



## Potentiometric Displacement Sensor

### Set-up Instructions

Refer to drawings

M124A00 for Press Nr. 20.100  
M124B00 for Press Nr. 23 - 25  
M124C00 for Press Nr. 27

- 1) Mount components per assembly drawing (leaving the four mounting screws loose on the sensor).
- 2) Loosen the set screw for the stroke fine adjustment. Screw the stroke fine adjustment nut down until it contacts the cylinder housing.
- 3) Fully retract the cylinder with air.
- 4) Set the stroke limit block to the maximum stroke of the press. (read from the tag on cylinder for the stroke length).
- 5) Lock the two socket head cap screws on the stroke limit block, tighten the two 25mm lock nuts (Nr. 27 only) above the stroke limit block.
- 6) Screw in the fine adjustment stud 1/2-20 (item 9) until it bottoms out on the flag (item 4). Unscrew 1-1/4 turn out and lock in place with the 10-32 set screw.
- 7) Adjust the potentiometric displacement sensor so that the ball tip just contacts the bottom of fine adjustment stud (item 9). Tighten the four mounting screws on the P.D Sensor.
- 8) Slowly extend the cylinder to it full stroke making sure that the P.D Sensor doesn't run out of travel.
- 9) Install modified hood.