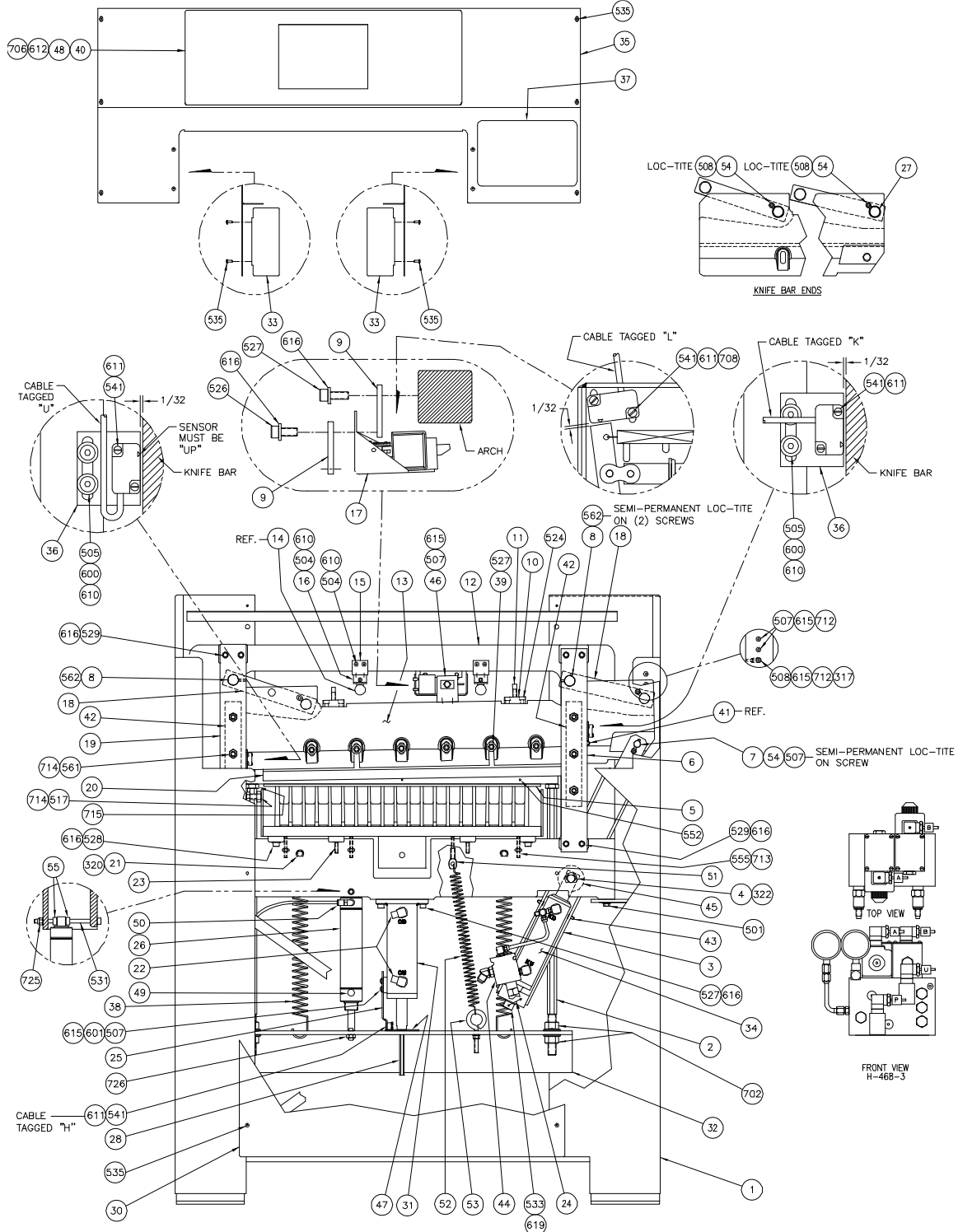


13.0 Parts List & Sequence of Operations

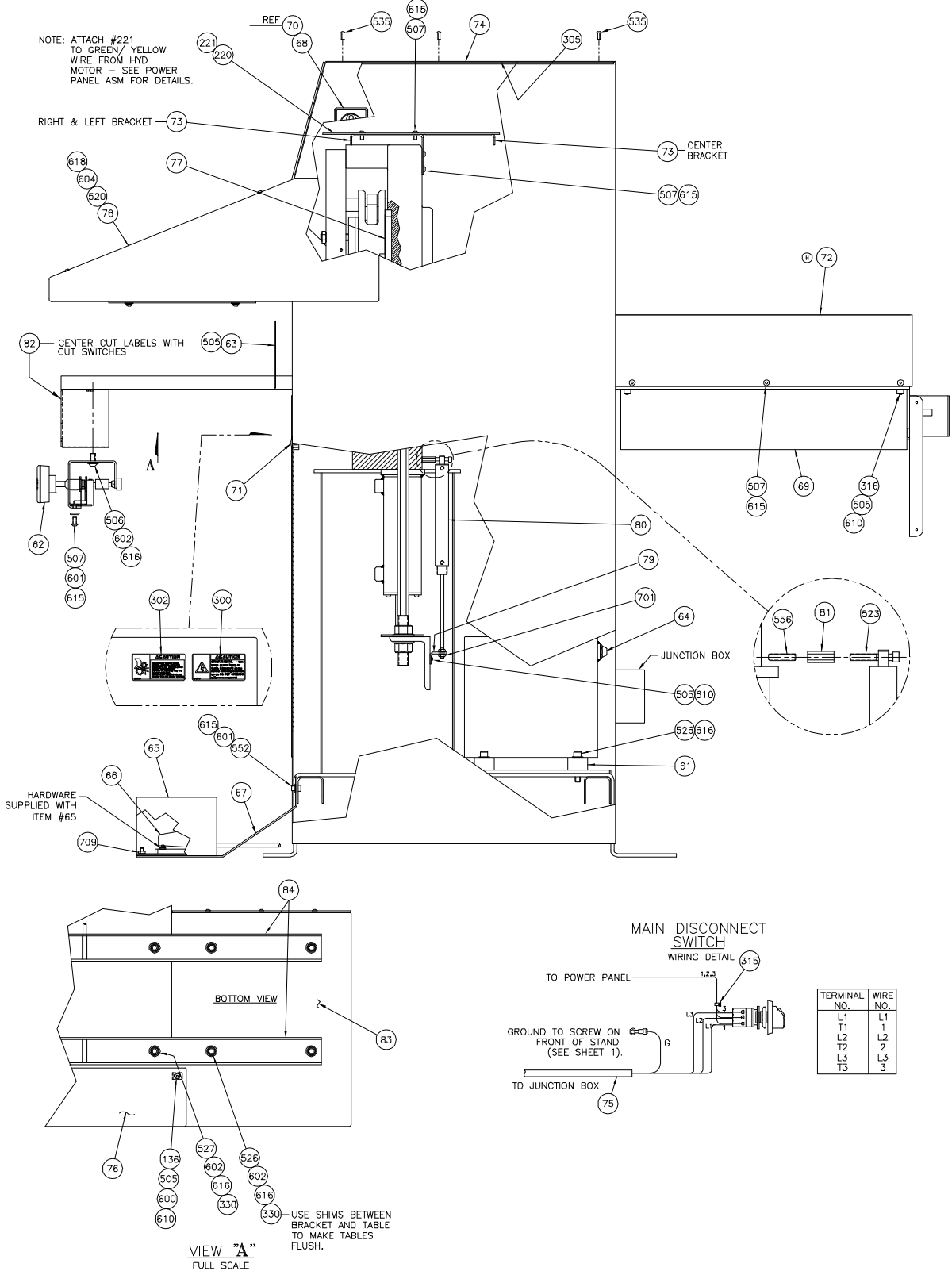
13.1 Main Assembly – Front View

44600 Sheet 1, Rev. B (See 44600 Sheets 5 & 6 for item descriptions)



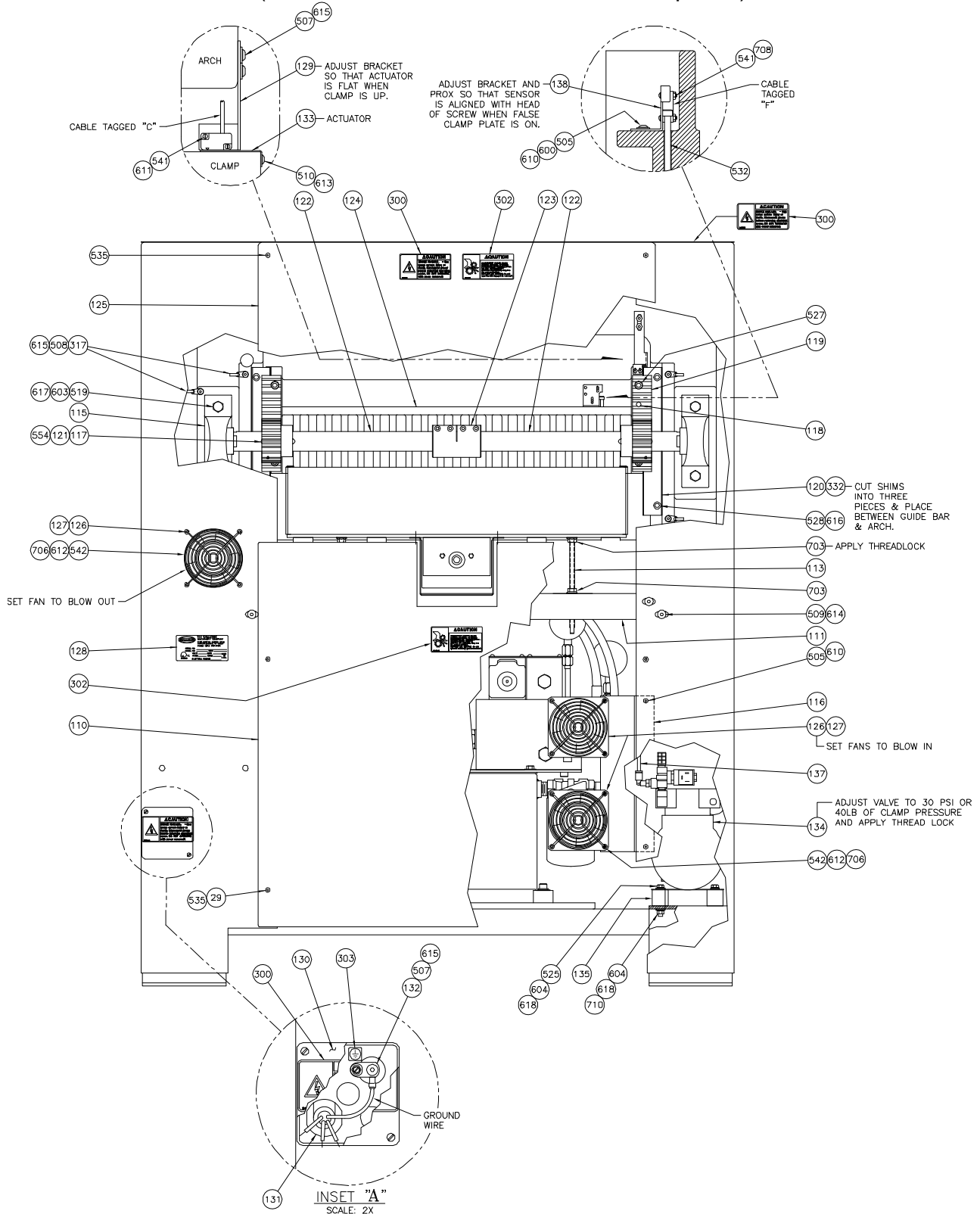
13.2 Main Assembly – Side View

44600 Sheet 2, Rev. A (See 44600 Sheet 5 & 6 for item descriptions)



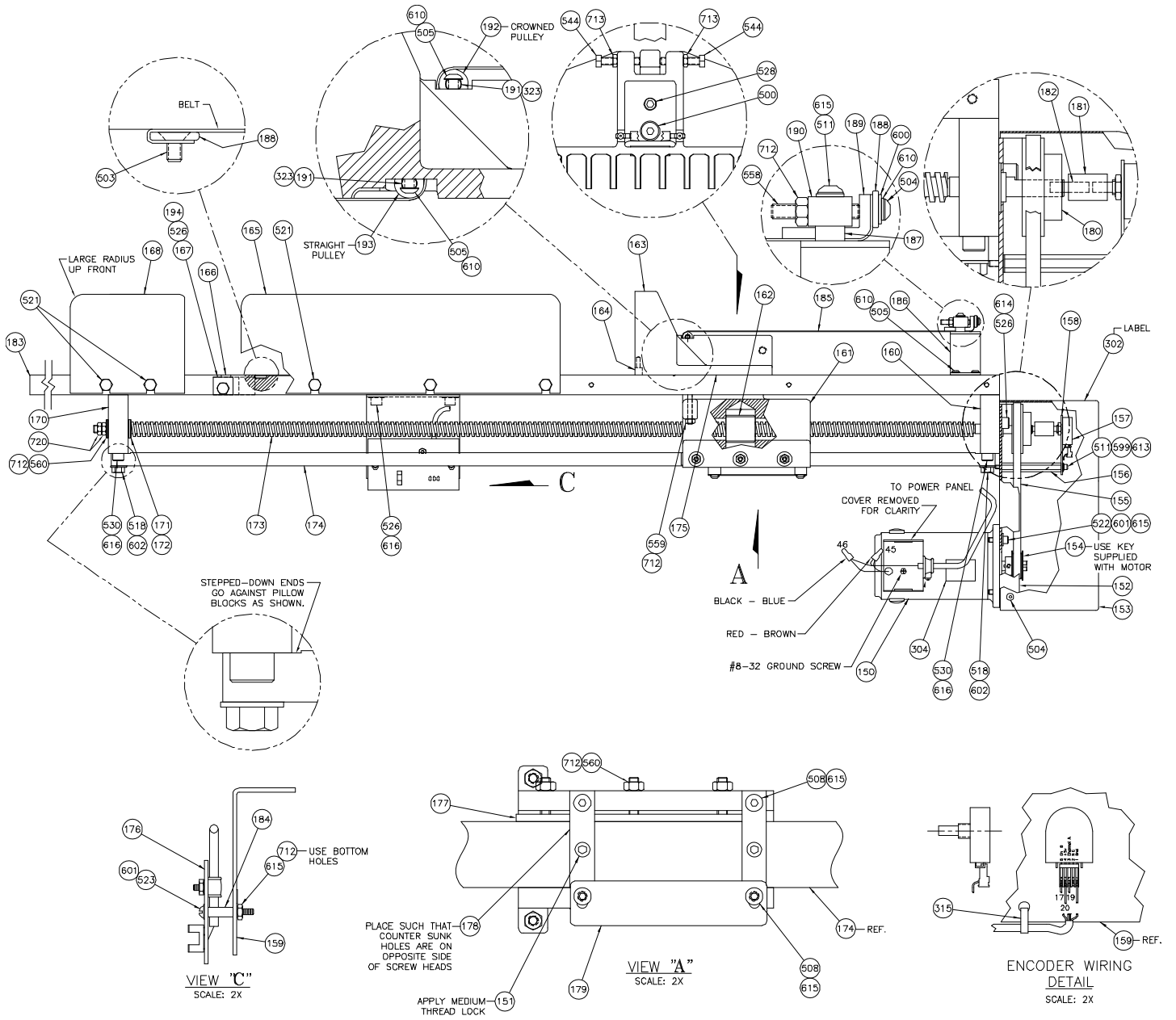
13.3 Main Assembly – Rear View

44600 Sheet 3, Rev. A (See 44600 Sheet 5 & 6 for item descriptions)



13.4 Main Assembly – Table View

44600 Sheet 4, Rev. A (See 44600 Sheet 5 & 6 for item descriptions)



13.5 Main Assembly – Parts List

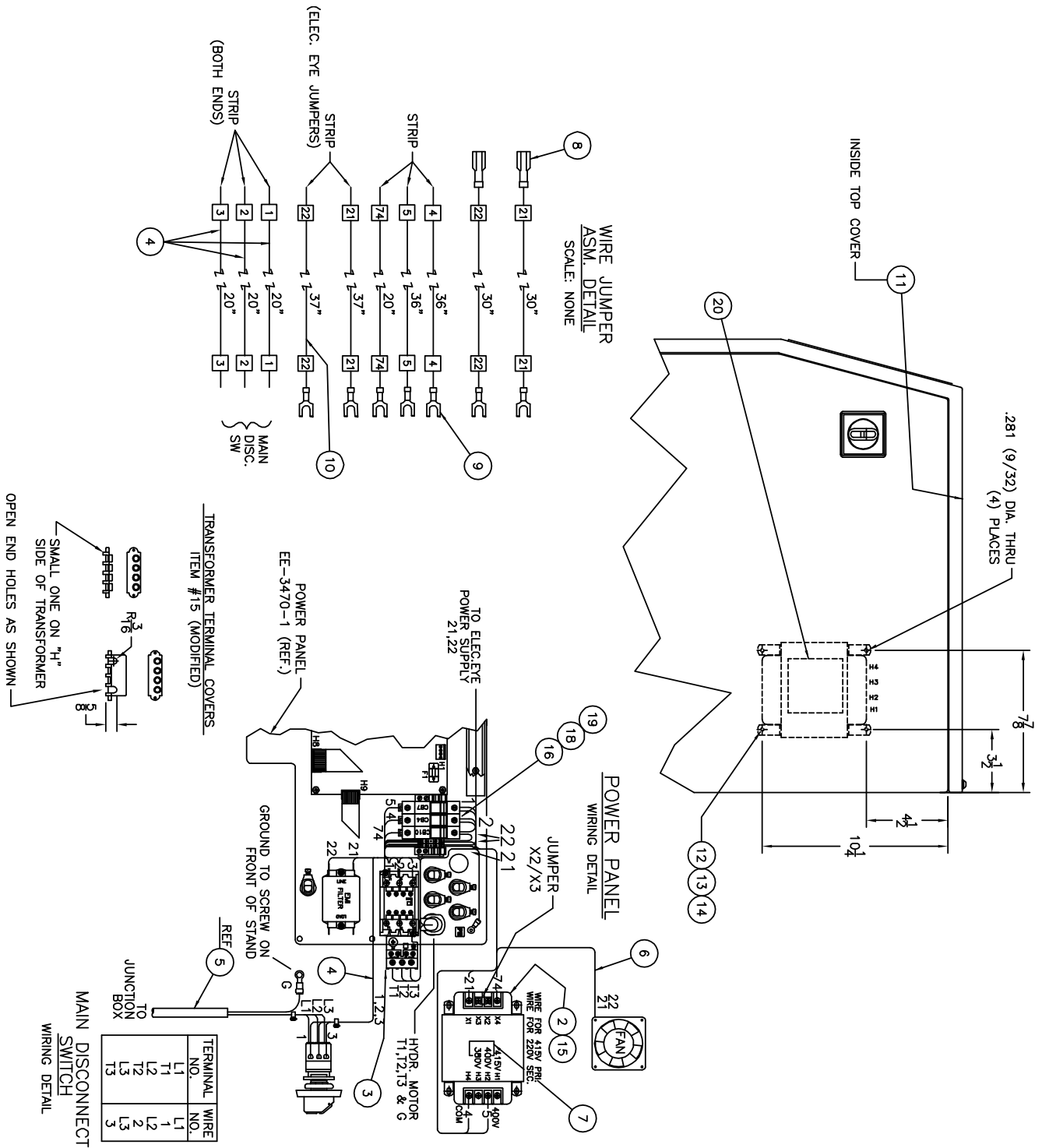
44600 Sheet 5, Rev. B

NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	44030-2	STAND ASSEMBLY	1
2	44013	PULL DOWN ROD	2
3	44058-3	CYL. BRACKET (S/N 265-D-181299 & BELOW)	1
	44058-4	CYL. BRACKET (S/N 265-D-181300 & ABOVE)	1
4	44065	PIN - KNIFE CYLINDER	1
5	44027	FALSE CLAMP PLATE	1
6	44016-2	PLATE - RIGHT KNIFE GIB	1
7	44079-1	PIN - KNIFE BAR	1
8	44066-1	PIN - KNIFE LINK	2
9	44114	BRACKET - KNIFE LATCH	2
10	8175	BRACKET - KNIFE ADJ. SCREW	2
11	4449	KNIFE ADJUSTING SCREW	2
12	44002-2	ARCH/BASE	1
13	8963-2	KNIFE BAR ASSEMBLY	1
14	E-967-1	LIGHT BULB	REF.
15	44078	LINE LIGHT BRACKET	2
16	EE-2779	LINE LIGHT ASM.	2
17	47568-1	KNIFE LATCH ASSEMBLY	1
18	44008-1	LINK - KNIFE BAR	2
19	44015-1	PLATE - LEFT KNIFE GIB	1
20	2263-2	KNIFE	1
21	44064	PIN - CLAMP RETURN SPRING	2
22	H-230-6	ELBOW - 90° #6 O-RING TO #8 TUBE	2
23	44055	TAPER PIN	1
24	S-2024	SAFETY WIRE	8"
25	44077	BRACKET - HYD. UP PROX.	1
26	49243	AIR CYLINDER	1
27	8821-1	PIN - KNIFE BAR	2
28	43074	ROD - CLAMP CYLINDER	1
29	E-1152-61	STAND OFF - 3/4"	8
30	44025	COVER - FRONT STAND	1
31	H-505	CYLINDER - CLAMP	1
32	44046-2	FOOT PEDAL PULL DOWN BAR	1
33	44226	SIDE SHIELD	2
34	H-506-4	KNIFE CYL. (S/N 265-D-181299 & BELOW)	1
	H-506-5	KNIFE CYL. (S/N 265-D-181300 & ABOVE)	1
35	44220	BEVELED COVER	1
36	44014	BRACKET - KNIFE PROX. SWITCH	2
37	S-1781-116	LABEL - WARNING	1
38	47136-13	SPRING - CLAMP RETURN	2
39	8815	WASHER - KNIFE	6
40	EE-3456-2	CONTROL CONSOLE - TC	1
41	H-21S-375-	PIN - 3/8 X 3/4 ROLL	REF.
42	4505	KNIFE BAR GIB	2
43	E-2196-23	HOLE PLUG	2
44	H-551-2	COUNTERBALANCE VALVE ASM. (S/N'S 265-D-161106 & BELOW)	1
	H-551-3	COUNTERBALANCE VALVE ASM. (S/N'S 265-D-161107 TO 265-D-171151)	1
	H-551-4	COUNTERBALANCE VALVE ASM. (S/N'S 265-D-171152 & UP)	1
45	44111	DISK	1
46	47504	BRACKET - KNIFE BAR KEEPER	1
47	43076	ACTUATOR - HYD. UP PROX	1
49	P-511	SILENCER/MUFFLER - 1/4 NPT	1
50	P-503-402	ELBOW FITTING - 1/4 TUBE X 1/4 NPT	1
51	44195	EYE NUT	1
52	47136-15	SPRING	1
53	S-1885	EYE BOLT	1
54	44206	ROD END PIN RETAINER	3
55	A-10644-1	COLLAR	2
61	40016-5	VIBRATION MOUNT	4
62	49249	BACKGAUGE CONTROL ASSEMBLY	1
63	44163	BACKPLATE	2
64	H-571-2	HYD. UNIT - 380-415V 3PH 50HZ	1
	H-571-3	HYD. UNIT - 208-230V 3PH 60HZ	1
65	E-1719	GUARD - FOOTSWITCH	1
66	EE-3220	FOOTSWITCH ASM	1
67	44189	FOOTSWITCH BRACKET	1
68	E-3083	SWITCH FACE - MAIN DISCONNECT	1
69	44045	COVER - LEADSCREW	1
70	E-3082	SWITCH - MAIN DISCONNECT	REF
71	E-2196	HOLE PLUG	1
72	44225	BACKGAUGE COVER- SHEETMETAL	1
73	44007-1	BRACKET - ELEC. PANEL	3
74	44221	TOP COVER	1
75	EE-2865-2	CABLE ASM. - JUNCTION BOX	1
76	44212	BOX ASSEMBLY - CUT BUTTONS	1
77	44188	UHMW - REAR	2
78	EE-3363	ELEC EYE ASM	1
79	43061-1	BRACKET - CLAMP DAMPER	1
80	44023	DAMPER CYLINDER ASM.	1

NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
81	E-1152-69	STANDOFF - 1"	1
82	S-1781-115	LABEL - CUT BUTTON	2
83	44158	SIDE TABLE	2
84	44166	SUPPORT - SIDE TABLES	2
110	44053-1	COVER - REAR STAND BOTTOM	1
111	44044-1	SUPPORT - REAR STAND	1
113	44084	JACKSCREW	2
115	44096	BEARING	2
116	44196	FAN BRACKET	1
117	S-743	KEY - 3/8 X 3/8 X 2-1/4	2
118	H-5246-612	PIN - 3/8 X 1-1/2 DOWEL	2
119	44083	CLAMP RACK	2
120	44080	CLAMP GUIDE BAR	2
121	44094	GEAR	2
122	44095	SHAFT	2
123	44106	COUPLER	1
124	44005	CLAMP	1
125	44222	COVER - REAR STAND TOP	1
126	47092	GUARD - FINGER	6
127	E-2483-1	FAN - 230 V.	3
128	41130	SPEC. PLATE	1
129	44012	BRACKET - CLAMP UP PROX.	1
130	E-1369-1	COVER - JUNCTION BOX	1
131	S-1350-5	CLAMP - CORD GRIP	1
132	E-640-2	GROUND LUG	1
133	44197	CLAMP UP PROXIMITY ACTUATOR	1
134	44192	COMPRESSOR ASSEMBLY	1
135	40016-8	MOUNT - VIBRATION	4
136	49255-2	STAND-OFF - #10-24X 3-9/16"	2
137	P-303	TUBING - 1/4" AIR	
138	44194	PROX. BRKT - FALSE CLAMP PLATE	1
150	E-1600-166	MOTOR - 180V DC	1
151	S-1944-1	NYLON TIP SET SCREW	2
152	43027-2	BRACKET - MOTOR MOUNT	1
153	43028-1	COVER - BACKGAUGE	1
154	43063	PULLEY	1
155	7954	BELT - TIMING	1
156	E-1152-60	STANDOFF - 3"	2
157	E-2467	ENCODER	1
158	43029	PLATE - ENCODER MOUNT	1
159	10040-1	BRACKET - PRESET	1
160	44068	REAR PILLOW BLOCK ASM.	1
161	44006	BACKGAUGE CARRIER	1
162	43005-1	NUT - LEADSCREW	1
163	44017	BACKGAUGE	1
164	10065	PIN - BACKGAUGE	10
165	44054	SIDEGUIDE - REAR	2
166	4165	CUT STICK	1
167	47630	STOP - CUT STICK	1
168	44121	SIDEGUIDE	2
169	E-1237-6	WIRE NUT	2
170	44067	FRONT PILLOW BLOCK ASM.	1
171	S-1295-3	THRUST WASHER	4
172	S-1300-2	THRUST BEARING	2
173	44003-1	LEADSCREW	1
174	44021	GUIDEBAR - BACKGAUGE BRACKET	1
175	47264	TAPE - UHMW	3
176	EE-1688-1	P.C.B. ASSEMBLY - PRESET	1
177	44069	GIB - BACKGAUGE BRACKET	1
178	43060	STRAP	2
179	43032	PRESET WAND	1
180	43062	PULLEY	1
181	47053	COUPLING	1
182	H-21S-250-1000	PIN - 1/4 X 1" ROLL	1
183	44001-1	TABLE	1
184	E-1152-12	SPACER	2
185	44154	BELT	1
186	44155	BRACKET - BELT	1
187	E-1152-93	SPACER	2
188	44153	BELT CLAMP	2
189	44157	BRACKET - BELT ADJ	1
190	44156	BELT ADJ. BLOCK	1
191	47597	PIN - PULLEY	2
192	47588	CROWNED PULLEY	1
193	47601	STRAIGHT PULLEY	1
194	44210	CUT STICK STOP- LH	1
220	EE-3470	PANEL ASM, POWER - 208/230V	1
221	E-1214-63	CONNECTOR - 1/4 NON- ING RING	1
222	E-2441-11	OVERLOAD - 13A TO 19A (60HZ)	1

13.7 Main Assembly – 3 Phase 50 Hz Option

44600 Sheet 7, Rev. B



Main Assembly – 3 Phase 50Hz Option (cont)

INSTRUCTIONS:

- 1) REPLACE THE EXISTING CABLE FROM THE JUNCTION BOX TO THE MAIN DISCONNECT SWITCH WITH ITEM #5.
- 2) REPLACE THE EXISTING CABLE FROM THE POWER PANEL TO THE MAIN DISCONNECT SWITCH WITH ITEMS #4.

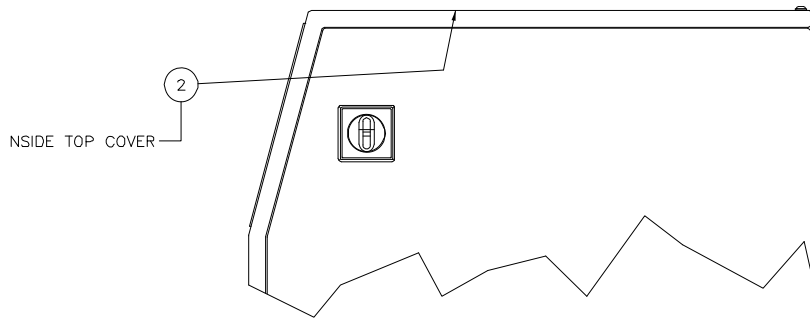
NOTE: IF YOUR MACHINE ALREADY HAS INDIVIDUAL WIRES RUNNING FROM THE POWER PANEL TO THE MAIN DISC. SWITCH, REPLACE THEM WITH THE SUPPLIED WIRES (ITEM #4) BECAUSE THE WIRE NUMBERS AND PANEL LOCATIONS CHANGE – SEE WIRE DETAIL.

- 3) REPLACE THE OVERLOAD CONTACT WITH ITEM #3. SET TO 8.5A
- 4) REMOVE THE FAN CABLE FROM THE POWER PANEL.
- 5) USING THE WIRE JUMPER DETAIL, CUT WIRES TO THE LENGTHS SHOWN. STRIP WIRE INSULATION BACK 1/4" ON ALL WIRES. IF REQUIRED, INSTALL WIRE CONNECTORS AS SHOWN IN THE CHART. WIRE TAG ALL WIRES AS SHOWN IN THE CHART.
- 6) DRILL (4) HOLES AT DIMENSIONS SHOWN.
- 7) INSTALL THE TRANSFORMER TO THE INSIDE OF THE MACHINE AS SHOWN.
- 8) REPLACE THE EXISTING TERM RAIL WITH THE NEW SUPPLIED ONE.
- 9) REWIRE THE POWER PANEL AS SHOWN IN WIRING DETAILS.

NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1			
2	E-1089-28	TRANSFORMER – 750VA 50Hz	1
3	E-2441-20	CONTACTOR – OVERLOAD, 7.6A TO 10A	1
4	E-798-B	WIRE – #12GA. BLACK MTW 20" LONG	3
5	EE-2865-2	CABLE ASM. – POWER CORD JUMPER, 3PH	REF
6	EE-2466-3	CABLE ASM. – FAN, 230V	1
7	E-1584-53	LABEL – TRANSFORMER, "T3"	1
8	E-1214-49	CONNECTOR – 1/4" FULLY INS. Q.D.	2
9	E-1214-1	CONNECTOR – #10 INS. LOCKING FORK	7
10	E-702-R	WIRE – #14 GA. RED MTW 226" TOTAL	1
11	S-1781-170	LABEL – POWER CONNECTION PROCEDURE	REF
12	H-6910-404	SCREW – 1/4-20 X 1/2 BUT HD CAP	4
13	H-7321-4	WASHER – 1/4 FLAT	4
14	H-6423-4	NUT – 1/4-20 HEX W/LOCKWASHER (KEP)	4
15	E-2974	COVER – TRANSFORMER TERMINALS (MODIFIED)	1
16	E-3264-6	CIRCUIT BREAKER – 5A (CB10)	1
17			
18	E-2068-8	TERMINAL BLOCK – THROUGH, #10 GA.	2
19	E-1977-10	TERMINAL RAIL – 3-1/2"	1
20	S-1781-167	LABEL – TRANSFORMER TAP SETTINGS	1

13.8 Main Assembly – 3 Phase 60Hz Option

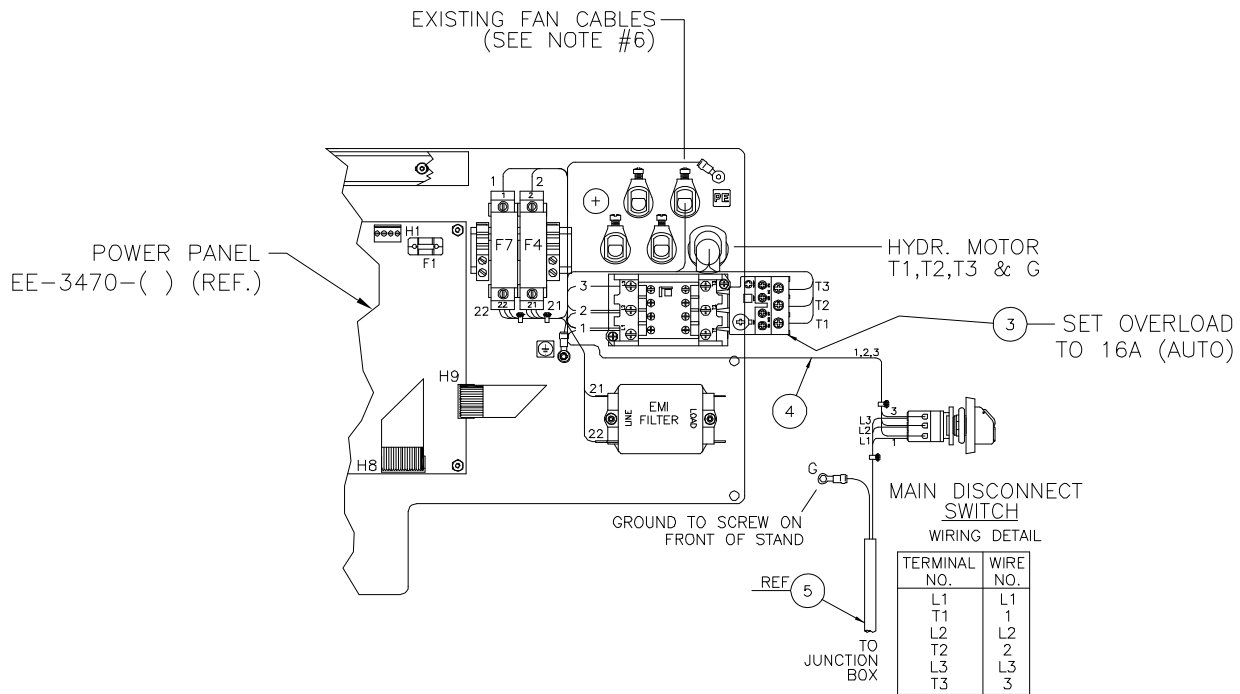
44600 Sheet 8, Rev. A



INSIDE TOP COVER

POWER PANEL

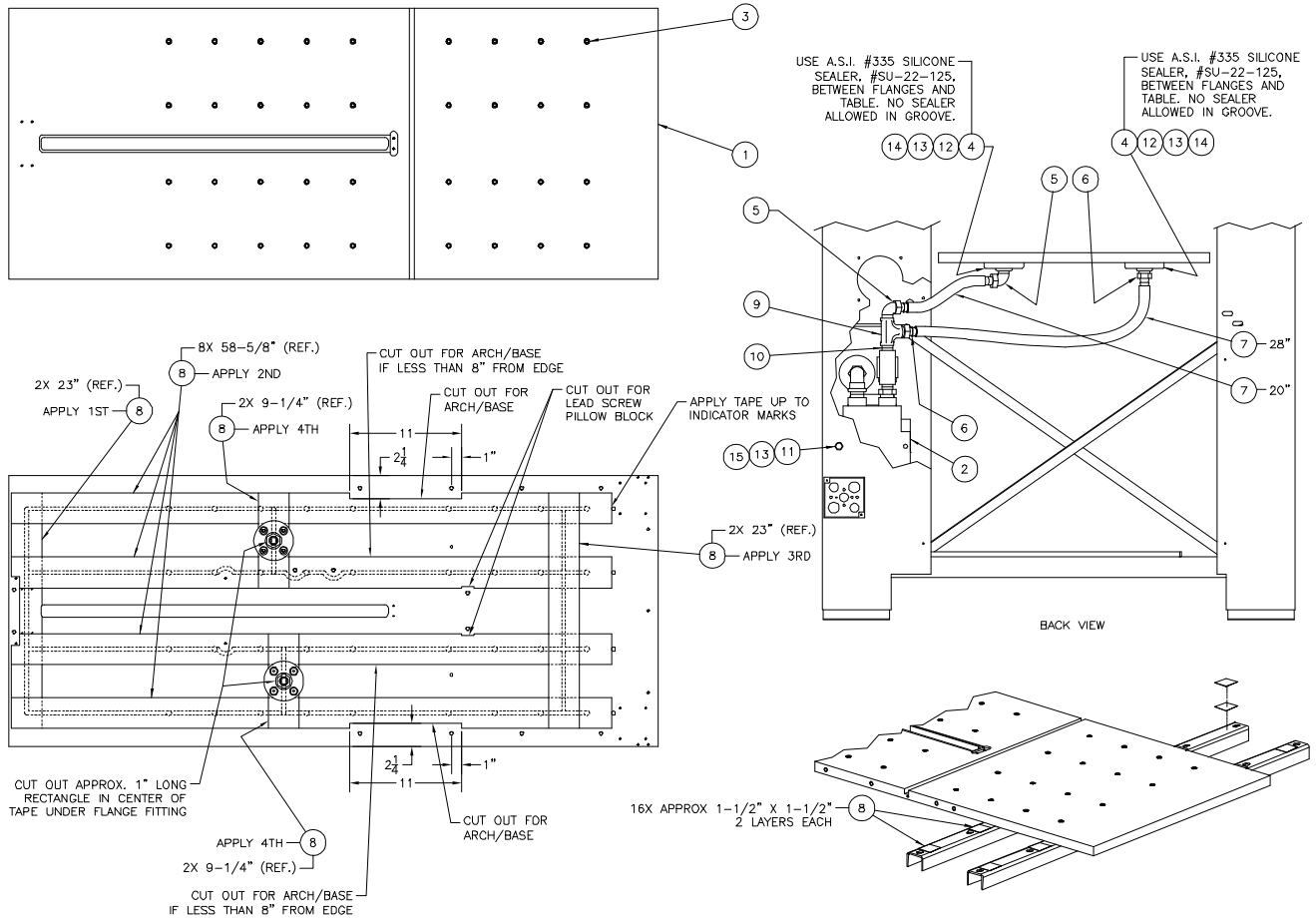
WIRING DETAIL



NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1			
2	S-1781-170	LABEL - POWER CONNECTION PROCEDURE	REF
3	E-2441-11	CONTACTOR - OVERLOAD, 13A TO 19A	REF
4	E-798-B	WIRE - #12GA BLACK MTW 20" LONG	3
5	EE-2865-3	CABLE ASM. - JUNCTION BOX POWER, 3PH	1
6	S-1694	TYRAP	2
7	EE-3068-1	CABLE ASM. - FILTER/MANIFOLD FANS	1

13.9 Main Assembly – Air Table Option

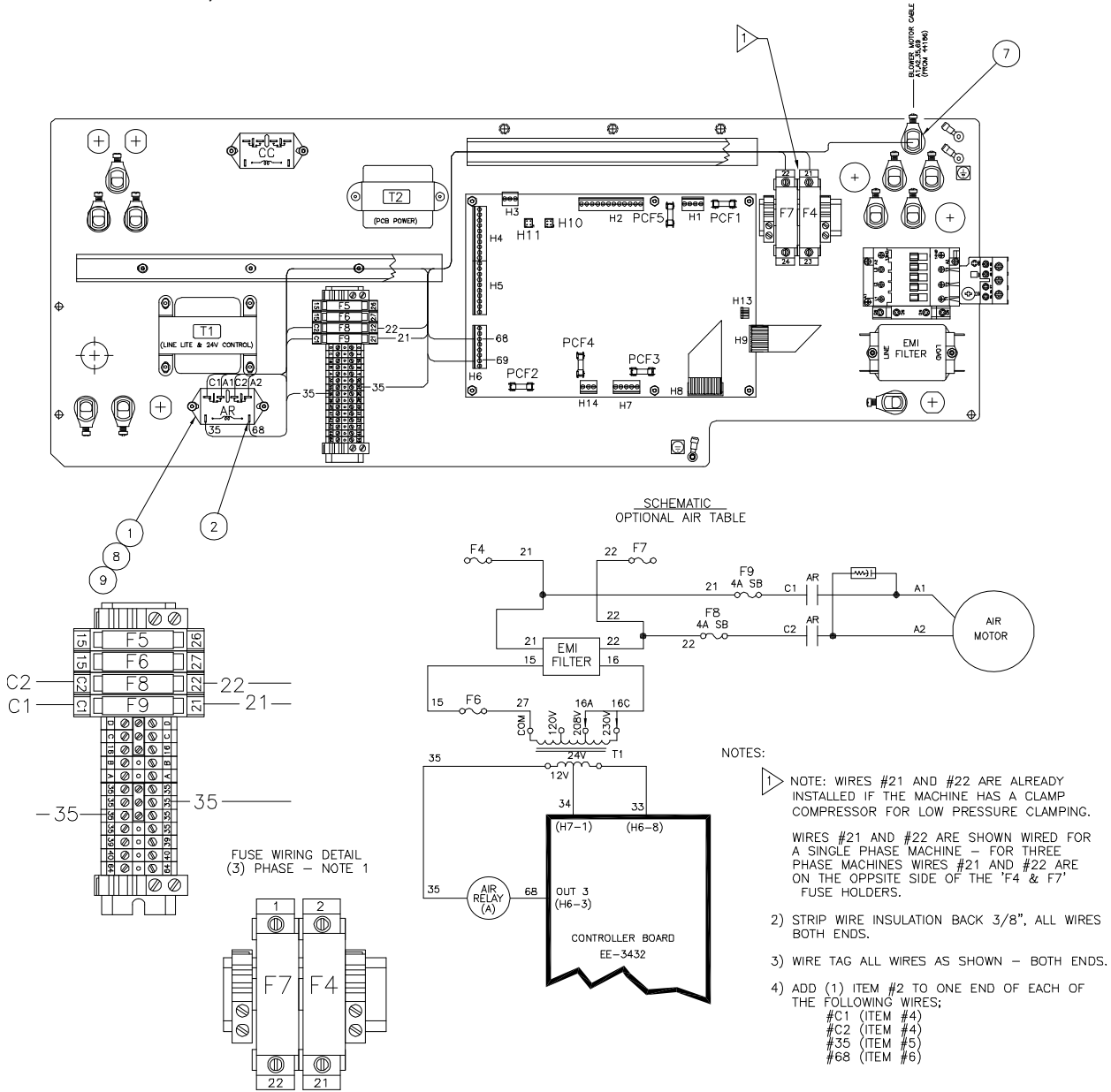
44600 Sheet 9, Rev. A



NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	44165	TABLE - AIR	1
2	44186	BLOWER ASSEMBLY	1
3	P-207-2	AIR JET	36
4	P-211	THREADED FLANGE FITTING - PVC	2
5	P-205-10	INSERT - 90% 176 ELBOW - 3/4 NPT X 3/4 TUBE	2
6	P-210-11	INSERT - 3/4 NPT X 3/4 TUBE	2
7	P-275	3/4" HOSE - REINFORCED PVC	48"
8	S-2015-1	TAPE - ALUMINUM	620"
9	P-463	TEE - 3/4 NPT (PVC)	1
10	H-6405-1212	NIPPLE - 3/4 NPT (STEEL)	1
11	H-6894-610	SCREW - 3/8-16 X 1-1/4 WHIZ LOCK	2
12	H-6910-608	SCREW - 3/8-16 X 1" BUT HD	8
13	H-7327-12	WASHER - 3/8 MEDIUM LOCK	10
14	H-7321-6	WASHER - 3/8 PLAIN	8
15	H-6417-6	NUT - 3/8-16 HEX	2

13.10 Main Assembly – Air Table Option Blower (w/Fuses)

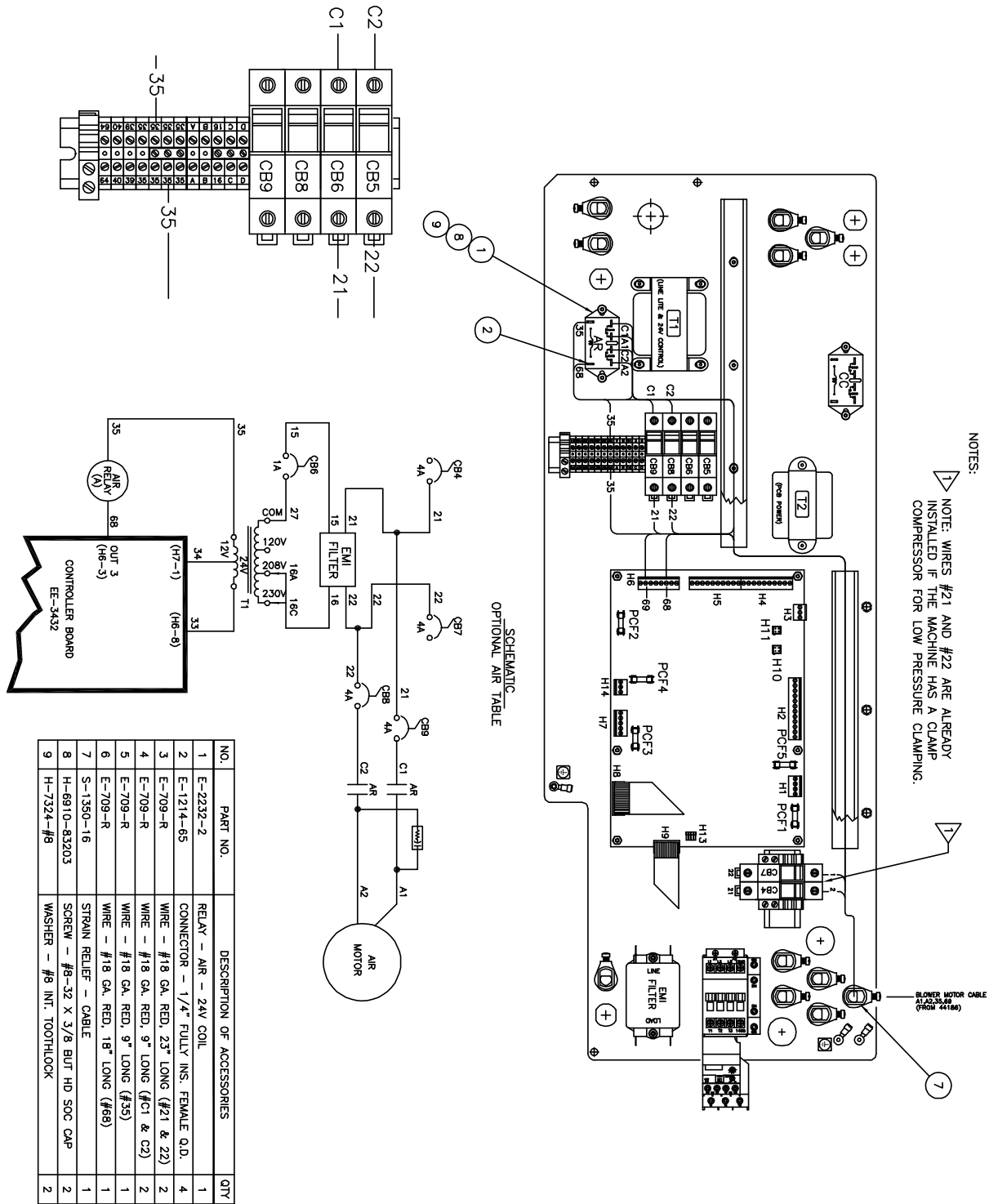
44600 Sheet 10, Rev. A



NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	E-2232-2	RELAY - AIR - 24V COIL	1
2	E-1214-65	CONNECTOR - 1/4" FULLY INS. FEMALE Q.D.	4
3	E-709-R	WIRE - #18 GA. RED, 23" LONG (#21 & 22)	2
4	E-709-R	WIRE - #18 GA. RED, 9" LONG (#C1 & C2)	2
5	E-709-R	WIRE - #18 GA. RED, 9" LONG (#35)	1
6	E-709-R	WIRE - #18 GA. RED, 18" LONG (#68)	1
7	S-1350-16	STRAIN RELIEF - CABLE	1
8	H-6910-83203	SCREW - #8-32 X 3/8 BUT HD SOC CAP	2
9	H-7324-#8	WASHER - #8 INT. TOOTHLOCK	2

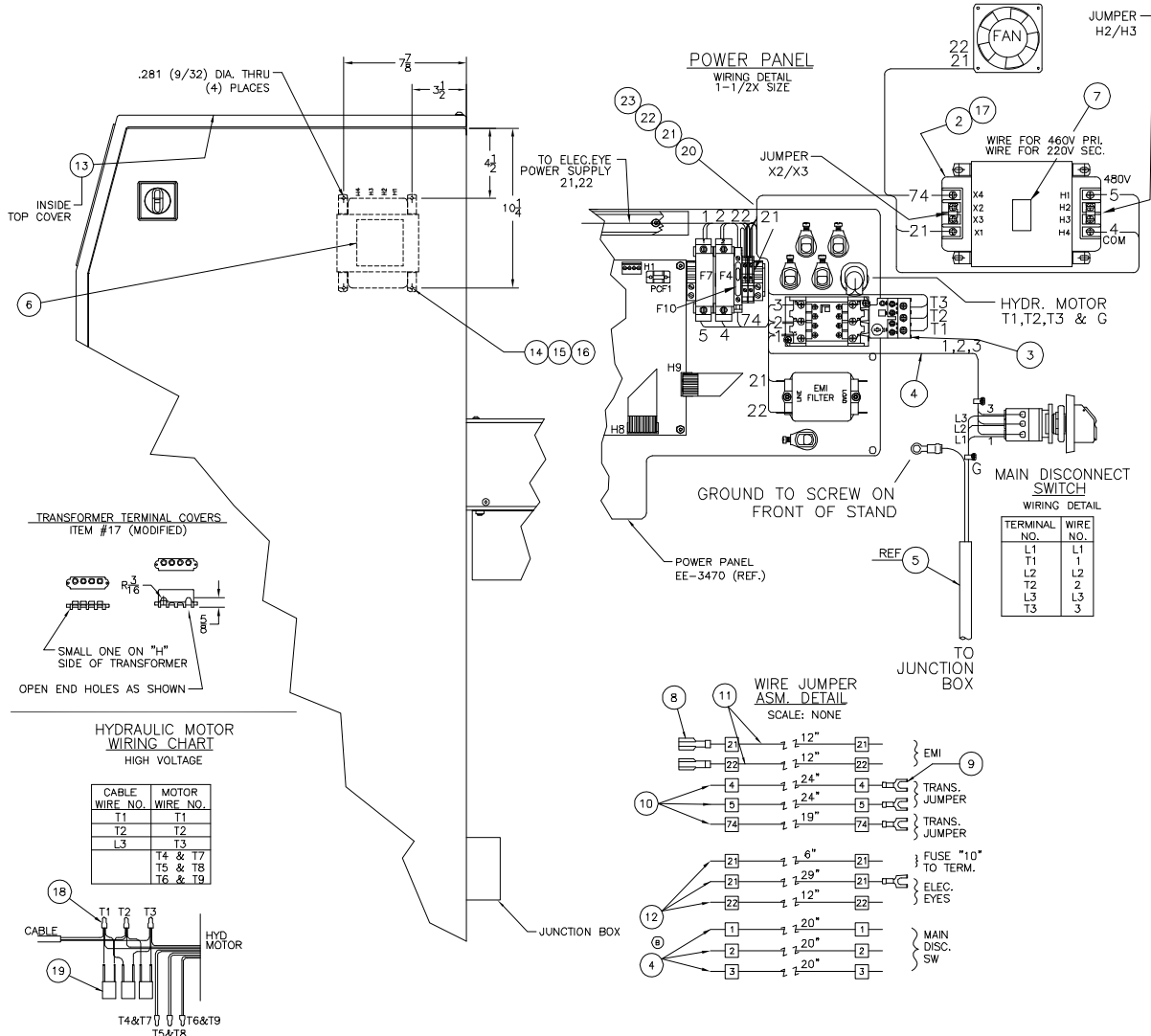
Main Assembly – Air Table Option Blower (w/circuit breakers)

44600 Sheet 10 – Rev. B



13.11 Main Assembly – 460 Volt 3 Phase 60 Hz Option

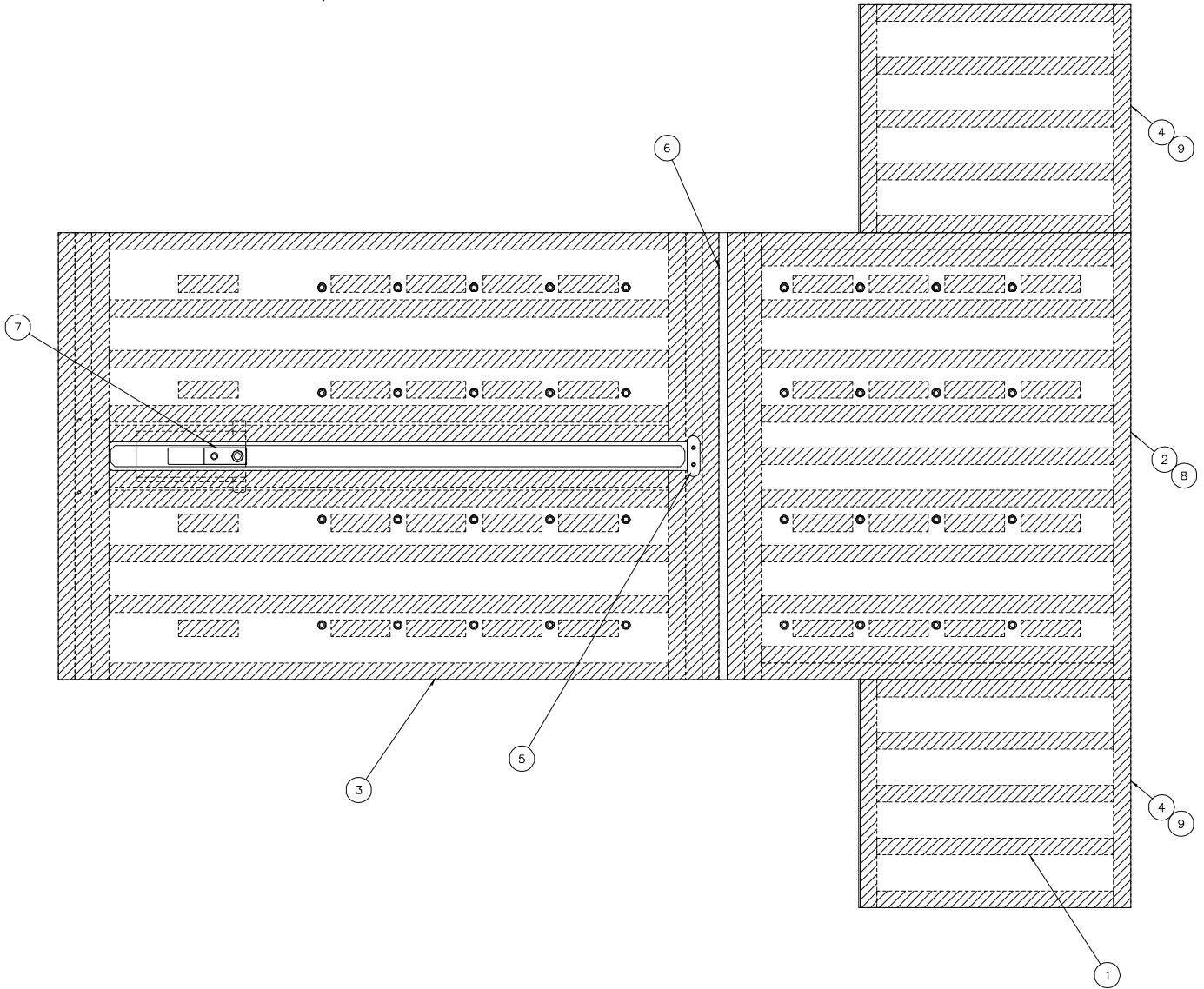
44600 Sheet 11, Rev. A



NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1			
2	E-1089-46	TRANSFORMER - 750VA	1
3	E-2441-13	CONTACTOR - OVERLOAD, 7.5A TO 11A	1
4	E-798-B	WIRE - #12GA. BLACK MTW 20" LONG (1,2,3)	3
5	EE-2865-2	CABLE ASM. - POWER CORD JUMPER, 3PH	REF
6	S-1781-167	LABEL - TRANSFORMER TAP SETTINGS	1
7	E-1584-53	LABEL - TRANSFORMER, "T3"	1
8	E-1214-49	CONNECTOR - 1/4" FULLY INS. Q.D.	2
9	E-1214-1	CONNECTOR - #10 INS. LOCKING FORK	4
10	E-702-R	WIRE - #14 GA. RED MTW 67" TOTAL	1
11	E-849-R	WIRE - #16 GA. RED MTW 29" TOTAL	1
12	E-709-R	WIRE - #18 GA. RED MTW 41" TOTAL	1
13	S-1781-170	LABEL - POWER CONNECTION PROCEDURE	REF
14	H-6910-404	SCREW - 1/4-20 X 1/2 BUT HD CAP	4
15	H-7321-4	WASHER - 1/4 FLAT	4
16	H-6423-4	NUT - 1/4-20 HEX W/LOCKWASHER (KEP)	4
17	E-2974	COVER - TRANSFORMER TERMINALS (MODIFIED)	1
18	E-1237-2	WIRE NUT	6
19	E-1736-2	QUENCHARC	3
20	E-1974-9	FUSE HOLDER - GLASS (1/4 X 1-1/4)(F10)	1
21	E-889-6	FUSE - 5A SLO-BLO GLASS (F10)	1
22	E-2068-9	TERMINAL BLOCK - UK5 RETURN, #10 GA.	2
23	E-1977-10	TERMINAL RAIL - 3-1/2"	1

13.12 Main Assembly – Stainless Steel Table Option

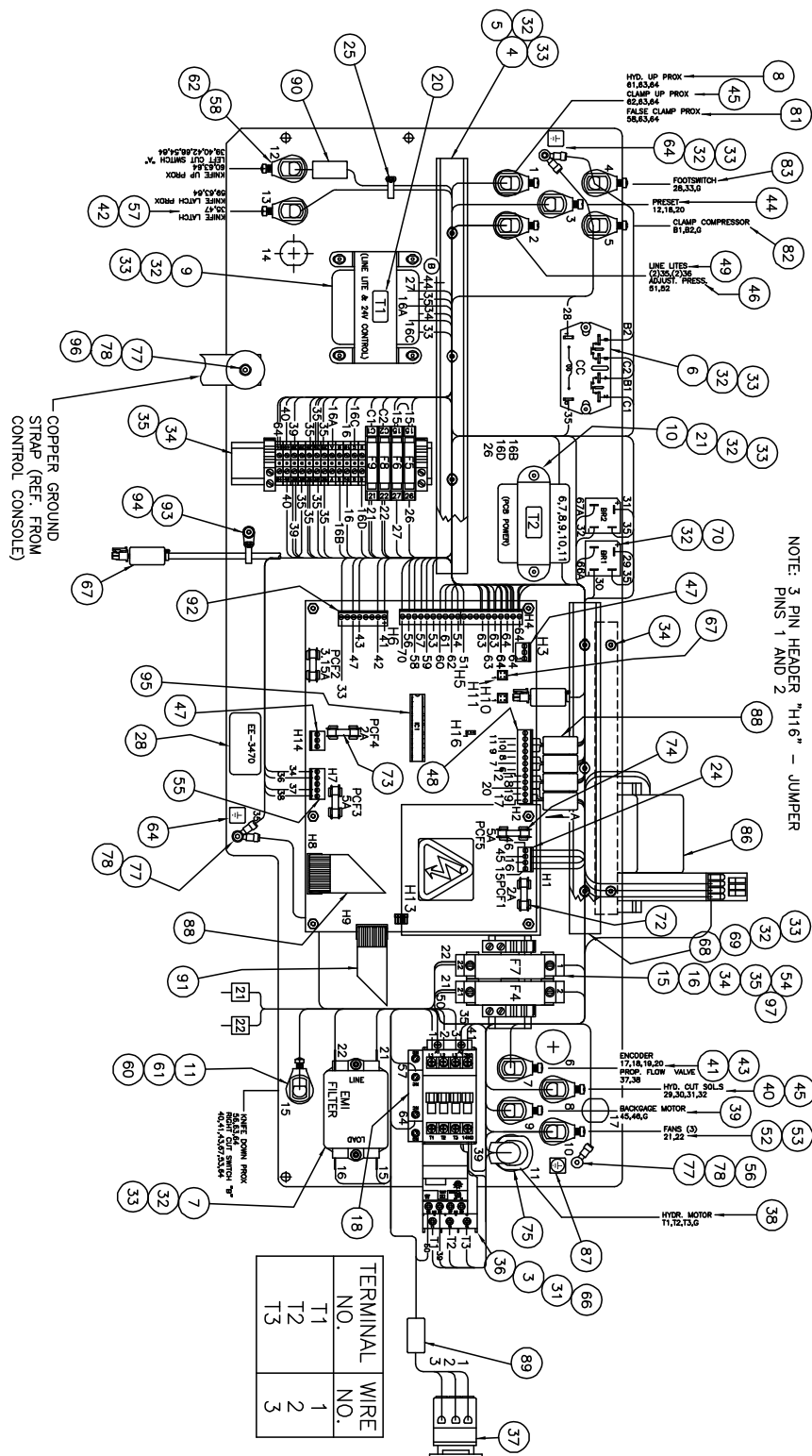
44600 Sheet 12, Rev. A



NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	35222-1	TAPE- ADHESIVE TRANSFER, 1 X .005	89'
2	44198	FRONT TABLE	1
	44205	FRONT TABLE- AIR	
3	44199	REAR TABLE	1
	44204	REAR TABLE- AIR	
4	44200	SIDE TABLE	2
5	44202	BELT CLAMP SHIM	1
6	44201	CUT STICK SHIM	1
7	44203	BACKGAUGE SHIM	1
8	44165-1	AIR TABLE- TITAN 265, NO PAINT	1
	44001-2	TABLE- TITAN 265, NO PAINT	
9	44158-1	SIDE TABLE- TITAN 265, NO PAINT	2

13.13 Electrical Panel Assembly – (w/Fuses)

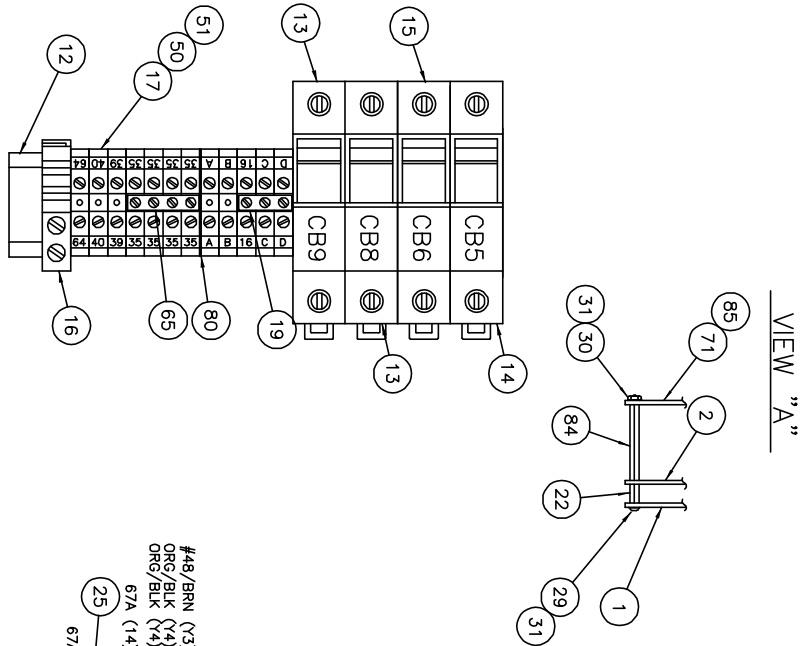
EE-3470, Rev. P



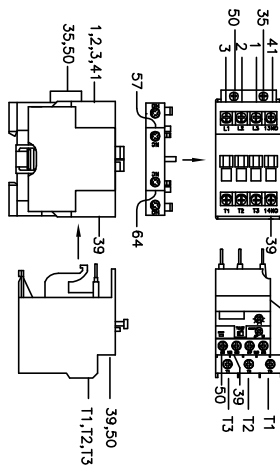
NOTES

Electrical Panel Assembly (cont.)

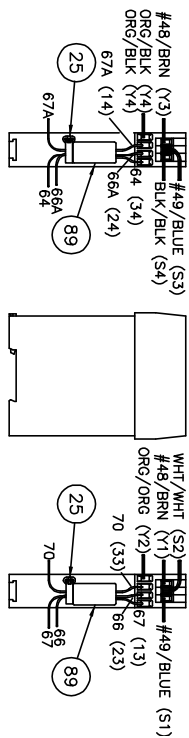
TRANSFORMER COLOR CODE	
T 1	
WIRE COLOR	WIRE NO.
BLACK	27
BLACK/YELLOW	16A
BLACK/RED	16C
WHITE	35
YELLOW	34
RED	33
GREEN	44
T 2	
WIRE COLOR	WIRE NO.
BLACK	26
BLACK/YELLOW	16B
BLACK/RED	16D
BLUE	9
BLUE/YELLOW	10
BLUE	11
RED	8
RED/YELLOW	7
RED	6



WIRING DETAIL
STARTER/OVERLOAD



RELAY WIRE DETAIL
(ITEM #86)



Electrical Panel Assembly (cont.)

NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	43006-2	PANEL - ELECTRICAL	1
2	EE-3432-2	P.C.B. ASSEMBLY - CONTROLLER	1
3	E-2805-6	STARTER - CONTACTOR	1
4	E-1429-14	WIRE DUCT - 13-1/2" LONG	1
5	E-2719-14	COVER - WIRE DUCT, 13-1/2" LONG	1
6	E-2232-2	RELAY - CLAMP COMPRESSOR (CC)	1
7	E-2730-3	FILTER - EMI, PANEL MOUNT	1
8	EE-2770-1	PROXIMITY ASSEMBLY - HYDRUALIC UP	1
9	E-2742-6	TRANSFORMER - 120/208/230V PRIM., "T1"	1
10	E-2742-5	TRANSFORMER - 120/230V PRIM., "T2"	1
11	S-1350-16	STRAIN RELIEF - CABLE	12
12	E-1977-18	RAIL - TERMINAL BLOCK, 6-1/2 LONG	1
13	E-3264-5	CIRCUIT BREAKER - 4A (CB4,7,8,9)	4
14	E-3264	CIRCUIT BREAKER - 1/2A (CB5)	1
15	E-3264-1	CIRCUIT BREAKER - 1A (CB6)	1
16	E-2070-1	END BRACKET - TERMINAL BLOCK	4
17	E-2068-8	TERMINAL BLOCK - THROUGH, #10 GA.	12
18	E-2376-8	CONTACTOR - AUXILIARY (SIDE MOUNT)	1
19	E-2507-3	FIXED BRIDGE - TERMINAL BLOCK - 3 POLE	2
20	E-1584-51	LABEL - TRANSFORMER, "T1"	1
21	E-1584-52	LABEL - TRANSFORMER, "T2"	1
22	E-1152-56	STAND-OFF - 1/2" LONG, #6-32 THR'D	6
23	E-2066-10	CONNECTOR - PLUG IN PCB TERMINAL BLOCK	2
24	E-2066-4	CONNECTOR - PLUG IN PCB TERMINAL BLOCK	1
25	S-1694	CABLE TIE	7
26	S-1694-2	CABLE TIE - SCREW MOUNT	1
27	EE-1888-24	IC CHIP - PROGRAMMED (USES E-2056-13)	REF
28	E-1584-()	LABEL - PART NUMBER/ REVISION LEVEL	1
29	H-6910-63203	SCREW - #6-32 X 3/8" BUT HD	6
30	H-6423-#6	NUT - #6-32 HEX	6
31	H-7324-#6	WASHER - #6 INT. TOOTHLOCK	14
32	H-6910-83204	SCREW - #8-32 X 1/2" BUT	18
33	H-7324-#8	WASHER - #8 INT. TOOTHLOCK	16
34	H-6910-102403	SCREW - #10-24 X 3/8" BUT HD	6
35	H-7324-#10	WASHER - #10 INT. TOOTHLOCK	4

Electrical Panel Assembly (cont.)

NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
36	E-2441-18	OVERLOAD - CONTACTOR, 13A TO 19A	1
37	E-3082	SWITCH BODY - MAIN DISCONNECT	1
38	EE-2858-1	CABLE ASSEMBLY - HYDRAULIC MOTOR	REF
39	EE-2768	CABLE ASSEMBLY - BACKGAGE MOTOR	1
40	EE-2769-10	CABLE ASSEMBLY - CUT SOLENOID "A"	1
41	EE-2534-1	CABLE ASSEMBLY - ENCODER	1
42	EE-2775-1	CABLE ASSEMBLY - KNIFE LATCH	1
43	EE-2769-21	CABLE ASSEMBLY - PROP. FLOW CONTL VALVE	1
44	EE-1688-1	CABLE ASSEMBLY - PRESET	1
45	EE-2769-11	CABLE ASSEMBLY - CUT SOLENOID "B"	1
46	EE-2769-3	CABLE ASSEMBLY - ADJUST. PRESS. SOL.	1
47	E-2066-3	CONNECTOR - PLUG IN TERM. 3 POLE	2
48	E-2066-12	CONNECTOR - PLUG-IN PCB TERM. BLOCK	1
49	EE-3060	WIRE ASSEMBLIES - CUT LIST	1
50	E-1356-133	LABEL - TERMINAL BLOCK	1
51	E-1356-134	LABEL - TERMINAL BLOCK	1
52	EE-2961-24	CABLE ASSEMBLY - FAN	1
53	EE-2961-23	CABLE ASSEMBLY - FILTER/MANIFOLD FANS	1
54	E-1977-3	RAIL - TERMINAL BLOCK, 3" LONG	1
55	E-2066-5	CONNECTOR - PLUG IN PCB TERM. 5 POLE	1
56	E-1214-64	CONNECTOR -1/4" NON-INS RING	1
57	EE-2770-5	PROXIMITY SWITCH ASSEMBLY - KNIFE LATCH	1
58	EE-2770-4	PROXIMITY SWITCH ASSEMBLY - KNIFE UP	1
59	EE-2770-2	PROXIMITY SWITCH ASSEMBLY - CLAMP UP	1
60	EE-2770-3	PROXIMITY SWITCH ASSEMBLY - KNIFE DOWN	1
61	EE-3384	SWITCH ASSEMBLY - CUT BUTTON "B" (RH)	1
62	EE-3385	SWITCH ASSEMBLY - CUT BUTTON "A" (LH)	1
63	E-2066-8	CONNECTOR - PLUG-IN PCB TERM. BLOCK	2
64	S-1781-42	LABEL - GROUND SYMBOL, SECONDARY	2
65	E-2507-4	FIXED BRIDGE - TERMINAL BLOCK, 4 POLE	1
66	EE-2855-16	RIBBON CABLE ASM. - 14 PIN	REF
67	EE-3460-1	CABLE ASM. - CAN 'PLUG', TITAN 265	1
68	E-1429-15	WIRE DUCT - 10-3/4" LONG	1
69	E-2719-15	COVER - WIRE DUCT, 10-3/4" LONG	1

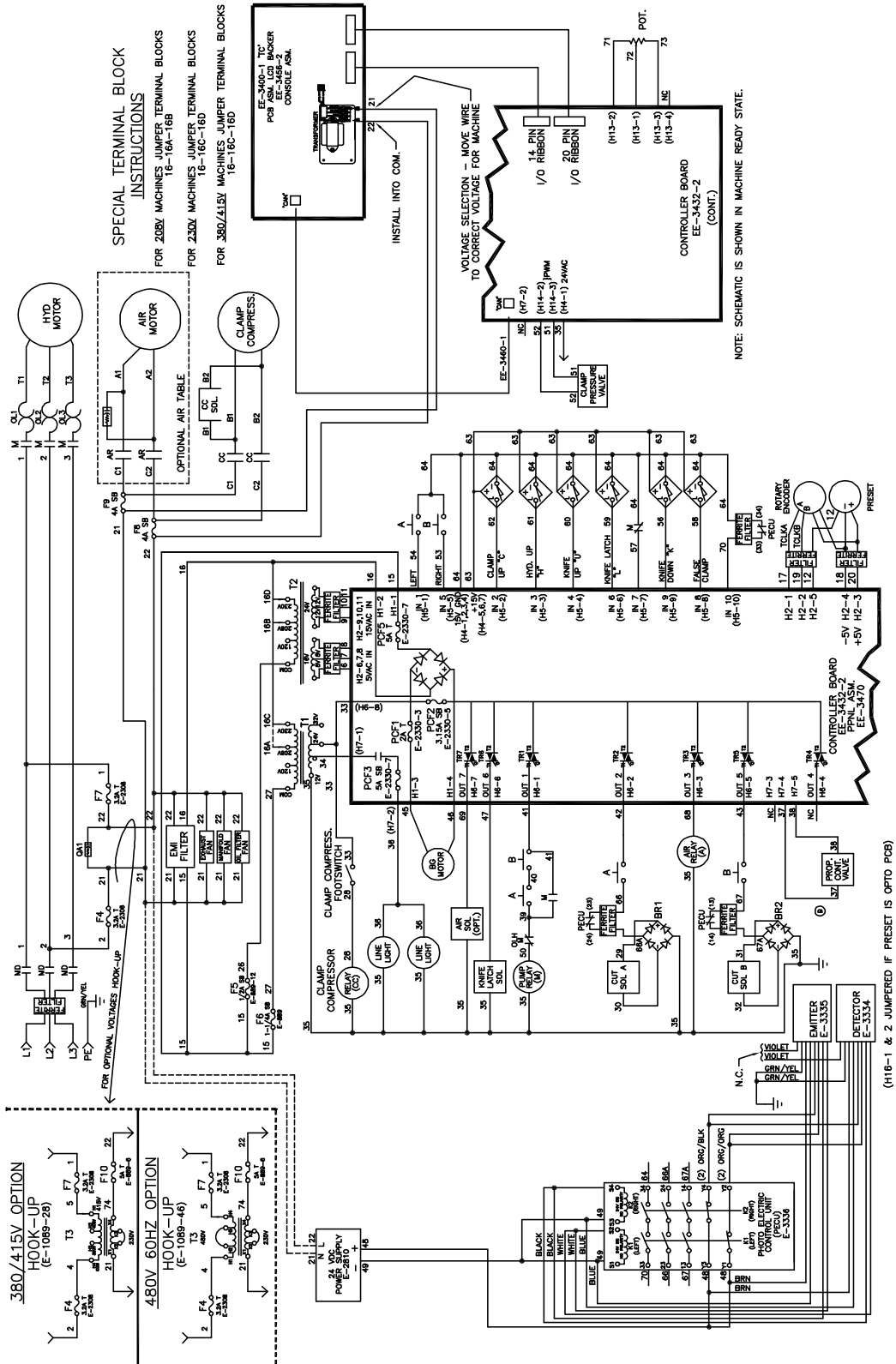
Electrical Panel Assembly (cont.)

NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
71	47157-7	P.C.B. COVER - CLEAR	1
72	E-2330-3	FUSE - 2A SB, GLASS METRIC (PCF1& PCF4)	2
73	E-2756-3	FILTER - FERRITE CORE	7
74	E-2756-6	FILTER - FERRITE CORE	2
75	S-1350-5	CLAMP - CORD GRIP	1
76	E-1453-6	SHRINK TUBING - 1/8" DIA., 1" LONG	2
77	H-6910-404	SCREW - 1/4-20 X 1/2 BUT HD CAP	3
78	H-7324-8	WASHER - 1/4" INT. TOOTHLOCK	3
79			
80	E-2864	SEPARATOR PLATE - TERMINAL BLOCK	1
81	EE-2770-6	PROX. ASM. - FLASE CLAMP	1
82	EE-3219	CABLE ASSEMBLY - CLAMP COMPRESSOR POW.	REF
83	EE-3220	CABLE ASSEMBLY - FOOT SWITCH, AIR CLAMP	REF
84	E-1152-43	STAND-OFF - 2" LONG HEX	2
85	S-1781-35	LABEL - CAUTION, ELECTRICAL SHOCK	1
86	EE-3363	KIT - ELECTRIC EYE SUB-ASM.	1
87	S-1781-197	LABEL - GROUND SYMBOL, PRIMARY	1
88	EE-2855-15	RIBBON CABLE ASSEMBLY - 20 PIN	REF
89	H-6910-63205	SCREW - #6-32X5/8 BUT HD CAP	2
90	H-6910-83204	SCREW - #8-32X1/2 BUT HD CAP	1
91	H-6993-510	WASHER - 5/16 X 1-1/4 FENDER	1

NOTES

13.15 Basic Machine Schematic – Standard Cut Buttons w/fuses

E-3473, Rev. C



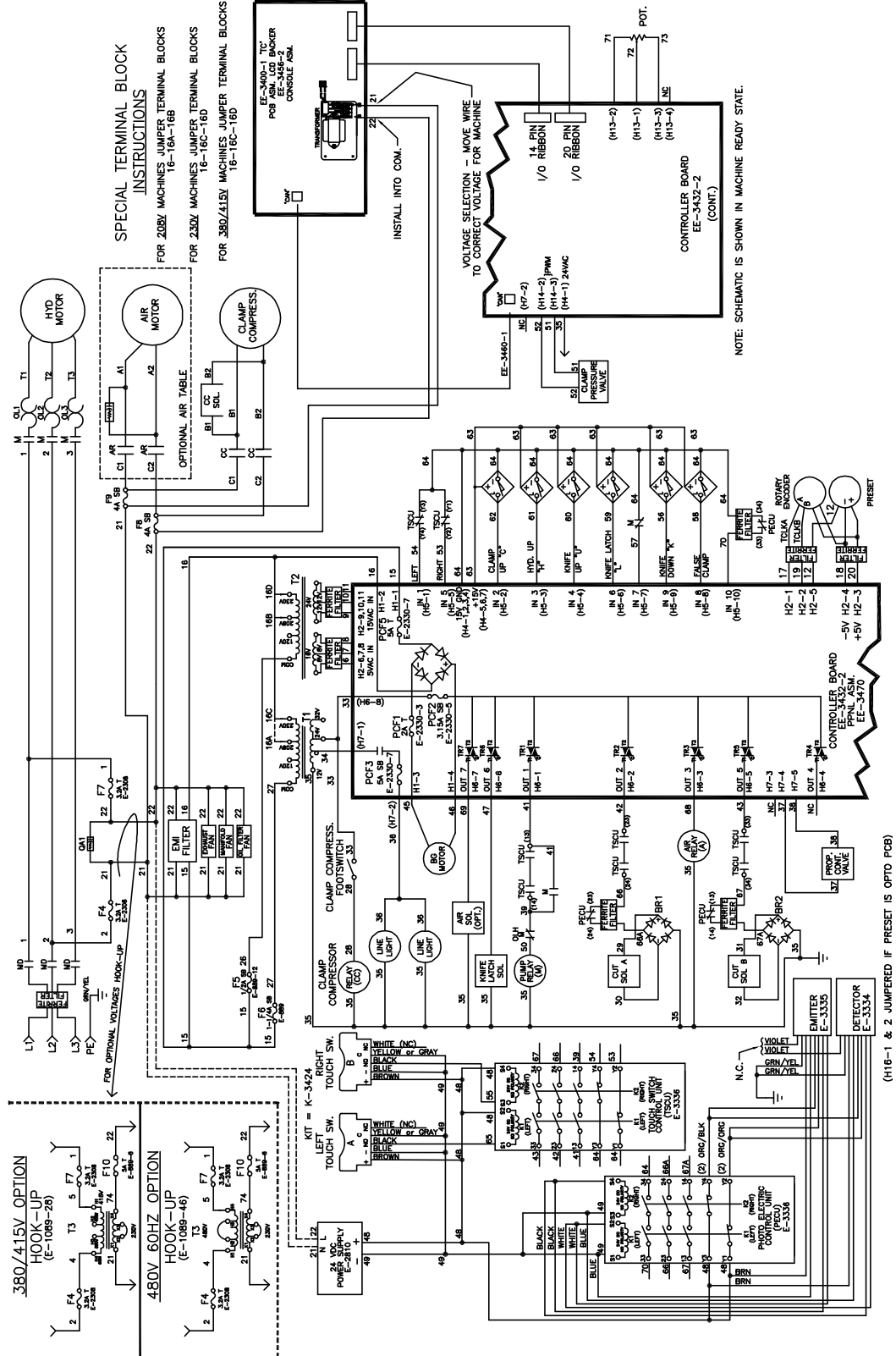
(H1B-1 & 2 JUMPERED IF PRESET IS OPTO PCB)

SPECIAL TERMINAL BLOCK INSTRUCTIONS
 FOR 200V MACHINES JUMPER TERMINAL BLOCKS 16-16A-16B
 FOR 230V MACHINES JUMPER TERMINAL BLOCKS 16-16C-16D
 FOR 380/415V MACHINES JUMPER TERMINAL BLOCKS 16-16C-16D

NOTE: SCHEMATIC IS SHOWN IN MACHINE READY STATE.

13.16 Basic Machine Schematic – Ergo Cut Buttons w/fuses

E-3473, Rev. C



13.19 Electrical Sequence of Operation

NOTE: Please see the section on Hydraulic Sequence of Operation for more details.

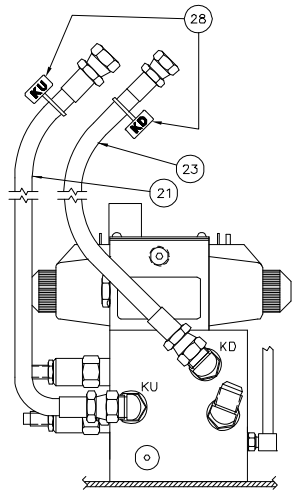
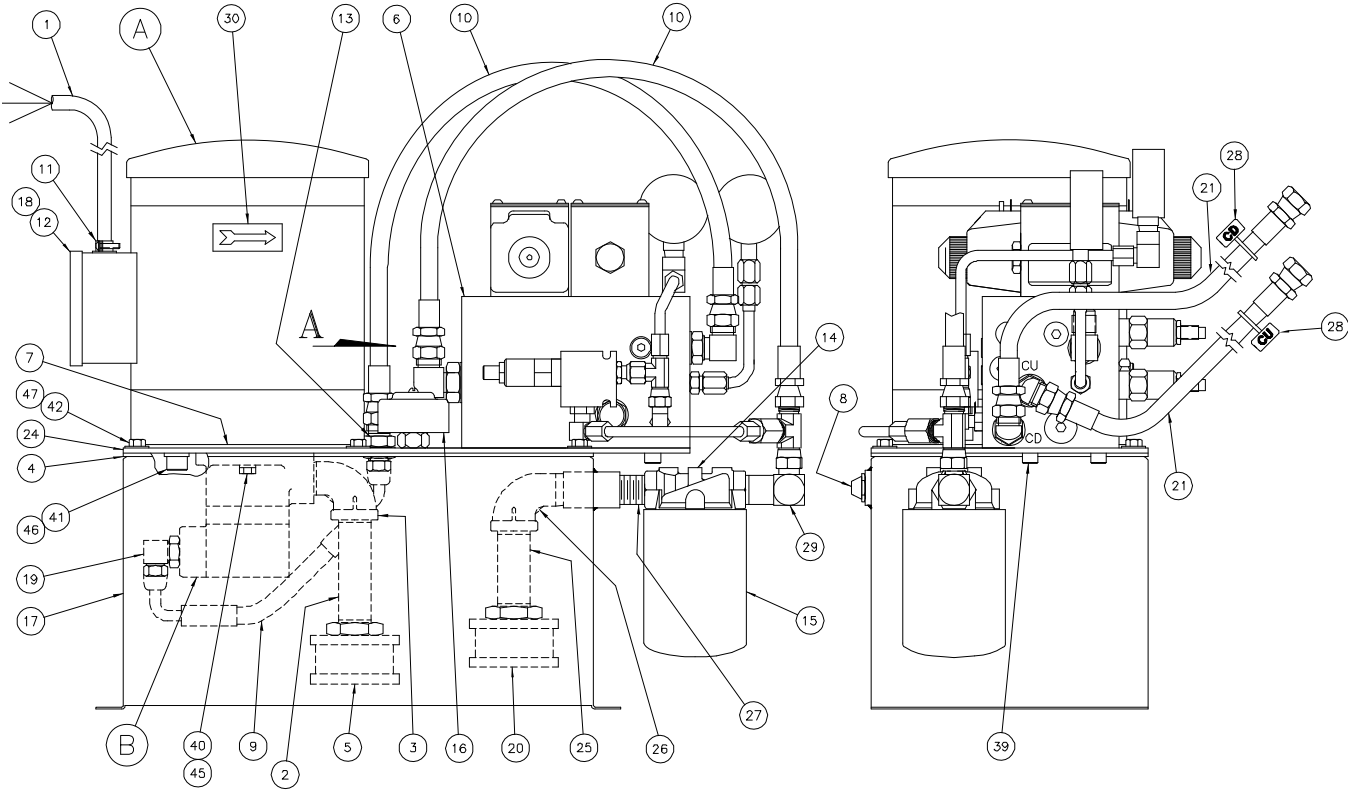
Electrical Sequence of Operation	Electrical Schematic References: Section 13.15 page 76
A. Turn Main Disconnect switch to “on” position.	If fuses F4 and F7 or CB4 and CB7 are conductive, power is brought to the main control board. The line lights will illuminate. Power is also brought to the circuit board. Fuse PCF1 and PCF3 are located on the main control board in the power panel. If fuse PCF3 is conductive, power will be supplied to the logic on the board. If the logic is functioning, the operator’s console display will function. If fuse PCF1 and PCF5 are conductive, power will be supplied for backgauge movement.
B. Press PRESET on the screen to direct the backgauge forward through the presetter.	To coordinate the console display with the actual backgauge position, the backgauge must be brought forward through the presetter. When the backgauge position reaches approximately 3.75 inches, the presetter, located beneath the table, is actuated. The display will then count up and down from this point as signals are received from the incremental encoder. For general backgauge information see C below.
C. Backgauge control via front hand knob.	The backgauge control knob on the front of the table is used to manually control the backgauge position. The speed of the backgauge motor will depend upon how far the knob is turned.
D. Make a cut by pressing the cut buttons.	When the CUT buttons are pressed, the hydraulic motor relay (PUMP RELAY) will energize, and power will be brought to the hydraulic motor. The KNIFE LATCH solenoid will energize and the knife latch will pull in. CUT solenoid A, B, and unload valve will energize, and the machine will make a cut. When the knife reaches the down position, the KNIFE DOWN prox (IN 9) will open, which after a slight time delay, causes the logic to de-energize the CUT solenoids, bringing the knife and clamp to the up position. When the clamp reaches the up position, the HYD UP prox. (IN 3) will close, which causes the logic to de-energize the unload valve. The hydraulic motor will stop after a preset idle time.

NOTES

13.20 Hydraulic Power Unit Assembly

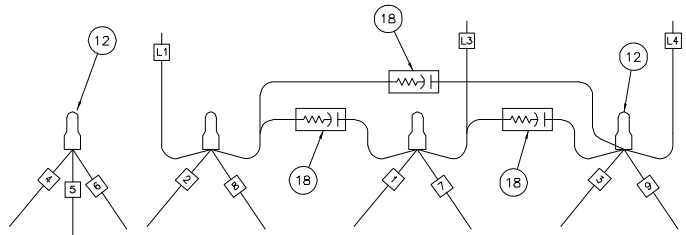
H-571-(), Rev. C (S/N 161106 and below)

PART NO.	VOLTAGE OPTION	A (MOTOR)	B (PUMP)
H-571-2	380-415 V. 3PH. 50 HZ.	E-1600-183	H-387-1
H-571-3	208-230V. 3PH. 60 HZ.	E-1600-181	H-387



VIEW "A"
FULL SCALE

MOTOR WIRING DETAIL
(230V 3PH WIRING SHOWN)



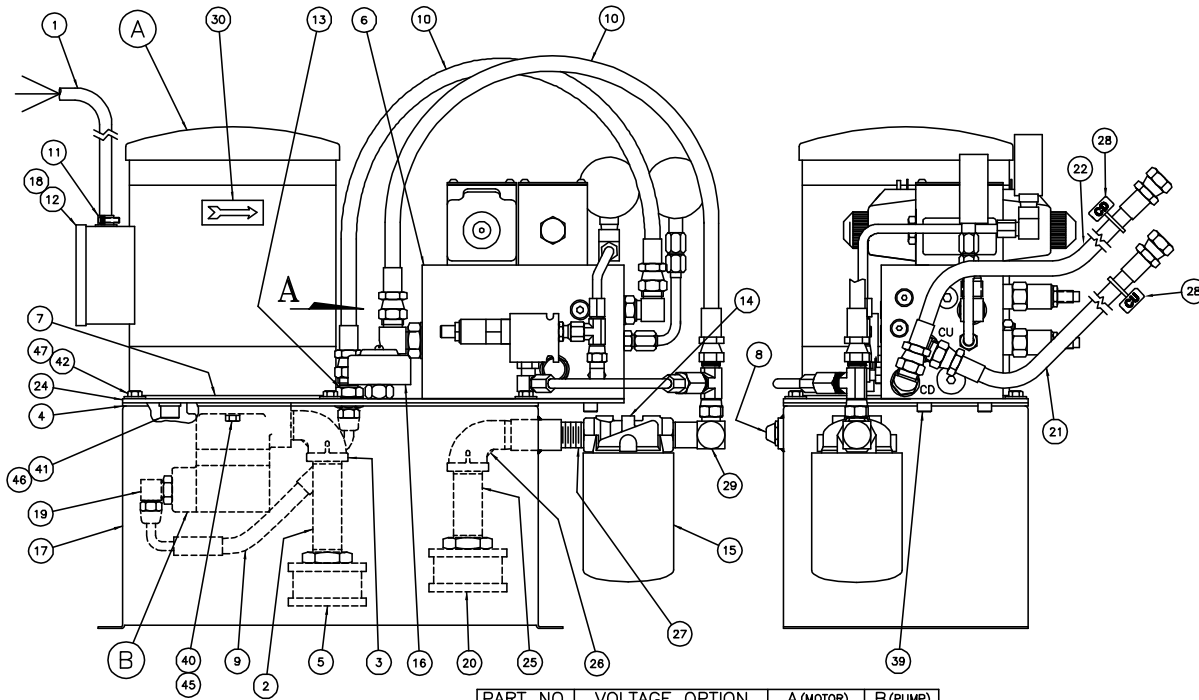
MOTOR WIRES

H-571-() Parts List

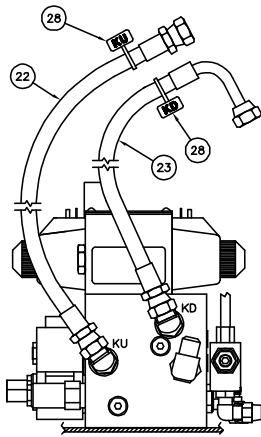
NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	EE-2858-1	CABLE ASM. - HYD. MOTOR	1
2	H-6405-1640	NIPPLE - 1" X 5" PIPE	1
3	H-248-2	ELBOW - 1" X 90%%D STREET	1
4	13947	GASKET - TANK COVER	1
5	H-238-4	STRAINER - OIL	1
6	H-562-1	MANIFOLD ASM.	1
7	13946	GASKET - MOTOR	1
8	H-281-2	SIGHT GAGE	REF
9	H-242-77	HOSE	1
10	H-242-76	HOSE - 28"	2
11	E-894-1	CORD CLAMP	1
12	E-1237-2	WIRE NUT	4
13	H-441	BULKHEAD UNION FITTING 3/4 T. TO 3/4 T.	1
14	H-226-2	HEAD - FILTER, 'O'-RING PORTED	1
15	H-227-1	FILTER	1
16	H-287-2	BREATHER	1
17	44104	TANK	1
18	E-1736-2	QUENCH ARC (3PH 60HZ ONLY)	3
	E-1736-2	QUENCH ARC (1PH ONLY)	1
19	H-230-4	ELBOW - 90° "O" RING TO TUBE	REF
20	H-338	DIFFUSER	1
21	H-242-73	HOSE - 32" CU, CD, & KU	3
22			
23	H-242-75	HOSE - 23-3/4" KD	1
24	44105-1	COVER ASSEMBLY	1
25	H-6405-1232	NIPPLE - 3/4" X 4" PIPE	1
26	H-248-1	ELBOW - 3/4" X 90° STREET	1
27	H-434-1	ADAPTER - STRAIGHT MALE, 'O'-RING TO 'O'-RING	1
28	S-1694-5	TYRAP - ID	4
29	H-230-12	ELBOW - 90° 3/4 T. X 1-1/16 'O' RING	1
30	S-1106	LABEL - DIRECTIONAL ARROW	1
39	H-6918-606	SCREW - 3/8-16 X 3/4 SOC HD. CAP	2
40	H-6913-608	SCREW - 3/8-16 X 1" HEX HD. CAP	2
41	H-6918-808	SCREW - 1/2-13 X 1" SOC. HD. CAP	4
42	H-6913-508	SCREW - 5/16-18 X 1" HEX HD CAP	6
43			
44			
45	H-7327-12	WASHER - 3/8 MED. LOCK	2
46	H-7327-16	WASHER - 1/2 MED. LOCK	4
47	H-7321-5	WASHER - 5/16 PLAIN	6

13.21 Hydraulic Power Unit Assembly

H-571-(), Rev. E (S/N 161107 and up)

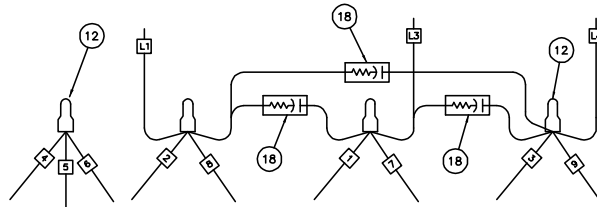


PART NO.	VOLTAGE OPTION	A (MOTOR)	B (PUMP)
H-571-2	380-415 V. 3PH. 50 HZ.	E-1600-183	H-387-1
H-571-3	208-230V. 3PH. 60 HZ.	E-1600-181	H-387



VIEW "A"
FULL SCALE

MOTOR WIRING DETAIL
(230V 3PH WIRING SHOWN)



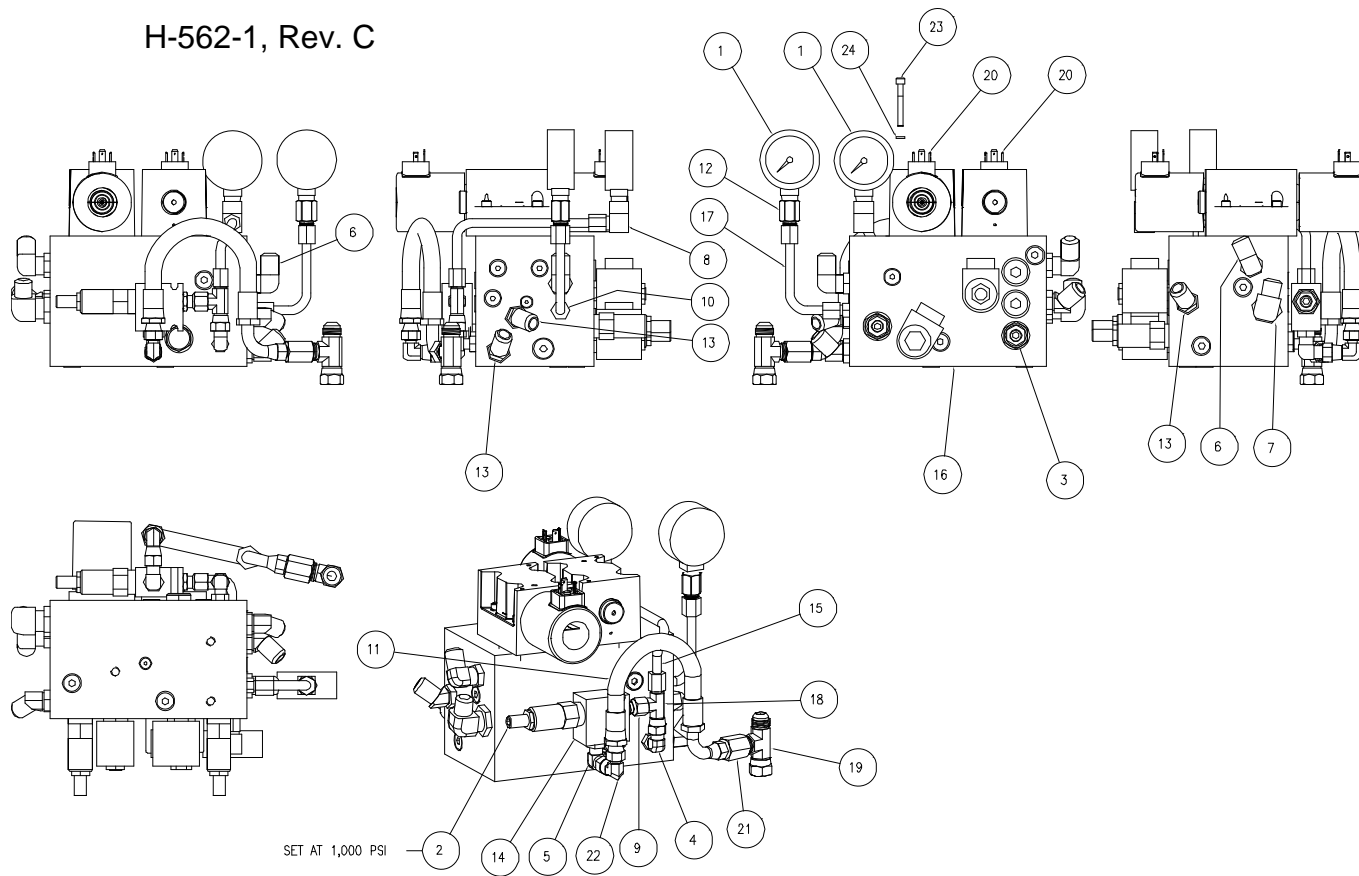
MOTOR WIRES

H-571-() Parts List

NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	EE-2858-1	CABLE ASM. - HYD. MOTOR	1
2	H-6405-1640	NIPPLE - 1" X 5" PIPE	1
3	H-248-2	ELBOW - 1" X 90%%D STREET	1
4	13947	GASKET - TANK COVER	1
5	H-238-4	STRAINER - OIL	1
6	H-562-1	MANIFOLD ASM.	1
7	13946	GASKET - MOTOR	1
8	H-281-2	SIGHT GAGE	REF
9	H-242-77	HOSE	1
10	H-242-76	HOSE - 28"	2
11	E-894-1	CORD CLAMP	1
12	E-1237-2	WIRE NUT	4
13	H-441	BULKHEAD UNION FITTING 3/4 T. TO 3/4 T.	1
14	H-226-2	HEAD - FILTER, 'O'-RING PORTED	1
15	H-227-1	FILTER	1
16	H-287-2	BREATHER	1
17	44104	TANK	1
18	E-1736-2	QUENCH ARC (3PH 60HZ ONLY)	3
	E-1736-2	QUENCH ARC (1PH ONLY)	1
19	H-230-4	ELBOW - 90° "O" RING TO TUBE	REF
20	H-338	DIFFUSER	1
21	H-242-73	HOSE - 32" CU	1
22	H-242-86	HOSE - 33" KU & CD	2
23	H-242-94	HOSE - 32" W/LONG 90 DEGREE - KD	1
24	44105-1	COVER ASSEMBLY	1
25	H-6405-1232	NIPPLE - 3/4" X 4" PIPE	1
26	H-248-1	ELBOW - 3/4" X 90° STREET	1
27	H-434-1	ADAPTER - STRAIGHT MALE, 'O'-RING TO 'O'-RING	1
28	S-1694-5	TYRAP - ID	4
29	H-230-12	ELBOW - 90° 3/4 T. X 1-1/16 'O' RING	1
30	S-1106	LABEL - DIRECTIONAL ARROW	1
39	H-6918-606	SCREW - 3/8-16 X 3/4 SOC HD. CAP	2
40	H-6913-608	SCREW - 3/8-16 X 1" HEX HD. CAP	2
41	H-6918-808	SCREW - 1/2-13 X 1" SOC. HD. CAP	4
42	H-6913-508	SCREW - 5/16-18 X 1" HEX HD CAP	6
43			
44			
45	H-7327-12	WASHER - 3/8 MED. LOCK	2
46	H-7327-16	WASHER - 1/2 MED. LOCK	4
47	H-7321-5	WASHER - 5/16 PLAIN	6

13.22 Hydraulic Manifold Assembly

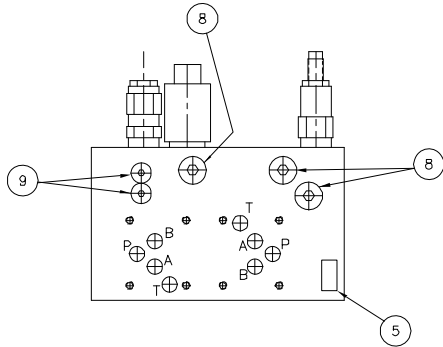
H-562-1, Rev. C



NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	8P-629-3	GAUGE	2
2	H-203-26	RELIEF VALVE	1
3	H-203-43	RELIEF VALVE	1
4	H-230	ELBOW- ORING TO TUBE	1
5	H-230-3	ELBOW- ORING TO TUBE	1
6	H-230-4	ELBOW- ORING TO TUBE	2
7	H-230-8	ELBOW- ORING TO TUBE	1
8	H-231-2	ELBOW- PIPE (EXT) TO TUBE	1
9	H-236-10	ADAPTER - 'O' RING TO TUBE	1
10	H-236-5	ADAPTER - 'O' RING TO TUBE	1
11	H-242-85	HYDRAULIC HOSE - 13"	1
12	H-253-2	ADAPTER - PIPE (INT) TO TUBE FLANGE	1
13	H-272-3	ELBOW- 45 DEG O-RING TO TUBE	3
14	H-298-3	VALVE BODY	1
15	H-425-3	TUBE ASSEMBLY	1
16	H-468-3	MANIFOLD	1
17	H-518	TUBE	1
18	H-553	TEE - SWIVEL RUN - TUBE	1
19	H-553-1	TEE - SWIVEL RUN - TUBE	1
20	H-557	DIRECTIONAL CONTROL VALVE	2
21	H-570	SWIVEL TO TUBE REDUCER	1
22	H-572	ELBOW - SWIVEL TUBE	1
23	H-6918-414	SCREW - 1/4-20 X 1-3/4 SOCKET HEAD CAP	8
24	H-7329-4	WASHER - 1/4 HIGH COLLAR LOCK	8

13.23 Hydraulic Manifold

H-468-3, Rev. C



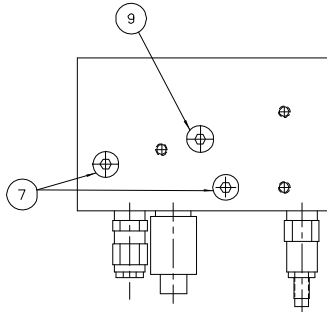
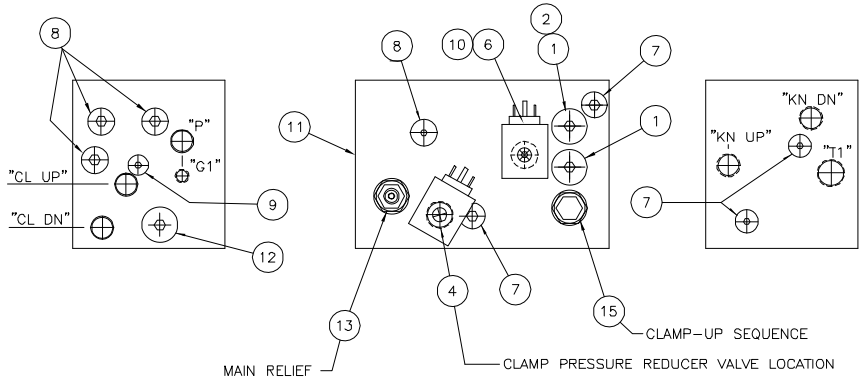
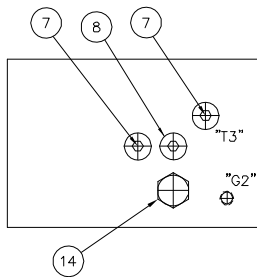
REPAIR NOTES:

'O' RING REPLACEMENT KIT - PART NUMBER H-504-SK

PLUG REPLACEMENT KIT- PART NUMBER H-504-PK

'O' RING REPLACEMENT KIT FOR PLUGS PART NUMBER H-504-PSK

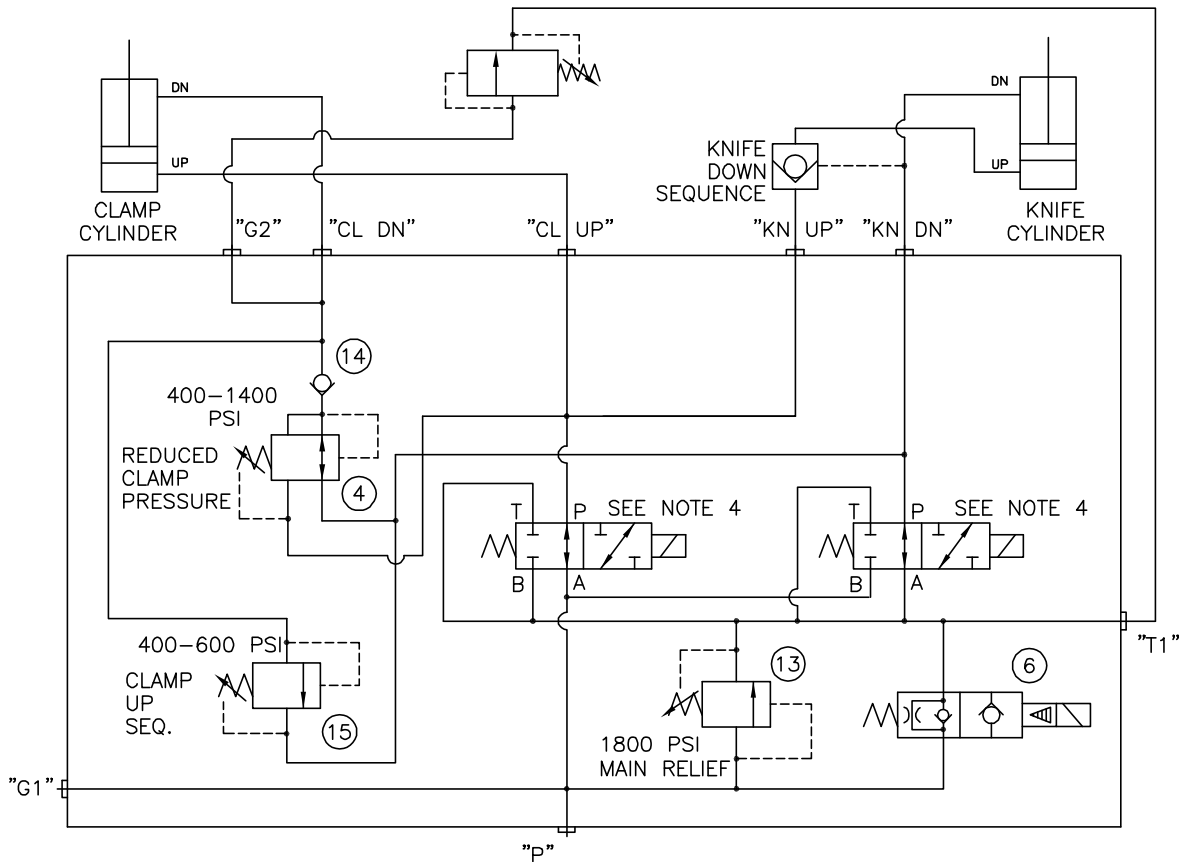
TIGHTEN PLUGS TO TORQUES SPECIFIED IN PARTS LIST



NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	H-427-4	PLUG - SAE	2
2	H-427	PLUG - SAE	1
3			
4	H-203-41	PRES. RED. VALVE- ELECTRICAL (TC)	1
5	N/P	NAMEPLATE	1
6	E-1069-26	COIL (24 VAC)	1
7	H-427-5	SAE PLUG (220 IN-LB TORQUE)	8
8	H-427-2	SAE PLUG (180 IN-LB TORQUE) SAE PLUG	9
9	H-427	SAE PLUG (35 IN-LB TORQUE) SAE PLUG	4
10	H-563	PROPORTIONAL FLOW VALVE	1
11	N/P	VALVE MANIFOLD	1
12	H-427-3	SAE PLUG (550 IN-LB TORQUE)	2
13	H-203-26	RELIEF VALVE	1
14	H-203-38	CHECK VALVE - 10 PSI	1
15	H-203-43	RELIEF VALVE	1

13.24 Hydraulic Schematic

H-468-3, Rev. C



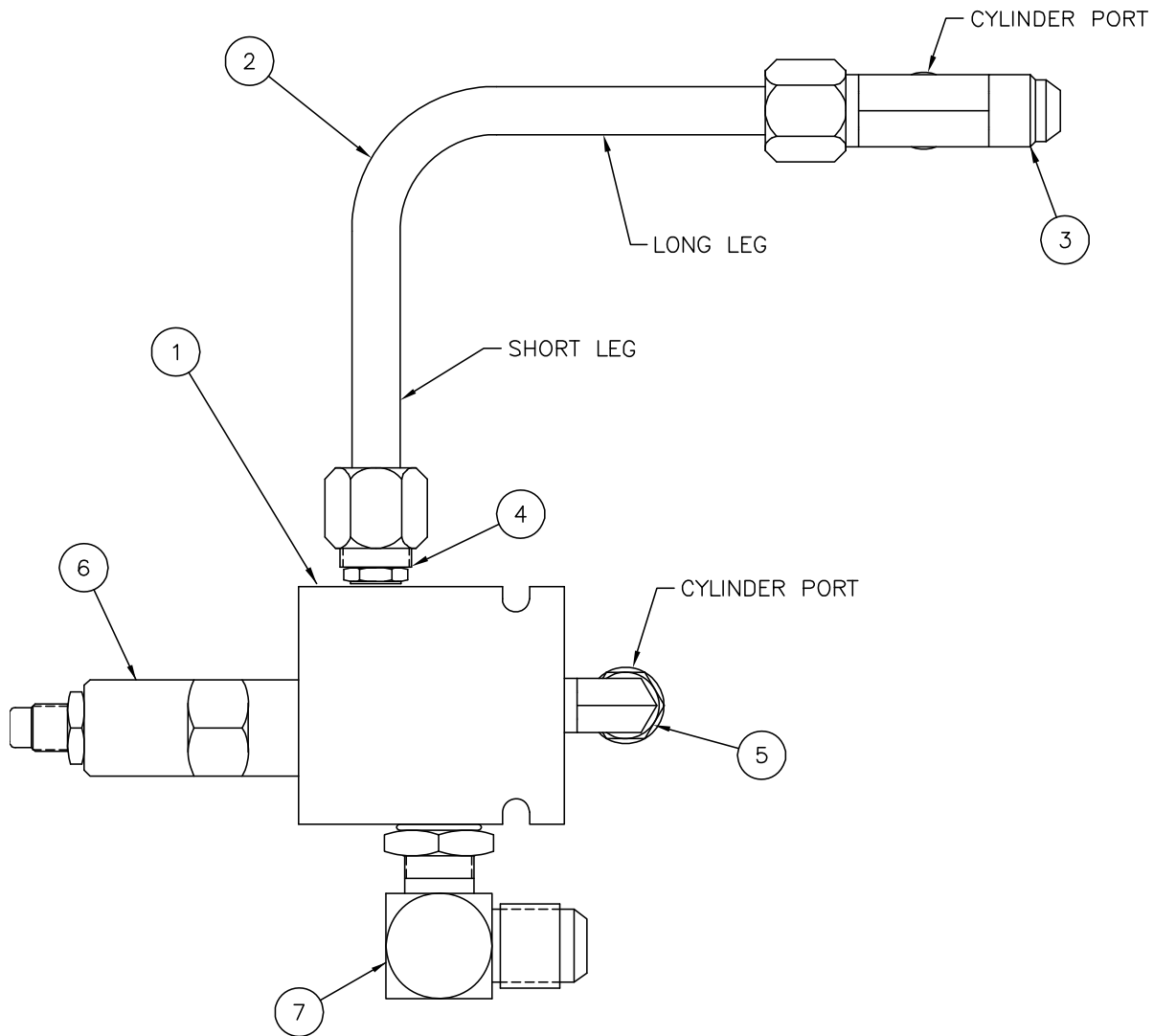
13.25 Hydraulic Sequence of Operation

NOTE: Please see the section on electrical sequence of operation for more details.

Hydraulic Sequence of Operation	Hydraulic Schematic References: Section 13.24 page 89
A. Dump solenoid de-energized (open) while outside cut cycle. (Motor and pump run continuously.)	The hydraulic motor drives the pump continuously. When the cut cycle is initiated, the dump solenoid energizes (closes), and the knife latch is retracted.
B. Energize two CUT solenoids. (Knife and Clamp are sent down.)	When the CUT solenoids are energized, oil will flow freely to the knife down (KD) cylinder port and through the pressure reducing valve to the clamp down cylinder port (CD). Both CUT solenoids must energize to continue the sequence. Since oil is restricted by the knife sequence valve and blocked by a check valve, the knife will stay up, and the clamp will start down. When the clamp stops downward motion, the system pressure will rise. Pressure in the clamp down line will level off to the setting of the pressure reducing valve. The system pressure will continue to rise until the knife sequence pressure valve opens allowing the knife to come down. The knife will continue down until the cylinder reaches the extreme of its travel. System pressure will increase until the main system relief valve trips. At this time, the electronics will sense that the knife is down, and de-energize the CUT solenoids.
C. De-energize two CUT solenoids. (Knife and Clamp are sent up.)	With the CUT solenoids de-energized, oil flow is directed to the knife up cylinder port (KU) and the clamp up cylinder port (CU). Since the clamp down port (CD) is blocked by a check valve and the clamp up sequence valve the clamp will stay down while the knife goes up. When the knife reaches the up extreme, system pressure builds until the clamp up sequence valve opens and allows the clamp to move up. System pressure will increase until the main system relief valve trips. At this time, the electronics will sense that the knife and clamp are up and de-energize the dump solenoid sending oil flow back to the tank. The knife latch is engaged.

13.26 Counterbalance Valve Assembly

H-551-4, Rev. A

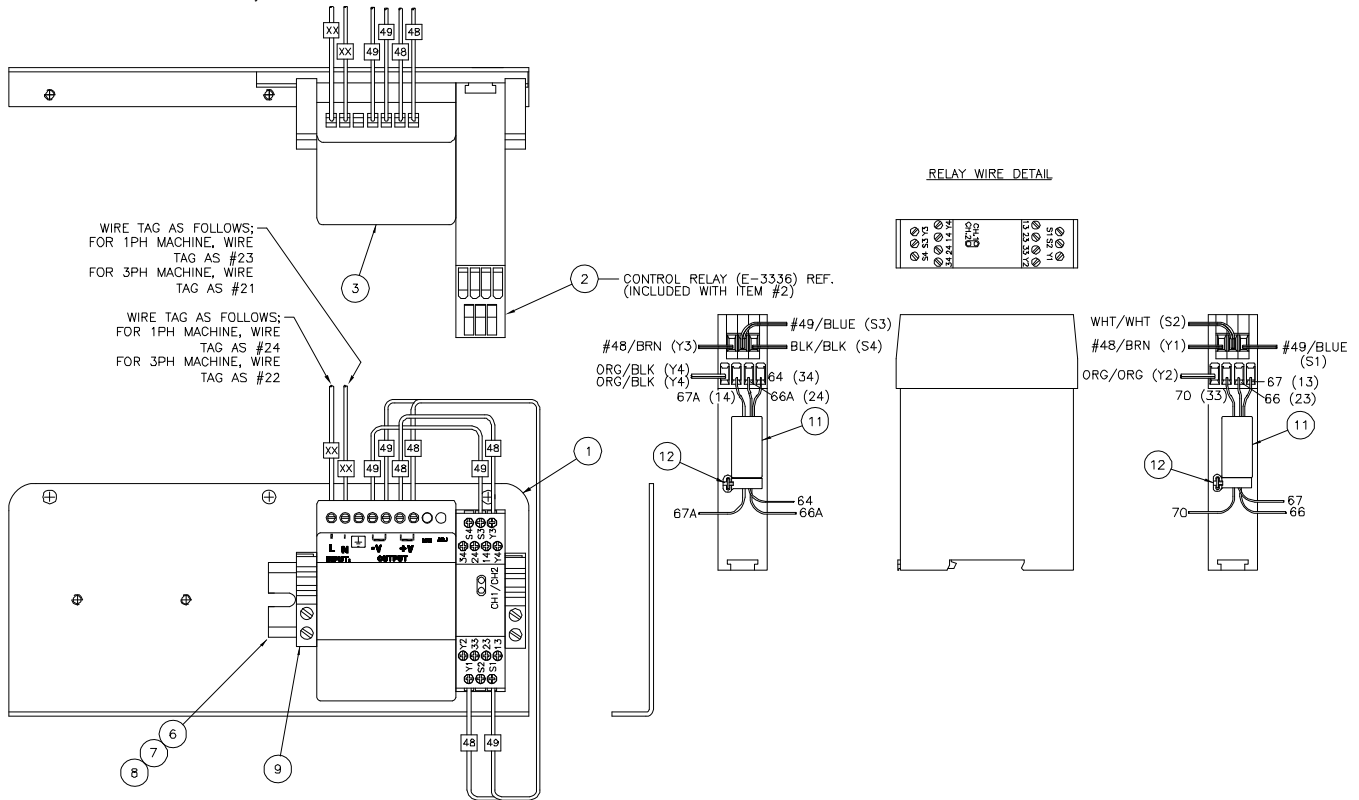


NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	56167	VALVE BODY	1
2	H-518-4	TUBE ASSEMBLY	1
3	H-435-3	TEE - (#8) TUBE/(#6) 'O'-RING/(#8) TUBE	1
4	H-236-11	STR. FITTING (#4) 'O' RING TO (#8) TUBE	1
5	H-552	ELBOW - #6 'O' RING TO #6 'O' RING	1
6	H-203-40	VALVE - COUNTER BALANCE	1
7	H-230-6	ELBOW - 9/16-18 'O' RING TO 3/4-16 TUBE	1

NOTES:

13.27 Electric Eyes Assembly

EE-3363 Sheet 1, Rev. B

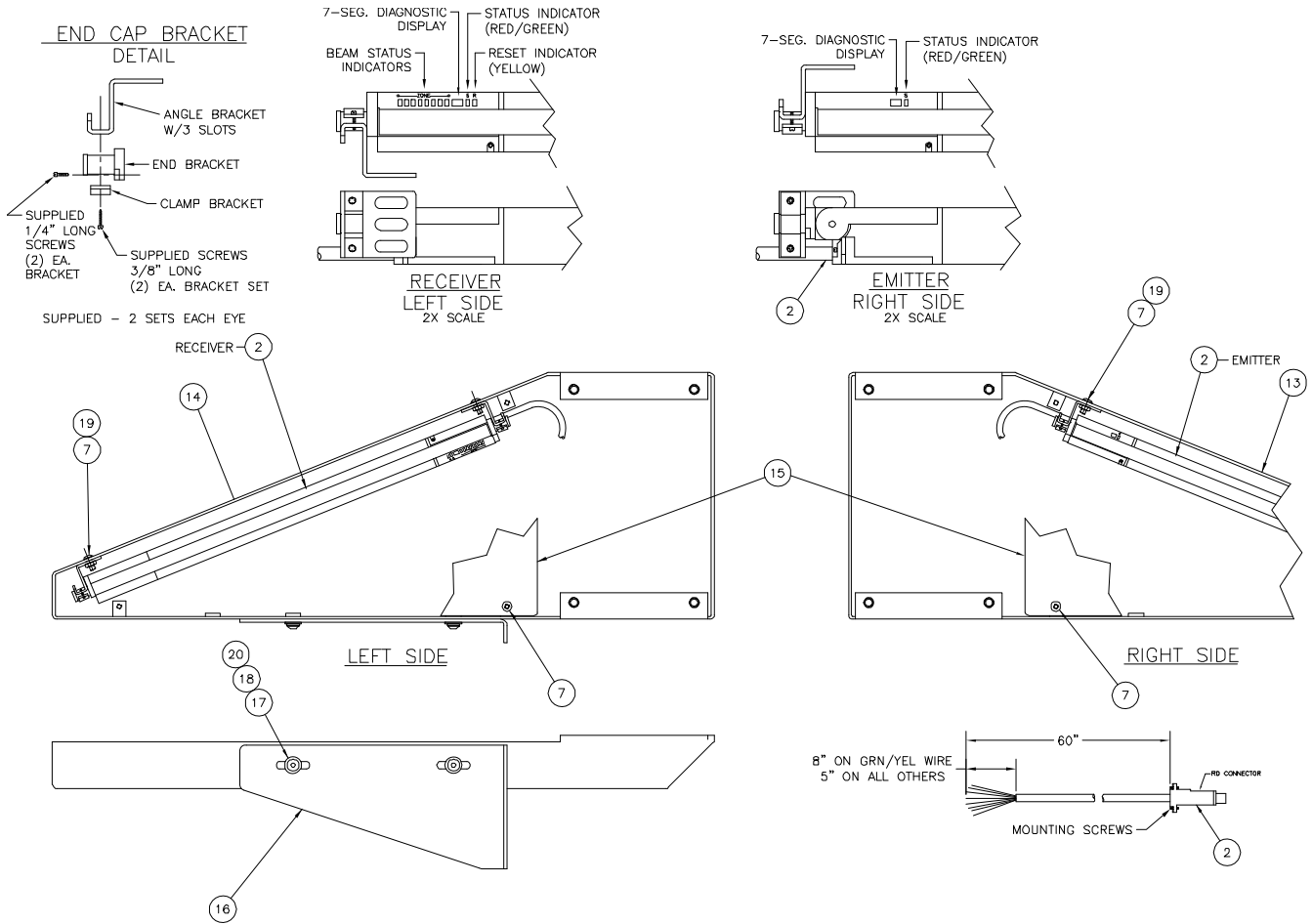


(REF ONLY)

WIRE NO.	WHERE USED	WIRE NO.	WIRE GA.	CUT LENGTH	WIRE TERMINATION	WHERE USED
21 or 23	POWER SUPPLY TERM. "N" TO 'F4' FUSE HOLDER (PPNL)	21 or 23	18	26"	STRIP BOTH ENDS	POWER SUPPLY TERM. "N" TO 'F4' FUSE HOLDER (PPNL)
22 or 24	POWER SUPPLY TERM. "L" TO 'F7' FUSE HOLDER (PPNL)	22 or 24	18	26"	STRIP BOTH ENDS	POWER SUPPLY TERM. "L" TO 'F7' FUSE HOLDER (PPNL)
49	FROM POWER SUPPLY -V TO EYE CONTROLLER S1	49	20	24"	STRIP BOTH ENDS	FROM POWER SUPPLY -V TO EYE CONTROLLER S1
49	FROM POWER SUPPLY -V TO EYE CONTROLLER S3	49	20	6"	STRIP BOTH ENDS	FROM POWER SUPPLY -V TO EYE CONTROLLER S3
48	FROM POWER SUPPLY +V TO EYE CONTROLLER Y1	48	20	23"	STRIP BOTH ENDS	FROM POWER SUPPLY +V TO EYE CONTROLLER Y1
48	FROM POWER SUPPLY +V TO EYE CONTROLLER Y3	48	20	6"	STRIP BOTH ENDS	FROM POWER SUPPLY +V TO EYE CONTROLLER Y3
66	EYE CONTROLLER TERM. #23 - FROM CUT SW. (REF)	66	-	-	-	EYE CONTROLLER TERM. #23 - FROM CUT SW. (REF)
66A	EYE CONTROLLER TERM. #24 - HANG LOOSE	66A	18	25"	STRIP ONE END/1/4" Q.D. OTHER END	EYE CONTROLLER TERM. #24 - HANG LOOSE
67	EYE CONTROLLER TERM. #13 - FROM CUT SW. (REF)	67	-	-	-	EYE CONTROLLER TERM. #13 - FROM CUT SW. (REF)
67A	EYE CONTROLLER TERM. #14 - HANG LOOSE	67A	18	21"	STRIP ONE END/1/4" Q.D. OTHER END	EYE CONTROLLER TERM. #14 - HANG LOOSE
70	EYE CONTROLLER TERM. #33 - HANG LOOSE	70	20	18"	STRIP BOTH ENDS	EYE CONTROLLER TERM. #33 - HANG LOOSE
64	EYE CONTROLLER TERM. #34 - HANG LOOSE	64	20	18"	STRIP BOTH ENDS	EYE CONTROLLER TERM. #34 - HANG LOOSE

NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	43100-1	BRACKET - CONTROLLER MOUNT	1
2	E-3370	LIGHT CURTAIN - 16" W/CONTROL RELAY	1
3	E-2810	POWER SUPPLY - 24V OUTPUT	1
4	E-1163-10	WIRE - #20GA. BLACK HOOK-UP 95" TOTAL	1
5	E-709-R	WIRE - #18GA. RED MTW 98" TOTAL	1
6	E-1977-23	RAIL - TERMINAL, 5" LONG	1
7	H-6910-102404	SCREW - #10-24 x 1/2" BUT HD	12
8	H-7324-#10	WASHER - #10 INT. TOTHLOCK	2
9	E-2070-1	END BRACKET - TERMINAL BLOCK	2
10	E-1214-65	CONNECTOR - 1/4" FULLY INS. Q.D.	2
11	E-2756-3	FILTER - FERRITE CORE	2
12	S-1694	TY-RAP	2
13	44173	HOUSING - ELEC EYE, RH	1
14	44172	HOUSING - ELEC EYE, LH	1
15	44174-1	ELEC EYE COVER	2
16	44176	SHIELD - EXTENSION TABLE	1
17	H-6910-404	SCREW - 1/4-20 X 1/2 BUT HEAD	2
18	H-7324-8	WASHER - 1/4 INT TOOTH	2
19	H-6423-#10	NUT - #10-24 HEX KEP	4
20	H-7321-4	WASHER - 1/4 PLAIN	2

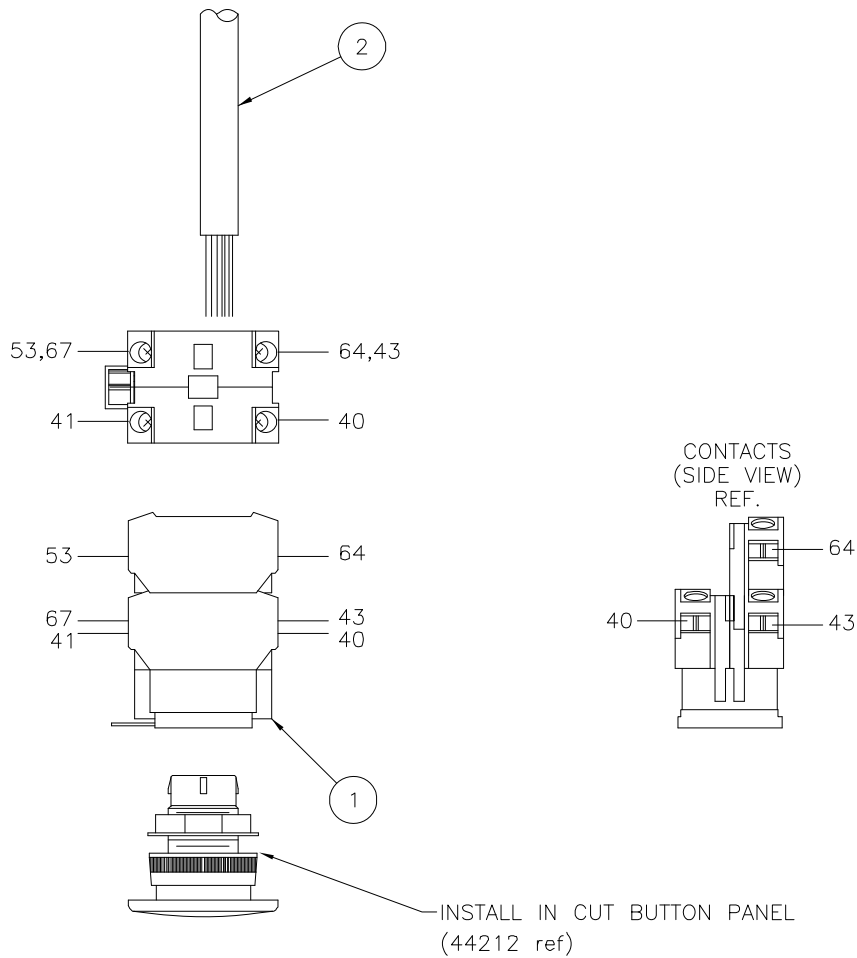
EE-3363 Sheet 2



NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	43100-1	BRACKET - CONTROLLER MOUNT	1
2	E-3370	LIGHT CURTAIN - 16" W/CONTROL RELAY	1
3	E-2810	POWER SUPPLY - 24V OUTPUT	1
4	E-1163-10	WIRE - #20GA. BLACK HOOK-UP 95" TOTAL	1
5	E-709-R	WIRE - #18GA. RED MTW 98" TOTAL	1
6	E-1977-23	RAIL - TERMINAL, 5" LONG	1
7	H-6910-102404	SCREW - #10-24 x 1/2" BUT HD	12
8	H-7324-#10	WASHER - #10 INT. TOTHLOCK	2
9	E-2070-1	END BRACKET - TERMINAL BLOCK	2
10	E-1214-65	CONNECTOR - 1/4" FULLY INS. Q.D.	2
11	E-2756-3	FILTER - FERRITE CORE	2
12	S-1694	TY-RAP	2
13	44173	HOUSING - ELEC EYE, RH	1
14	44172	HOUSING - ELEC EYE, LH	1
15	44174-1	ELEC EYE COVER	2
16	44176	SHIELD - EXTENSION TABLE	1
17	H-6910-404	SCREW - 1/4-20 X 1/2 BUT HEAD	2
18	H-7324-8	WASHER - 1/4 INT TOOTH	2
19	H-6423-#10	NUT - #10-24 HEX KEP	4
20	H-7321-4	WASHER - 1/4 PLAIN	2

13.28 Cut Button Assembly – Right Hand (Standard)

EE-3384, Rev. C



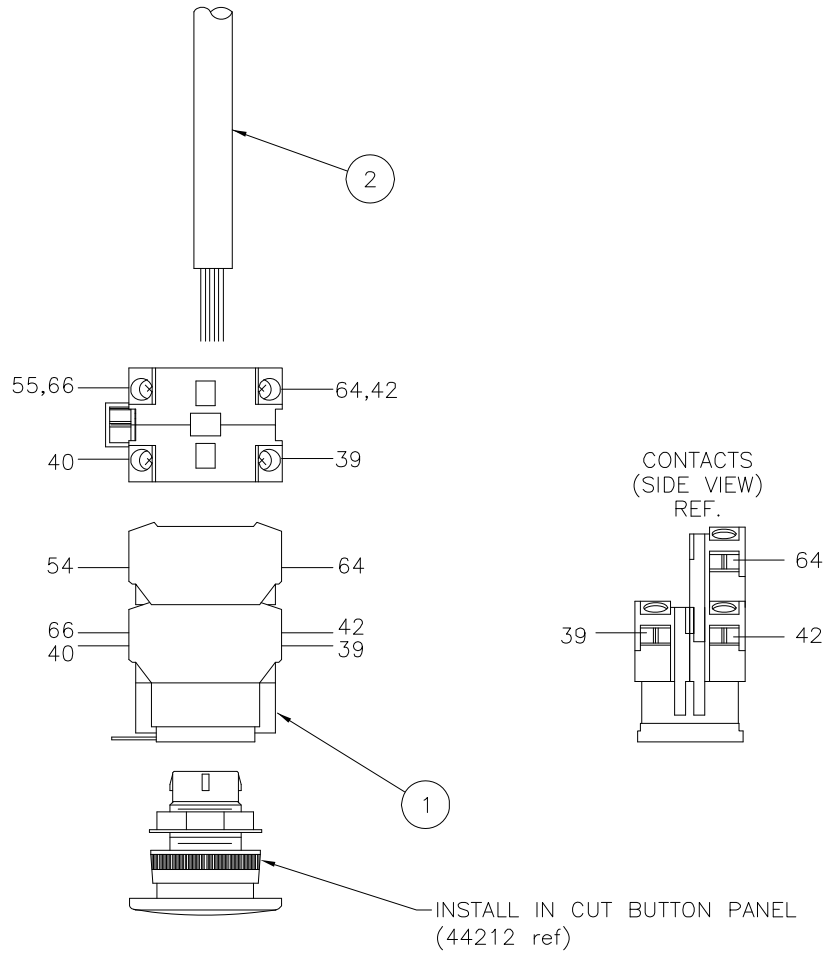
CABLE CHART – #2
RIGHT HAND SWITCH

64	GREEN	3B	27"	H4-1
53	WHITE	3A	31"	H5-5
67	BLACK	2B	26"	PECU #34
43	ORANGE	2A	32"	H6-5
41	BLUE	1B	32"	H6-1
40	RED	1A	35"	TB RT
WIRE NO.	COLOR	SWITCH TERMINAL	WIRE LENGTH	WIRE LOCATION

NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	E-3127-4	PUSHBUTTON SWITCH - MUSHROOM, 3 N.O.	1
2	E-2078	CABLE - #18GA. 6 COND. 92" LONG	1

13.29 Cut Button Assembly – Left Hand (Standard)

EE-3385, Rev.C



CABLE CHART
LEFT HAND SWITCH

64	GREEN	3B	21'	H4-1
54	WHITE	3A	21"	H5-1
66	BLACK	2B	35"	PECU #23
42	ORANGE	2A	21"	H6-2
39	BLUE	1B	18"	TB LT
40	RED	1A	18"	TB LT
WIRE NO.	COLOR	SWITCH TERMINAL	WIRE LENGTH	WIRE LOCATION

NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	E-3127-4	PUSHBUTTON SWITCH - MUSHROOM, 3 N.O.	1
2	E-2078	CABLE - #18GA. 6 COND. 92" LONG	1

Cut Button Assembly – Ergo Touch Option (Cont.)

INSTALLATION INSTRUCTIONS:

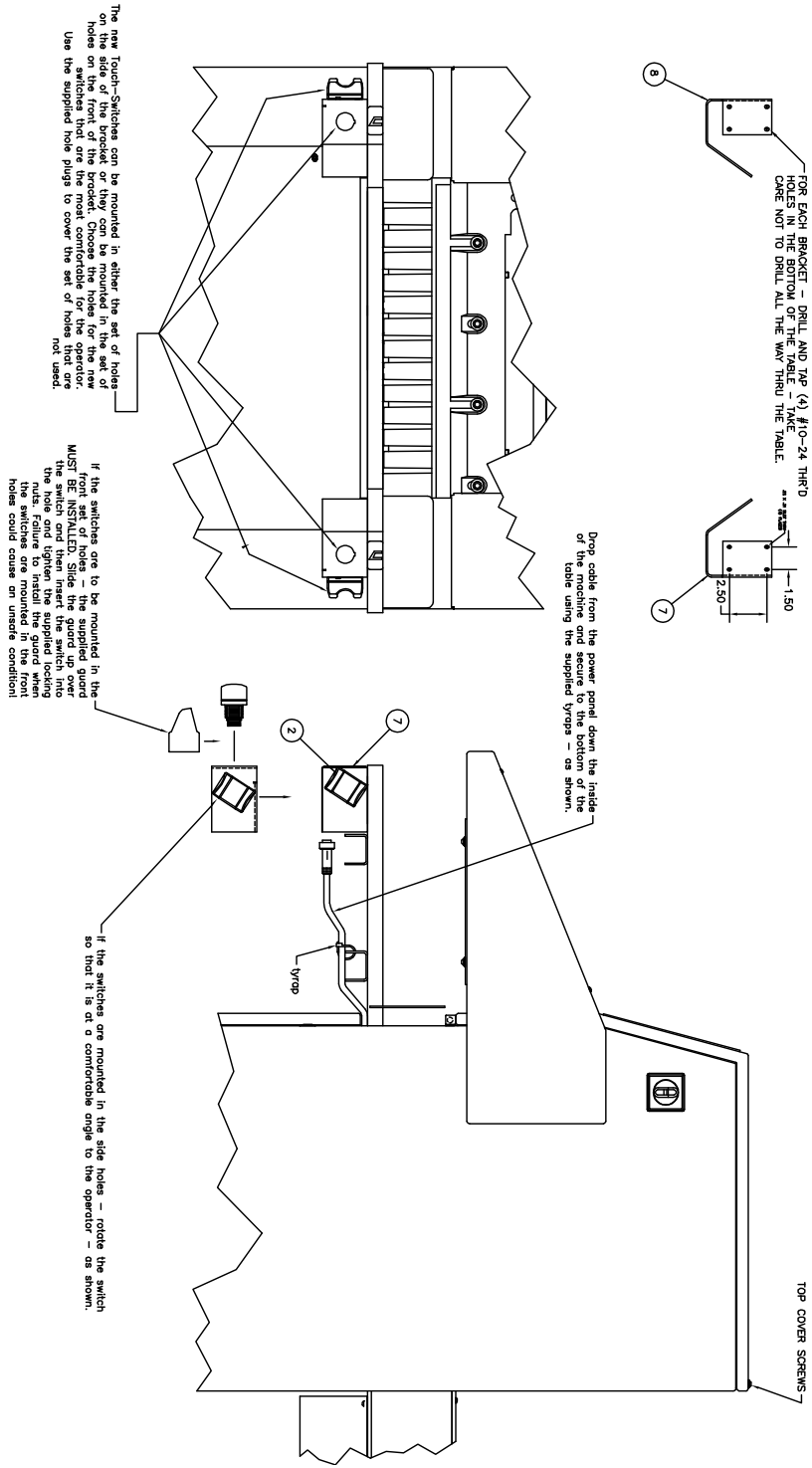
- 1) On the rear of the machine – Locate the electric eye controller and power supply that is mounted, hanging off the power panel. Remove the existing power supply from the rail – remove the existing terminal rail and install the longer supplied rail in it's place. Re-install the power supply and snap the new touch-switch controller (the end that has 'S1,S2 and Y1 is up) onto the rail and lock it in place using the terminal end block (item #5).
- 2) Follow the details to the left and below to run the wires from the new controller assembly to their proper locations.
- 3) Follow sheet 2 to mount the new Touch Switch box. Use the screws that previously mounted the cut switches to mount your new box.
- 4) There are two cables with plugs hanging off of the new Touch Switch controller. Each cable is marked for the left and right switches. Run these cables down the side of the power panel and drop down each side of the machine. See sheet 2 for routing directions to the Touch Switch box. Use the supplied tyraps to secure the cables to the power panel and away from all moving parts.
- 5) Mount the new switches into the two side holes (tighten the nuts 1/4 turn pass finger tight)
- 6) Plug the cables into the new Touch Switches.
- 7) If this machine is a NON-TC machine – the software will need to be changed – replace the existing programmed Eprom with the supplied programmed Eprom (item #6).

WIRE NO.	TOUCH-SWITCH CONTROLLER	FINAL DESTINATION
39	TERMINAL #14	TERMINAL BLOCKS
41	TERMINAL #13	PCB H6-1
42	TERMINAL #23	PCB H6-2
43	TERMINAL #33	PCB H6-5
48	TERMINAL #S2	POWER SUPPLY
48	TERMINAL #S4	POWER SUPPLY
53	TERMINAL #Y2	PCB H5-5
54	TERMINAL #Y4	PCB H5-1
55	TERMINAL #S3	-
64	TERMINAL #Y1	PCB H4-1
64	TERMINAL #Y3	PCB H4-1
65	TERMINAL #S1	-
66	TERMINAL #24	EYE CONTROLLER TERMINAL #23
67	TERMINAL #34	EYE CONTROLLER TERMINAL #13

NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	EE-3350-1	CONTROLLER ASSEMBLY – TOUCH SWITCH	1
2	E-3347	TOUCH SWITCH	2
3	E-1977-19	RAIL – TERMINAL, 5-1/2" LONG	1
4	S-1694-2	TYRAP – WIRE	12
5	E-2070-1	END BLOCK – TERMINAL	1
6	EE-1766-109	IC-PROGRAMMED EPROM (TITAN 265)	1
7	42065	BRACKET – TOUCH-SWITCH, R.H.	1
8	42066	BRACKET – TOUCH-SWITCH, L.H.	1
9	E-2196-17	HOLE PLUG – 1-1/4" DIA.	2
10	K-3367	INSTRUCTIONS – DRAWINGS ONLY – BOTH SHTS	1

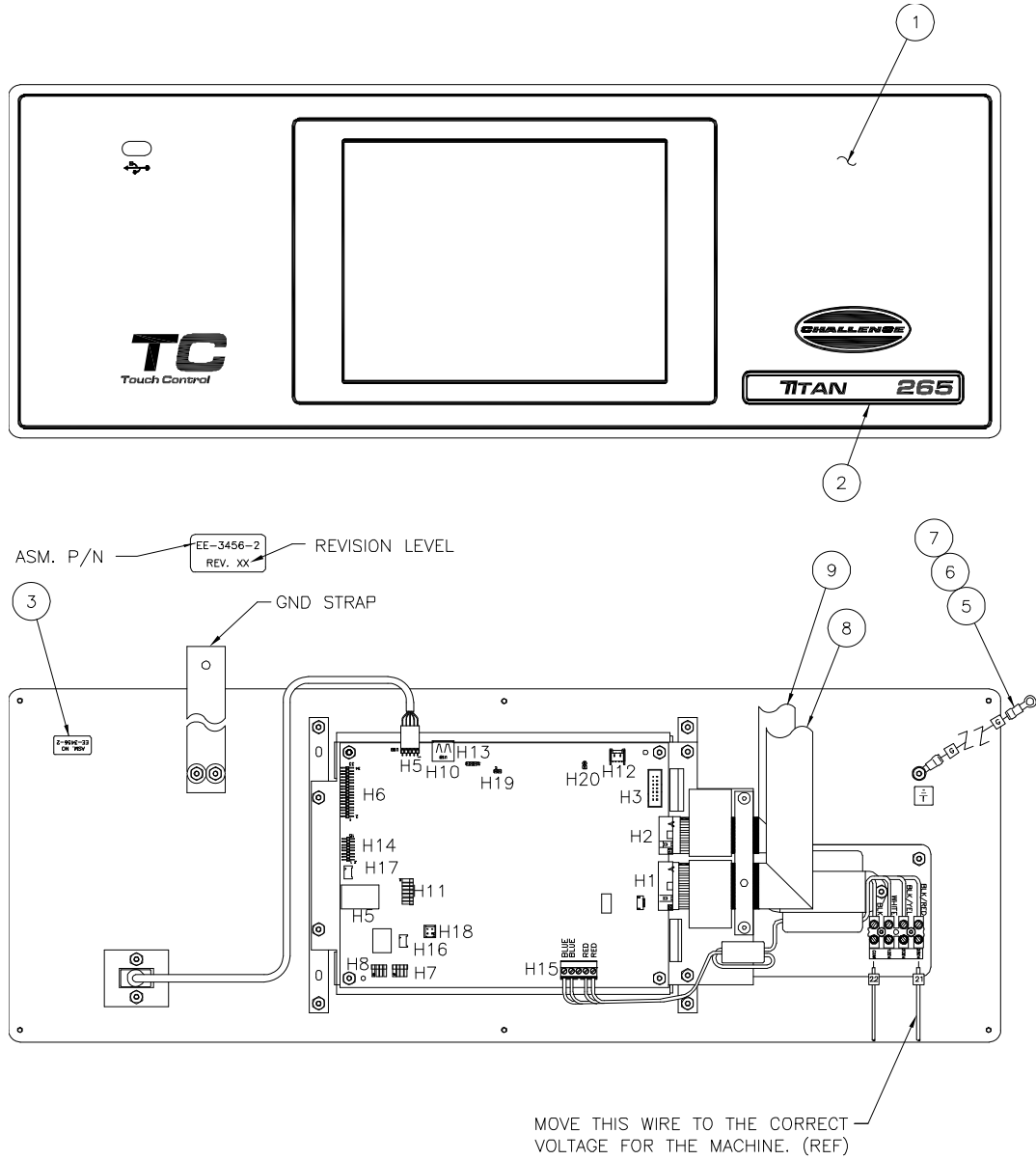
13.31 Cut Button Assembly – ErgoTouch Option

K-3367 sh't 2, Rev. D



13.32 TC Control Console Assembly

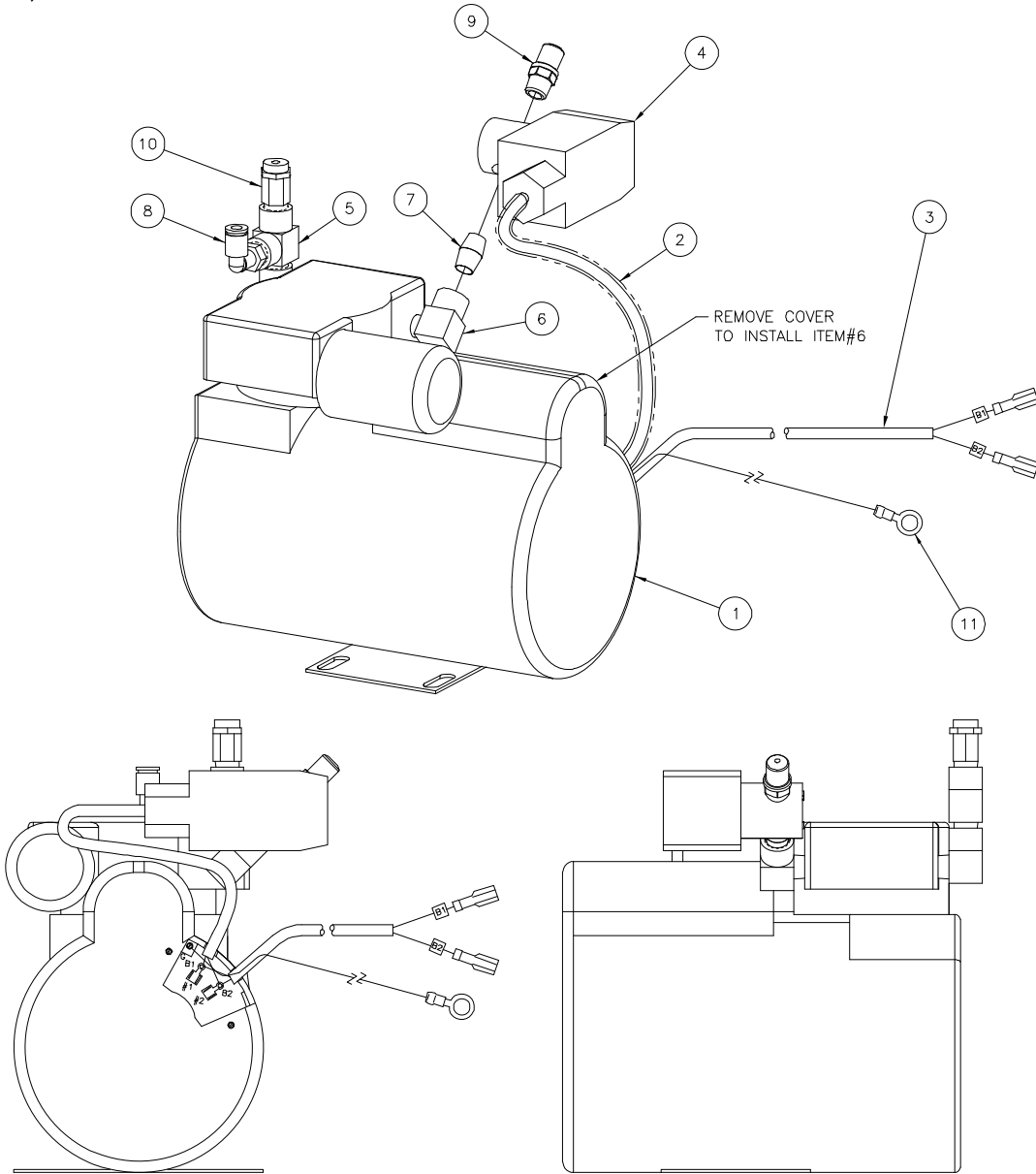
EE-3456-2, Rev. D



NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	EE-3471	PANEL ASM. - FRONT CONTROL, TC	1
2	47701-3	TC PANEL INSERT - TITAN 265	1
3	E-1584-()	LABEL - ASM. NO./REV. LEVEL	1
4			
5	E-1214-2	CONNECTOR - #6 INS. RING	1
6	E-1214-64	CONNECTOR - 1/4" NON-INS. RING	1
7	E-2743	WIRE - #18 GA. YEL/GREEN MTW 15" LONG	1
8	EE-2855-15	RIBBON CABLE ASM. - 20 POS.	1
9	EE-2855-16	RIBBON CABLE ASM. - 14 POS.	1

13.33 Pre-Clamp Compressor Assembly

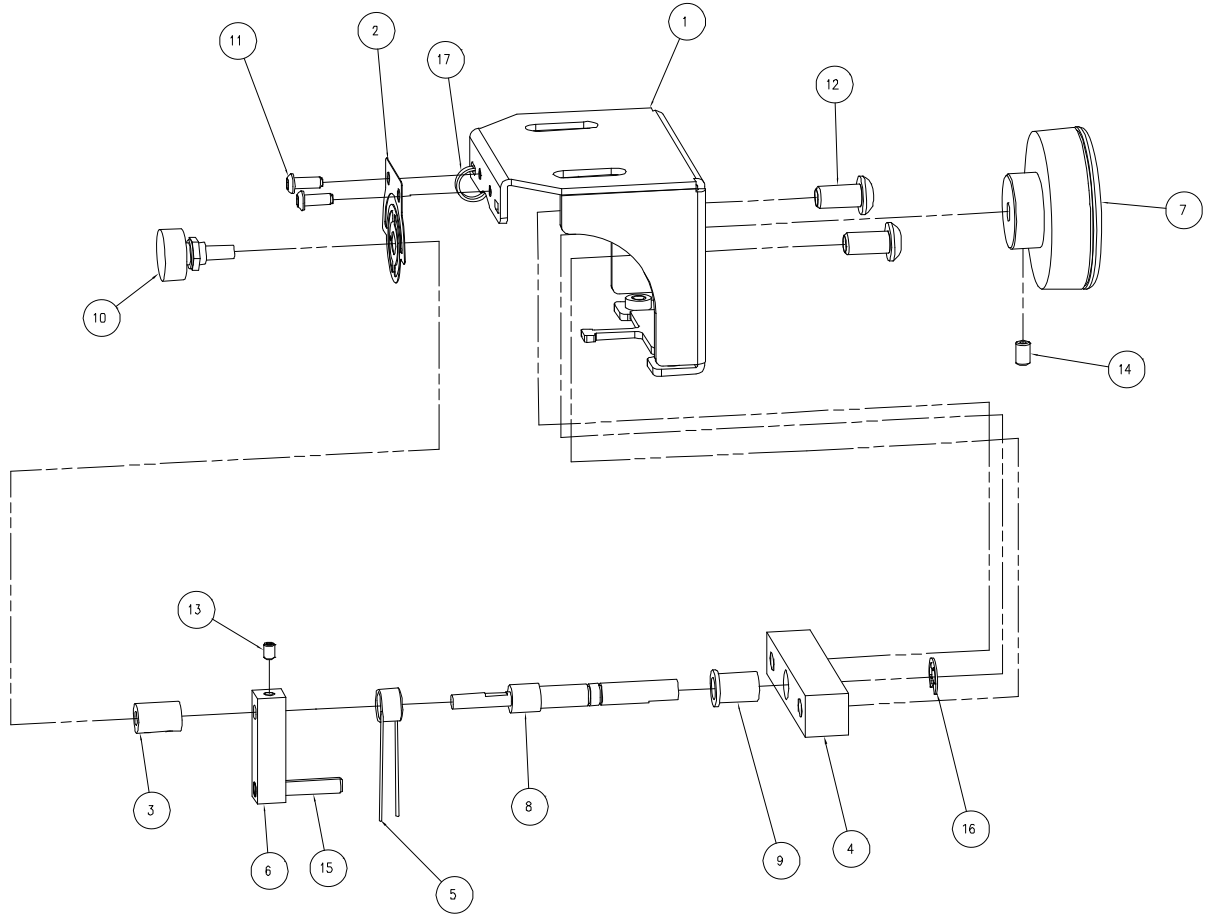
44192, Rev. J



NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	47644	COMPRESSOR	1
2	E-1710-3	SPLIT TUBING	12"
3	EE-3210	CABLE ASSEMBLY- COMPRESSOR POWER	1
4	P-521	VALVE- 2-WAY, N.O.	1
5	H-261-3	TEE- 1/4 MALE RUN, BRASS	1
6	H-269-2	ELBOW - 90%176 STREET, BRASS	2
7	H-6406-407	NIPPLE- 1/4" X 7/8", BRASS	1
8	P-503-402	ELBOW-1/4 TUBE X 1/4 NPT	1
9	P-511	SILENCER - 1/4 NPT	1
10	P-520-60	VARIABLE PRESSURE RELIEF (YELLOW SPRING)	1
11	EE-3212	WIRE ASM. - COMPRESSOR GROUND	1
12	S-1694	TYRAP - WIRE	2
13	E-1214-9	CONNECTOR - #8 RING	2

13.34 Backgauge Control Assembly

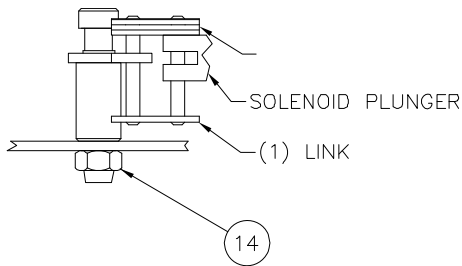
49249, Rev. J



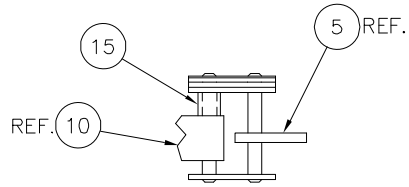
NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	49248-1	BACKGAUGE CONTROL BRACKET	1
2	49261	ENCODER MOUNTING BRACKET	1
3	56676-1	COUPLING	1
4	63210-1	FRONT PILLOW BLOCK	1
5	63213	TORSION SPRING	1
6	63214	ACTUATOR	1
7	63218	KNOB	1
8	63221	CONTROL KNOB SHAFT	1
9	EE-3213	POTENTIOMETER	1
10	H-6423-#10	NUT - #10-24 HEX KEP	2
11	H-6910-102404	SCREW - #10-24 X 1/2 BUTTON HEAD CAP	2
12	H-6910-606	SCREW - 3/8-16 X 3/4 BUTTON HEAD CAP	2
13	H-6940-102404	SCREW - #10-24 X 1/4 FLAT SOC SET	1
14	H-6940-406	SCREW - 1/4-20 X 3/8 FLAT SOC SET	1
15	H-21S-250-1500	ROLL PIN - 1/4 X 1-1/2	1
16	S-1193-37	E-RING - 3/8"	1
17	S-1694	TYRAP	1

13.35 Knife Latch Assembly

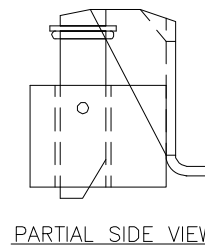
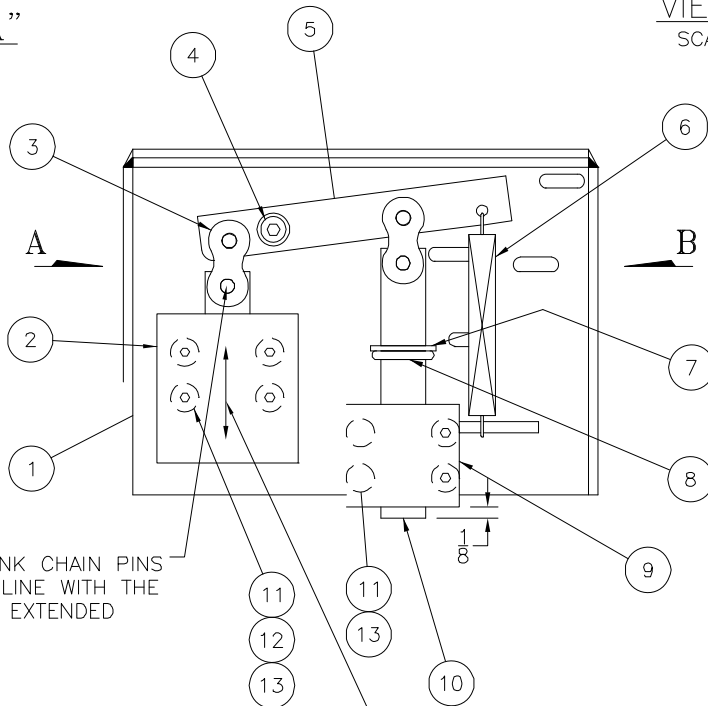
47568-1, Rev. A



VIEW "A"
SCALE: 1X



VIEW "B"
SCALE: 1X



PARTIAL SIDE VIEW

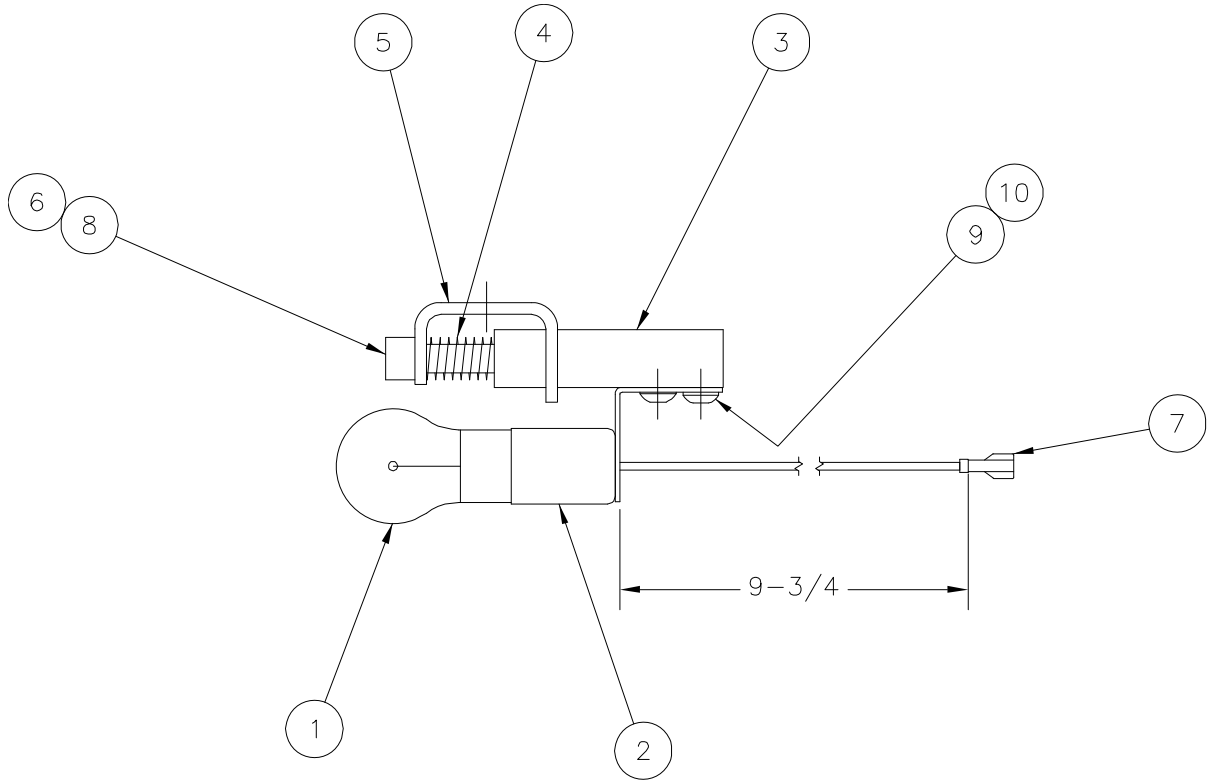
POSITION THE LINK CHAIN PINS SO THEY ARE IN LINE WITH THE SOLENOID WHEN EXTENDED

ADJUST SOLENOID IN THIS DIRECTION SO THAT THE ROD (ITEM #10) IS 1/8" BEYOND THE BLOCK WHEN SOLENOID IS ENERGIZED.

NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	47505-1	PLATE- KNIFE LATCH MOUNT	1
2	E-974-3	SOLENOID	1
3	47567	LINK- CHAIN	2
4	H-5254-510	SCREW- 5/16 X 1-1/4 SOC. SHOULDER	1
5	47553-1	LINK ASSEMBLY- KNIFE LATCH	1
6	41117-1	SPRING- EXTENSION	1
7	H-6451-0500	RETAINING RING- GRIPPING EXTERNAL	1
8	S-1810-9	O' RING	1
9	41112-2	ASSEMBLY- KNIFE LATCH BLOCK	1
10	41116-2	ROD- KNIFE LATCH	1
11	H-6910-83203	SCREW- #8-32 X 3/8 BUT. HD. SOC.	8
12	H-7321-#8	WASHER- #8 SAE FLT PLTD	4
13	H-7324-#8	WASHER- #8 INT. TOOTH	8
14	H-5247-4	NUT- 1/4-20 FLEX LOCK	1
15	E-1152-9	SPACER	1

13.36 Line Light Assembly

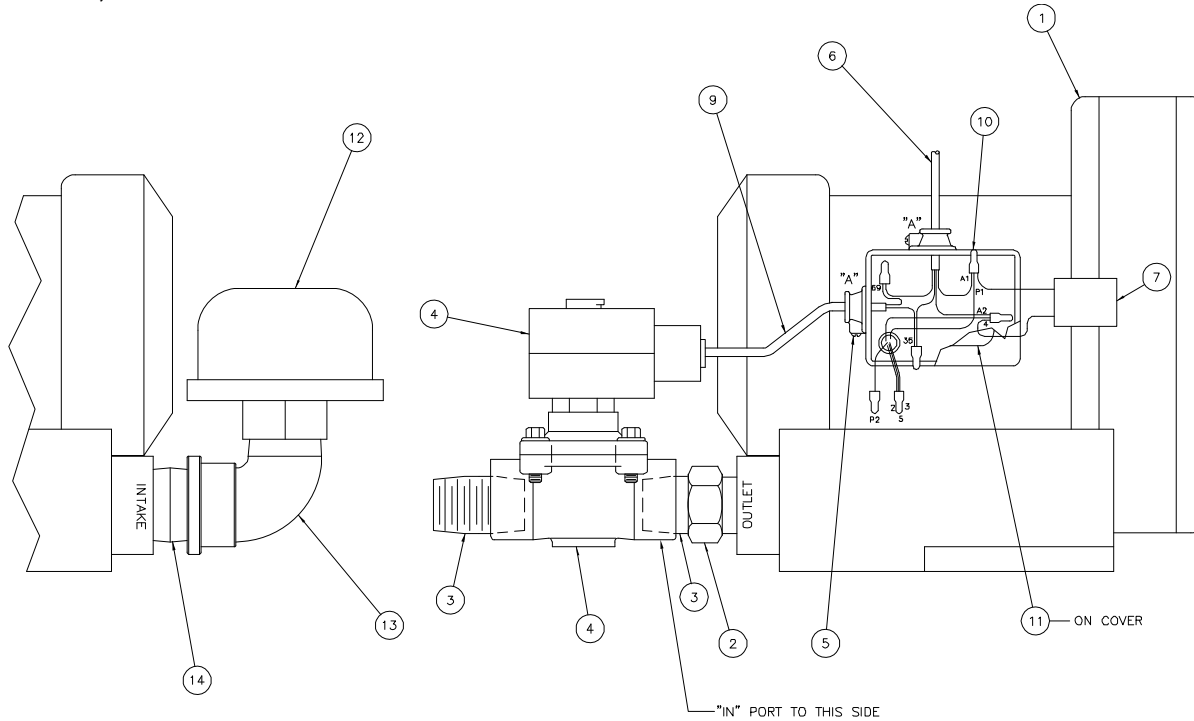
EE-2779, Rev. D



NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	E-967-1	LAMP - LINE LIGHT	1
2	E-1260-1	SOCKET - LINE LIGHT	1
3	9127-1	SUPPORT - LINE LIGHT	1
4	35048-13	SPRING	1
5	9126-2	BRACKET - LINE LIGHT	1
6	SU-10-106	GREASE - DAMPENING	1
7	E-1214-47	CONNECTOR - FEM. FULLY INS. QUICK DISC.	1
8	H-6918-412	SCREW - 1/4-20 X 1-1/2 SOC HEAD CAP	1
9	H-6910-83203	SCREW - #8-32NC X 3/8" BUT HD CAP	2
10	H-7324-#8	WASHER - #8 INTERNAL TOOTH	2

13.37 Blower Assembly – Air Table Option

44186, Rev. B



HIGH VOLTAGE	WIRE NO.	CONNECT TO BLOWER NO.
230V 60Hz 240V 50Hz	A1	P1
	A2	4
	-	P2
	-	2, 3 & 5

NO.	PART NO.	DESCRIPTION OF ACCESSORIES	QTY
1	E-1223-4	BLOWER - 1PH	1
2	P-204	REDUCER - PVC	1
3	H-6405-1212	NIPPLE - STEEL	1
4	P-202-1	VALVE - SOLENOID	1
5	S-1350-16	STRAIN RELIEF	2
6	E-748	CABLE - #18 GA. 4 COND. (LENGTH - SEE NOTE)	1
7	E-1736-2	QUENCHARC - 3" WIRE LEADS	1
8	E-1214-4	CONNECTOR - #8 INS. LOCKING FORK	1
9	E-1453-1	SHRINK TUBING - 6" LONG	1
10	E-1237-1	NUT - WIRE, SM YELLOW	6
11	S-1781-12	LABEL - EURO SHOCK W/TEXT	1
12	P-102	STRAINER	1
13	P-214	ELBOW - 90° STREET NPT, NYLON	1
14	P-212-1	PIPE NIPPLE - 1" x 1-1/2 PLASTIC	1
15	E-1214-65	CONNECTOR - 1/4" FULLY INS. QUICK DISC.	2