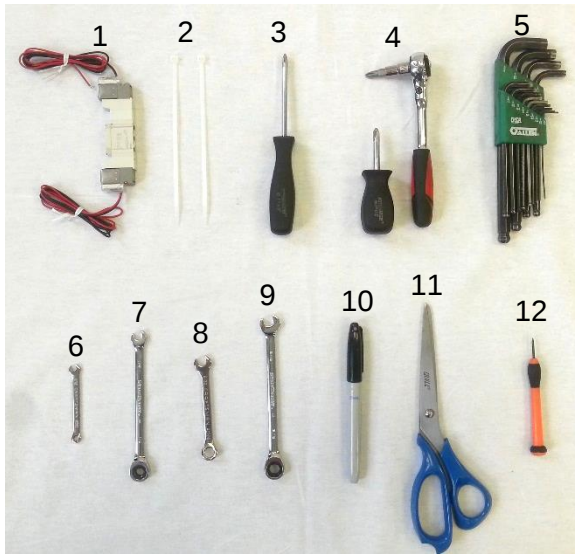


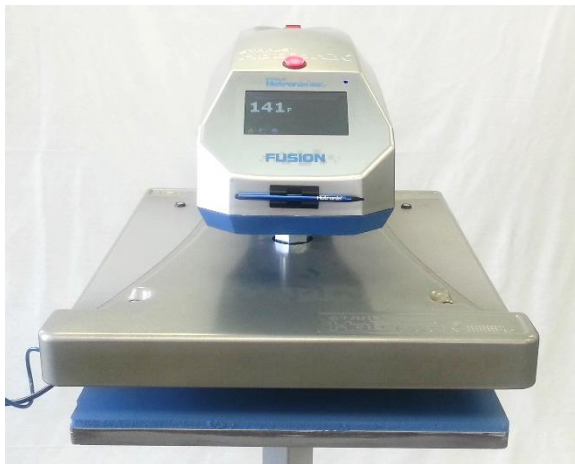


Included Parts:

1. Swing Valve
2. Zip Ties

Required Tools:

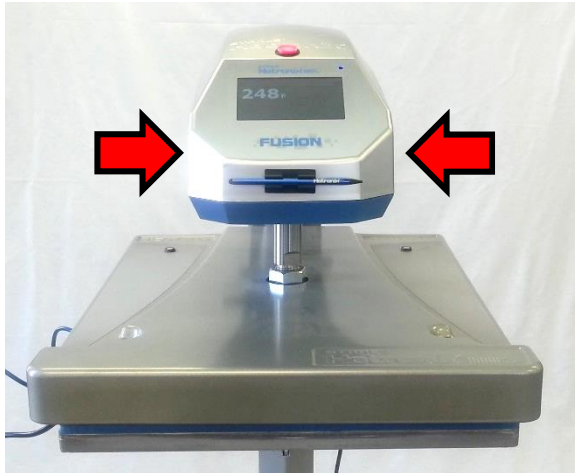
3. #1 Phillips Screwdriver
4. Short #2 Phillips Screwdriver or Ratchet with #2 Phillips Bit
5. Allen Wrench (1/8")
6. 5/32" Combination Wrench or Needle Nose Pliers
7. 1/4" Combination Wrench or Needle Nose Pliers
8. 9/32" Combination Wrench
9. 5/16 Combination Wrench
10. Permanent Marker
11. Scissors
12. 2mm Precision Screwdriver



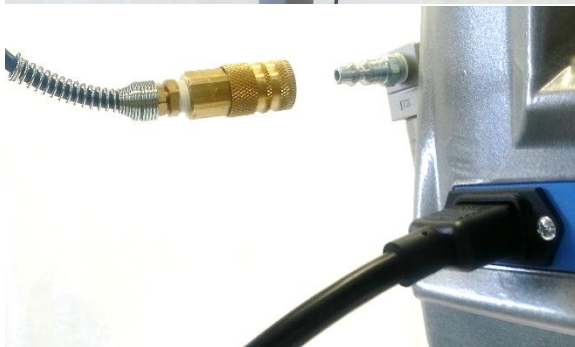
Turn press ON



Set timer for 15 seconds or more



Press Print Switches to lower heater



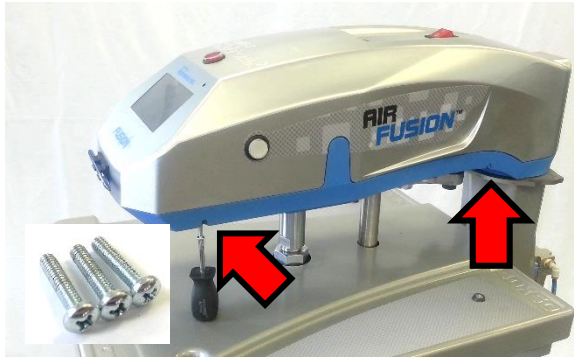
While heater is lowered, disconnect air supply line from air filter



Turn press OFF



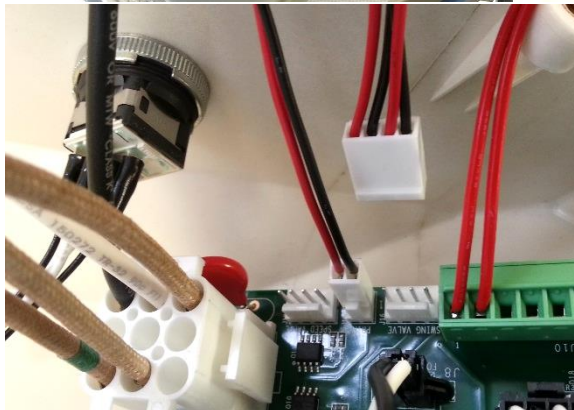
CAUTION: Detach power cord before proceeding



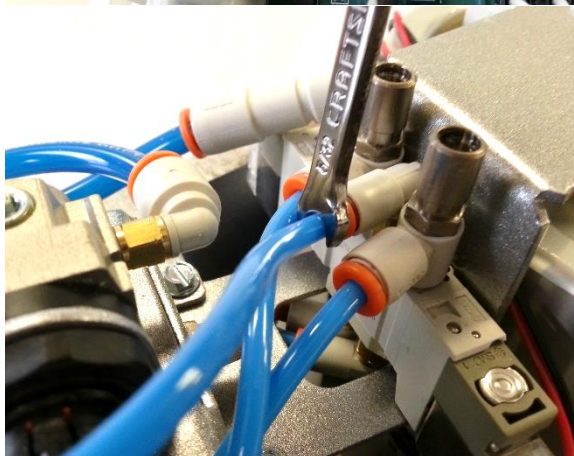
Remove three #8-32 x 3/4" Screws from Control Housing using Short #2 Phillips Screwdriver



Lift off Control Housing and lay it gently on left side of press



Disconnect Swing Valve connector from Controller



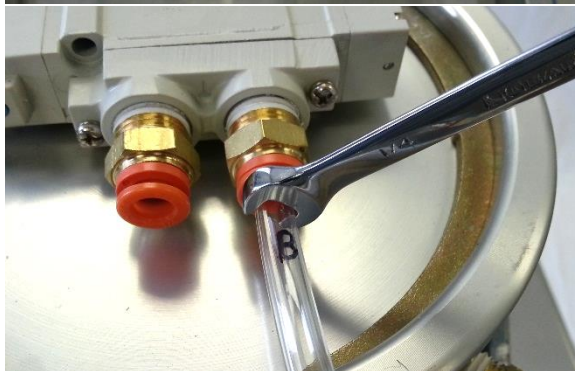
Remove top center air tube from old Swing Valve by pressing down on push-to-connect fitting collar with 5/32" Combination Wrench or Needle-Nose Pliers while pulling out air tube



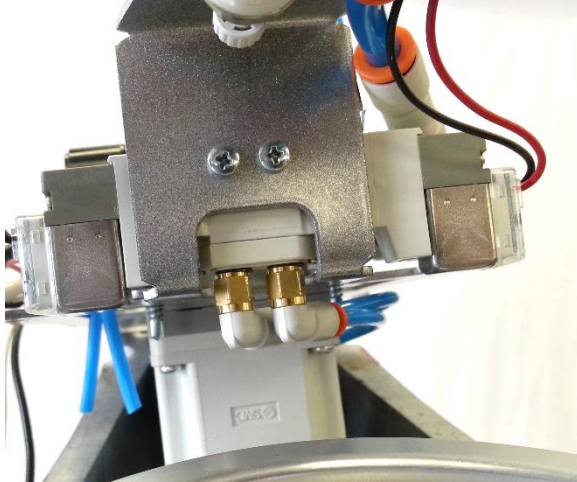
Unscrew 4x 1/4"-20 x 1/2" Low Profile
Socket-Head Cap Screws using 1/8" Allen
Wrench



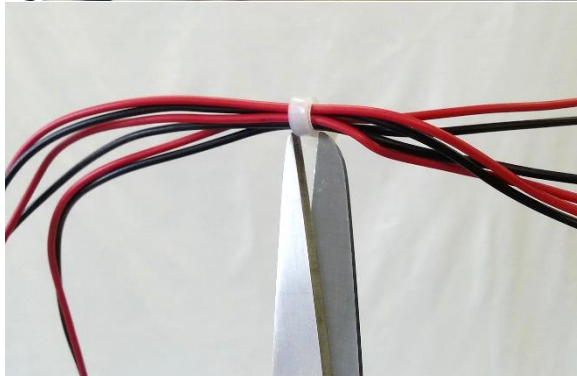
Mark front air tubes on Print Valve "T" and
"B" with Permanent Marker as shown



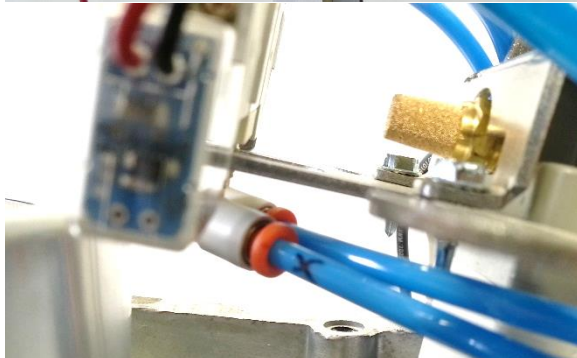
Remove front air hoses from Print Valve by
pressing down on push-to-connect fitting
collar with 1/4" Combination Wrench or
Needle-Nose Pliers while pulling out air tube



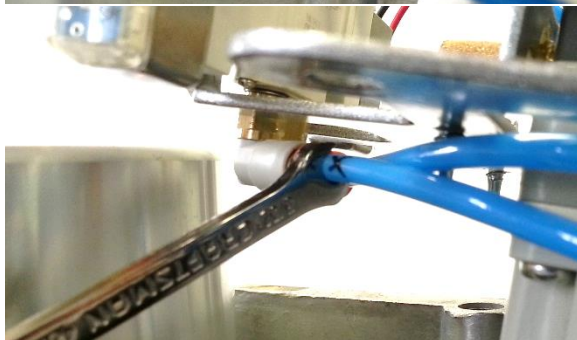
Lift up Pneumatic Package to allow access to Swing Valve mounting screws



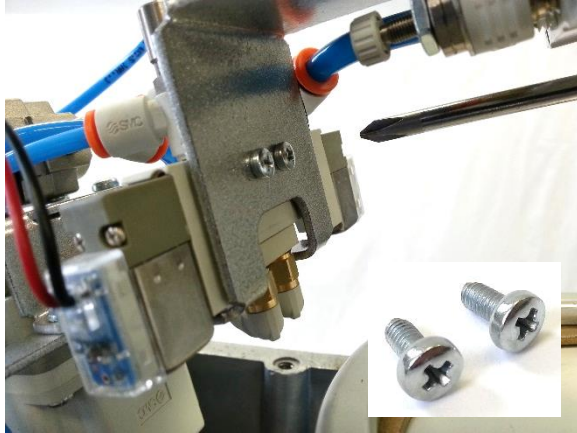
Cut zip tie holding Print Valve and Swing Valve wires together using Scissors



Mark air tube on old Swing Valve "X" with Permanent Marker as shown



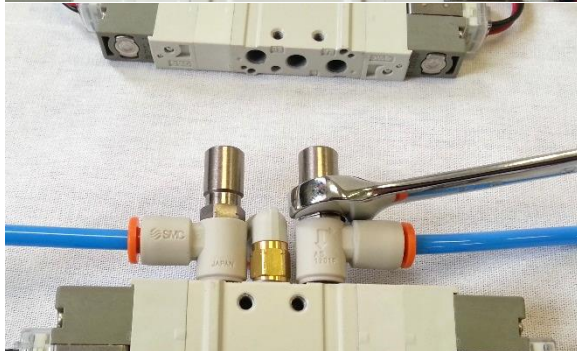
Remove bottom air tubes from old Swing Valve by pressing down on push-to-connect fitting collar with 5/32" Combination Wrench or Needle-Nose Pliers while pulling out air tube



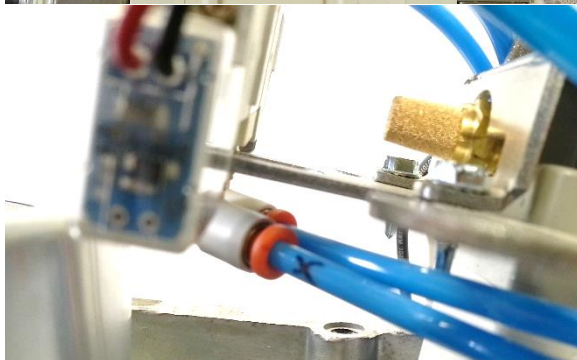
Unscrew 2x M3 x 5mm Screws from old Swing Valve using #1 Phillips Screwdriver while supporting Swing Valve against bracket



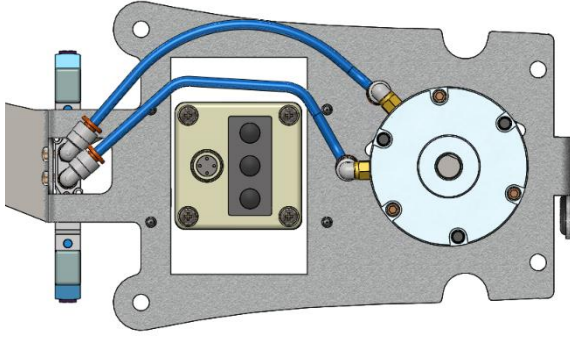
Unscrew elbow fittings from old Swing Valve one at a time and screw into new Swing Valve using 9/32" Combination Wrenches



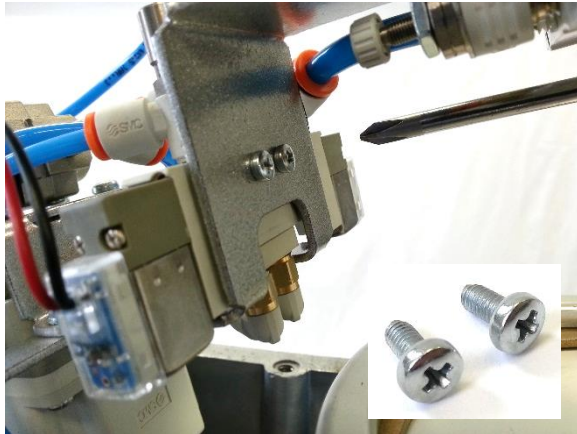
Unscrew Adjustment Valves from old Print Valve and screw into new Print Valve using 5/16" Combination Wrench



Connect bottom air hoses to new Swing Valve as shown by pushing hose into push-to-connect fitting until it seats securely and cannot be pulled out



Verify air tube connections are correct as shown in view from bottom



Mount new Swing Valve to bracket by screwing in 2x M3 x 5mm Screws using #1 Phillips Screwdriver



Connect top center air tube to new Swing Valve by pushing hose into push-to-connect fitting until it seats securely and cannot be pulled out



Plug Swing Valve connector into Controller

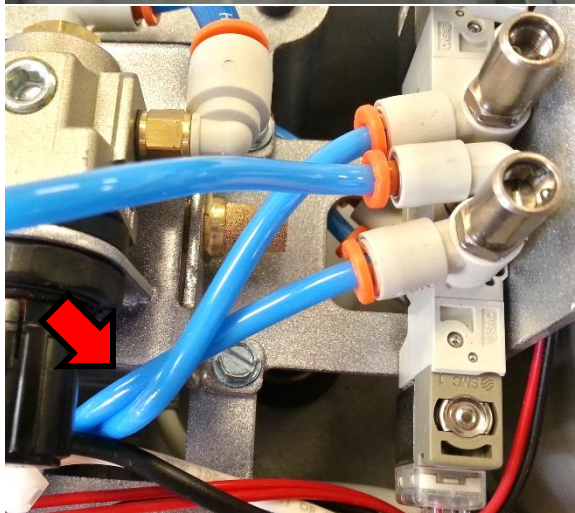


Install Pneumatic Package by screwing in 4x 1/4"-20 x 1/2" Low Profile Socket-Head Cap Screws using 1/8" Allen Wrench



Connect front air tubes to Print Valve as shown by pushing hose into push-to-connect fitting until it seats securely and cannot be pulled out

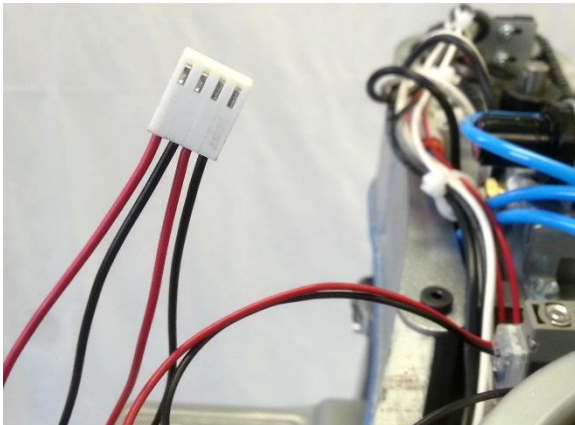
NOTE: "T" on left as shown connects to top print cylinder fitting; "B" on right as shown connects to bottom print cylinder fitting



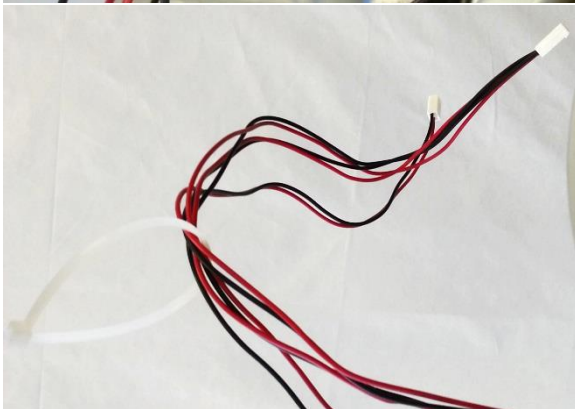
Route two top exhaust air tubes through bracket hole as shown



Insert Wires from “B” side (right) solenoid into connector pins 1 (red) & 2 (black) as shown



Insert Wires from “A” side (left) solenoid into connector pins 3 (red) & 4 (black) as shown

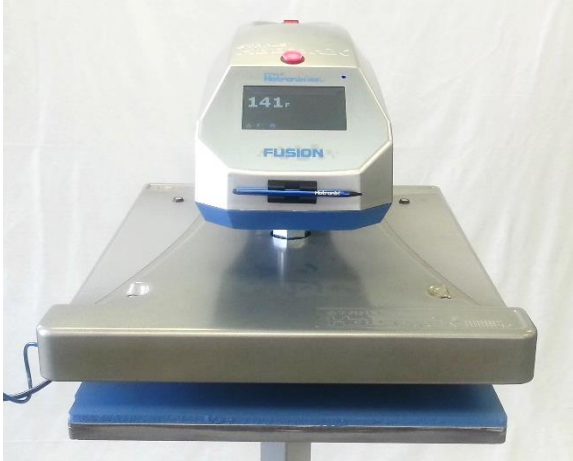


Secure Print Valve and Swing Valve wires together using Zip Tie



Replace Housing onto press and screw in three #8-32 x 3/4” Screws using Short #2 Phillips Screwdriver

NOTE: Take care not to pinch any wires between Housing and Upper Casting



Plug in press and turn ON to verify proper operation



Remove right 1/2" plastic cap and adjust speed of swing-away (head moves right) using 2mm Precision Screwdriver

- Turn screw clockwise to reduce swing speed
- Turn screw counter-clockwise to increase swing speed

Remove left 1/2" plastic cap and adjust speed of return swing (head moves left) using 2mm Precision Screwdriver

- Turn screw clockwise to reduce swing speed
- Turn screw counter-clockwise to increase swing speed