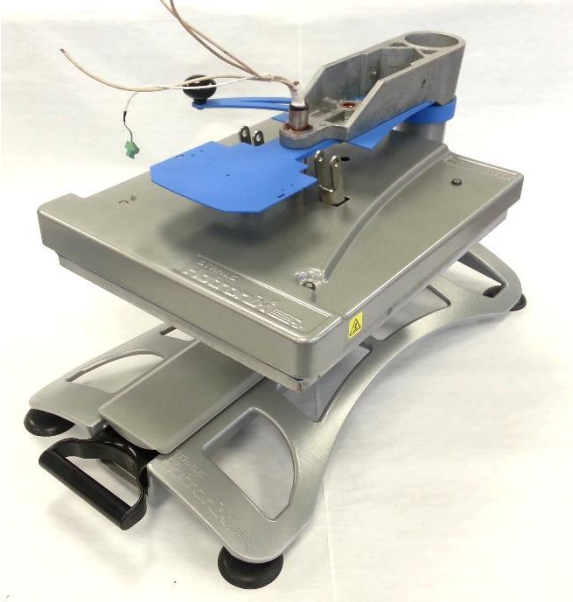
Lift old Upper Casting off of Main Spindle and Guide Tube and discard



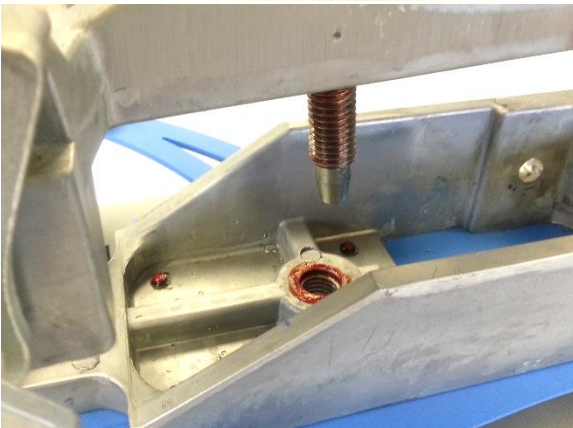
Check that all spacers (inner bearing races) are still present on Main Spindle as shown, otherwise retrieve from inside old Upper Casting



Thread Heater and Probe Wires through new Upper Casting guide tube hole



Install new Upper Casting onto Main Spindle and Heater Guide Tube



Install Adjustment Casting into new Upper Casting and thread in Adjustment Spindle



Re-insert existing rear pin

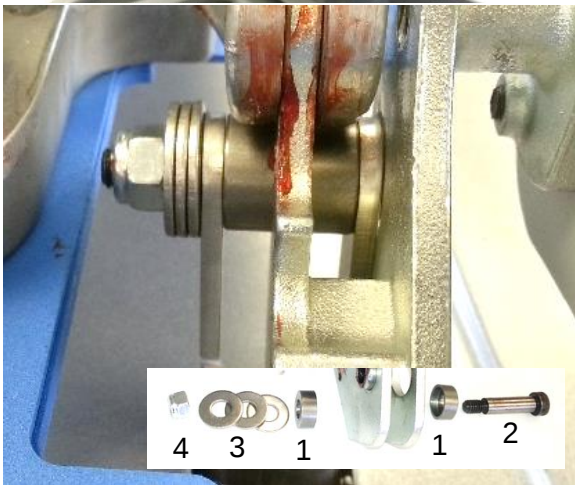


Attach provided Hub Cap to rear pin and squeeze to secure

NOTE: A clamp or vise may make this easier



Align Heater with Lower Platen

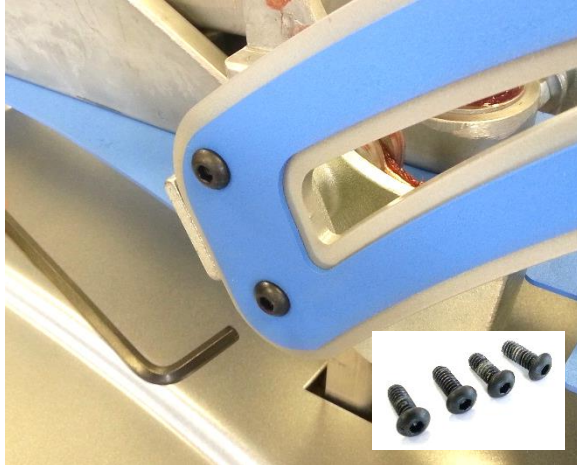


Attach pressure link on each side as shown:

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

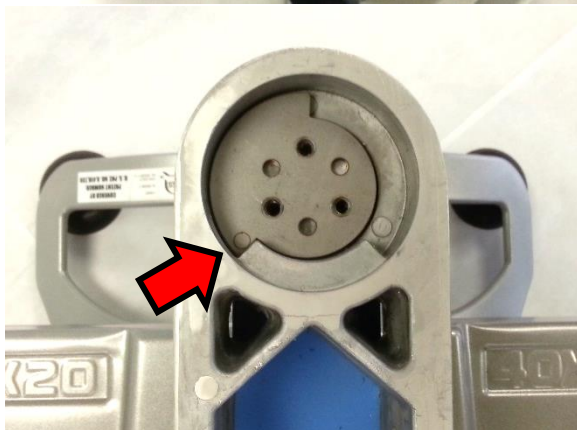
NOTE: After tightening, shoulder bolt should spin with only moderate resistance; if not, loosen and line washers up properly, then re-tighten



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



Thread Hand-Retractable Plunger into blue
collar using 9/16" Combination Wrench and
lock into place



Position Stop Plate on top of Main Spindle,
ensuring engraved circle is on top side, as
shown.

NOTE: newer models use engraved letters
"TOP" to indicate top side of Stop Plate



Install Stop Plate as shown and screw down with 3x 1/4"-28 x 3/4" Screws and 1/4" Lock Washers using 3/16" Allen Wrench



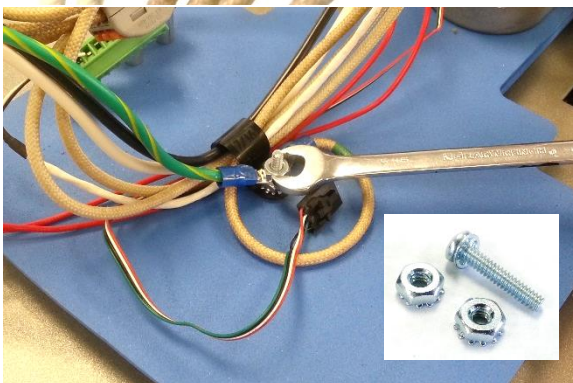
Re-connect 2 braided cloth Heater Wires from Heater to 9-Pin Connector using Lever Nuts

NOTE: If your press did not previously use Lever Nuts, see next step

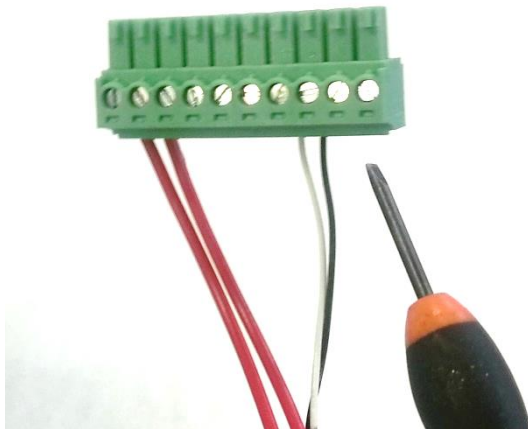


Match up ground wires from 9-Pin Connector and Heater and connect with provided Lever Nuts

NOTE: If your press previously used 2 lever nuts, the ground wires do not use Lever Nuts but instead bolt to the Upper Casting as in the next step



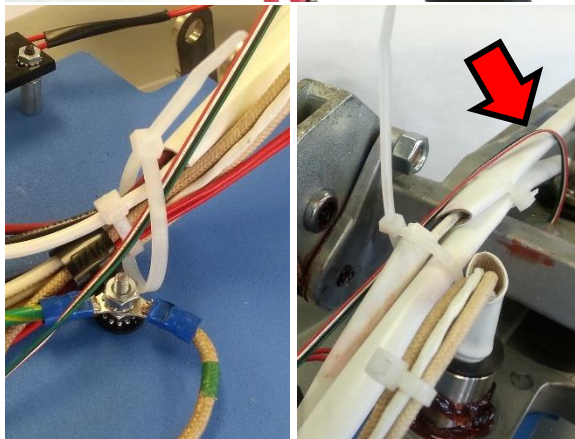
Install black plastic Cable Clamp onto new Upper Casting as shown by tightening #6-32 x 1" screw and 2x #6-32 Nuts using 5/16" Combination Wrench



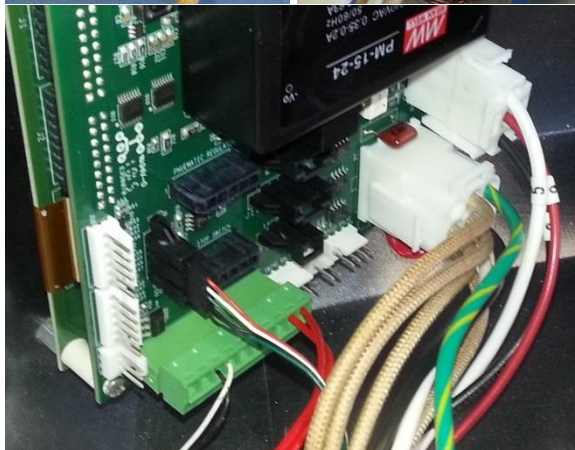
Install new Temperature Probe wires into 10-pin I/O connector positions 7 & 8 as shown using 2mm Precision Flathead Screwdriver

NOTE: Wire colors are interchangeable as polarity does not matter

NOTE: older models use a 25-pin D-Sub connector, pins 1 & 14



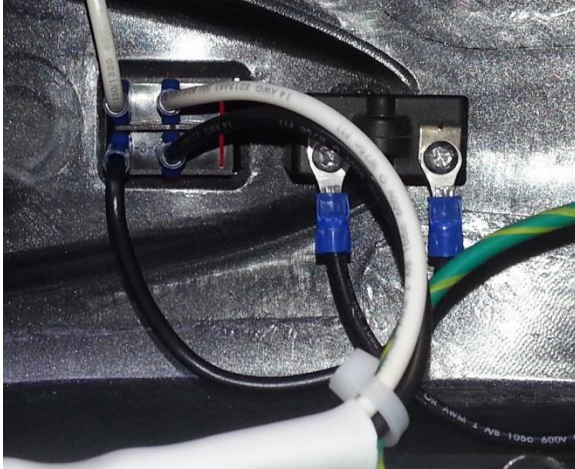
Install 2 Zip Ties to secure cables, being sure to leave slack in Strain Gauge cable as shown to allow for motion of adjustment casting



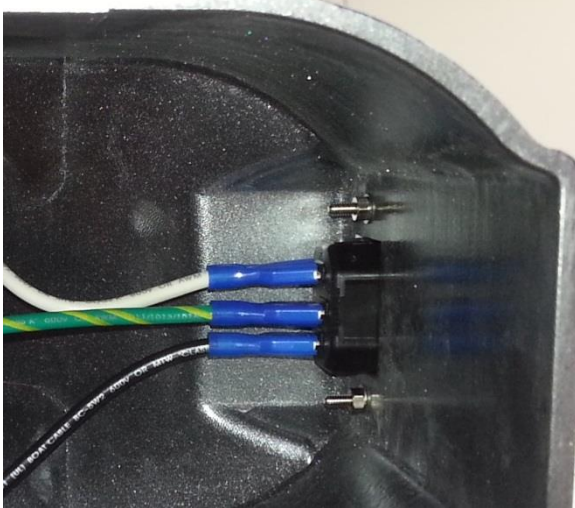
Plug connectors into Controller as shown:

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

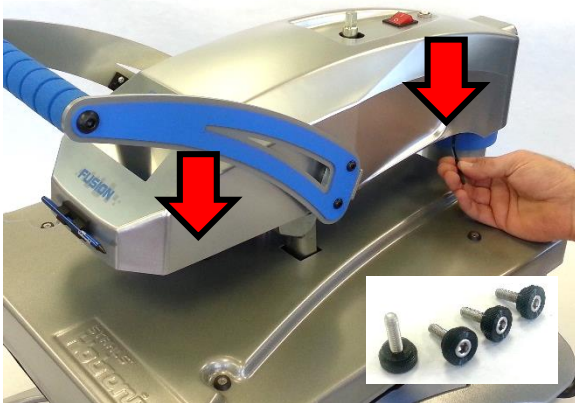
NOTE: For Version 2 and prior models, connect 25-pin D-sub adapter.



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