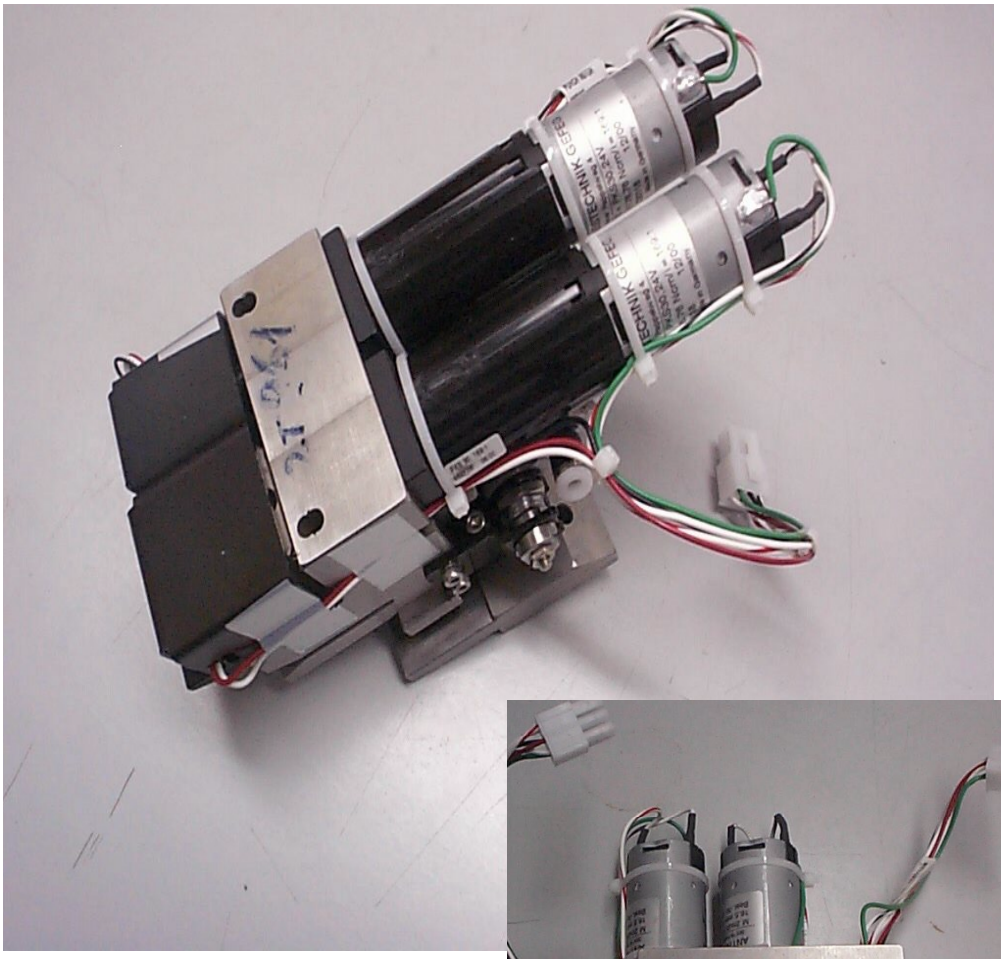
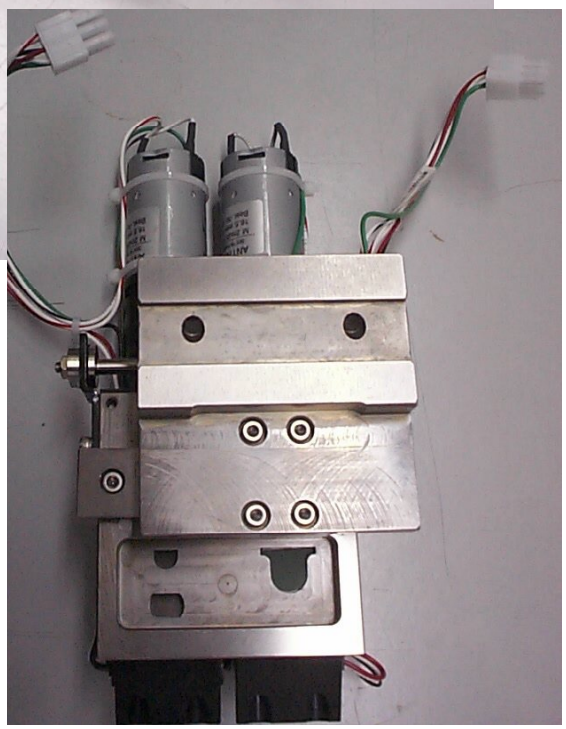
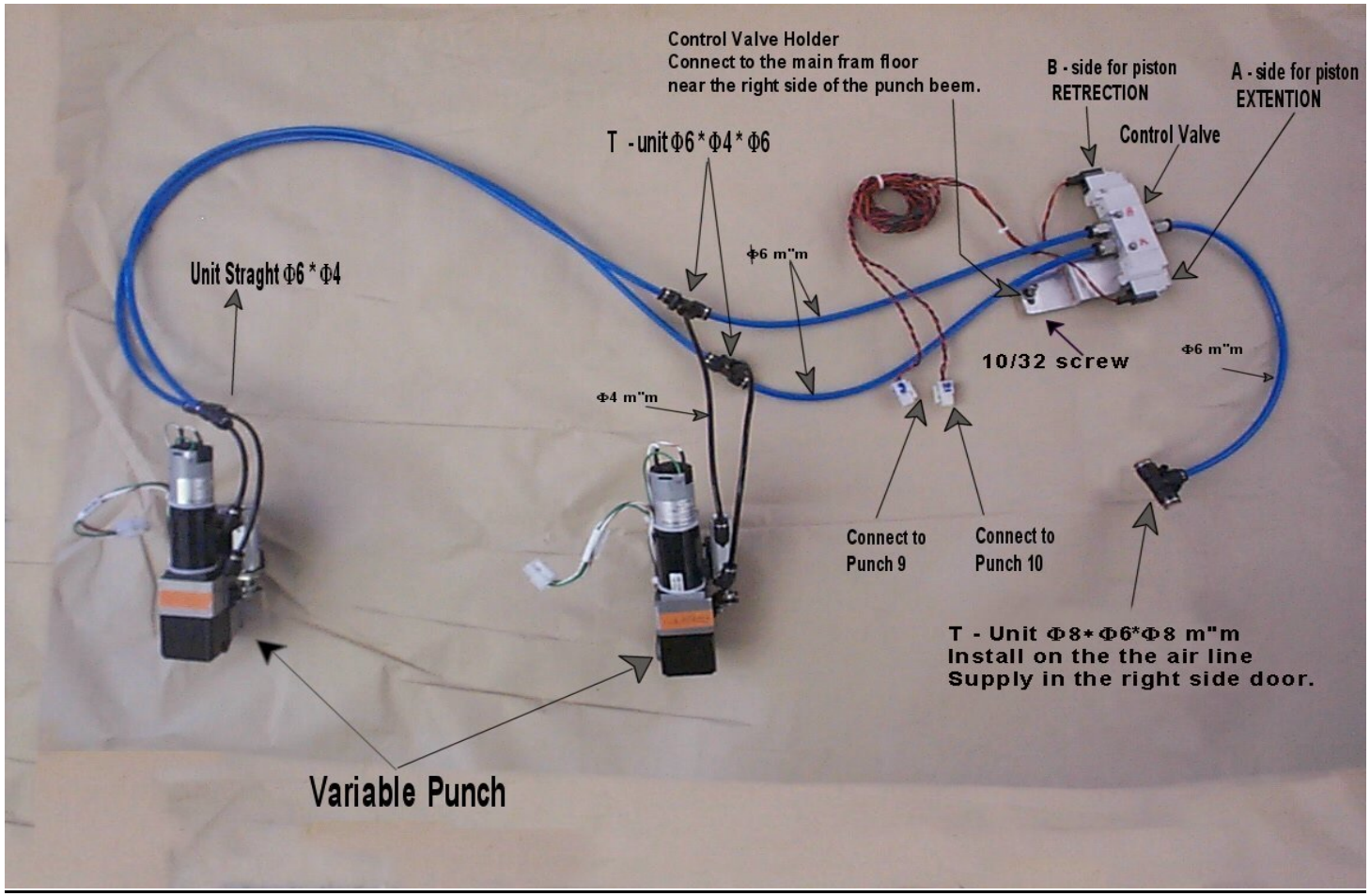
Variable (movable) punch Kit
Installation Procedure





Lotem 800 movable punches kit

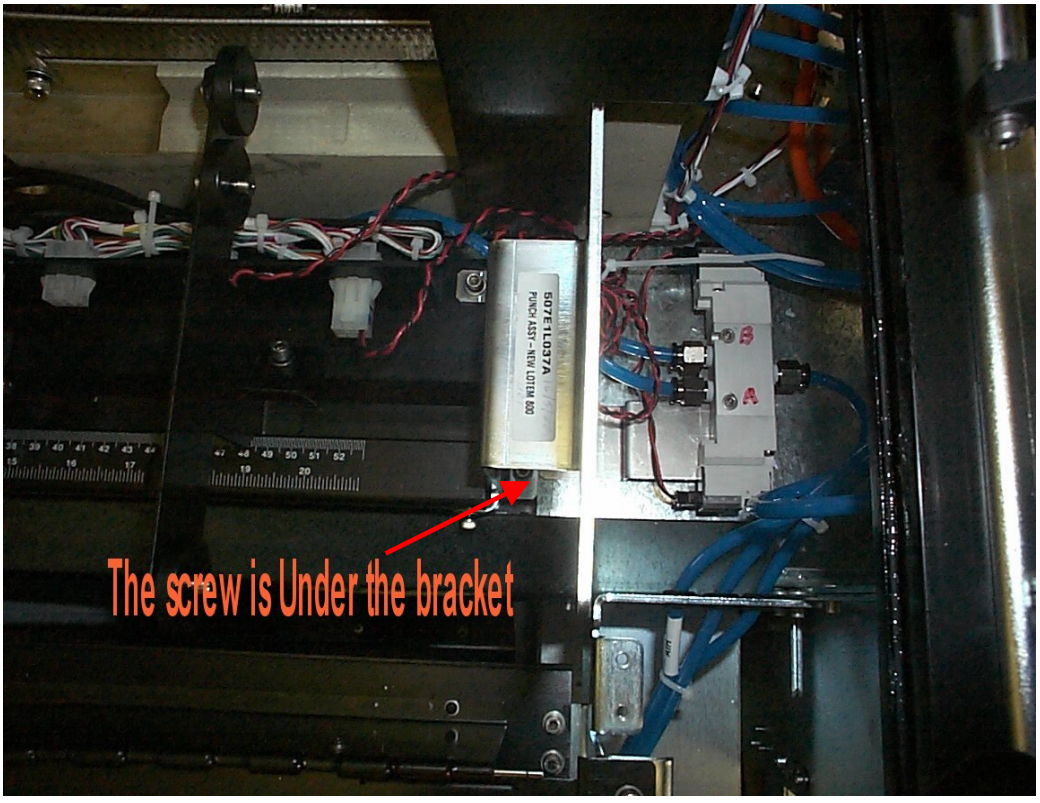


Installation Procedure

Hardware Changes

1. Open Top front door ,Right side door .
2. Shut air pressure supply off.
3. Shut Off the power From the main
4. Assemble the new punch unit on the bar and place diamond nut into the T-slot on the punch bar. (Note : Punch connectors 9,10 are saved for control).
5. Tighten the screw connecting the punch to the diamond nut.
   The diamond nut also turns until it comes into contact with the wall of the T-slot. Continue tightening the screw until the punch is secured firmly in place on the bar.
6. Take all measurements from the ruler on the punch bar.
7. Assemble the new punch control valve on the right side of the punch beam to the main frame, use 5/32 inch screw (10/ 32 Allan head),See picture 2.

   Picture 2



8. Route the air tubes & the harness from the control valve to the left side of the machine behind the punch beam.

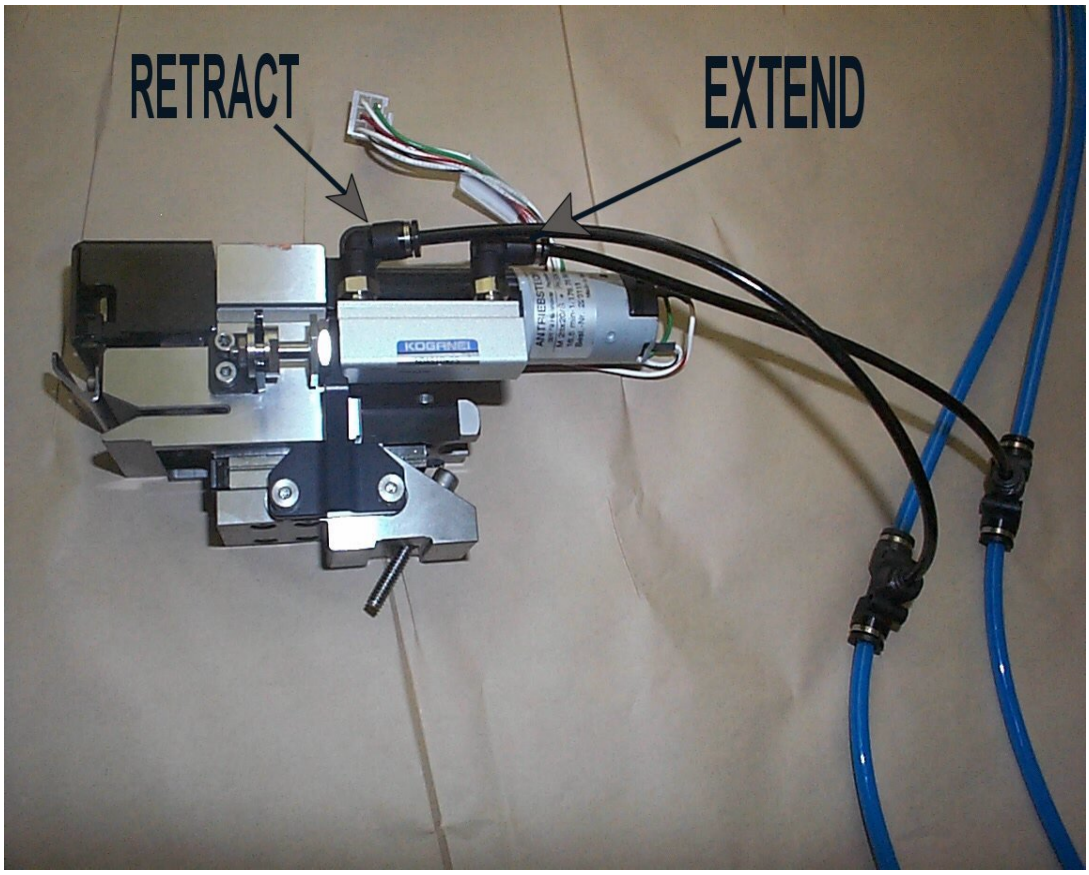
9. Install the new air T connector on the main supply line, which noted with label “MANIFOLD PRESR” (Orange air tube) , See picture 3.

Picture 3



10. Connect the air tubes Labeled **Extend** to the **Extend** side of the swivel connectors of each new punch cylinders, see picture 4.
11. Connect the air tubes Labeled **Retract** d to the **Retract** side of the swivel connectors of each new punch cylinders, see picture 4.

Picture 4



12. Trim excess length of air tubes.
13. Connect the electrical connectors of the control valve harness to existing punch harness connectors # 9 & 10 as labeled.

Software setting

1. Perform the following changes in the Lotem registry:
    a. Open all required punch motors , including motors 9 & 10.

       (to do that you need to change the " Open " from " 0 " to " 1 ")

    b. Open all required punch motors detectors , except motors 9 & 10 which must to remain " 0 ".

    c. On punch motor 9 & 10 ,change the time out from "15 " to " 5 " sec.
2. Define punch sets in the punch Data Base as follows:
    a. For punch sets that include the double Action punches ,but do not required

       The piston to be activated ,configure as usual .(Do not include punch motor

       9 & 10).

    B. For punch sets that require activating of the piston , include punch motor

       9 & 10 .
3. Close all the machine covers and test the punch variable unit

Testing

Note: refer to punch setting configuration.

After all the punches have been installed load a plate using the automatic loading system:

1. Punch the plate and then remove it for visual comparison with the master to confirm position of holes.
2. Move the punches if necessary or the positioning pin or a plate guide.
3. Let the press operator install the plate on press to verify position of punches.