

Power off during tool change

Condition 1



Step 1
Make sure emergency switch is off.



Emergency switch

Step 2
Put a paper board or cushion on table.



Paper board

Step 3

Have Person A climb up magazine. Pull lever left to release brake.



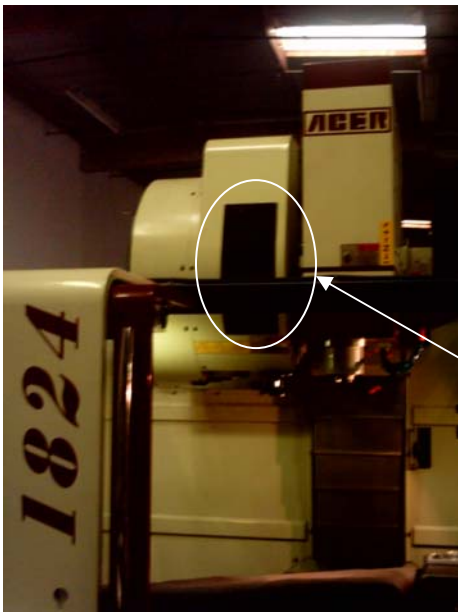
12 mm socket wrench

Motor brake lever

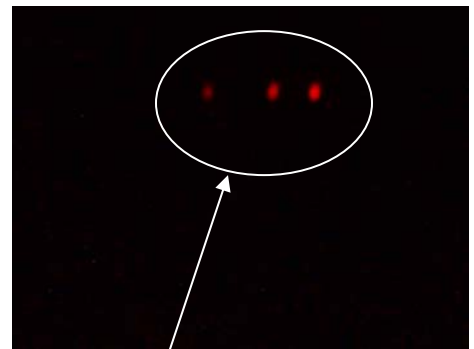
Step 4

Use 12mm socket wrench and turn **counterclockwise** until the arm turns. **Warning: make sure the arm swing back to Home Position away from tool (be careful, tool might drop).**

Have Person B on ground watch for three lights on magazine acrylic plate.



Magazine acrylic plate



Three lights

Give signal to Person A to stop turning until **only one center light remains.**



Single light



Arm must be perpendicular to operator.
After one light remains, Person A **needs to make sure to pull lever right, back to original position.**



Step 5
Push Shift key and exit control. Turn power off (Red push button).



Step 6
Restart machine. Release emergency switch. Press “SERVO RESET”, tool will pop up automatically.

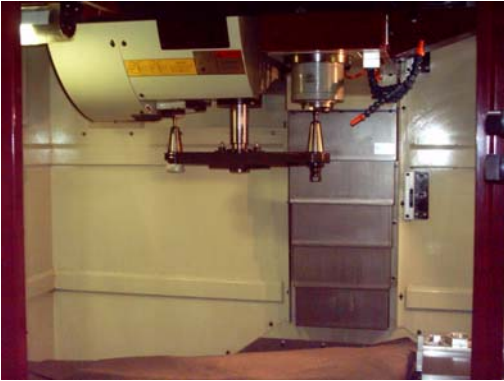
Step 7

Remove tool from magazine with tool from tool box.



Tool magazine needs to be retooled.

Condition 2



Step 1

Make sure emergency switch is off.



Emergency switch

Step 2

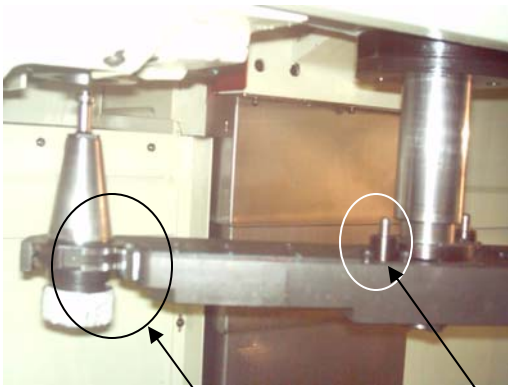
Put a paper board or cushion on table.



Paper board

Step 3

Clear both tools by releasing the tool release pin and tool lock from arm.



Tool engaged
lock

Tool release
pin

Step 4

Have Person A climb up magazine. Pull lever left to release brake.

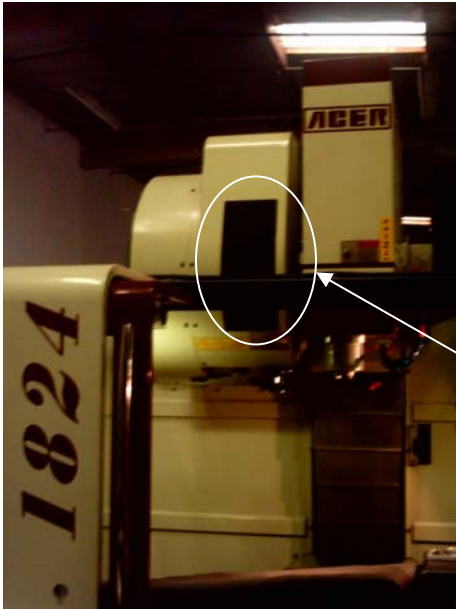


12 mm socket
wrench

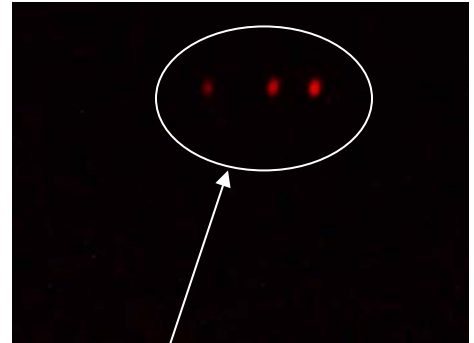
Motor brake
lever

Step 5

Use 12mm socket wrench and turn clockwise until the arm turns (be careful, tool might drop). Have Person B on ground watch for three lights on magazine acrylic plate.



Magazine acrylic plate



Three lights

Give signal to Person A to stop turning until **only one center light remains.**



Single light



Arm must be perpendicular to operator.

After one light remains, Person A **needs to make sure to pull lever right, back to original position.**

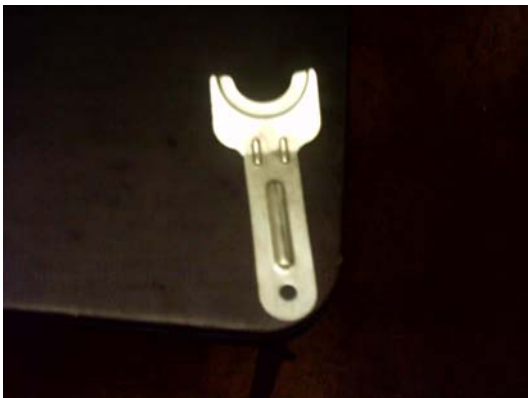


Step 6
Push Shift key and exit control. Turn power off (Red push button).



Step 7
Restart machine. Release emergency switch. Press “SERVO RESET”, tool will pop up automatically.

Step 8
Remove tool from magazine with tool from tool box.



Tool magazine needs to be retooled.