

STU 45 SLIDE TABLE INSTALLATION INSTRUCTIONS

1. Remove head unit from column by unscrewing the two (2) 6mm SHCS from the height adjustment mounting plate, then unscrewing the bolts attaching the head to the column. (NOTE: HOLD THE HEAD UNIT WHEN UNSCREWING BOLTS SO IT DOES NOT SLIDE DOWN COLUMN AND PINCH HANDS OR DAMAGE PRESS ETC.)

UNSCREW BOLTS HERE



2. Transfer Punch third hole in pneumatic package before removing (see drawing 2041A02) Remove pneumatic package from column by unscrewing the (2) Socket Head Cap Screws (SHCS) on the manifold block.

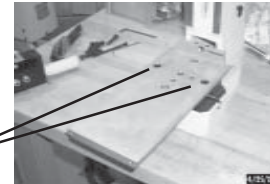
3. Modify (drill & tap) column base per drawing # 2041A02

4. Lay (Black) spacer plate on platen with the two holes on the right side. Install slide assembly on top of spacer plate.



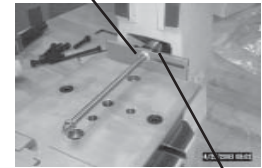
5. Secure slide base with two (2) 8mm T-Nuts (slide into T-slot) using (2) 8MM-1.25 X 40mm SHCS. Tighten these screws.

TIGHTEN SCREWS



6. Insert Air cylinder through the back of the column and through the threaded hole in the mounting plate. (cylinder rod end first). Tighten cylinder so that the retract port is facing down at 6:00 (Make sure O-Ring is installed between cylinder and mounting plate). Tighten two (2) #10 Set Screws in mounting plate to lock cylinder in position.

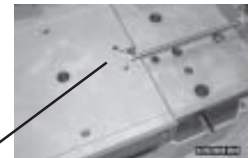
SCREW IN



TIGHTEN SET SCREWS

7. Thread cylinder rod onto slide table T-Nut. Adjust rod until the slide contacts the switch mounting plate when it is in the retracted position. Tighten the locking nut.

THREAD ROD INTO T-NUT



8. Install Straight 1/4" Tube fitting into retract port on the cylinder. Using a piece of 1/4" plastic tube as a tool, screw the fitting in with the plastic tube, then remove the tube and tighten with a 5/32 Allen Wrench.



USE TUBE AS TOOL

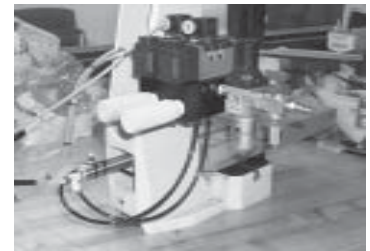
9. Install 1/4" plastic tube with the in-line flow control into the retract cylinder port. Cable tie the flow control onto the end of the cylinder.



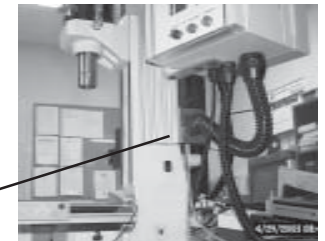
10. Remove the filter/regulator assembly from the existing manifold assembly. Sandwich existing manifold with the new manifold (Make sure the O-Ring is in the counter bore of the new manifold). Tighten (3) 6mm-1 x 100mm SHCS.



11. Reinstall Filter/Regulator assembly using the new 1/4" Hex Nipple. Insert 1/4" x 15" lg plastic tube with the in-line flow control attached, into the bottom rear port of the new manifold block. Insert 1/4 x 13" lg plastic tube into the 90° flow control on the rear of the slide cylinder, the other end goes to the front fitting on the new manifold. Screw both adjustments on the flow control valves in all the way, then back them out half (1/2) of a turn. These flow control valves will need to be adjusted after assembly has been completed. They will be used to control the speed of the table movement.



12. Install the two (2) 5/16-18 x 1" lg SHCS with a flat washer through the two (2) 3/8" diameter holes drilled into the right side of the column (Step 2 above). Attach the two (2) bar nuts - do not tighten. Slide the aluminum strut with the PC200 Control down over the two (2) bar nuts. (Inserting the bar nuts into the rear slot of the strut), Leave at least 6" up from the bottom of the base. Tighten the (2) 5/16 SHCS.



REAR SLOT

13. Connect the yellow female disconnect from the conduit to the male black disconnect from the slide table cylinder mounting plate.



14. Connect the square black electrical plug labeled solenoid #1 to the existing press cylinder pneumatic solenoid valve (closest to column.)

Connect the square black electrical plug labeled solenoid #2 to the slide table pneumatic valve solenoid.



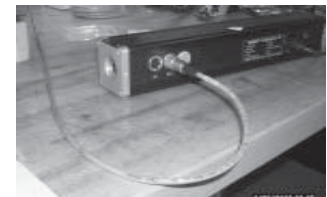
SOLENOID # 1

SOLENOID # 2

15. Attach the two (2) PNP inductive magnet sensors to the front right tie rod on the press cylinder. The one marked 'Retracted' goes on the top, the one marked 'Extended' goes on the bottom of the tie rod. These two (2) sensors will need to be adjusted. (See ram tie rod sensor setup in the PC200 Manual)



16. Connect the wire marked 'PC50' to the PressControl50 Two Hand Control unit at port X2.



17. Plug the power cords from the PC200 control and the PC50 control units into a 110 Volt outlet.

