

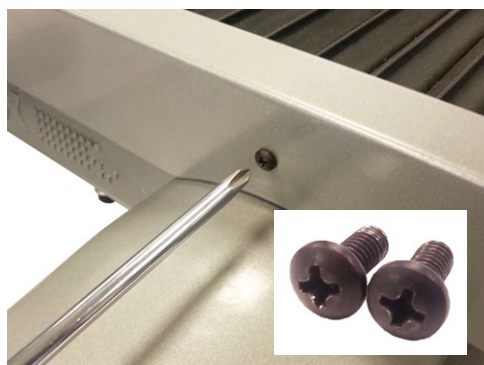


Included Parts:

1. Press Mount Casting
2. Press Mount Skeleton
3. 10x 1/4"-20 x 1-1/8" Screw
4. 12x M5 x 25mm Flat Head Screw
5. 1/2" x 1-1/4" Shoulder Bolt
6. 2x Lever Nuts
7. 3x Zip Ties

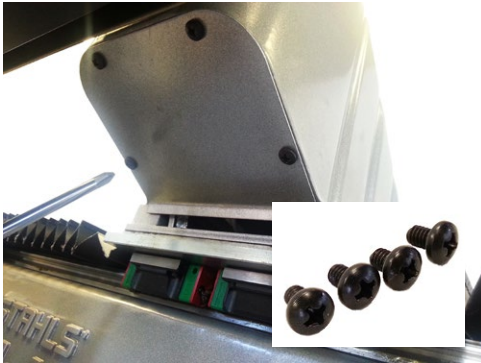
Required Tools:

8. #2 Phillips Screwdriver
9. Short #2 Phillips Screwdriver or Ratchet with #2 Phillips Bit
10. 2mm Precision Flathead Screwdriver
11. Allen Wrenches (1/8", 3/16", 1/4", 3mm, 4mm)
12. Wire Stripper (14ga)
13. Wire Cutter
14. Ruler
15. Permanent Marker
16. 5/32" Combination Wrench
17. 1/4" Combination Wrench
18. 1" Combination Wrench
19. 1-1/2" Combination Wrench
20. Clutch Holding Tool



Remove Front Base Cover by unscrewing 2x #8-32 x 3/8" Screws using #2 Phillips Screwdriver

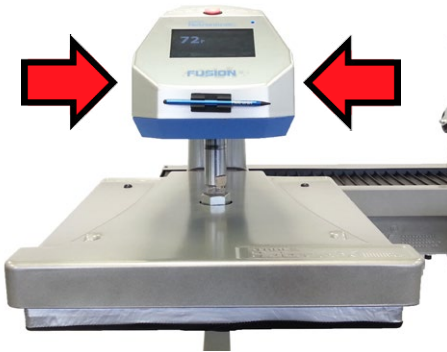
NOTE: Slide or shuttle press left & right and temporarily remove platens to access screws



Remove Press Mount Cover by unscrewing 4x #8-32 x 1/4" Screws using #2 Phillips Screwdriver



Turn press ON and set timer for 15 seconds or more



Press Print Switches to lower heater



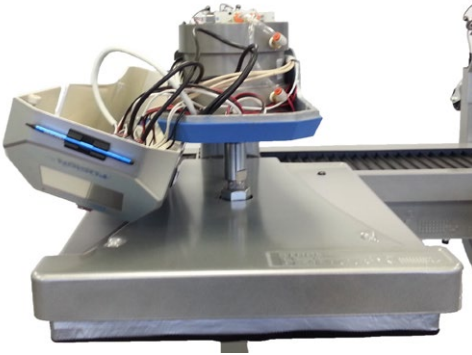
While heater is lowered,
disconnect air supply line from air
filter



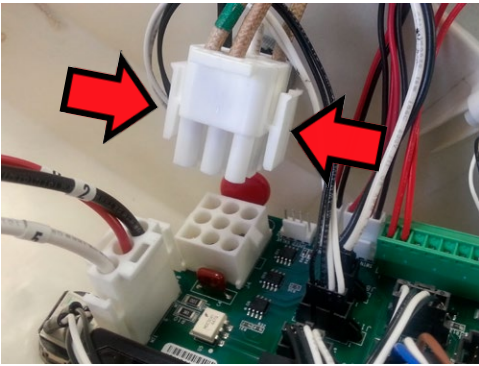
CAUTION: Turn press OFF
and detach power cord before
proceeding



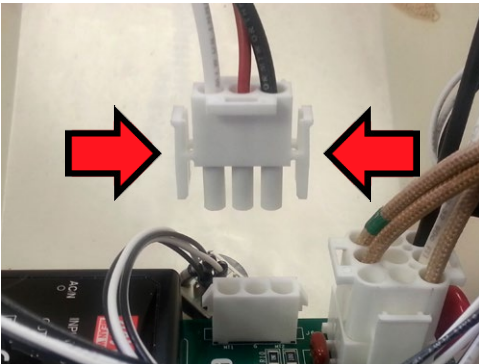
Remove four #8-32 x 3/4" Screws
from Control Housing using Short
#2 Phillips Screwdriver



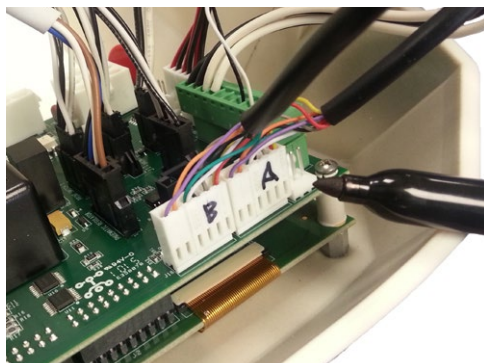
Lift off Control Housing and lay it gently on left side of press



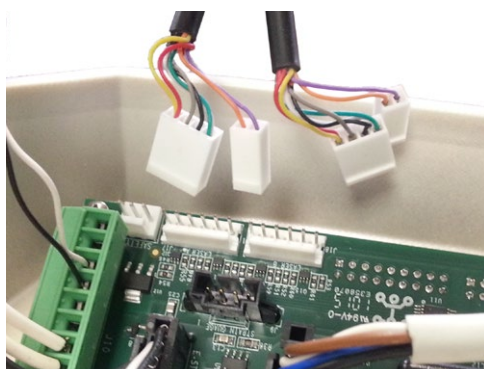
Unplug 9-pin connector from Controller by squeezing sides to release locking clips



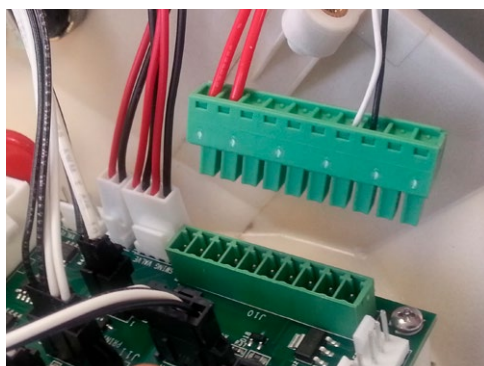
Unplug 3-pin TRIAC connector from Controller by squeezing sides to release locking clips



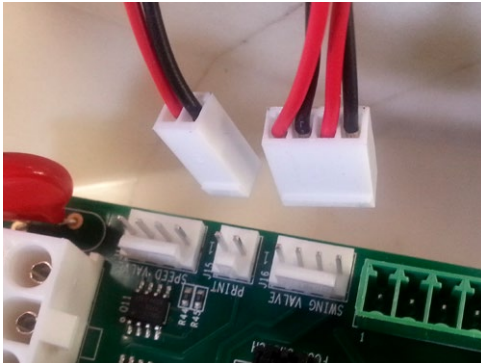
Mark Laser Alignment System connectors A & B using Permanent Marker as shown



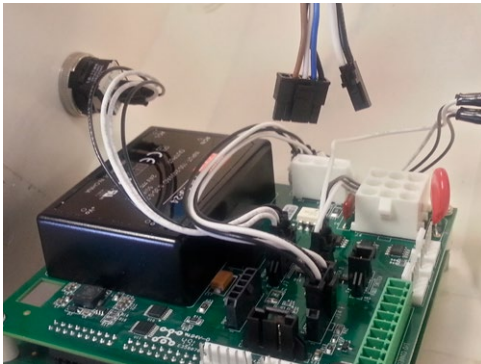
Disconnect 6-pin Laser Alignment System connectors from Controller



Unplug 10-pin I/O connector from Controller



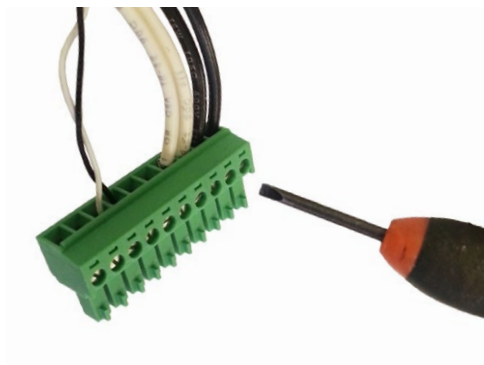
Disconnect Print Valve and Shuttle Valve connectors from Controller



Disconnect Electro-Pneumatic Regulator and Foot Switch connectors from Controller



Remove Control Housing and set aside

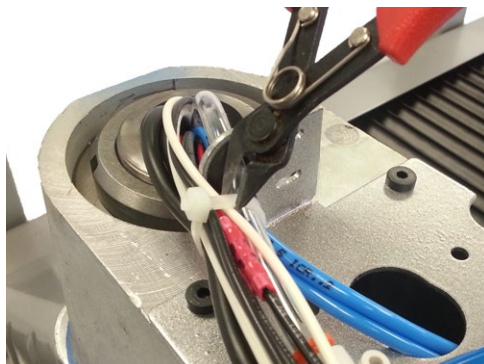


Unscrew Proximity Switch wires (22 AWG) from green 10-pin connector

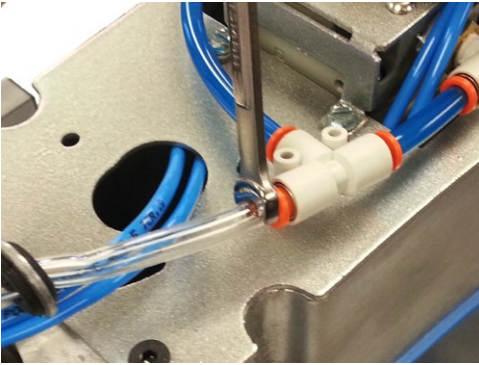
NOTE: Black wires are pins 1 & 2; white wires are pins 3 & 4; polarity does not matter



Cut white & black power cables approximately 6in from 9-pin connector using Wire Cutters



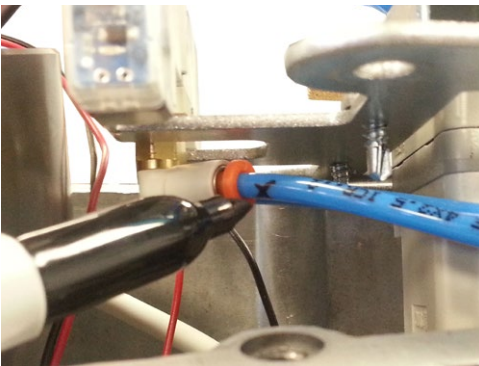
Cut Zip-Ties securing wiring and air tubes using Wire Cutters



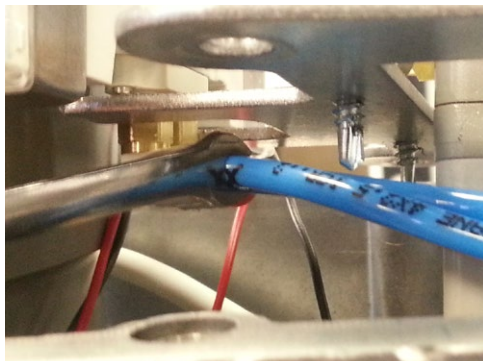
Disconnect Main Air Supply Tube from Tee Fitting by pressing down on push-to-connect fitting collar with 1/4" Combination Wrench or Pliers while pulling out air tube



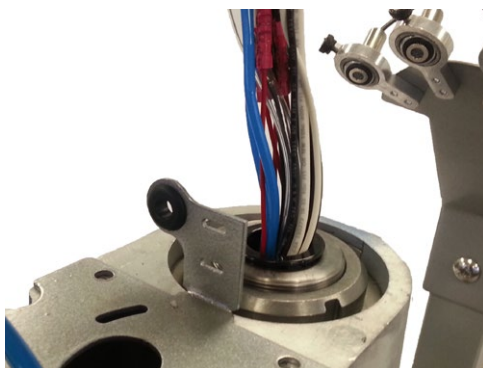
Unscrew 1/4"-20 x 3/4" Low-Profile Screws using 1/8" Allen Wrench



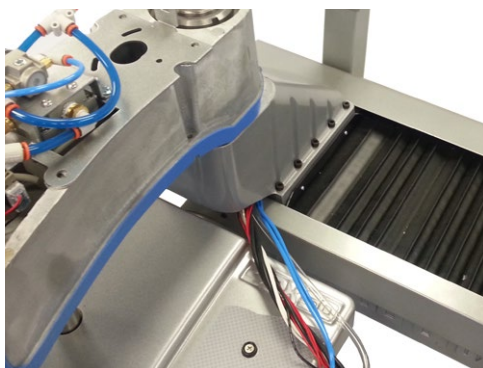
Lift up Pneumatic Package and mark Shuttle Valve air tube as shown using Permanent Marker



Disconnect air tubes from Shuttle Valve by pressing down on push-to-connect fitting collar with 5/32" Combination Wrench or Pliers while pulling out air tube



Check that all wiring and air tubes from top of Main Spindle are disconnected



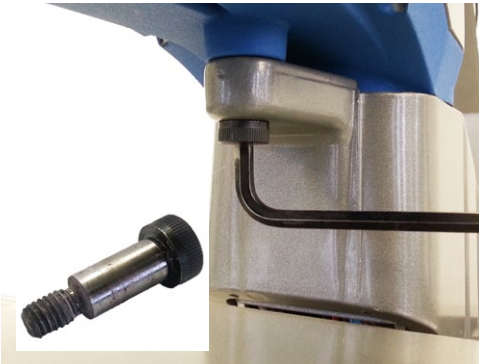
Remove wiring and air hose from main spindle tube by pulling them down through bottom of Press Mount Casting



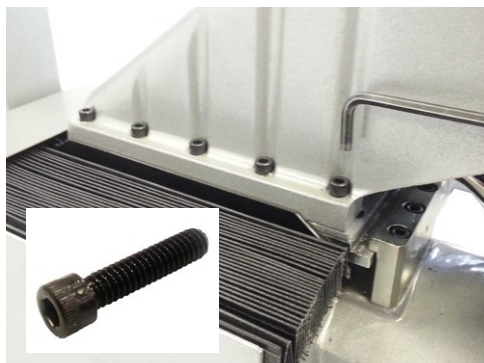
Unscrew 3x 5/16"-18 x 1" Screws from bottom of Main Spindle using 3/16" Allen Wrench



Loosen (but do not remove) 2"-18 Bearing Locknut using Spanner Wrench

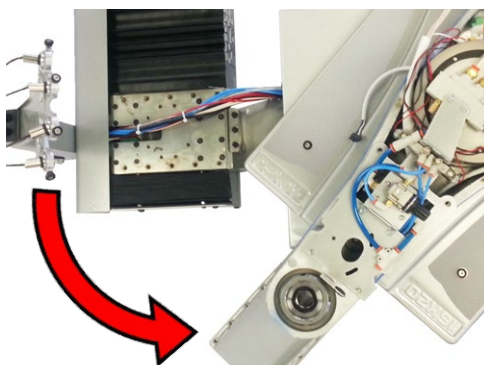


Unscrew 1/2" x 1" Shoulder Bolt using 1/4" Allen Wrench



Unscrew 10x 1/4"-20 x 1" screws from Press Mount Casting using 3/16" Allen Wrench and discard

CAUTION: When final screws are removed, entire Press Head assembly is detached from base.



Lift Press Head assembly to separate from Carriage and carefully rotate to gain access to Press Mount Casting

CAUTION: Practice safe lifting procedures as assembly weighs over 60lbs (30kg)

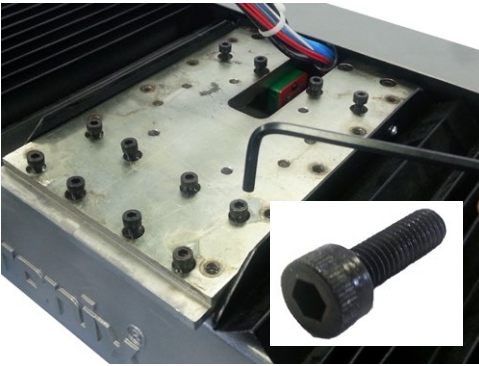
CAUTION: when released, assembly will lower as Print Cylinder retracts under weight of assembly



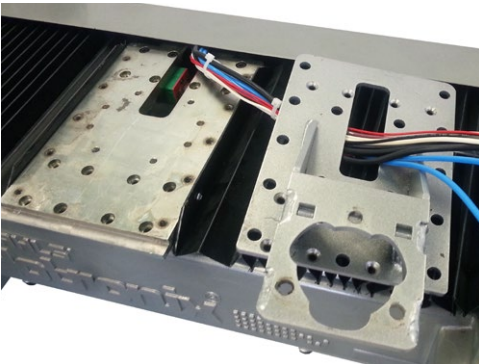
Unscrew 2"-18 Bearing Locknut and remove Press Mount Casting from Press Head Assembly



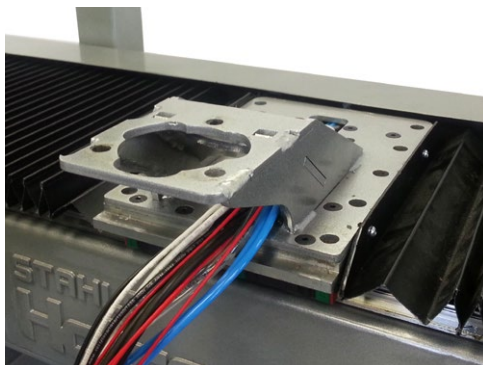
Remove Main Spindle and 4x Bearing Spacers from old Press Mount Casting and discard old Press Mount Casting



Unscrew 12x M5 x 15mm screws from Carriage Plate using 4mm Allen Wrench, ignoring 4x screws in back as shown



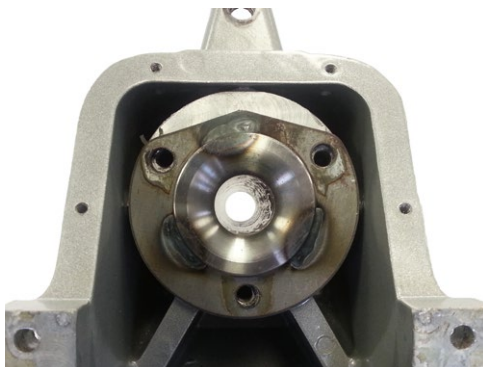
Thread wiring and air tube through hole in Press Mount Skeleton as shown



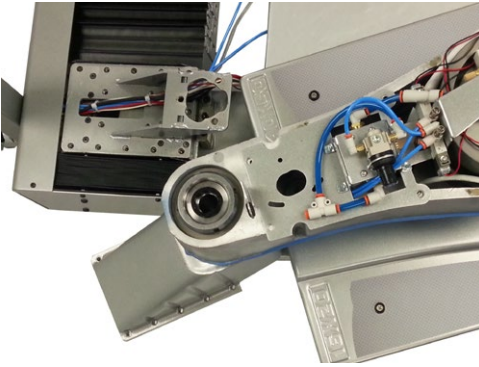
Position Press Mount Skeleton as shown and thread wiring and air tube through front



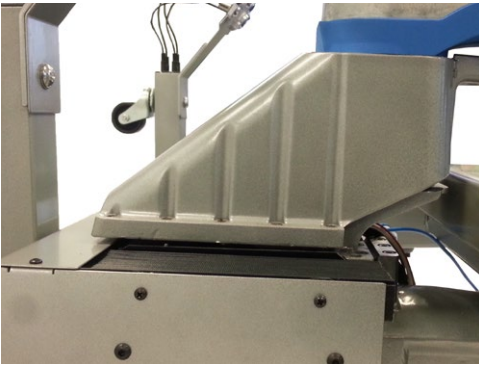
Attach Press Mount Skeleton to Carriage Plate by screwing in 12x M5 x 25mm Flat Head Screws using 3mm Allen Wrench



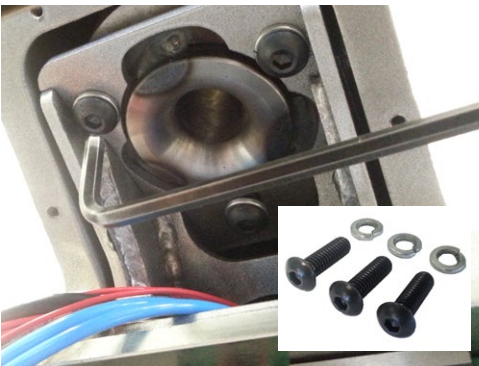
Insert Main Spindle into new Press Mount Casting, ensuring flange is aligned as shown



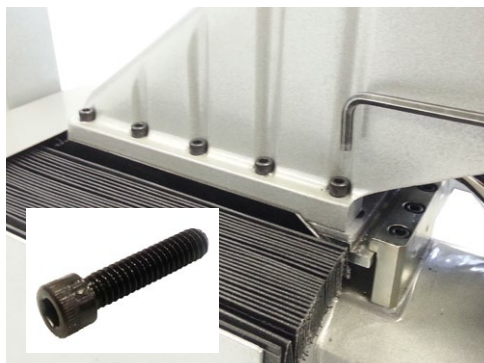
Install new Press Mount Casting with Main Spindle onto Press Head Assembly and loosely install 2"-18 Bearing Locknut onto Main Spindle



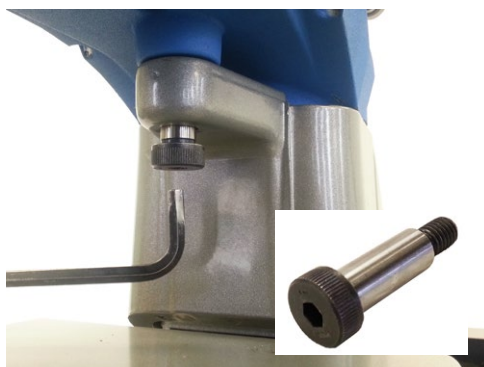
Carefully position Press Head Assembly to line up with Press Mount Skeleton



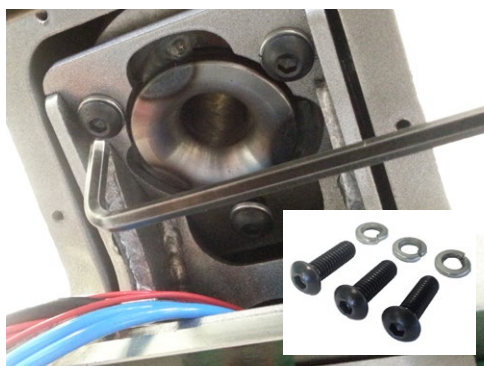
Loosely install 3x 5/16"-18 x 1" Screws into bottom of Main Spindle using 3/16" Allen Wrench



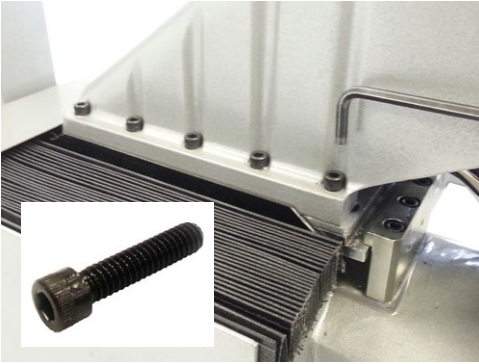
Loosely install 10x new 1/4"-20 x 1-1/8" screws using 3/16" Allen Wrench



Loosely install 1/2" x 1-1/4" Shoulder Bolt into Press Mount Casting using 1/4" Allen Wrench



Tighten 3x 5/16"-18 x 1" Screws using 3/16" Allen Wrench



Tighten 10x 1/4"-20 x 1-1/8"
screws using 3/16" Allen Wrench



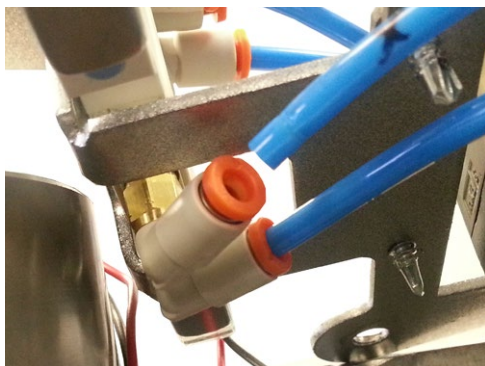
Tighten 2"-18 Bearing Locknut
using Spanner Wrench



Tighten 1/2" x 1-1/4" Shoulder
Bolt using 1/4" Allen Wrench



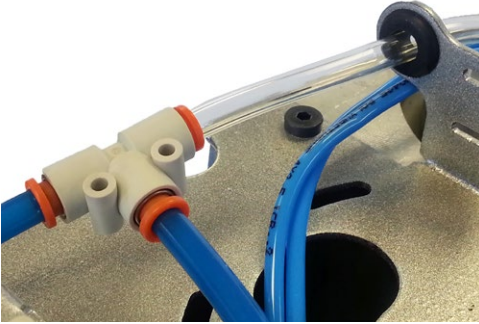
Thread wiring and air hose up through Main Spindle



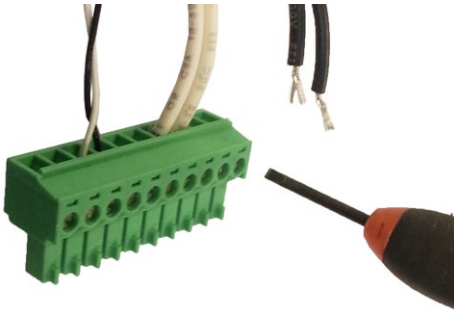
Lift up Pneumatic Package and connect 5/32" Air Tubes into Shuttle Valve by pushing tube into push-to-connect fitting until it seats securely, noting position of marked tube as shown



Attach Pneumatic Package to Upper Casting by screwing in 4x 1/4"-20 x 3/4" Low Profile Screws using 1/8" Allen Wrench



Connect Main Air Supply Tube into Tee Fitting by pushing tube into push-to-connect fitting until it seats securely



Screw Proximity Switch wires (22 AWG) into green 10-pin connector

NOTE: Black wires are pins 1 & 2; white wires are pins 3 & 4; polarity does not matter



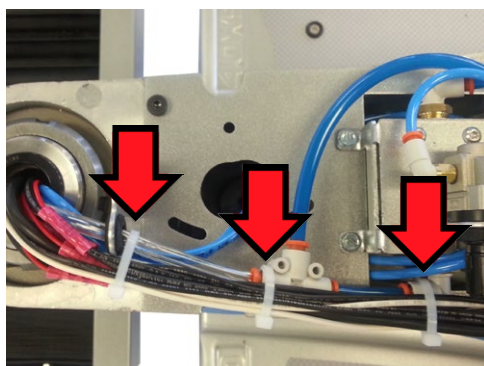
Use Wire Strippers to strip 10mm off ends of 4 black & white power wires (14 AWG)



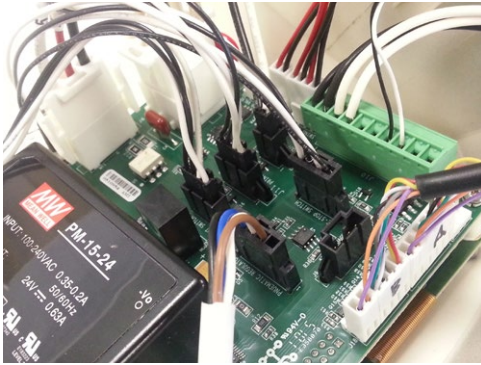
Unlock Lever Nuts by raising levers as shown



Connect power wires (white to white & black to black) using Lever Nuts as shown

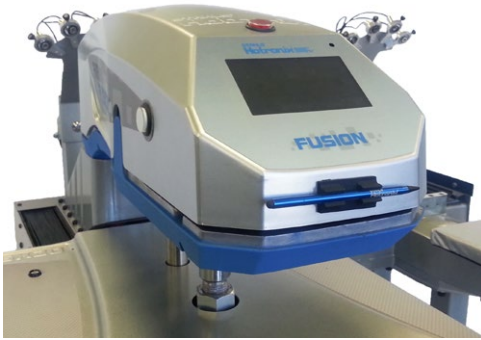


Secure cables and air tube using 3x Zip Ties



Plug connectors into Controller on Housing:

- 9-pin connector
- 3-pin TRIAC connector
- 10-pin I/O connector
- Foot Switch
- Print Valve
- Shuttle Valve
- Electro-Pneumatic Regulator
- Laser Alignment System



Replace Housing onto press

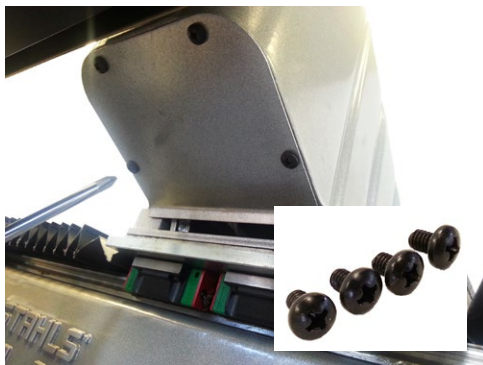
NOTE: Take care not to pinch any wires between Housing and Upper Casting



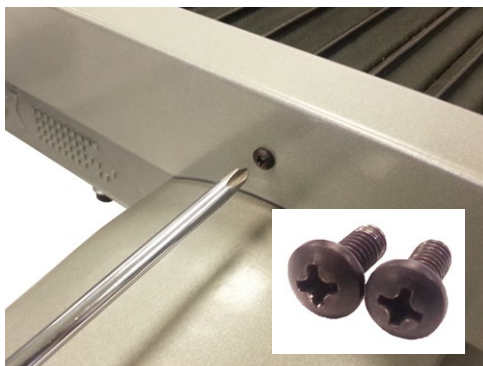
Plug in power cord and air supply line



Turn press ON and check for proper function (i.e. that all connectors are plugged in):
Foot Pedal Shuttle function
Shuttle position detection (A/B light up green)
Laser Alignment lights on/off
Temperature Probe reading



Install Press Mount Cover by screwing in 4x #8-32 x 1/4" Screws using #2 Screwdriver

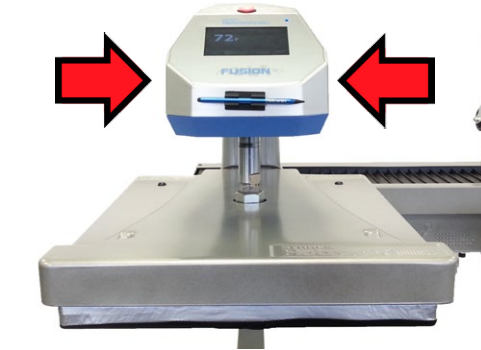


Install Front Base Cover by screwing in 2x #8-32 x 3/8" Screws using #2 Phillips Screwdriver

NOTE: Slide or shuttle press left & right and temporarily remove platens to access screws



Turn press ON and 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 and detach power cord



Screw in four #8-32 x 3/4"
Screws using Short #2 Phillips
Screwdriver



Plug in press and turn ON to
raise heater and check for proper
function