PRESS EXTENDED SENSOR SETUP

Press must be setup with tooling and work piece prior to setting the sensors.

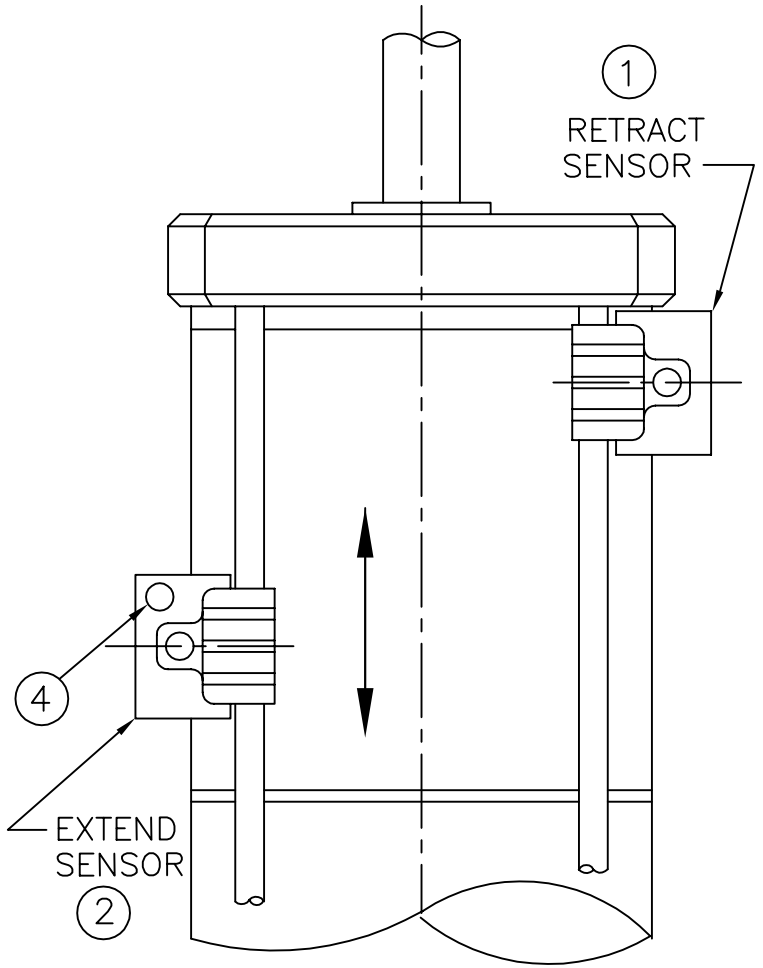
1) Power On control
2) Place work piece in fixture
3) Disconnect air
4) Extend ram until the upper tool contacts the work piece
5) Move lower sensor to bottom of cylinder wall
6) Slide sensor up slowly until LED is ON
7) Move sensor approximately 1/8" further up
   >> sensor is now in the correct position

PRESS RETRACTED SENSOR SETUP

This sensor is only used in conjunction with PLC based controls.

1) Power On control
2) Slide sensor to most upper position, while keeping LED ON
   >> sensor is now in the correct position

After setup is complete, process one part to ensure that the sensor are setup properly.



CUSTOMER	XXXXXXXXXXXXXXXXXXXXXXX XXXXXXXXXXXXXXXXXXXXXXX
TOLERANCES	UNDER 30 =± 0.2 30-120 = ±0.3 120-315 = ± 0.5 315-1000 = ± 0.8 ANGULAR = ±1/2 CHAMF. EDGES 0.80
TITLE	Instructions for setup of a cyl. sw.
DRAWN	MF — DATE April 95
CHECKED	XXXX — DATE XX/XX/XX
SCALE	XXXX
DWG #	W100A01

REV	NOTES	DATE	BY
XX	XXXXXXXXXXXXXXXXXXX	XX/XX	XX

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