

8.13 CONVERTER MAINTENANCE

This section is made up of two subsections that tell how to replace and adjust the converter.

8.13.1 CONVERTER REPLACEMENT

Replace converter as follows:

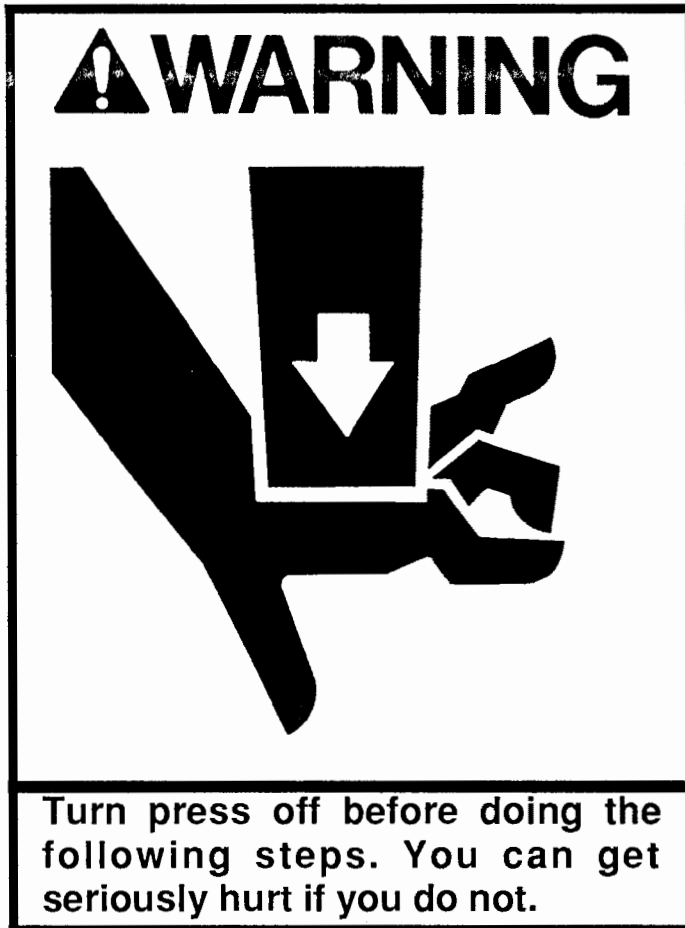
Tools Needed:

- 5/64" hex wrench (Allen wrench)
- 5/32" hex wrench (Allen wrench)
- 3/16" hex wrench (Allen wrench)
- special test fixture #38-730 (see Section 11.3)

Note

Use the Illustrated Parts List in Chapter 11 of this manual as an aid in replacing the converter. When you see something like "Remove hold-down guard (451, Fig. 13)" in the following procedure, the number (451) refers to a picture of the hold-down guard (and how the guard is attached to the press) in Figure 13 of the Illustrated Parts List.

8.13.1 CONVERTER REPLACEMENT



1. Remove hold-down guard screws (450, Fig. 13) with 5/32" hex wrench.
2. Remove hold-down guard (451) from press. Leave hold-down covers (448) and (449) attached to hold-down guard.
3. Disconnect converter cable from back of electronics package. See Figure 8.13 A.
4. Loosen converter cover screws (704, Fig. 21) with 5/64" hex wrench and remove converter cover (705).
5. Unscrew converter mounting screws (699) with 1/8" hex wrench and remove washers (700), shims (701), and converter.
6. Place new converter into position and secure in place with washers, shims, and screws using a 5/32" hex wrench.
7. Connect converter cable to electronics package as shown in Figure 8.13 A.

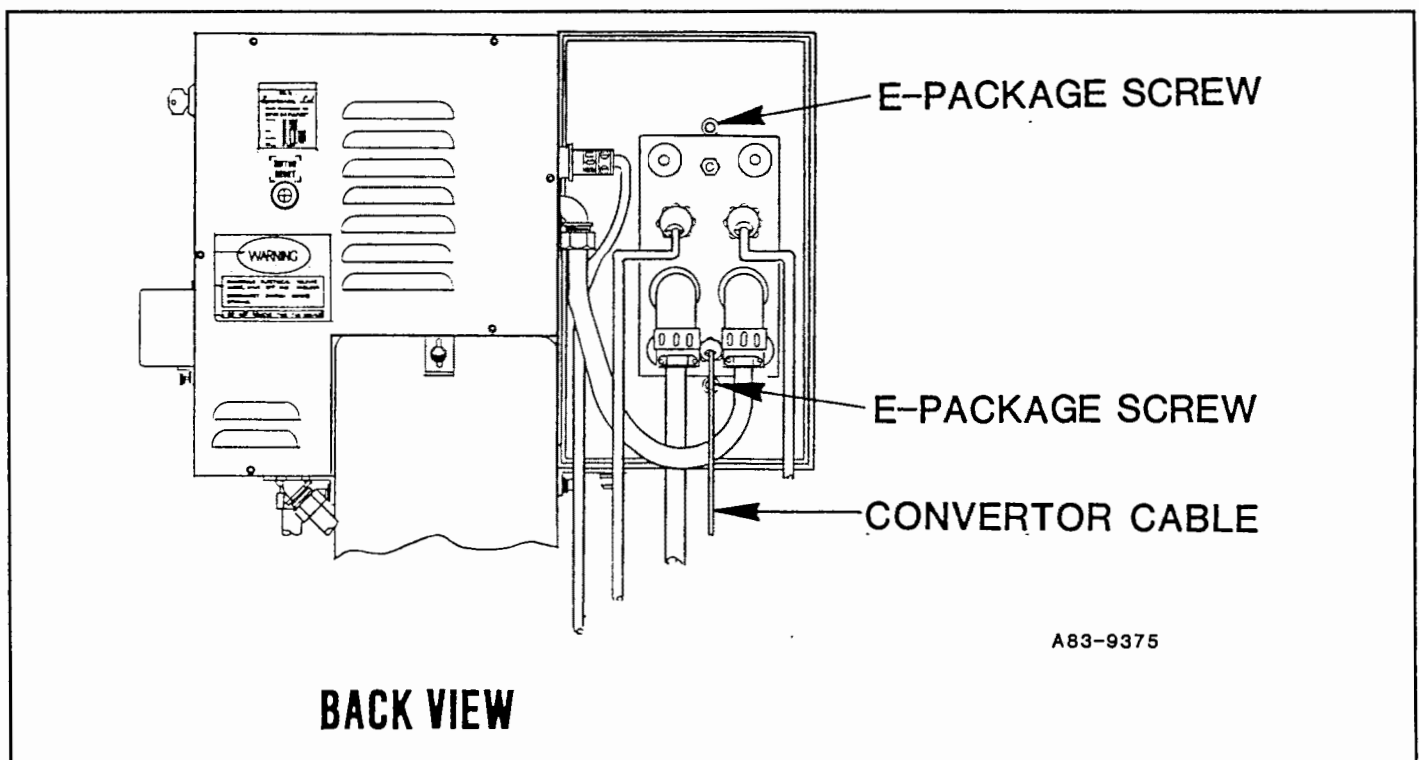


Figure 8.13 A

8.13.1 CONVERTER REPLACEMENT

8. Turn set up switch to "SET UP" position.
9. Turn converter switch on control panel to "ON" position.
10. Unscrew electronics package screws with 3/16" hex wrench. See Figure 8.13 A.
11. Slide electronics package a few inches out of brake guard and plug special test fixture into package as shown in Figure 8.9 C in Section 8.9.2.
12. Flip I-O and L-R switches on test fixture to "KILL" (up) position. See Figure 8.9 D in Section 8.9.2.
13. Flip trip switch on test fixture to "KILL TRIP" (up) position. See Figure 8.9 D in Section 8.9.2.

Caution

Make sure trip switch is in "kill trip" position before doing the following steps. The converter arm will be damaged if you do not.

14. Press "ON" button on control panel.
15. Place sheet of material under over die so that target is directly over die hole.
16. Press foot switch and see if converter arm comes down and lies flatly over target. If arm comes down and lies flatly over target, go to step 17. Otherwise, loosen the converter mounting screws, reposition the converter as required (use shims if necessary), retighten the mounting screws, and then go to step 17.
17. Press "OFF" button on control panel
18. Reattach converter cover (705, Fig. 21).
19. Reattach hold-down guard (451, Fig. 13).

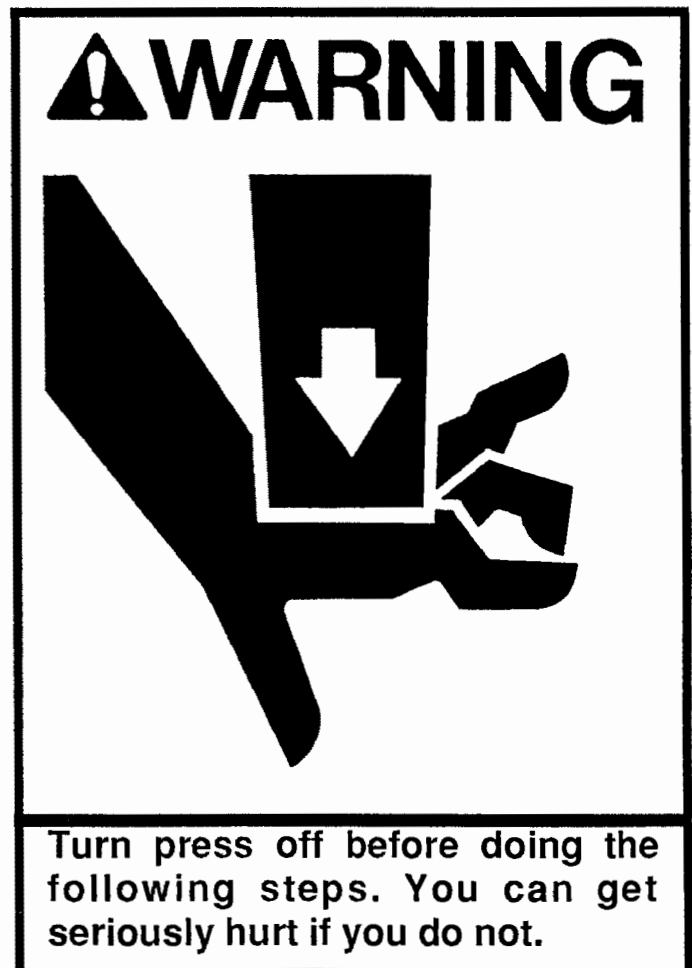
20. Pull test fixture out of electronics package.
21. Slide electronics package back into brake guard and secure in place with screws.

8.13.2 CONVERTER ADJUSTMENT

Adjust converter as follows:

Tools Needed:

- 5/64" hex wrench (Allen wrench)
- 5/32" hex wrench (Allen wrench)
- 3/16" hex wrench (Allen wrench)
- special test fixture #38-730 (see Section 11.3)



IMPORTANT!

YOU MUST READ THIS SAFETY NOTICE

The test box shown below is an optional feature that is used to troubleshoot certain problems with the press. There is an unmodified and modified version of this test box. A modified test box has an "M" marked next to its serial number as shown below.

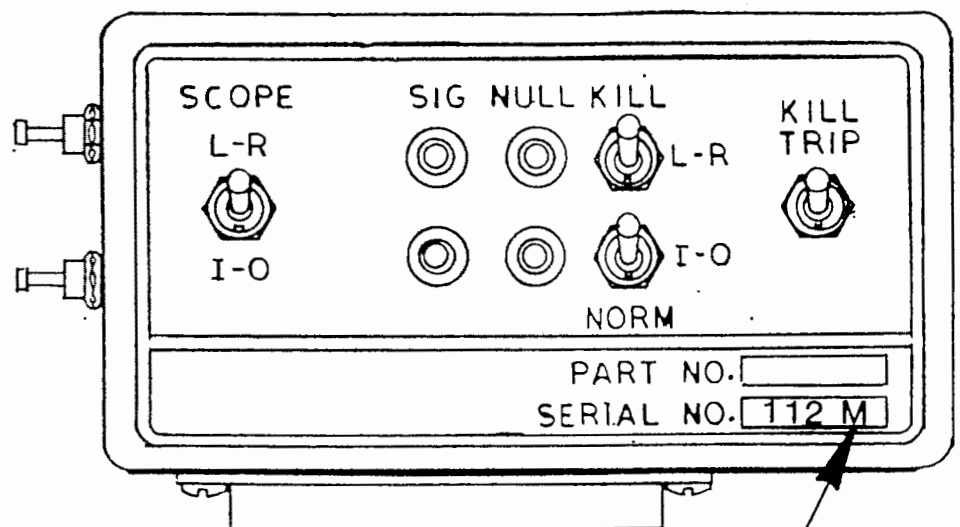
YOU MUST USE A MODIFIED TEST BOX TO TROUBLESHOOT A PRESS IF THE PRESS HAS A SERIAL NUMBER OF 184 OR HIGHER. YOU MAY BE INJURED OR THE PRESS MAY BE DAMAGED IF YOU DO NOT FOLLOW THIS RULE.

Using an unmodified test box on a press with a serial number of 184 or higher may cause the press to fire unexpectedly.

The serial number on press is located on the nameplate on the front of the press.

You may use either a modified or unmodified test box to troubleshoot a press if the press has a serial number of 183 or lower.

Unmodified test boxes will be modified at Spartanics at no charge.



"M" SHOWS THAT TEST BOX HAS BEEN MODIFIED

8.13.2 CONVERTER ADJUSTMENT**Note**

Use the Illustrated Parts List in Chapter 11 of this manual as an aid in adjusting the converter. When you see something like "Remove hold-down guard (451, Fig. 13)" in the following procedure, the number (451) refers to a picture of the hold-down guard (and how the guard is attached to the press) in Figure 13 of the Illustrated Parts List.

1. Remove hold-down guard screws (450, Fig. 13) with 5/32" hex wrench.
2. Remove hold-down guard (451) from press. Leave hold-down covers (448) and (449) attached to hold-down guard.
3. Loosen converter cover screws (704, Fig. 21) with 5/64" hex wrench and remove converter cover (705).
4. Loosen (but do not remove) converter mounting screws (699) with 1/8" hex wrench.
5. Turn set up switch to "SET UP" position.
6. Turn converter switch on control panel to "ON" position.
7. Unscrew electronics package screws with 3/16" hex wrench. See Figure 8.13 A in Section 8.13.1.
8. Slide electronics package a few inches out of brake guard and plug special test fixture into package as shown in Figure 8.9 C in Section 8.9.2.
9. Flip I-O and L-R switches on test fixture to "KILL" (up) position. See Figure 8.9 D in Section 8.9.2.
10. Flip trip switch on test fixture to "KILL TRIP" (up) position. See Figure 8.9 D in Section 8.9.2.
11. Press "ON" button on control panel.
12. Place sheet of material under over die so that target is directly over die hole.
13. Press and hold foot switch. The converter arm will come down onto target.
14. Adjust position of converter so that converter arm lies flatly over target and then tighten converter mounting screws.
15. Press "OFF" button on control panel
16. Reattach converter cover (705, Fig. 21).
17. Reattach hold-down guard (451, Fig. 13).
18. Pull test fixture out of electronics package.
19. Slide electronics package back into brake guard and secure in place with screws.

Caution

Make sure trip switch is in "kill trip" position before doing the following steps. The converter arm will be damaged if you do not.