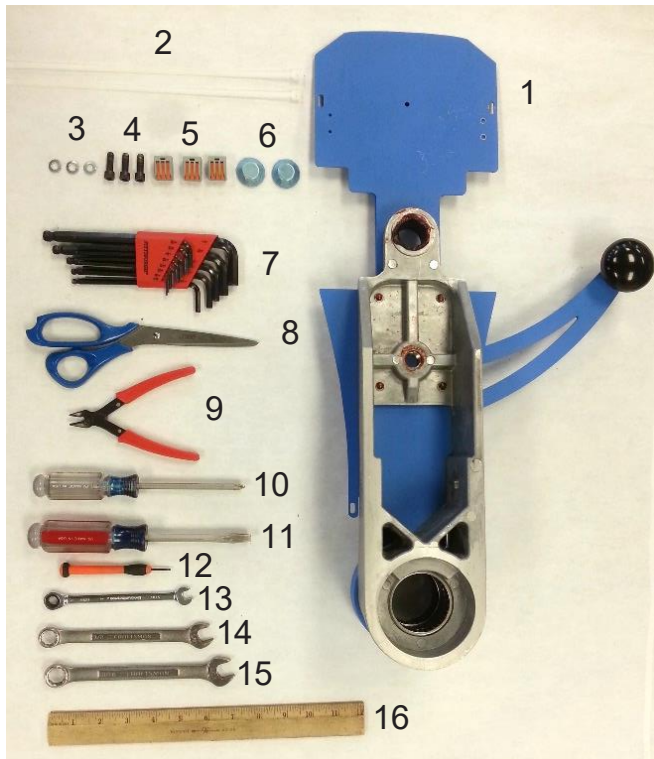




Included Parts:

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:

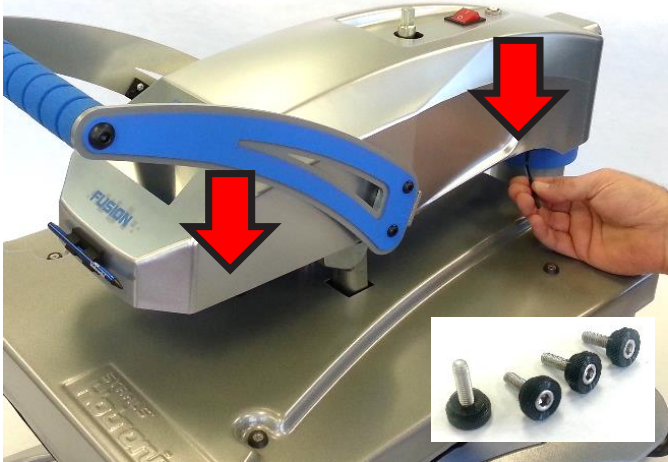
7. Allen Wrenches
(1/8" , 9/64" , 5/32" , 3/16")
8. Scissors
9. Wire Cutters
10. #2 Phillips Screwdriver
11. Flathead Screwdriver
12. 2mm Precision Flathead Screwdriver
13. 5/16" Combination Wrench
14. 1/2" Combination Wrench
15. 3/4" Combination Wrench
16. Ruler
17. Permanent Marker



CAUTION: Detach power cord before proceeding



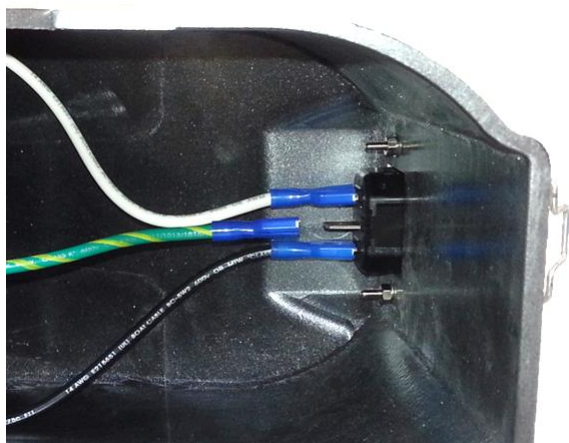
Using a 1/8" Allen wrench
Loosen set screw in shaft of pressure
adjustment knob and remove knob



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



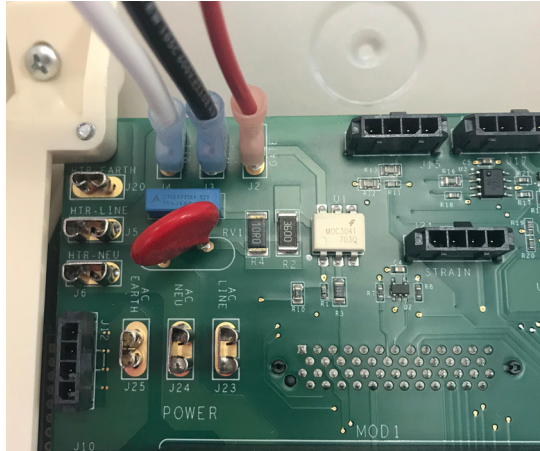
Unplug ground wire (green with yellow stripe) from IEC inlet at rear of housing



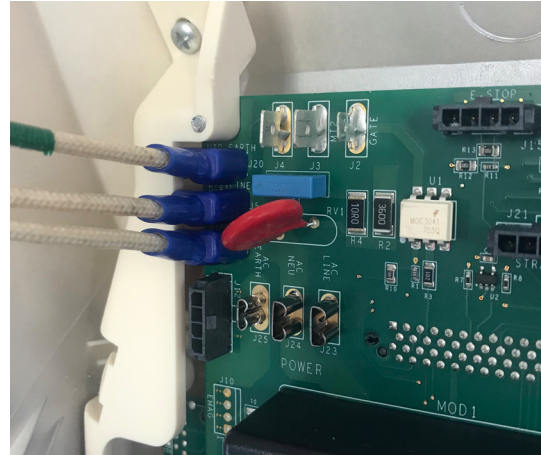
Unplug Black & White wires from Power Switch as shown to disconnect from Controller

Disconnect the Wires from the power board and remove the housing.

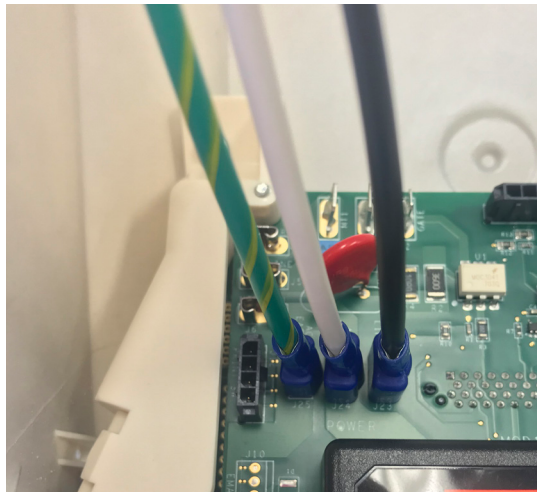
Unplug 3 Triac Wires Red, Black, & White Wires From the Controller.



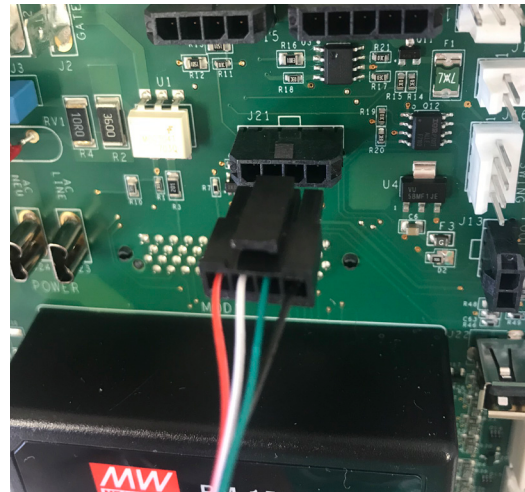
Unplug the 3 Braided Cloth Heater Wires from the controller.



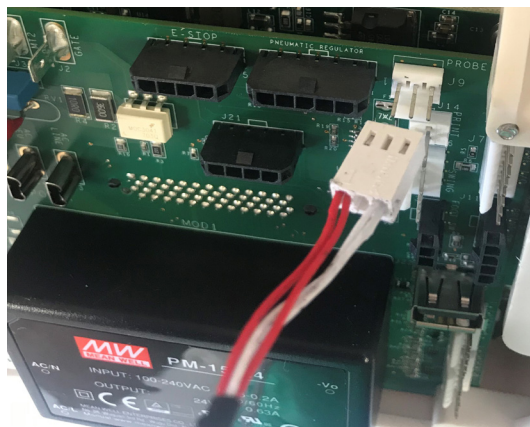
Unplug the ground wire and the 2 wires from the On/Off Switch from the controller.



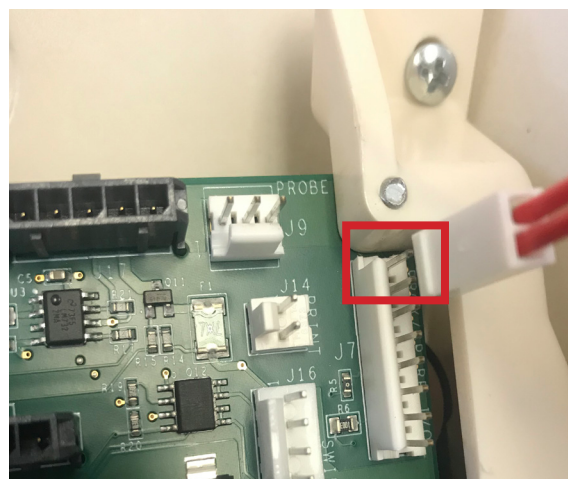
Unplug the 4-pin Strain Gauge Connector from the Controller depressing locking clip.



Unplug the 3-pin Temperature Probe Connector from the Controller depressing locking clip.

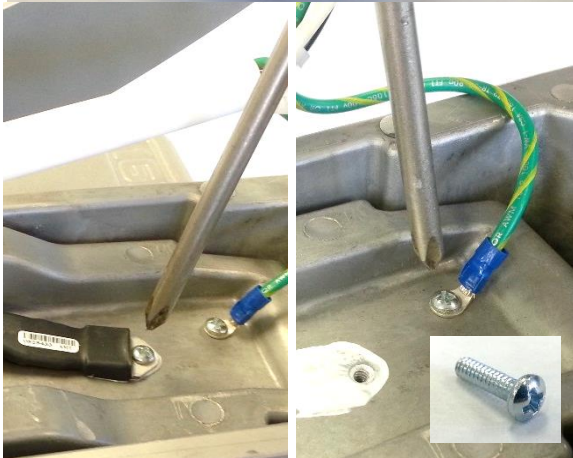


Unplug the 2-pin Proximity Sensor Connector from the Controller depressing locking clip.

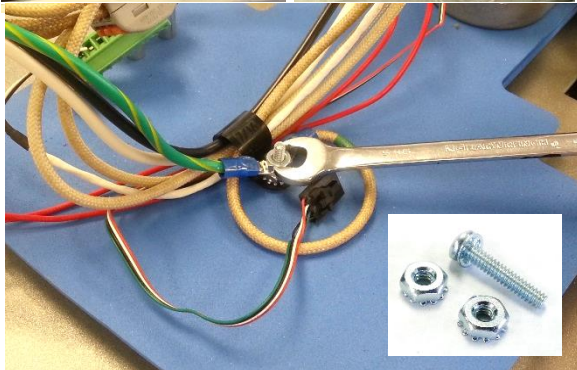




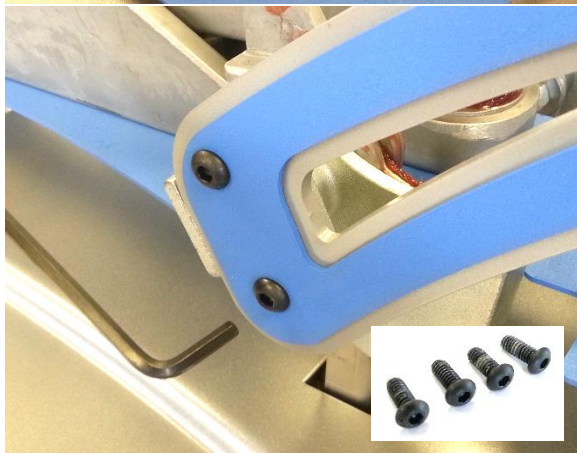
Remove control housing and set aside



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

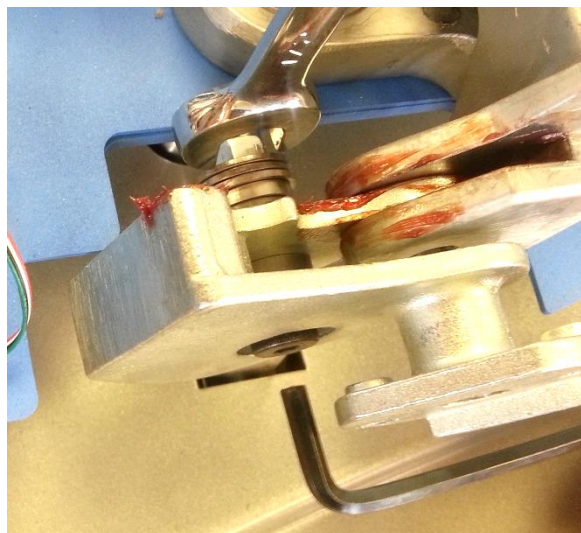


Loosen #6-32 x 1" screw using 5/16" Combination Wrench and remove cut Strain Gauge wires from sheathe and clamp, then re-tighten screw

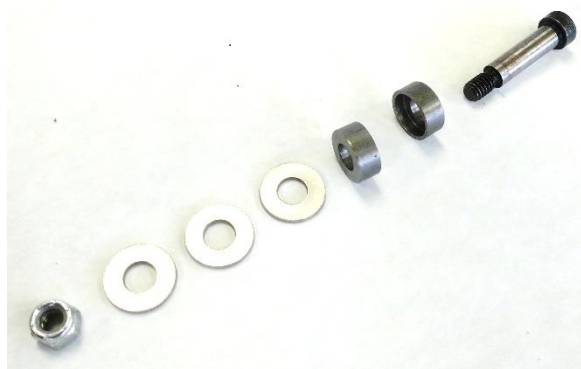


Remove handles by unscrewing 4x 1/4"-20 x 5/8" bolts from handles using 5/32" Allen Wrench

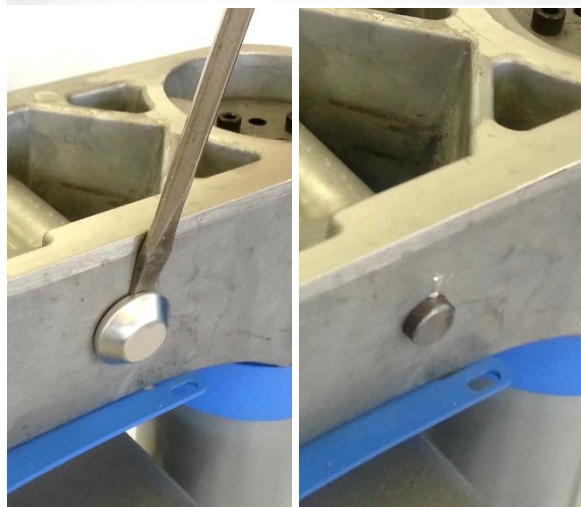
NOTE: Avoid dropping handles to prevent damage to painted surfaces below



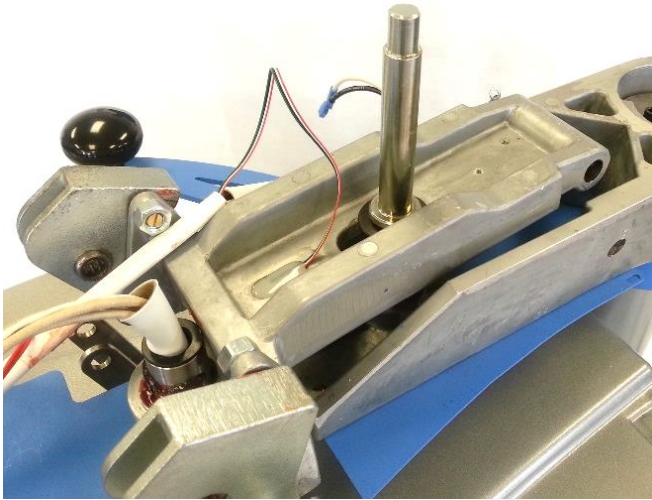
Remove shoulder bolts using 3/16" Allen Wrench and 1/2" Combination Wrench



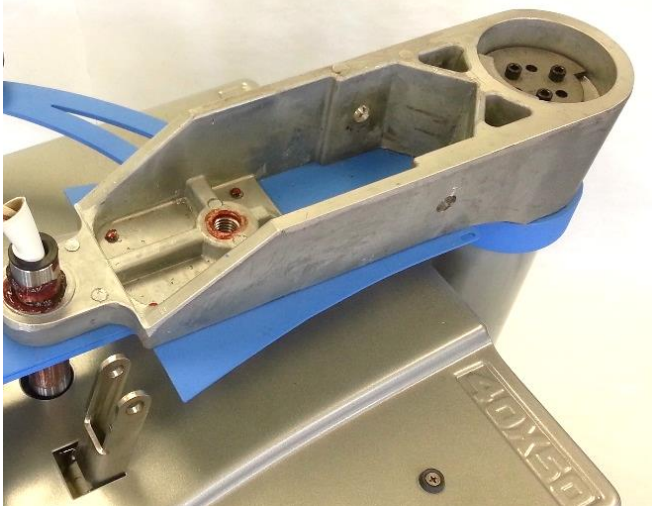
Group Shoulder Bolt hardware together to avoid re-assembly issues, noting order



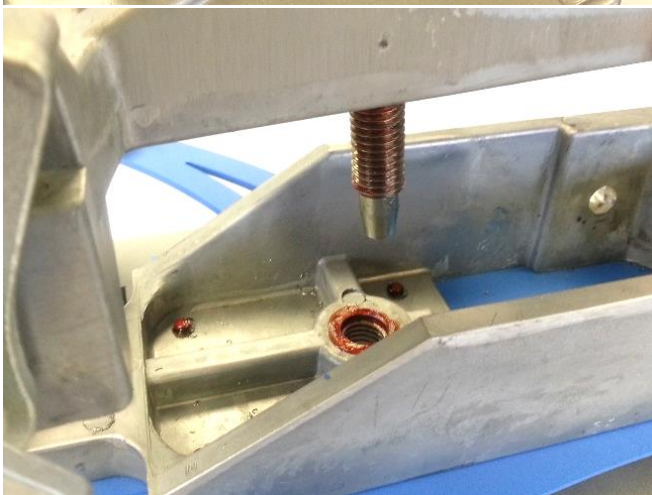
Remove one Hub Cap by prying with Flathead Screwdriver



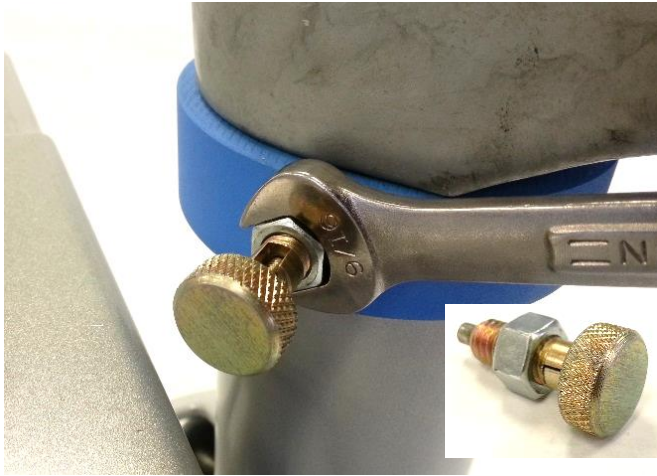
Remove rear pin and unthread Pressure Adjustment Spindle completely



Remove old Adjustment Casting and discard



Place replacement Adjustment Casting into press and thread in Adjustment Spindle



Unthread Hand-Retractable Plunger from blue collar using 3/4" 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



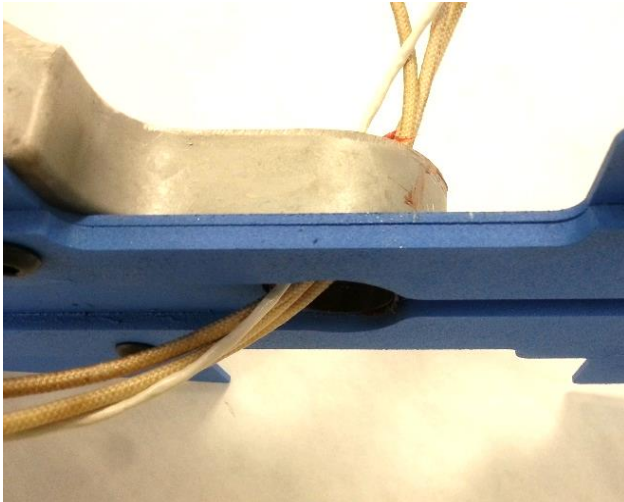
Remove Stop Plate and set aside



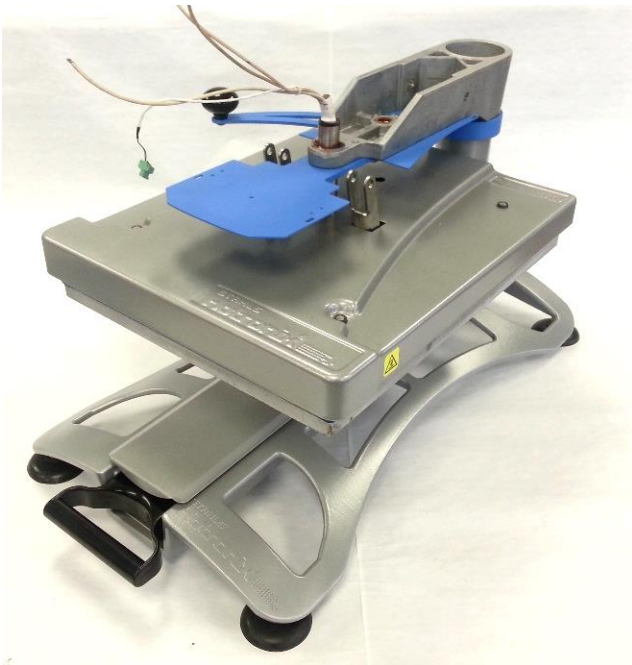
Lift old Upper Casting off of Main Spindle and Guide Tube and discard



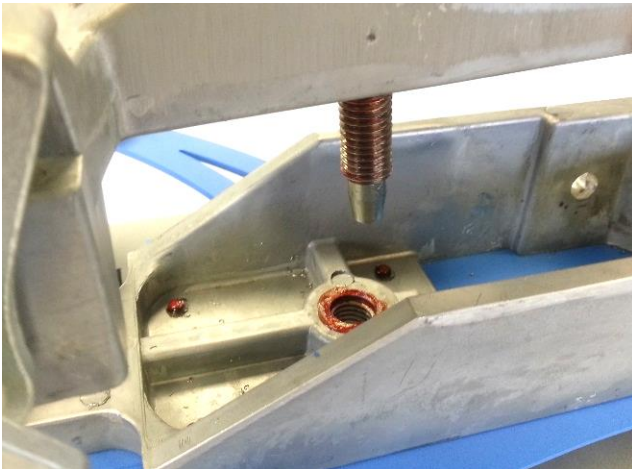
Check that all spacers (inner bearing races) are still present on Main Spindle as shown, otherwise retrieve from inside old Upper Casting



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

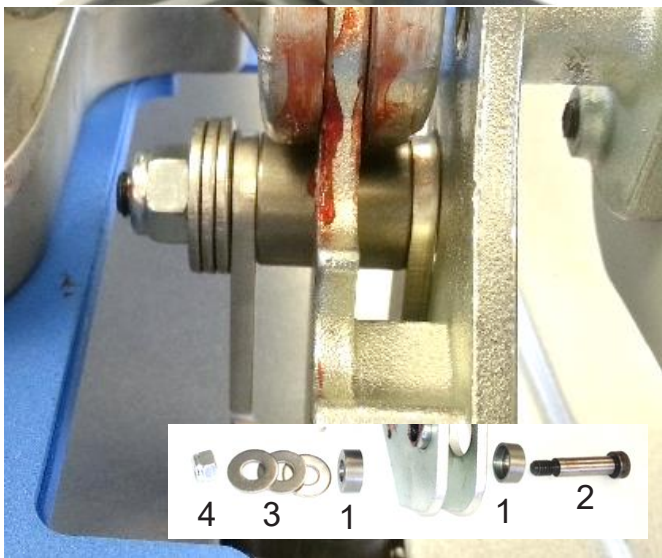


Attach provided Hub Cap to rear pin and squeeze to secure

NOTE: A clamp or vise may make this easier



Align Heater with Lower Platen

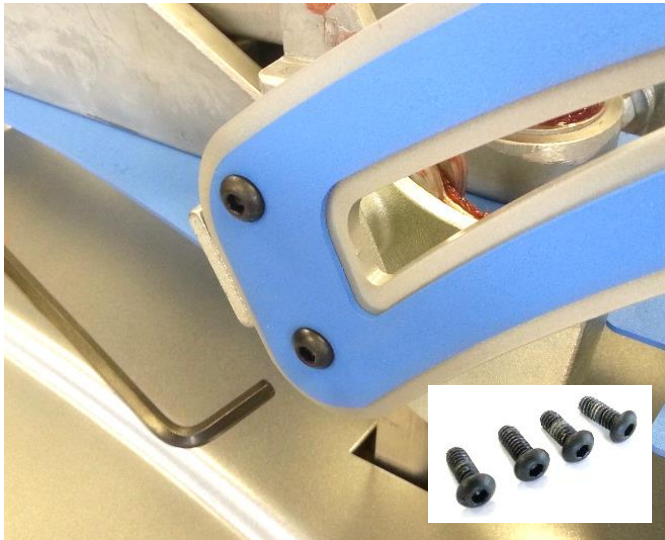


Attach pressure link on each side as shown:

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

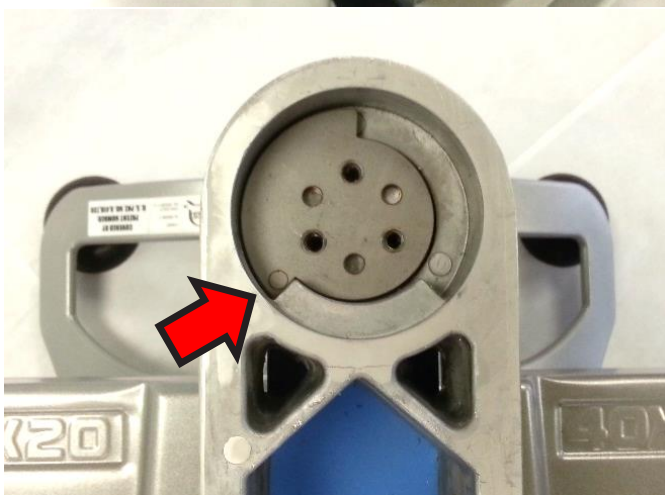
NOTE: After tightening, shoulder bolt should spin with only moderate resistance; if not, loosen and line washers up properly, then re-tighten



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 3/4" Combination Wrench and
lock into place

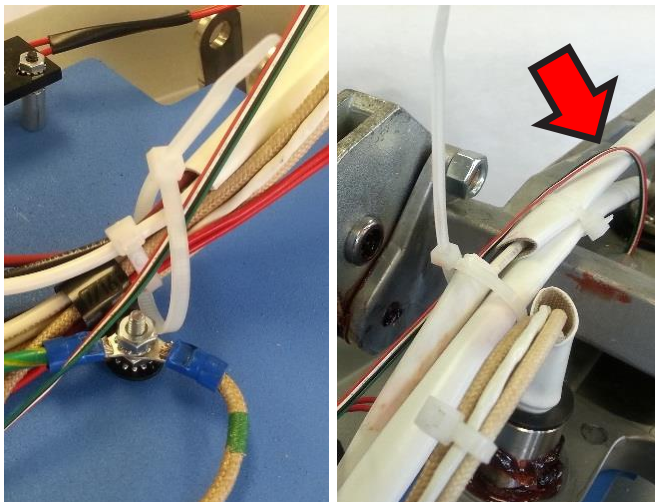


Position Stop Plate on top of Main Spindle,
ensuring engraved circle is on top side, as
shown.

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



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

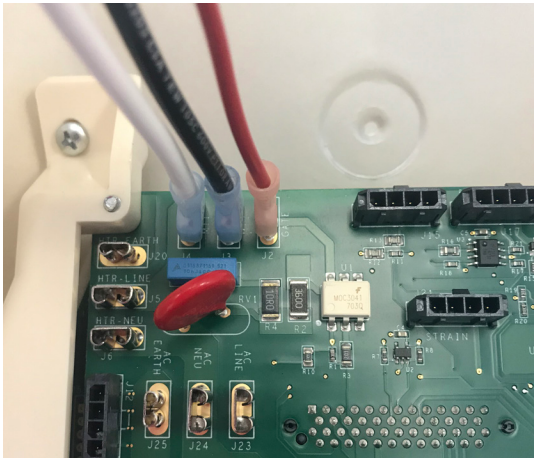


Install ground wire and TRIAC flat side down using provided #6-32 x 1/2" screws

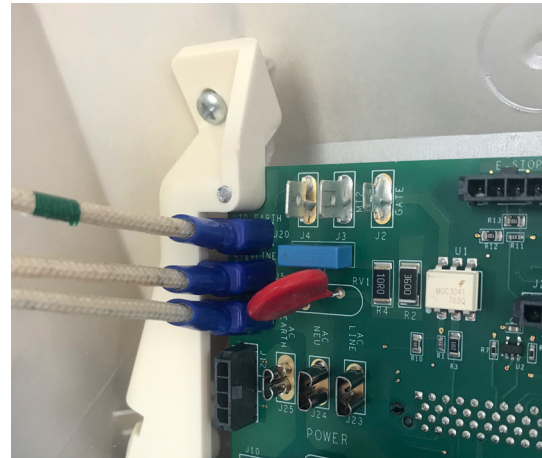
NOTE: orient TRIAC to direct wires around adjustment spindle and towards front of press as shown

Reconnect the Wires to the power board.

3 Triac Wires Red, Black, & White
Wires From the Controller.



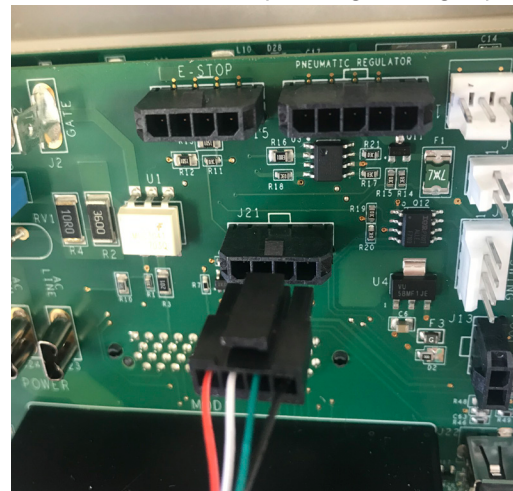
3 Braided Cloth Heater Wires
from the controller.



the ground wire and the 2 wires
from the On/Off Switch from the controller.



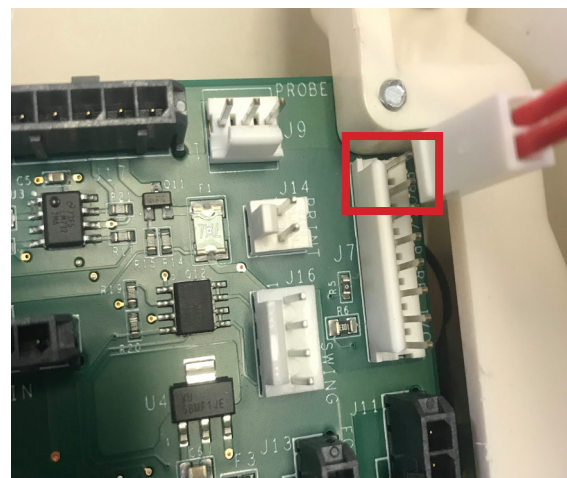
4-pin Strain Gauge Connector
from the Controller depressing locking clip.

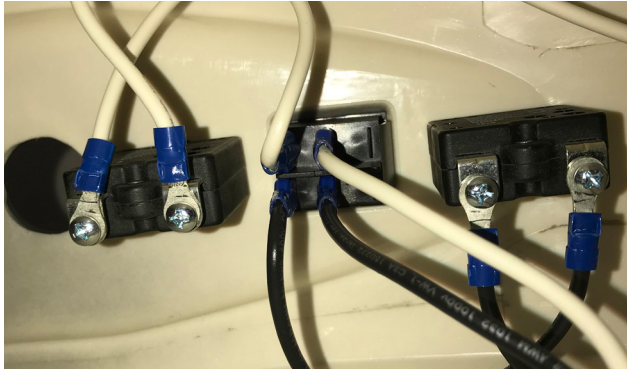


the 3-pin Temperature Probe Connector
from the Controller depressing locking clip.

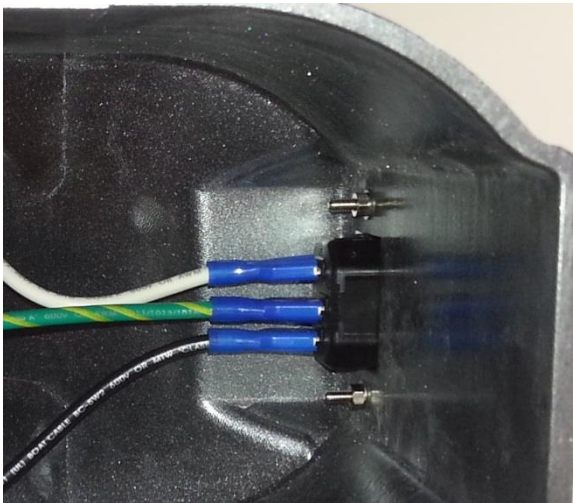


the 2-pin Proximity Sensor Connector
from the Controller depressing locking clip.

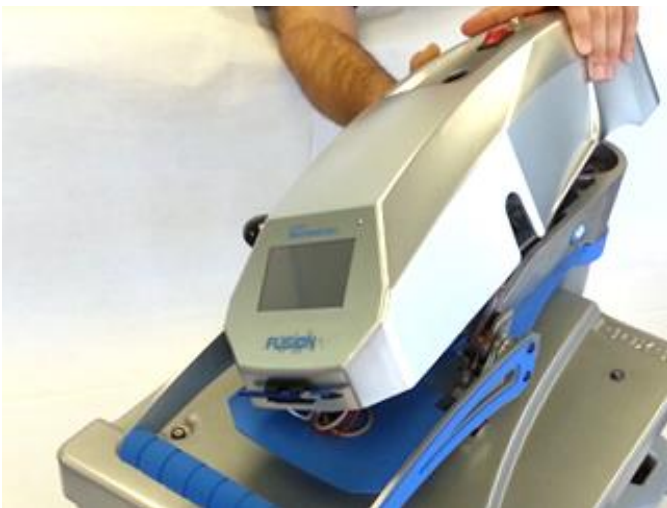




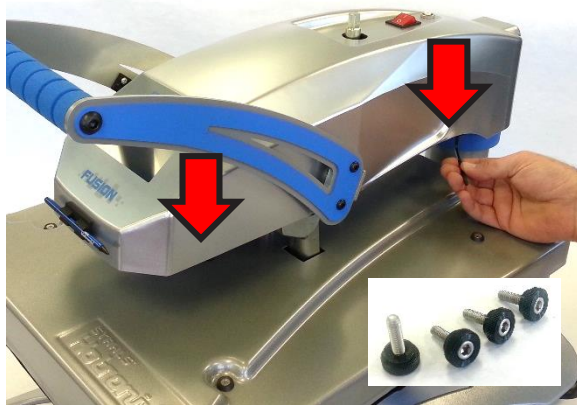
Plug in White & Black wires into ON/OFF switch on opposite sides of the divider as shown to connect to Controller



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



Replace the control housing over the top of the casting.



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 1/8" Allen Wrench



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

To Calibrate the Pressure

As Manger select the gear icon and choose calibration.

1. Choose Platen Pressure Calibration



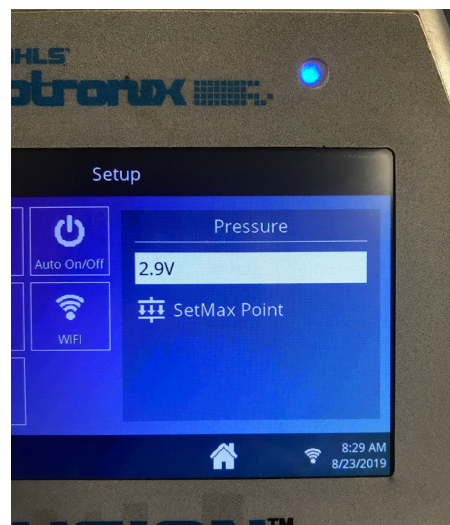
2. Tap the Calibrate Option to begin. Pressure and a box will appear with 2.5v on the display.



3. When you lock your press handle down the v number will change. You will need to manually adjust the pressure and lock the press down until it is set to 2.6v when closed. Then tap set Min Point.



4. After setting the Min Point increase the pressure knob to set the max point you want 2.9v to display when the press is closed. Then tap set Max Point.



The screen will prompt you that calibration is complete. You can return to the main menu and start using your press.