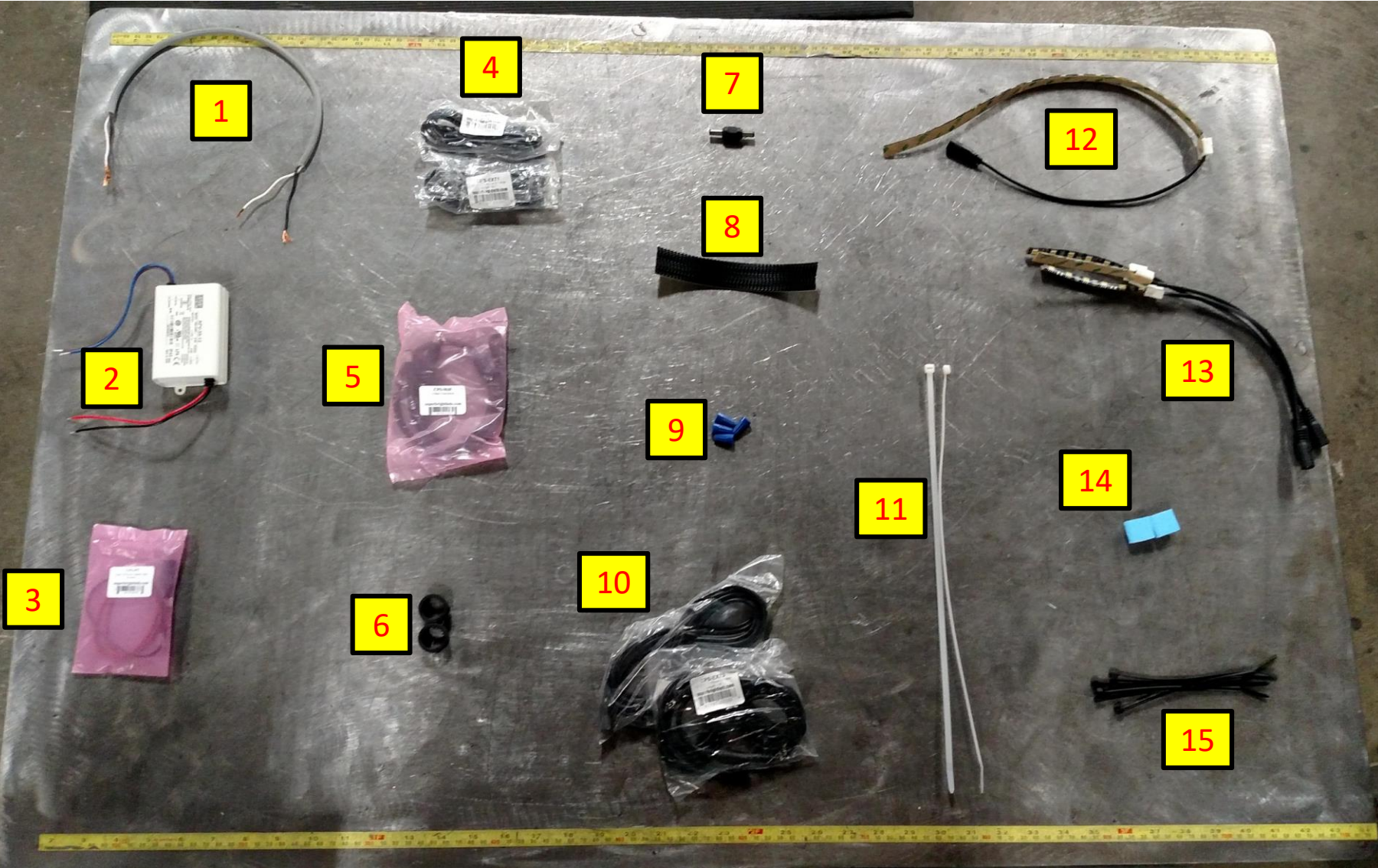


P/N 090513 –LED LIGHT 505EC RETROFIT KIT INSTRUCTIONS





1

4

7

12

2

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15

PARTS LIST

ITEM NUMBER	QUANTITY	PART NUMBER	DESCRIPTION
1	18 IN.	660461	18/2 SVO CORD
2	1	090508	LED LIGHT TRANSFORMER
3	1	090507	PIGTAIL CONNECTOR
4	2	090503	1 METER EXTENSION
5	1	090509	4-WAY SPLITTER
6	2	158003	#3104 SNAP BUSHING
7	1	090506	MALE-MALE CONNECTOR
8	6 IN.	013167	3M VELCRO
9	4	145005	SMALL BLUE WIRE NUT
10	2	090502	3 METER EXTENSION
11	2	045635	14" CABLE TIE AS
12	1	090544	21 LED BULB STRIP (14 IN.)
13	3	090540	6 LED BULB STRIP (4 IN.)
14	2	011713	LATCHING CLIP
15	12	660505	BLACK NYLON CABLE TIE

BASIC CONSIDERATIONS

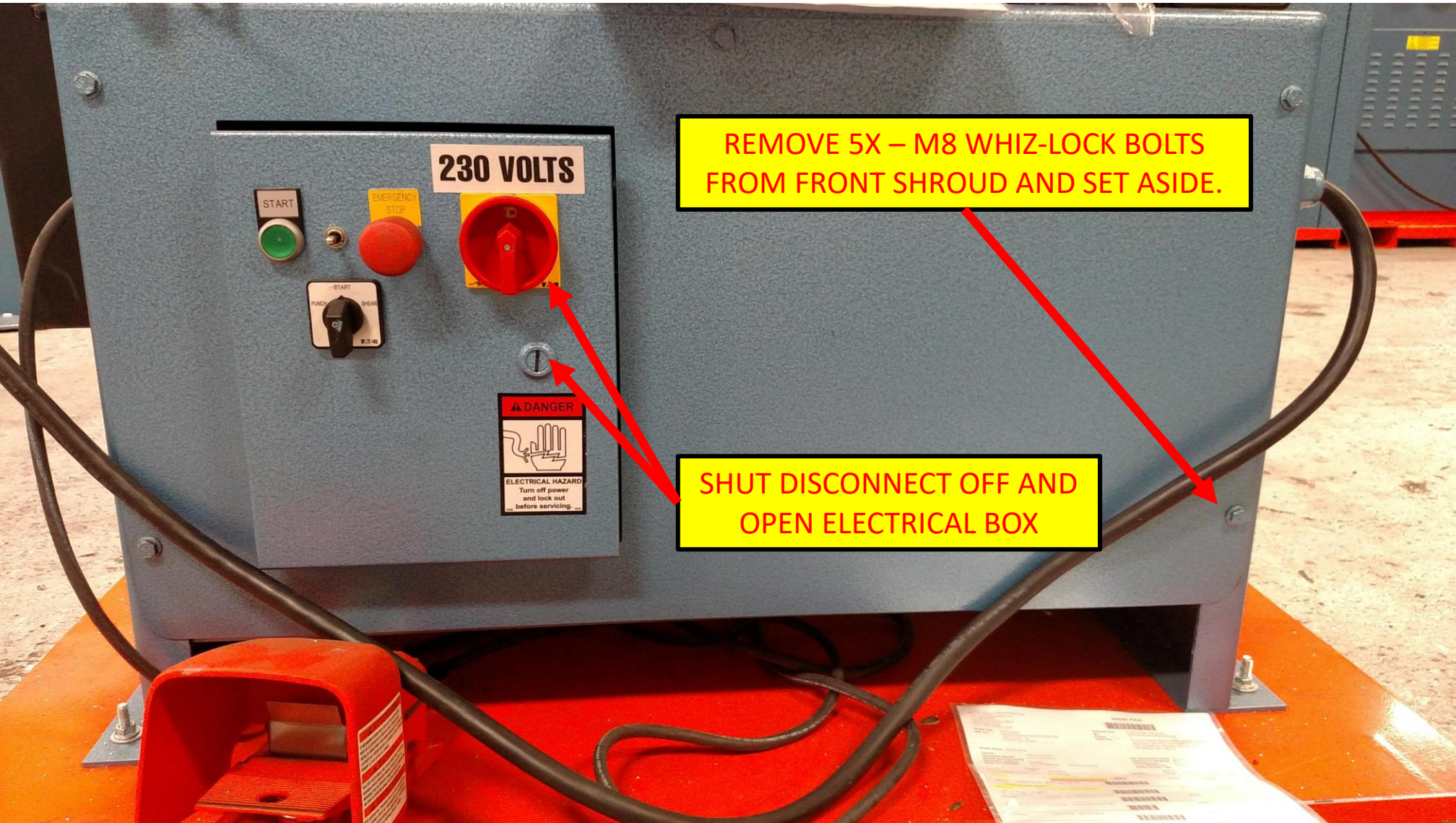
- Please read the instructions **FULLY** before attempting to install the product.
- Make sure to unplug the machine from its electrical source and perform any necessary lockout/tagout procedures.
- If the old worklight is installed, it will be necessary to remove the cord from the base. The light can stay on the machine, but it cannot be wired into the electrical box.
- **NOTE:** The 3M VHB Tape is a pressure activated adhesive. If **LIGHTLY APPLIED** to a surface, it may be possible to pull off and reapply. If **FIRMLY ATTACHED**, it will be near impossible to move.
- The strips are regarded as a one – time application product. Therefore, care must be undertaken when applying the strips.
- In the event of a strip that has fallen off or been pulled off, it may be possible to reapply either the whole strip or a portion with the application of cyanoacrylate adhesives (i.e. Super Glue).
- It is **NOT** a guarantee that a cyanoacrylate product will work, but depending on surface preparation and adhesion on the strip, there is a chance that it may.

SURFACE PREPARATION

- Scotchman Industries' machines ship with an oil – based rust preventative coating on exposed, unpainted surfaces. Due to application, certain areas where the LED strips will be installed may be coated with protectant.
- To prep the surface for the LED strips, it is recommended to use a 50:50 mixture of isopropyl alcohol (IPA) and water to clean the surface.
- For areas with heavy oil, grease, oxidation, or dust, a degreaser and/or abrasion may be necessary before the alcohol mixture to prep the surface.
- Click this [link](#) for an in – depth article about surface preparation for 3M™ VHB™ Tape Applications.
- You can also use this QR Code:



- Back to Shear ([Page 27](#)); Notcher ([Page 32](#)); Punch ([Page 39](#))



230 VOLTS

START

EMERGENCY STOP

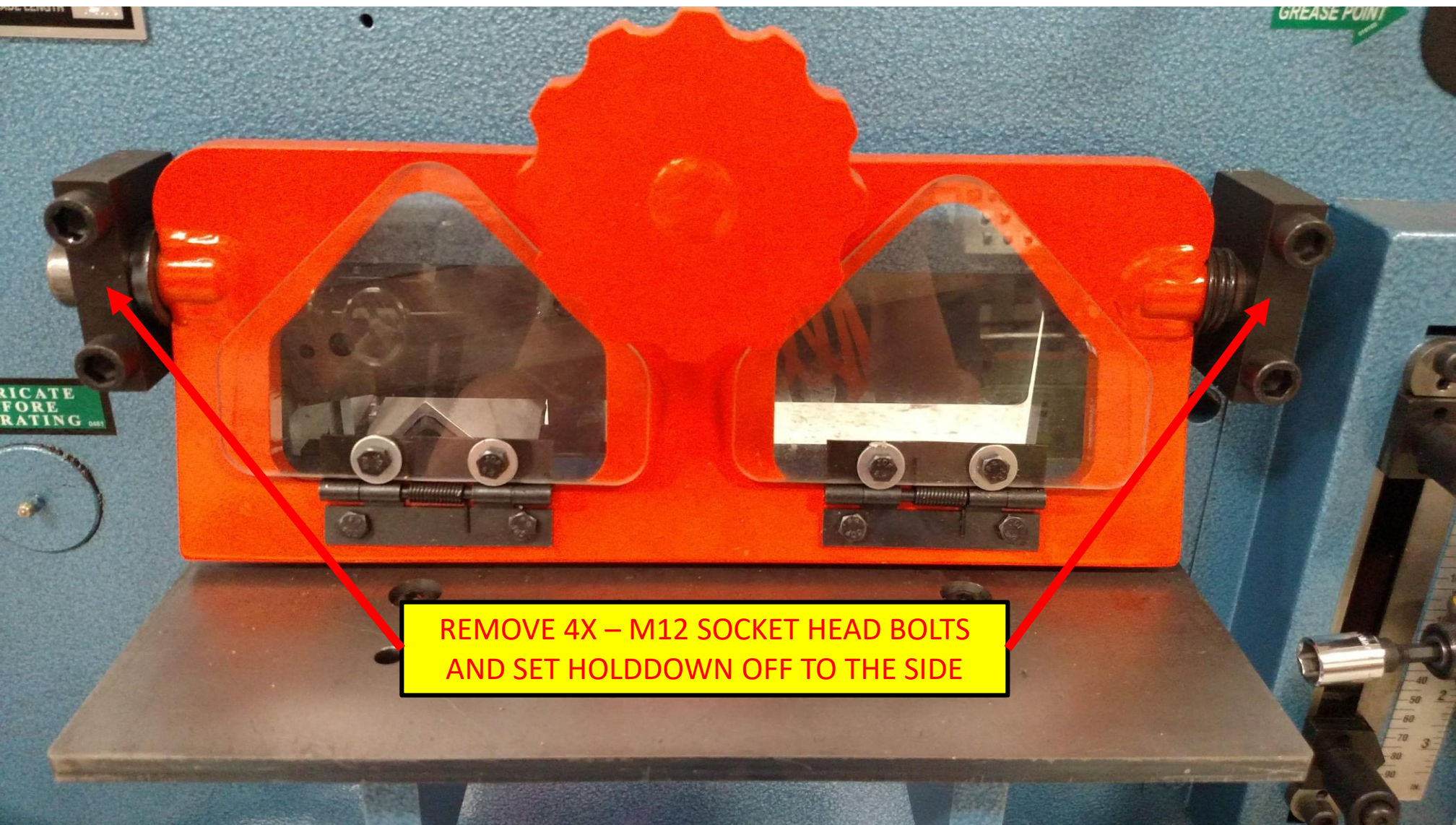
START
PUNCH BEAR

DISCONNECT SWITCH

DANGER
ELECTRICAL HAZARD
Turn off power and lock out before servicing

REMOVE 5X – M8 WHIZ-LOCK BOLTS FROM FRONT SHROUD AND SET ASIDE.

SHUT DISCONNECT OFF AND OPEN ELECTRICAL BOX



REMOVE 4X – M12 SOCKET HEAD BOLTS
AND SET HOLDDOWN OFF TO THE SIDE

UNBOLT ANGLE SHEAR AND
SLIDE IT BACK TOWARDS THE
CONNECTING LINK.

WARNING




TO PREVENT SERIOUS BODILY
INJURY DO NOT PLACE FINGERS
BEYOND THESE GUARDS

1210

003105

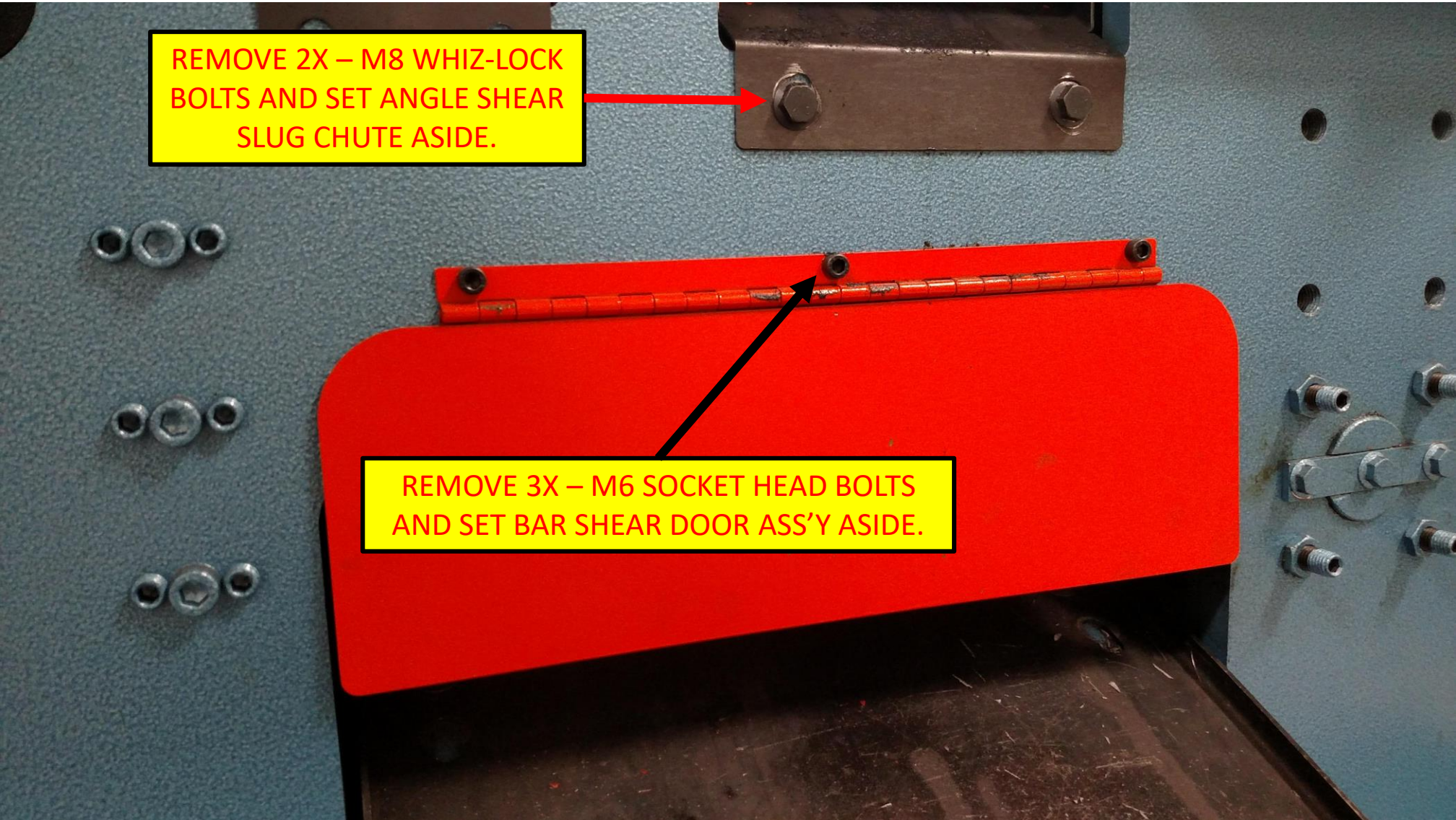
C
S
PSI TENSILE
RE
NOTC
2 1/2 X
2 1/2 X 2
63.5 X 76 X 8MM
63.5 X 70 X 10MM
GLE SHEAR
4X4X3/8"
90X100X10MM
8.16

A photograph of a blue metal electrical cabinet. A red arrow points upwards from a yellow text box to a small circular hole on the top surface of the cabinet. The cabinet is mounted on a concrete floor. In the background, there is a red fire extinguisher and some black cables.

OPTIONAL: REMOVE 5X – M8 WHIZ-LOCK BOLTS FROM REAR SHROUD. THIS MAY MAKE IT EASIER TO ACCESS WIRES INSIDE THE BASE

REMOVE 2X – M8 WHIZ-LOCK
BOLTS AND SET ANGLE SHEAR
SLUG CHUTE ASIDE.

REMOVE 3X – M6 SOCKET HEAD BOLTS
AND SET BAR SHEAR DOOR ASS'Y ASIDE.



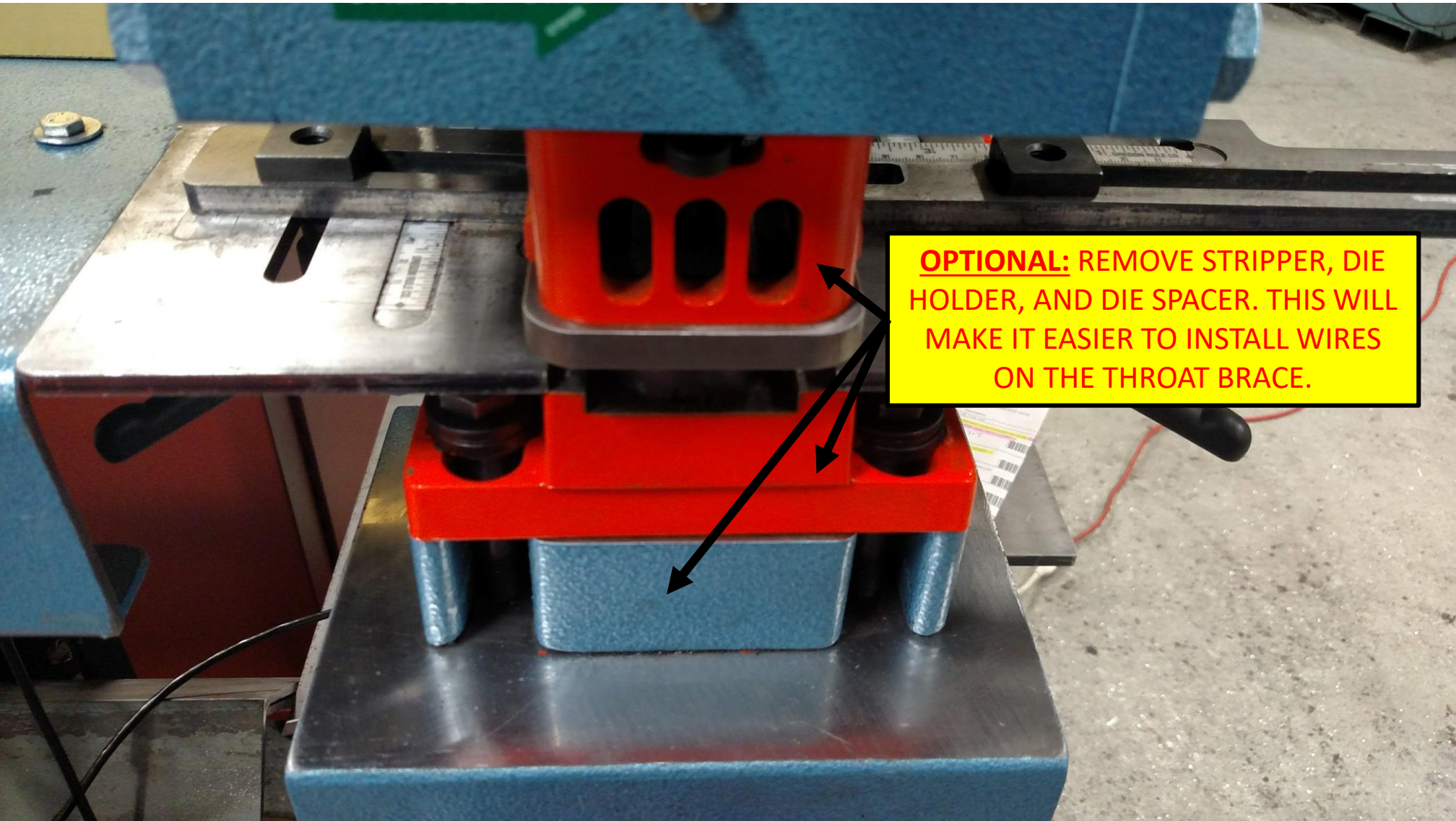


REMOVE 4X - M8 HEX HEAD
BOLTS AND SET NOTCHER
SLUG CHUTE ASIDE.

REMOVE 4X – M8 HEX HEAD BOLTS AND SET PUNCH SLUG CHUTE ASIDE.

REMOVE 2X – M8 HEX HEAD BOLTS AND SET NOTCHER GUARD ASIDE.

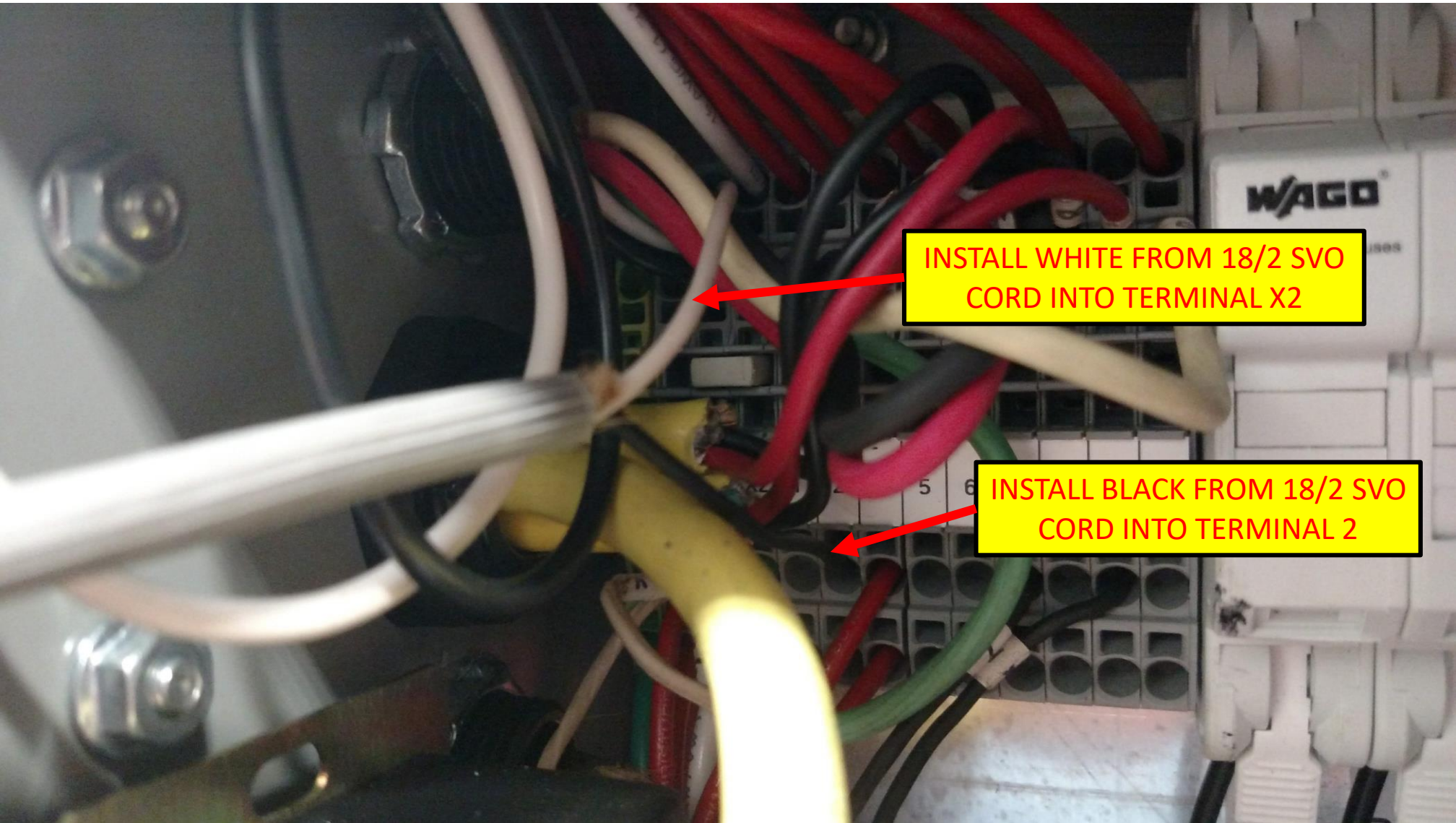




OPTIONAL: REMOVE STRIPPER, DIE HOLDER, AND DIE SPACER. THIS WILL MAKE IT EASIER TO INSTALL WIRES ON THE THROAT BRACE.



**IF NOT ALREADY INSTALLED, REMOVE KNOCKOUT
PLUG FROM ELECTRICAL BOX AND INSTALL P/N
158003 - #3104 SNAP BUSHING**



INSTALL WHITE FROM 18/2 SVO
CORD INTO TERMINAL X2

INSTALL BLACK FROM 18/2 SVO
CORD INTO TERMINAL 2

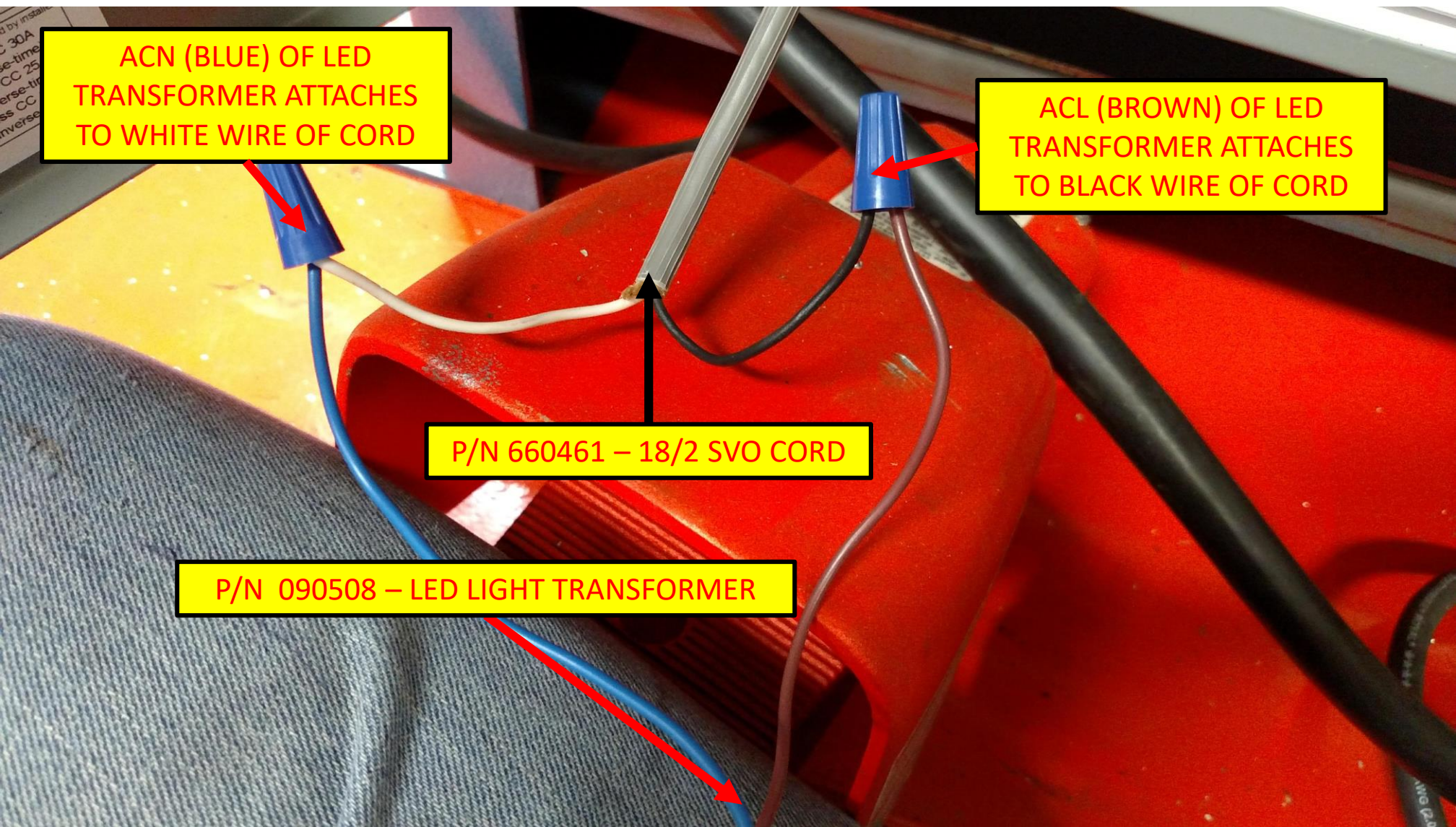
by instal
C 30A
e-time
CC 25
erse-tir
ss CC
nverse

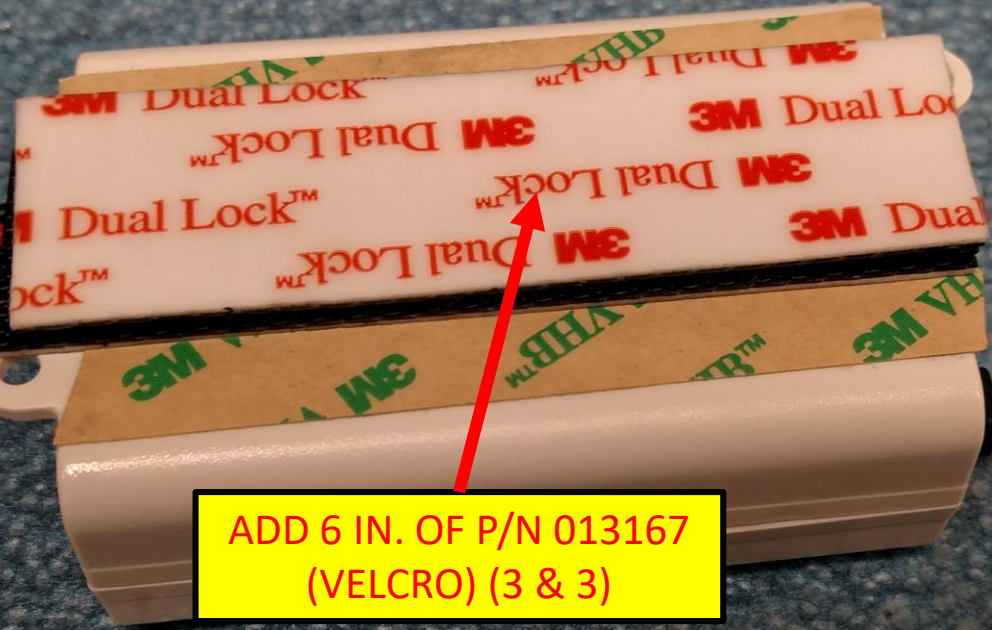
ACN (BLUE) OF LED
TRANSFORMER ATTACHES
TO WHITE WIRE OF CORD

ACL (BROWN) OF LED
TRANSFORMER ATTACHES
TO BLACK WIRE OF CORD

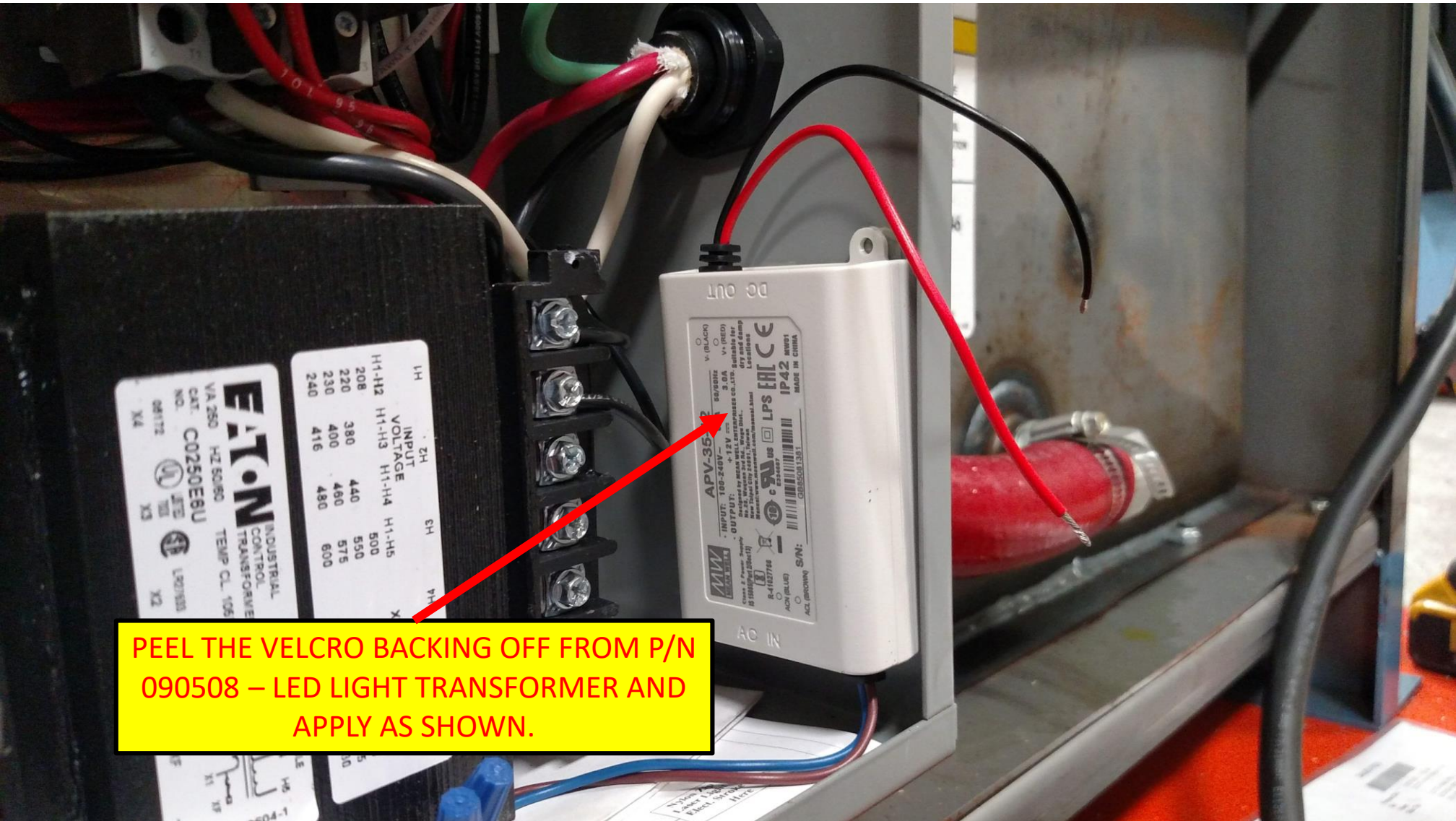
P/N 660461 – 18/2 SVO CORD

P/N 090508 – LED LIGHT TRANSFORMER





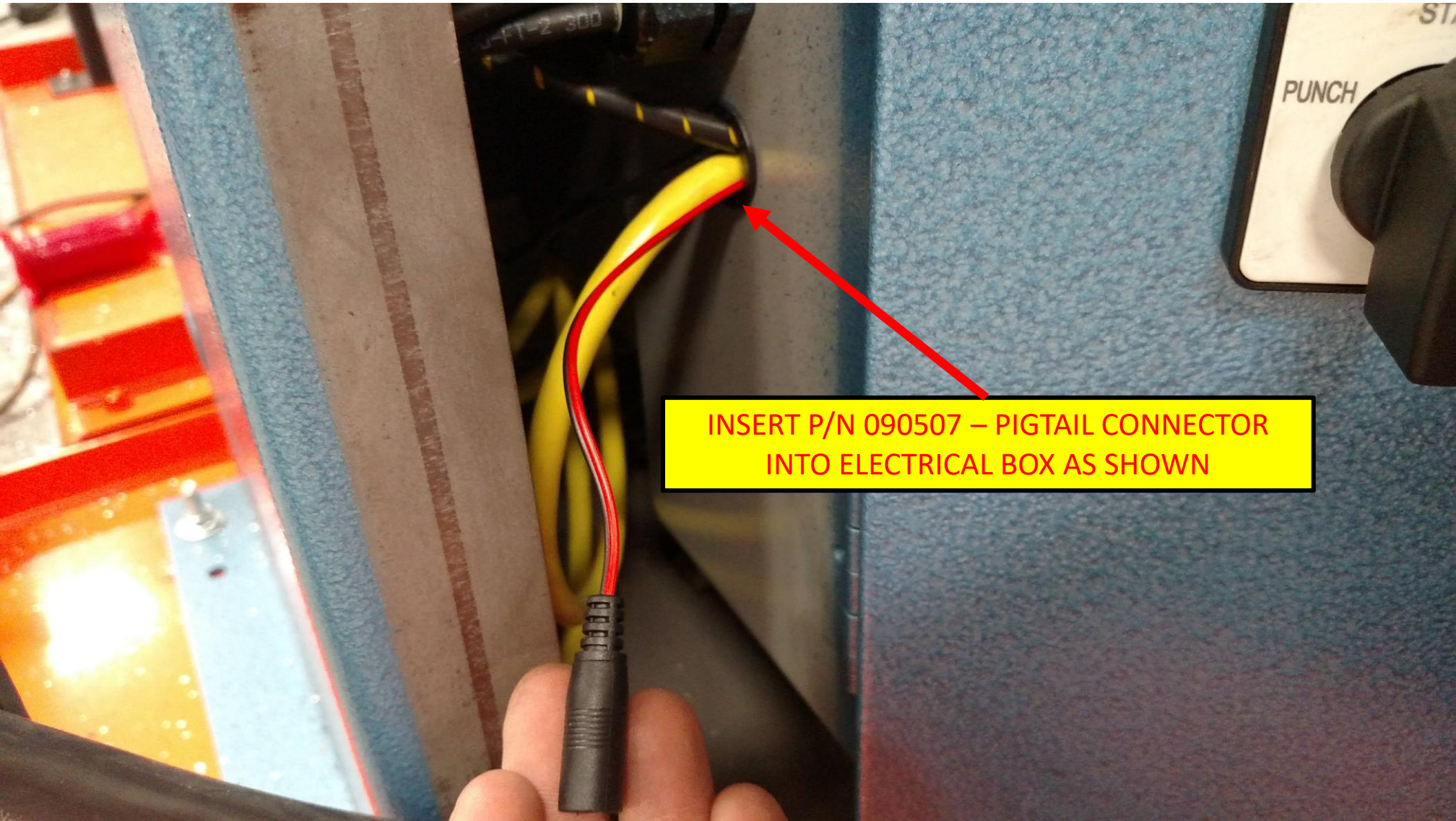
ADD 6 IN. OF P/N 013167
(VELCRO) (3 & 3)



PEEL THE VELCRO BACKING OFF FROM P/N 090508 - LED LIGHT TRANSFORMER AND APPLY AS SHOWN.

Eaton INDUSTRIAL CONTROL TRANSFORMER
VA 250 HZ 50/60 CAT. C0250E6U
NO. 08172
X1 X2 X3 X4

IH	2H	3H	4H
H1-H2	H1-H3	H1-H4	H1-H5
208	380	440	500
220	400	460	575
230	400	480	600
240	416	480	600

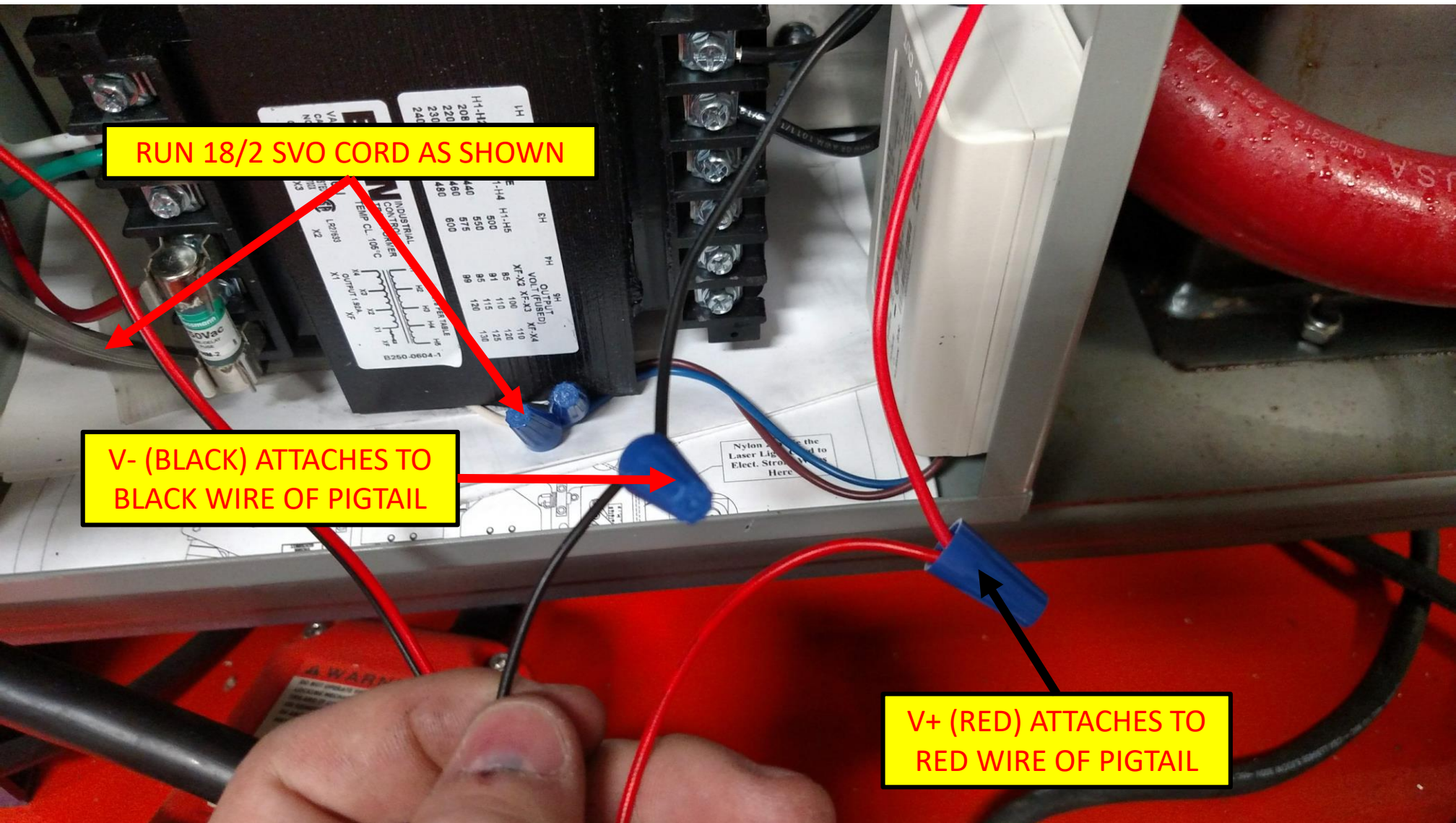


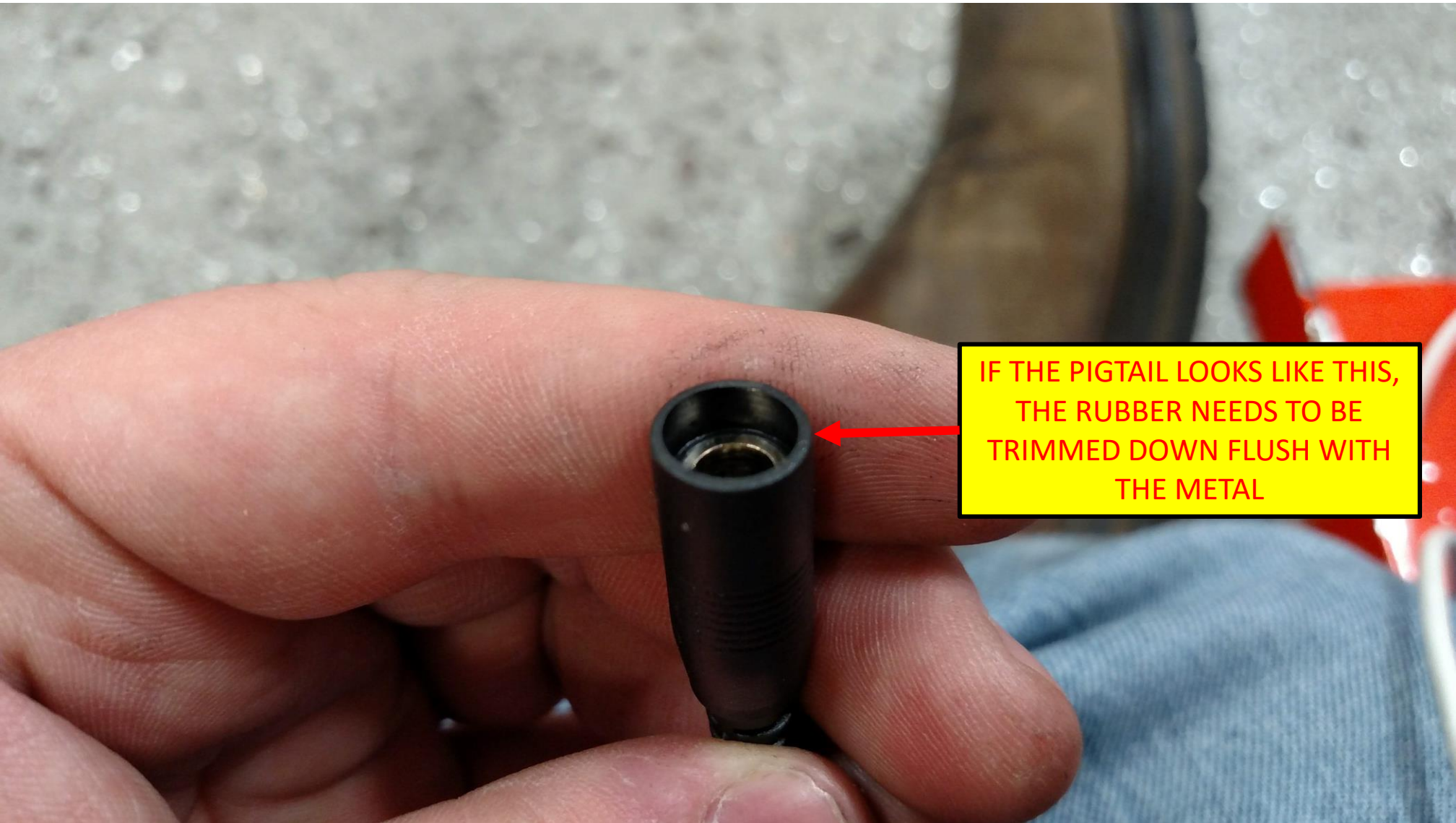
INSERT P/N 090507 – PIGTAIL CONNECTOR
INTO ELECTRICAL BOX AS SHOWN

RUN 18/2 SVO CORD AS SHOWN

**V- (BLACK) ATTACHES TO
BLACK WIRE OF PIGTAIL**

**V+ (RED) ATTACHES TO
RED WIRE OF PIGTAIL**





IF THE PIGTAIL LOOKS LIKE THIS,
THE RUBBER NEEDS TO BE
TRIMMED DOWN FLUSH WITH
THE METAL



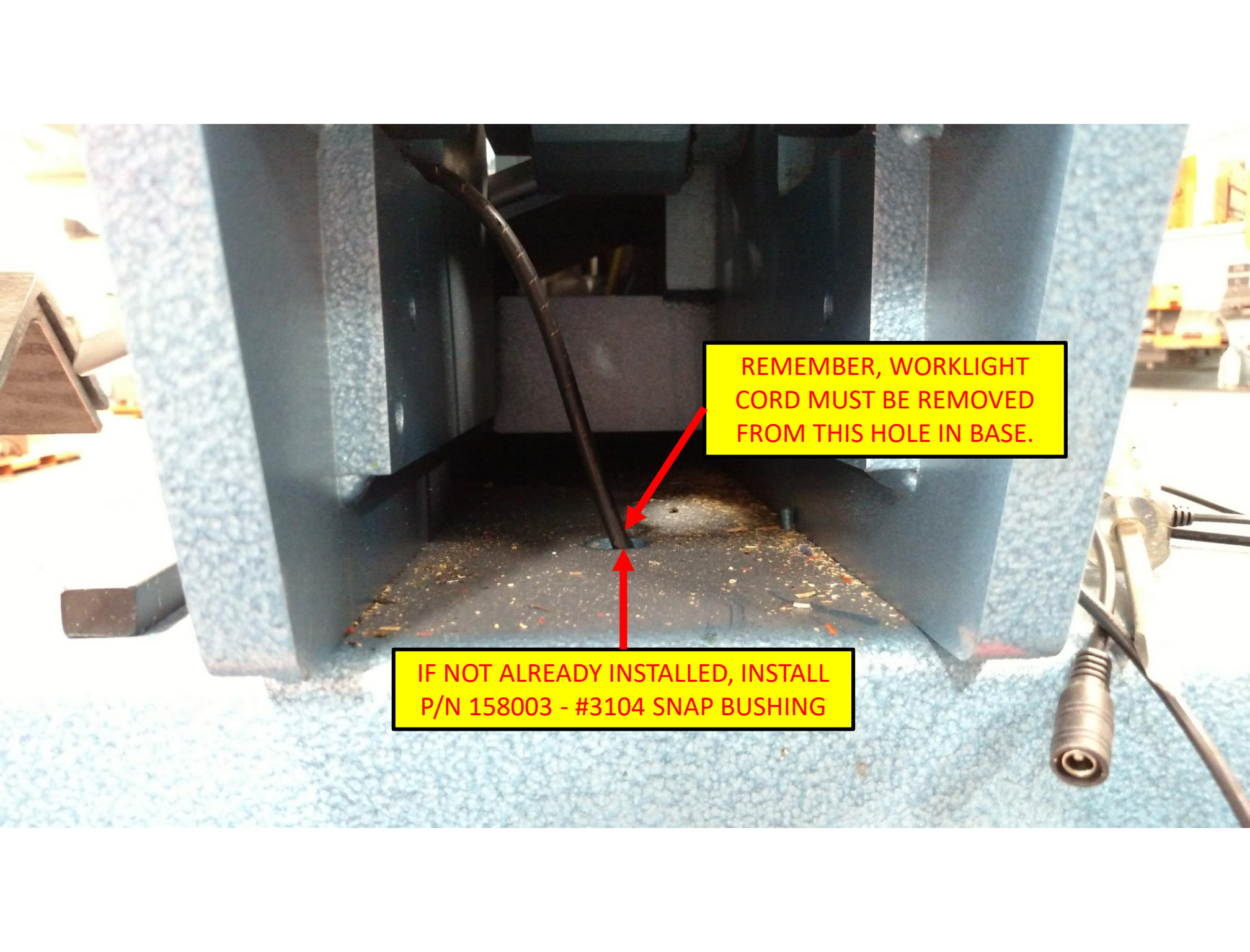
THIS IS WHAT IT SHOULD LOOK LIKE

P/N 090506 – MALE-MALE CONNECTOR





P/N 090509 – 4-WAY SPLITTER



REMEMBER, WORKLIGHT
CORD MUST BE REMOVED
FROM THIS HOLE IN BASE.

IF NOT ALREADY INSTALLED, INSTALL
P/N 158003 - #3104 SNAP BUSHING

MAKE A SMALL MARK IN THE MIDDLE
OF P/N 090544 – 21 LED BULB STRIP
(14 IN.) WITH A SHARPIE




NOTE: BEFORE APPLYING THE LED STRIP, IT IS VERY IMPORTANT TO CLEAN THE SURFACE AS DETAILED [HERE](#).

CLEAN UNDERSIDE.

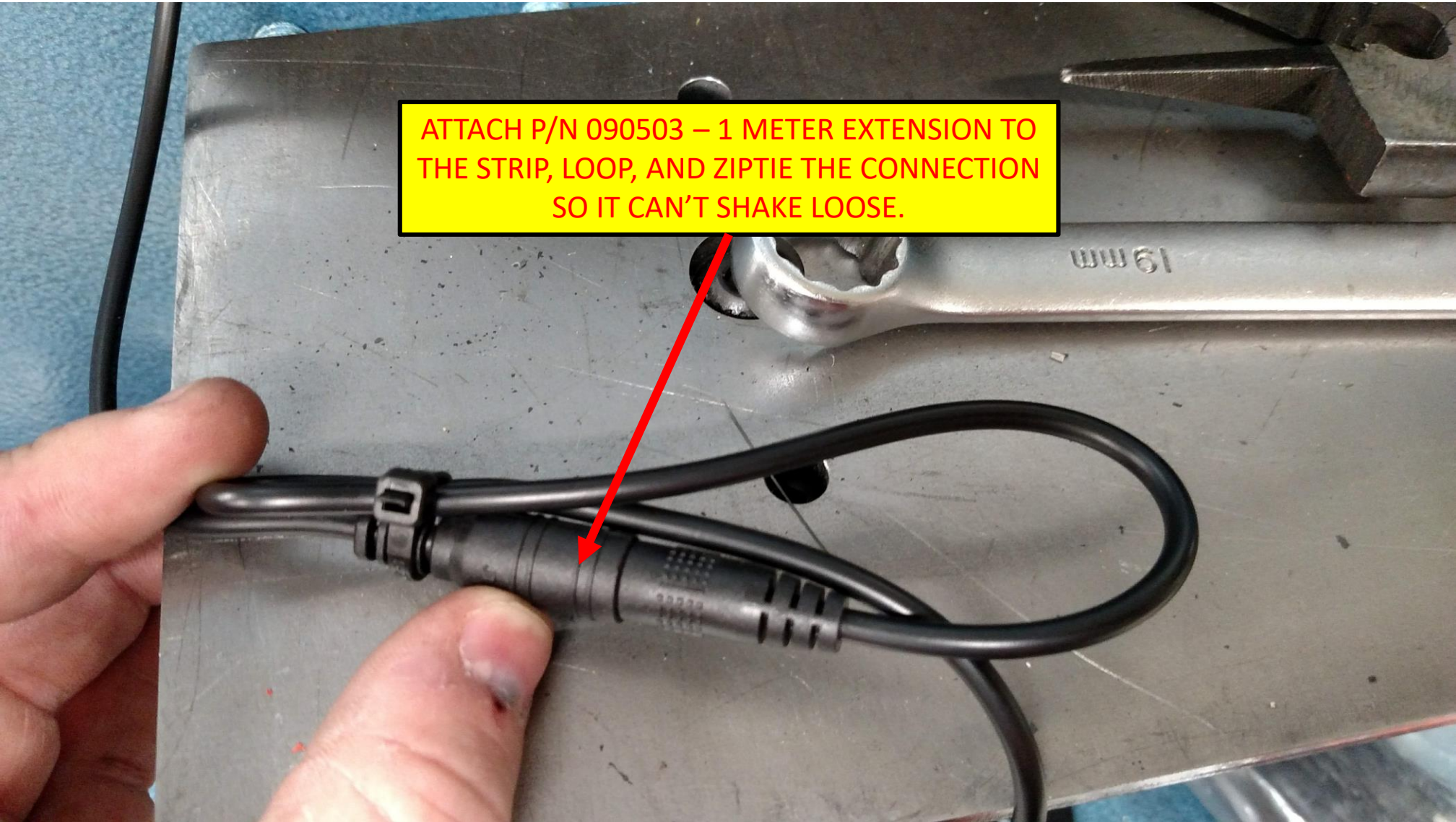
MAKE A SMALL MARK IN THE CENTER OF THE OPENING ON THE FRONT FRAME. YOU CAN HOLD THE STRIP UP AND CENTER IT TO MAKE YOUR MARK.

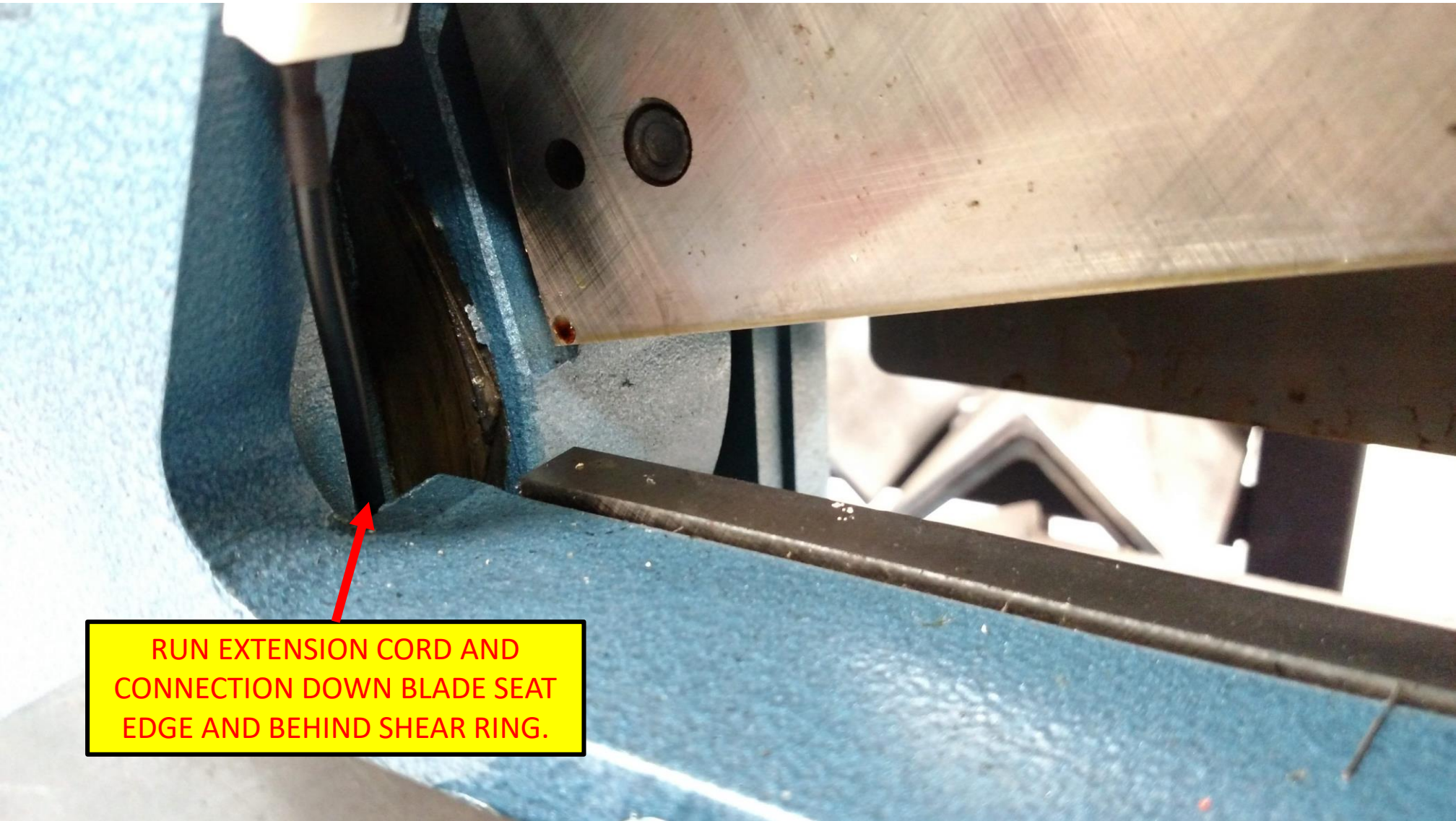
NOTE: THE 3M VHB TAPE IS A PRESSURE ACTIVATED ADHESIVE. IF **LIGHTLY APPLIED** TO A SURFACE, IT MAY BE POSSIBLE TO PULL OFF AND REAPPLY. IF **FIRMLY ATTACHED**, IT WILL BE NEAR IMPOSSIBLE TO MOVE.



PEEL THE TAPE BACKING OFF AND APPLY THE STRIP TO THE UNDERSIDE, MAKING SURE TO CENTER IN THE FRAME. RUN FINGER ALONG AND PRESS FIRMLY.

ATTACH P/N 090503 – 1 METER EXTENSION TO THE STRIP, LOOP, AND ZIPTIE THE CONNECTION SO IT CAN'T SHAKE LOOSE.





**RUN EXTENSION CORD AND
CONNECTION DOWN BLADE SEAT
EDGE AND BEHIND SHEAR RING.**

VIEWING DOWN FRONT OF MACHINE BETWEEN FRAMES

LOOPED AND ZIPTIED CONNECTION





CLEAN UNDERSIDE.

NOTE: BEFORE APPLYING THE LED STRIP, IT IS VERY IMPORTANT TO CLEAN THE SURFACE AS DETAILED [HERE](#).

5/16" (8MM)

NOTE: THE 3M VHB TAPE IS A PRESSURE ACTIVATED ADHESIVE. IF ***LIGHTLY APPLIED*** TO A SURFACE, IT MAY BE POSSIBLE TO PULL OFF AND REAPPLY. IF ***FIRMLY ATTACHED***, IT WILL BE NEAR IMPOSSIBLE TO MOVE.



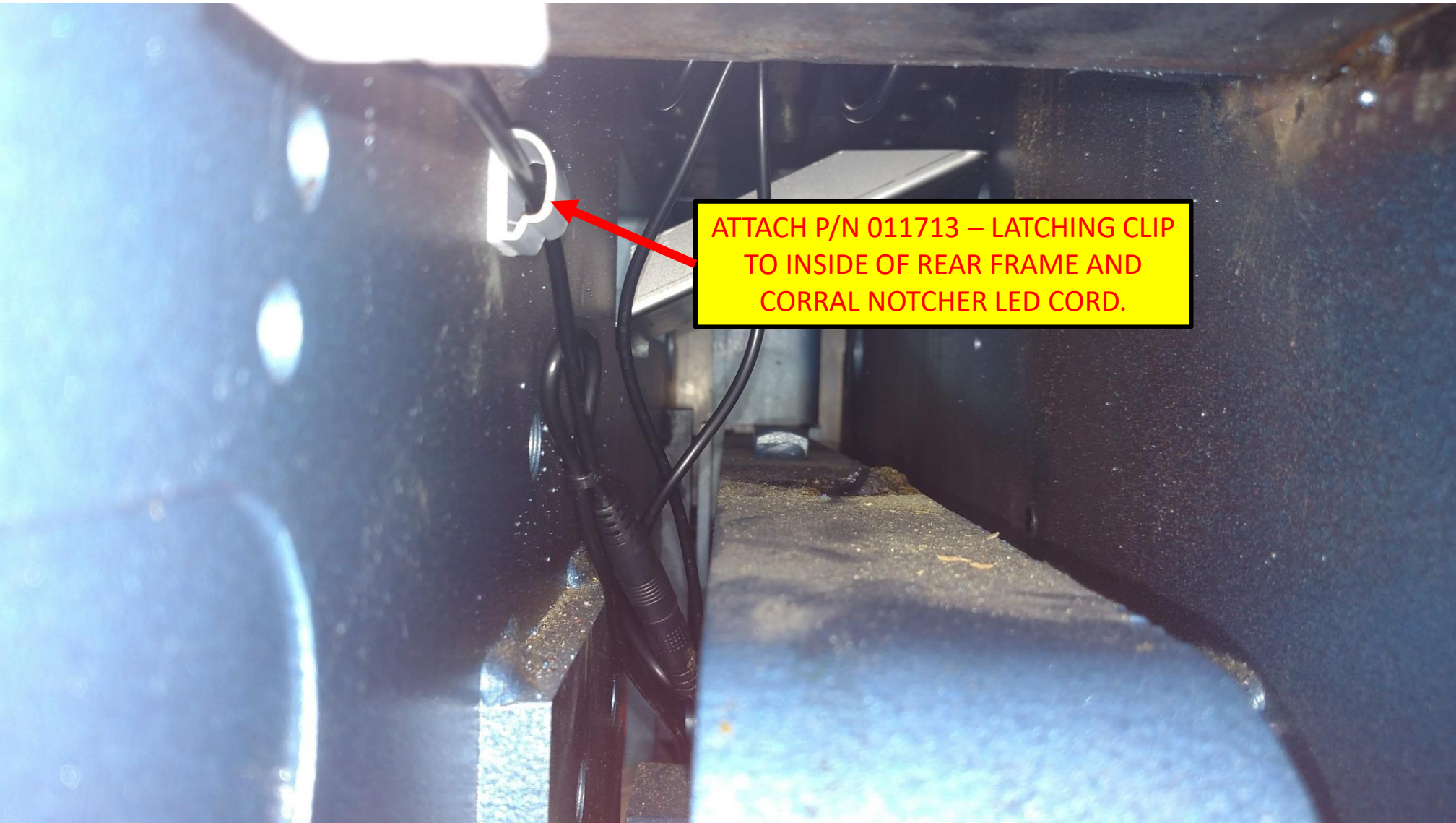
REMOVE TAPE BACKING AND APPLY P/N 090540 – 6 LED BULB STRIP (4 IN.) UNDER PUNCH BOLSTER. PRESS FIRMLY.



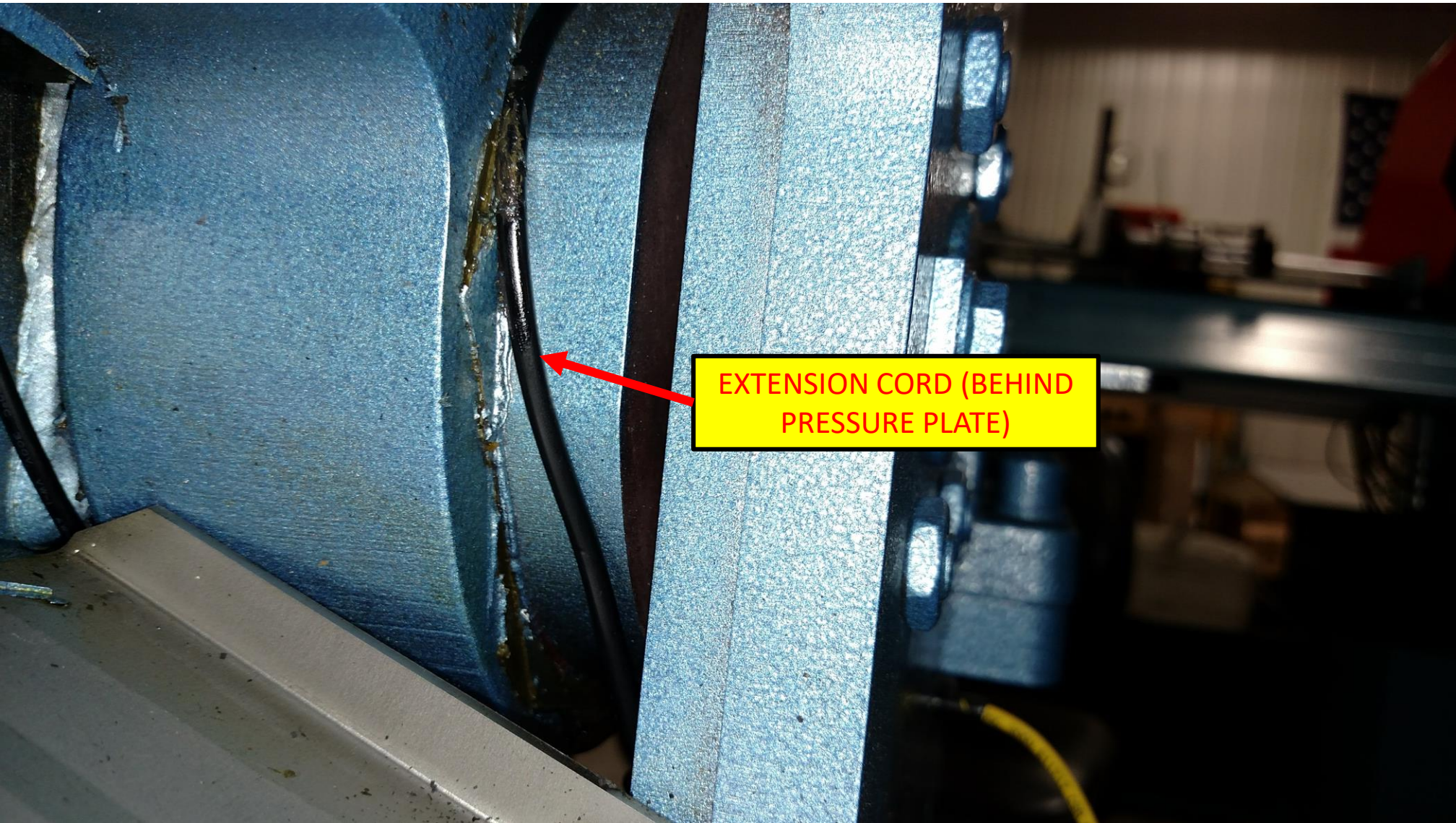
ATTACH P/N 090503 – 1 METER EXTENSION
TO THE STRIP, LOOP, AND ZIPTIE THE
CONNECTION SO IT CAN'T SHAKE LOOSE.



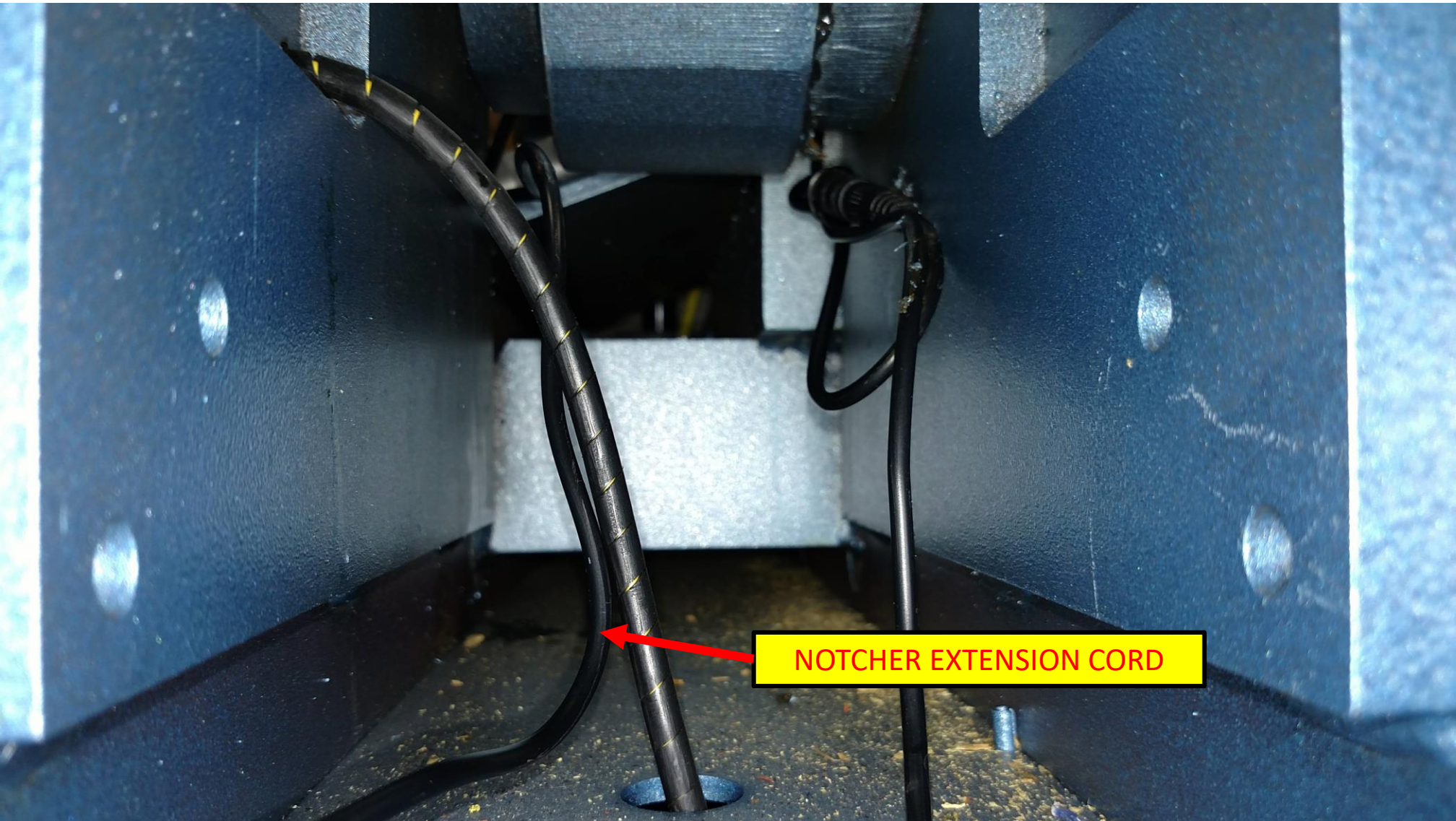
**RUN EXTENSION CORD AND CONNECTION OVER
PRESSURE PLATE AND DOWN BACKSIDE**



ATTACH P/N 011713 – LATCHING CLIP
TO INSIDE OF REAR FRAME AND
CORRAL NOTCHER LED CORD.



EXTENSION CORD (BEHIND
PRESSURE PLATE)



NOTCHER EXTENSION CORD




CLEAN THROAT BRACE
FROM TOP TO OVER
HALFWAY DOWN

NOTE: BEFORE APPLYING THE LED STRIP, IT IS VERY
IMPORTANT TO CLEAN THE SURFACE AS DETAILED [HERE](#).



ALIGN TOP OF
CONNECTORS WITH TOP
OF THROAT BRACE

REMOVE TAPE
BACKING AND APPLY
2X – P/N 090540 – 6
LED BULB STRIP (4
IN.). PRESS FIRMLY.



NOTE: THE 3M VHB TAPE IS A PRESSURE ACTIVATED ADHESIVE. IF *LIGHTLY APPLIED* TO A SURFACE, IT MAY BE POSSIBLE TO PULL OFF AND REAPPLY. IF *FIRMLY ATTACHED*, IT WILL BE NEAR IMPOSSIBLE TO MOVE.



RUN STRIP CORDS OVER
TOP OF THROAT BRACE
AND DOWN BACKSIDE.

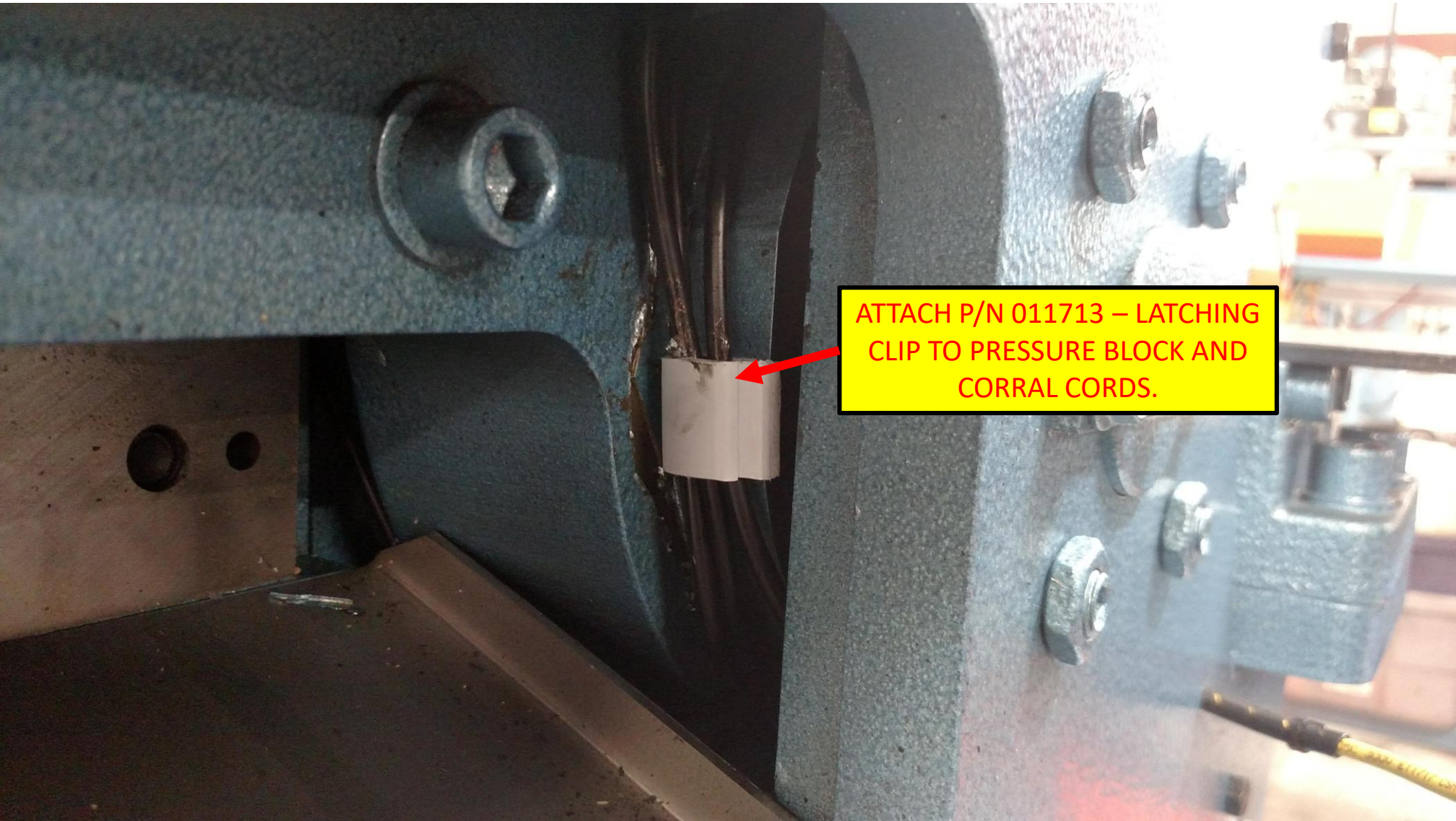
ATTACH 2X – P/N 090502 – 3
METER EXTENSION CORDS TO
STRIPS, LOOP, AND ZIPTIE.



KEEP EXTENSION CORDS ON THE
BACKSIDE OF THE SHEAR BEAM,
BEHIND THE PRESSURE PLATE.

A close-up photograph of a blue industrial machine. A yellow text box with a black border is overlaid on the left side, containing the text "RUN CORDS BEHIND PRESSURE PLATE AND UNDERNEATH." in red, all-caps font. A red arrow points from the text box to a bundle of black cables that are routed behind a vertical blue metal plate and underneath a horizontal metal surface. The background is slightly blurred, showing other parts of the machine and a white object.

**RUN CORDS BEHIND PRESSURE
PLATE AND UNDERNEATH.**

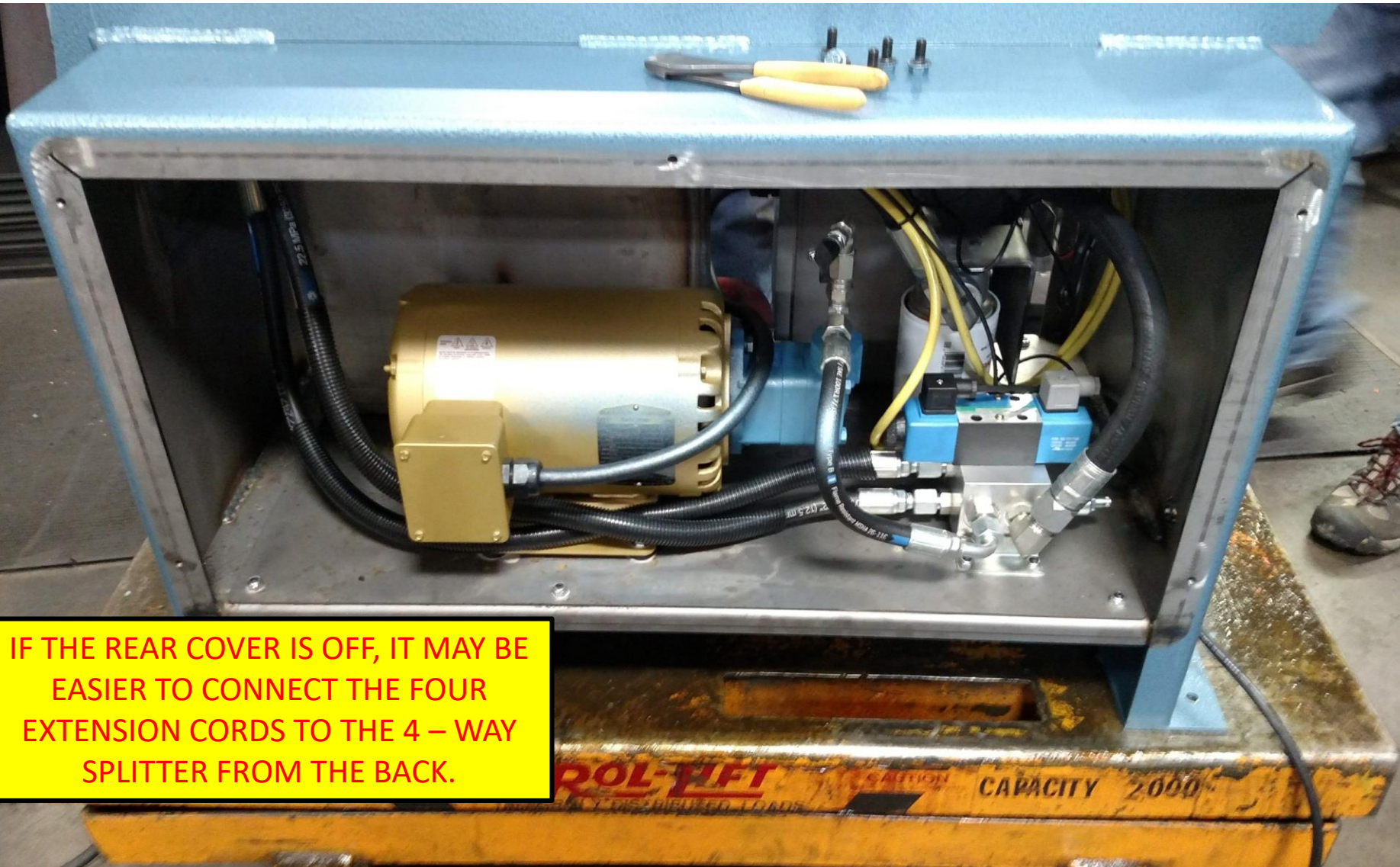


**ATTACH P/N 011713 – LATCHING
CLIP TO PRESSURE BLOCK AND
CORRAL CORDS.**



RUN ALL FOUR EXTENSION CORDS THROUGH BUSHING INTO BASE. LEAVE MAJORITY OF EXCESS ABOVE THE BASE.

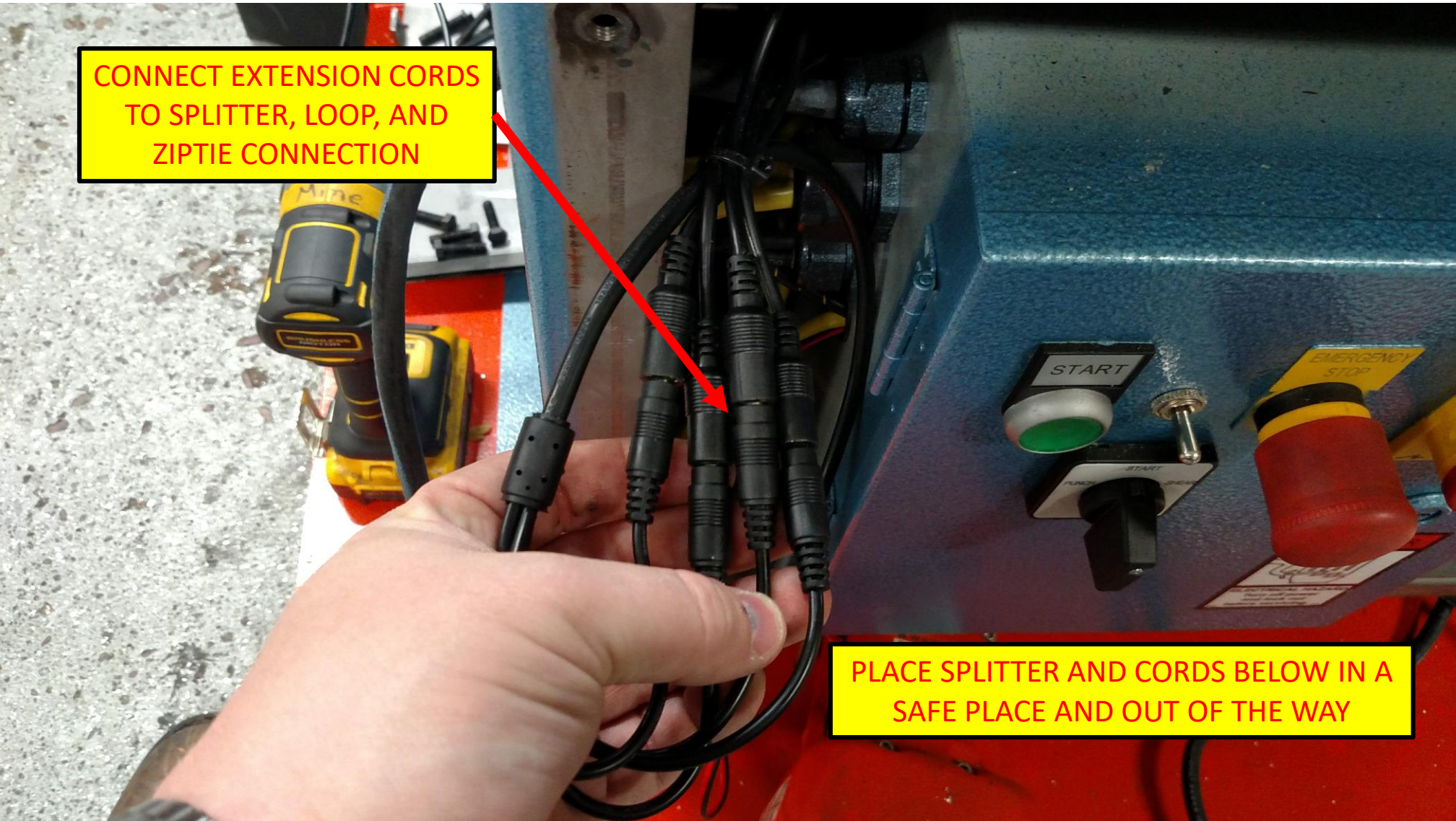
BUSHING NOT SHOWN.



IF THE REAR COVER IS OFF, IT MAY BE EASIER TO CONNECT THE FOUR EXTENSION CORDS TO THE 4 – WAY SPLITTER FROM THE BACK.

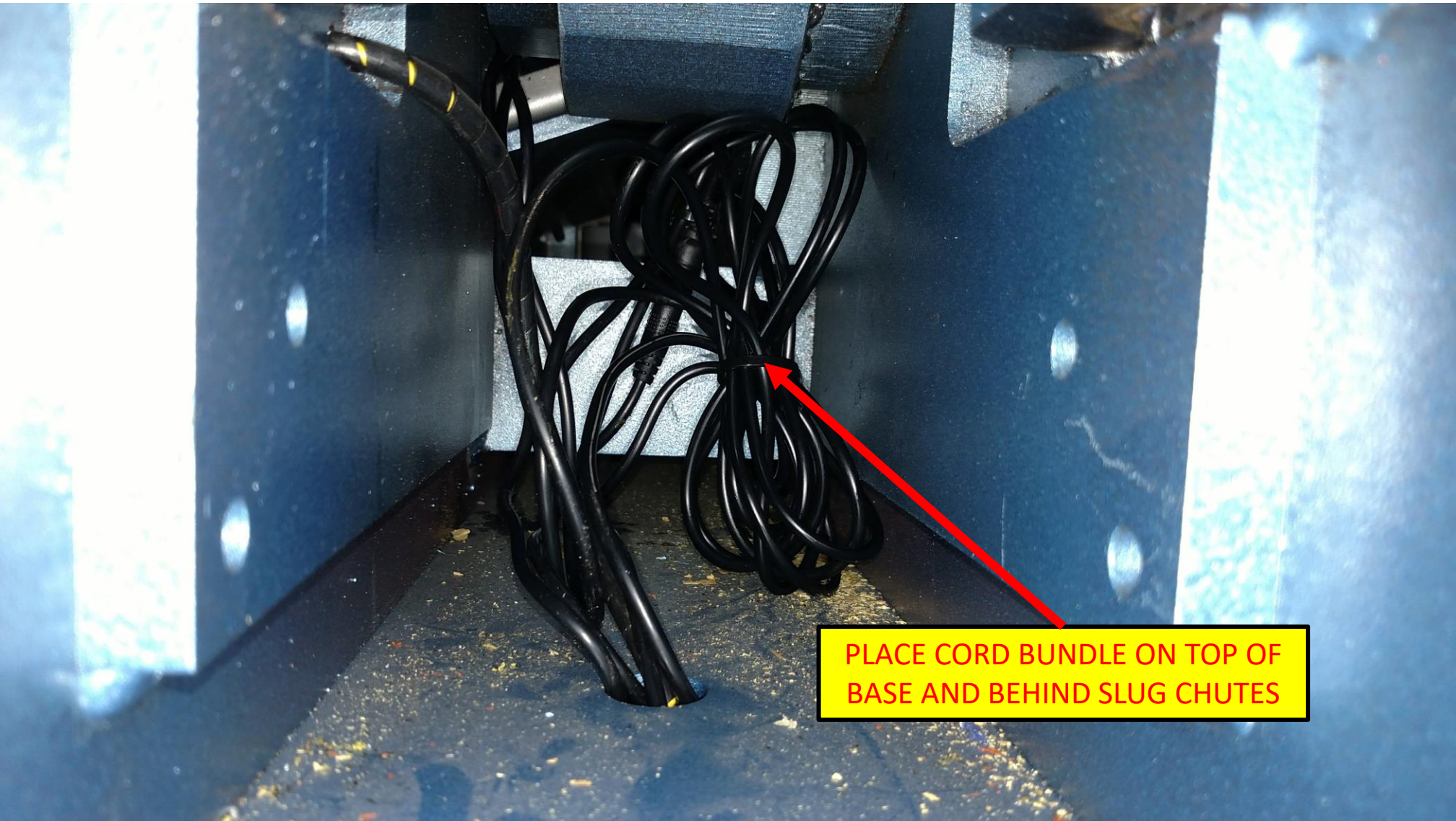
CONNECT EXTENSION CORDS
TO SPLITTER, LOOP, AND
ZIPTIE CONNECTION

PLACE SPLITTER AND CORDS BELOW IN A
SAFE PLACE AND OUT OF THE WAY

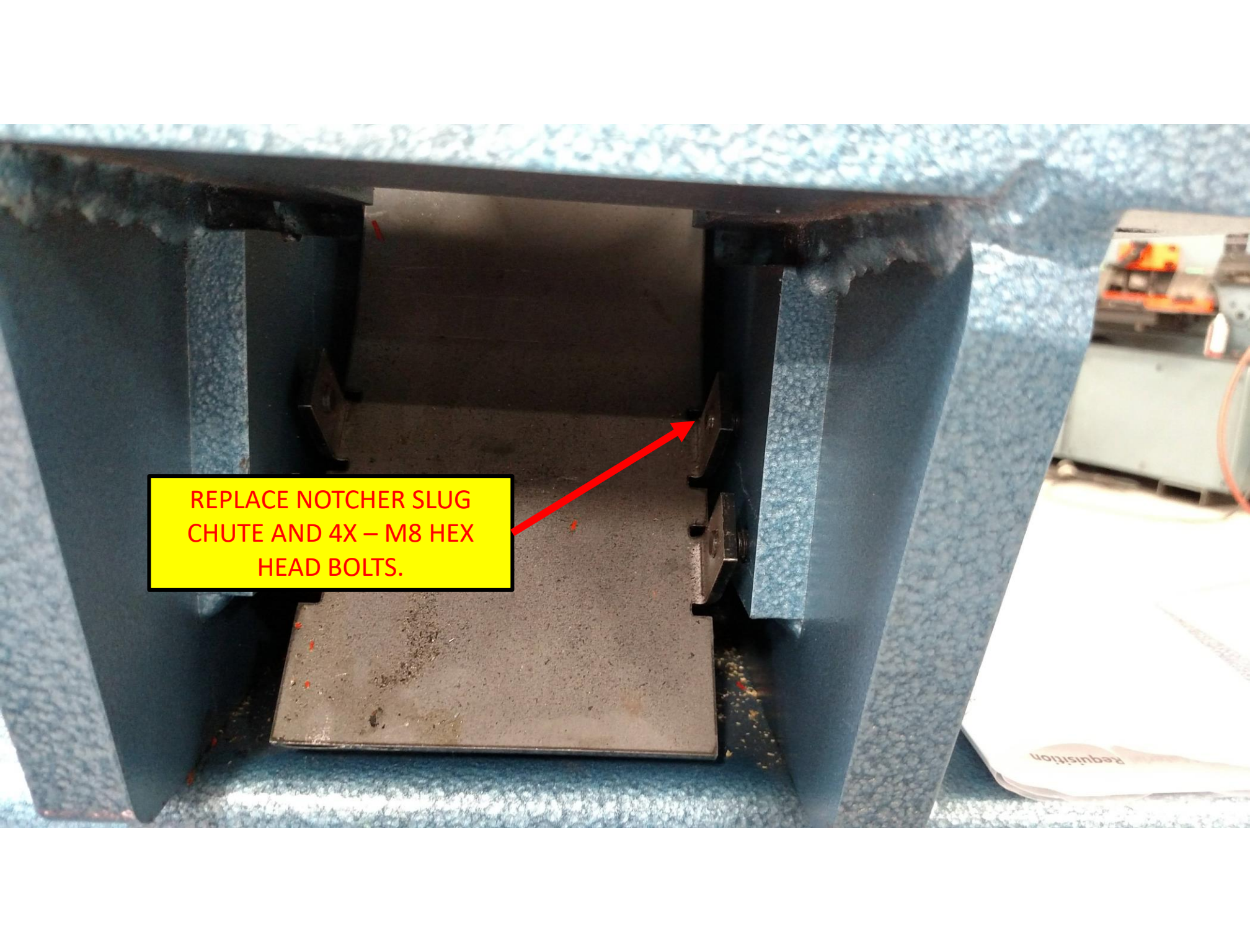




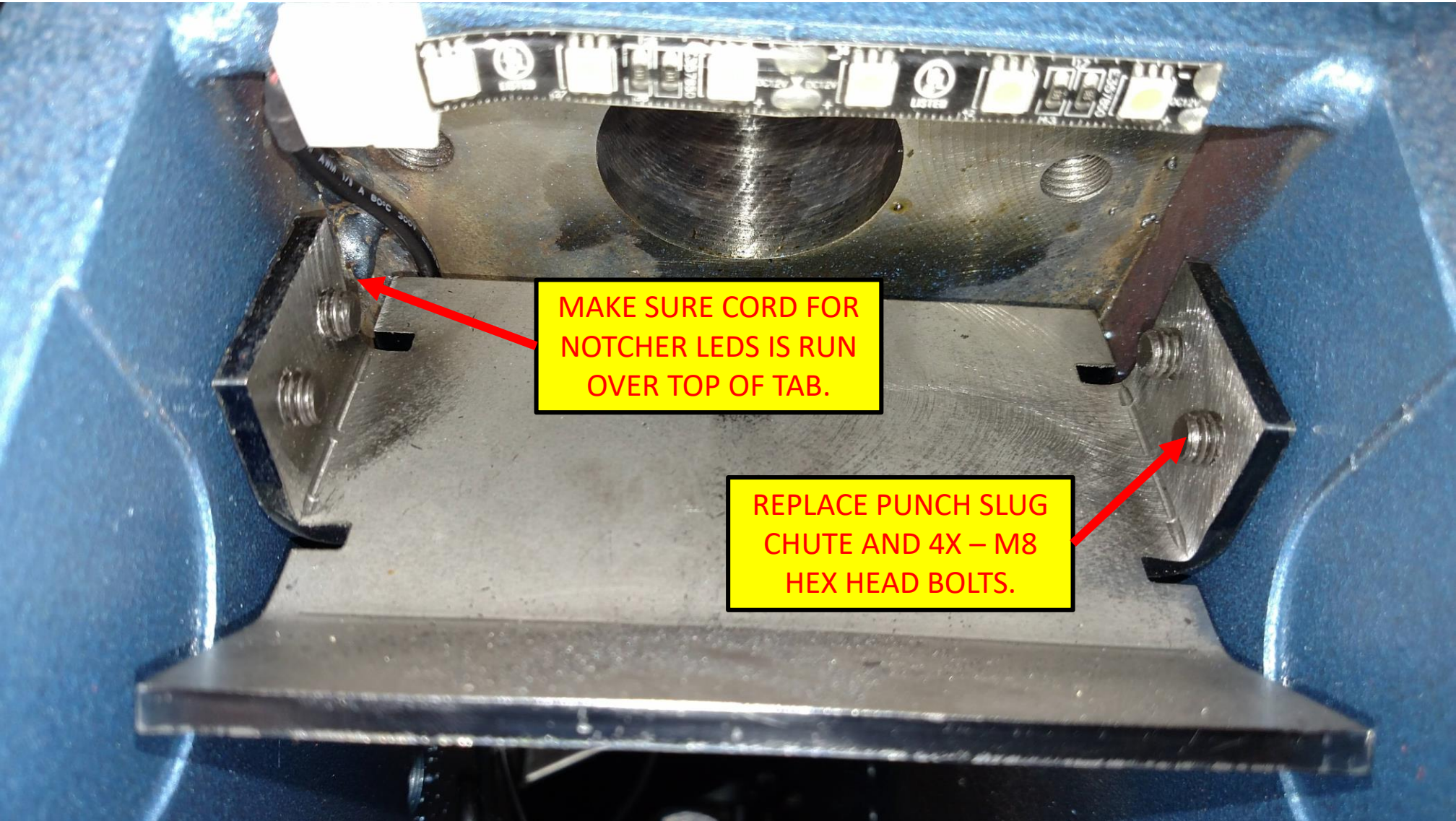
GATHER UP AND ZIPTIE EXCESS
CORD ABOVE THE BASE



**PLACE CORD BUNDLE ON TOP OF
BASE AND BEHIND SLUG CHUTES**

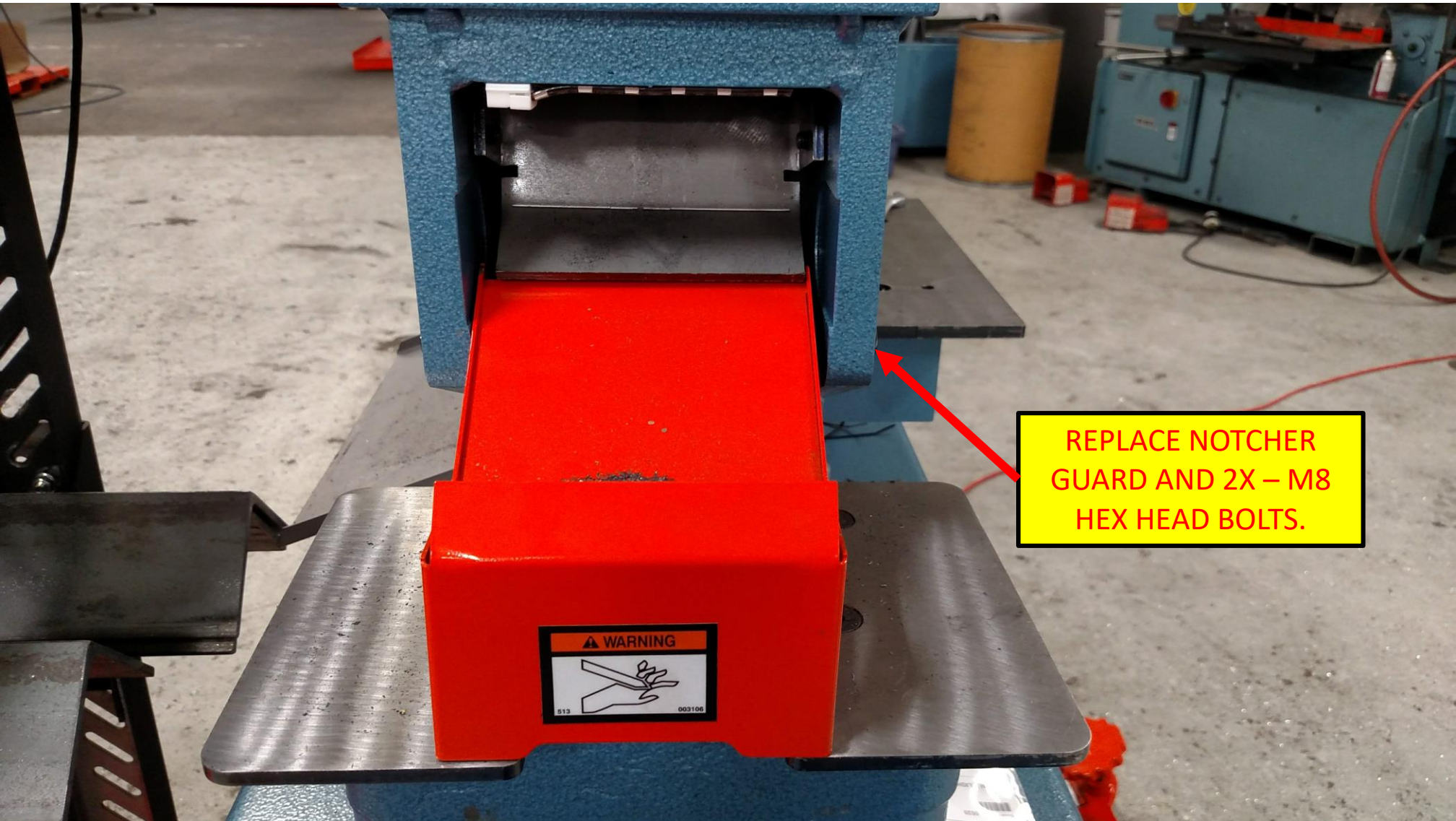
A close-up photograph of a mechanical assembly, likely a notcher, showing a central metal plate held in place by bolts. A yellow callout box with a black border contains red text. A red arrow points from the text to a bolt on the right side of the assembly. The background is a blue, textured surface.

REPLACE NOTCHER SLUG
CHUTE AND 4X – M8 HEX
HEAD BOLTS.



MAKE SURE CORD FOR NOTCHER LEDS IS RUN OVER TOP OF TAB.

REPLACE PUNCH SLUG CHUTE AND 4X - M8 HEX HEAD BOLTS.



REPLACE NOTCHER
GUARD AND 2X - M8
HEX HEAD BOLTS.

WARNING

513 003106



**INJURY DO NOT PLACE FINGERS
BEYOND THESE GUARDS**

1210

003105

HER
X 5/16
1/4 X 3/8
6 X 8MM
0 X 10MM

8.16

**SLIDE ANGLE SHEAR
FORWARD AND
TIGHTEN DOWN.**

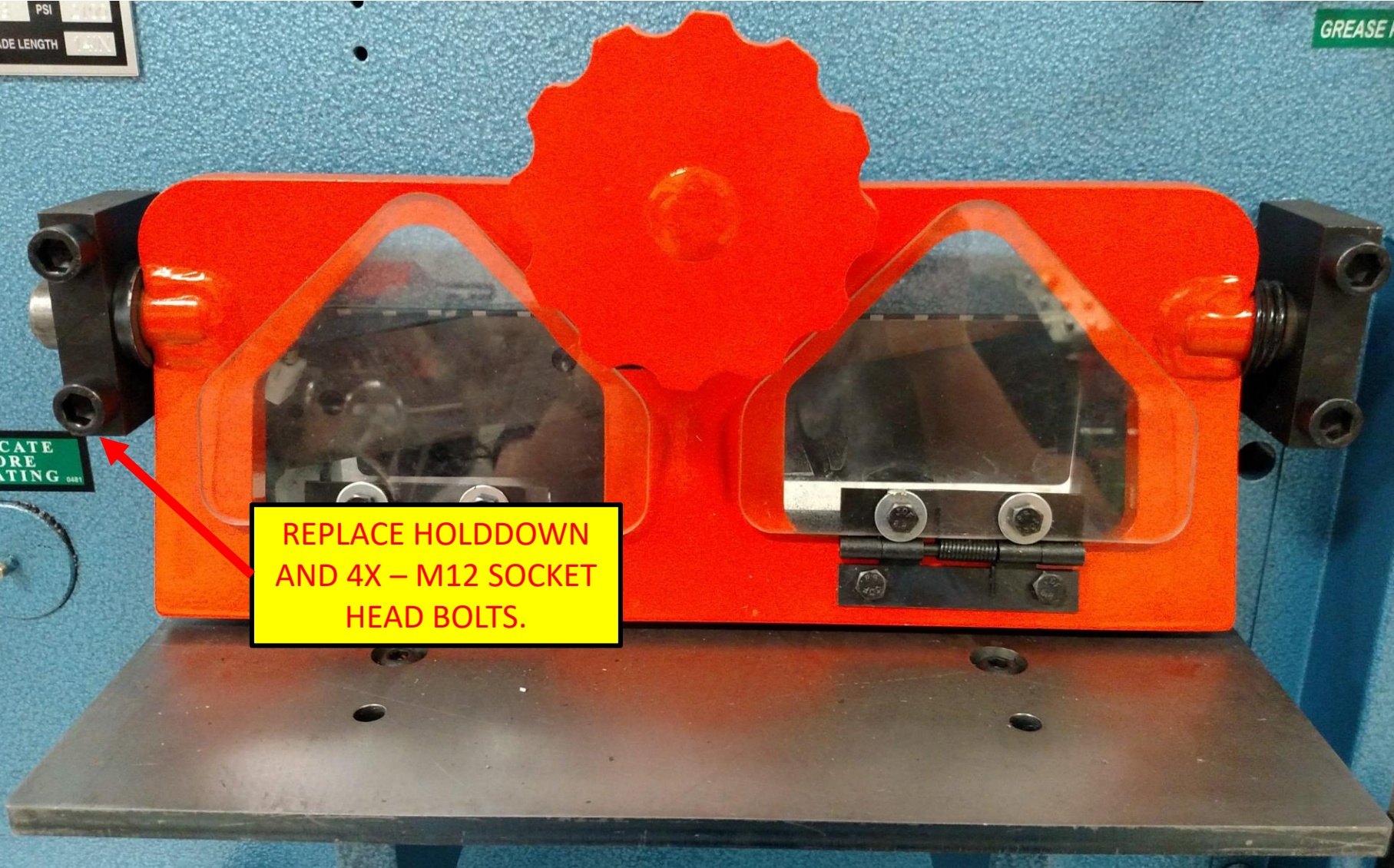


PH PSI
BLADE LENGTH

GREASE POINT

LUBRICATE
BEFORE
OPERATING

REPLACE HOLDDOWN
AND 4X – M12 SOCKET
HEAD BOLTS.

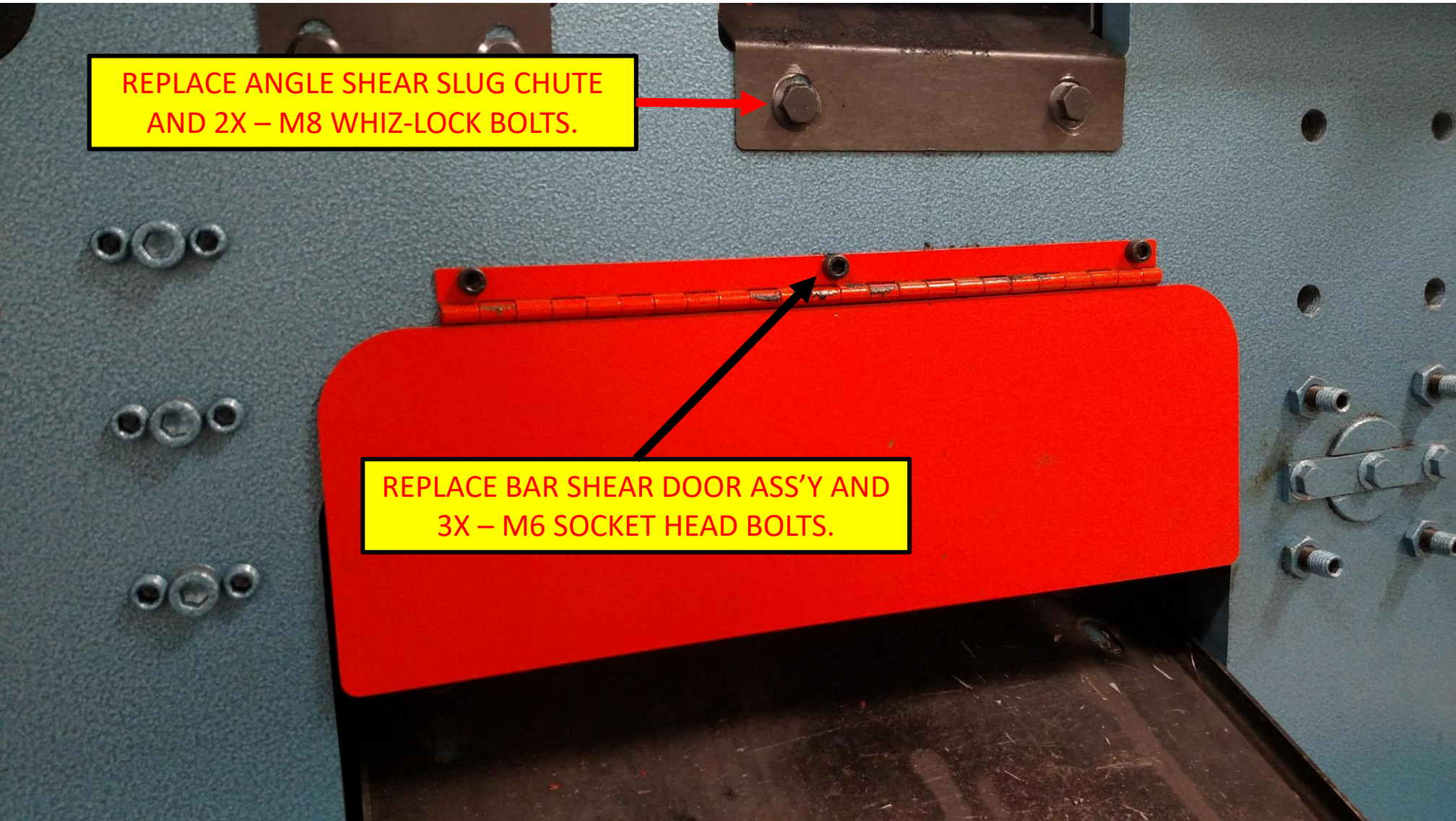


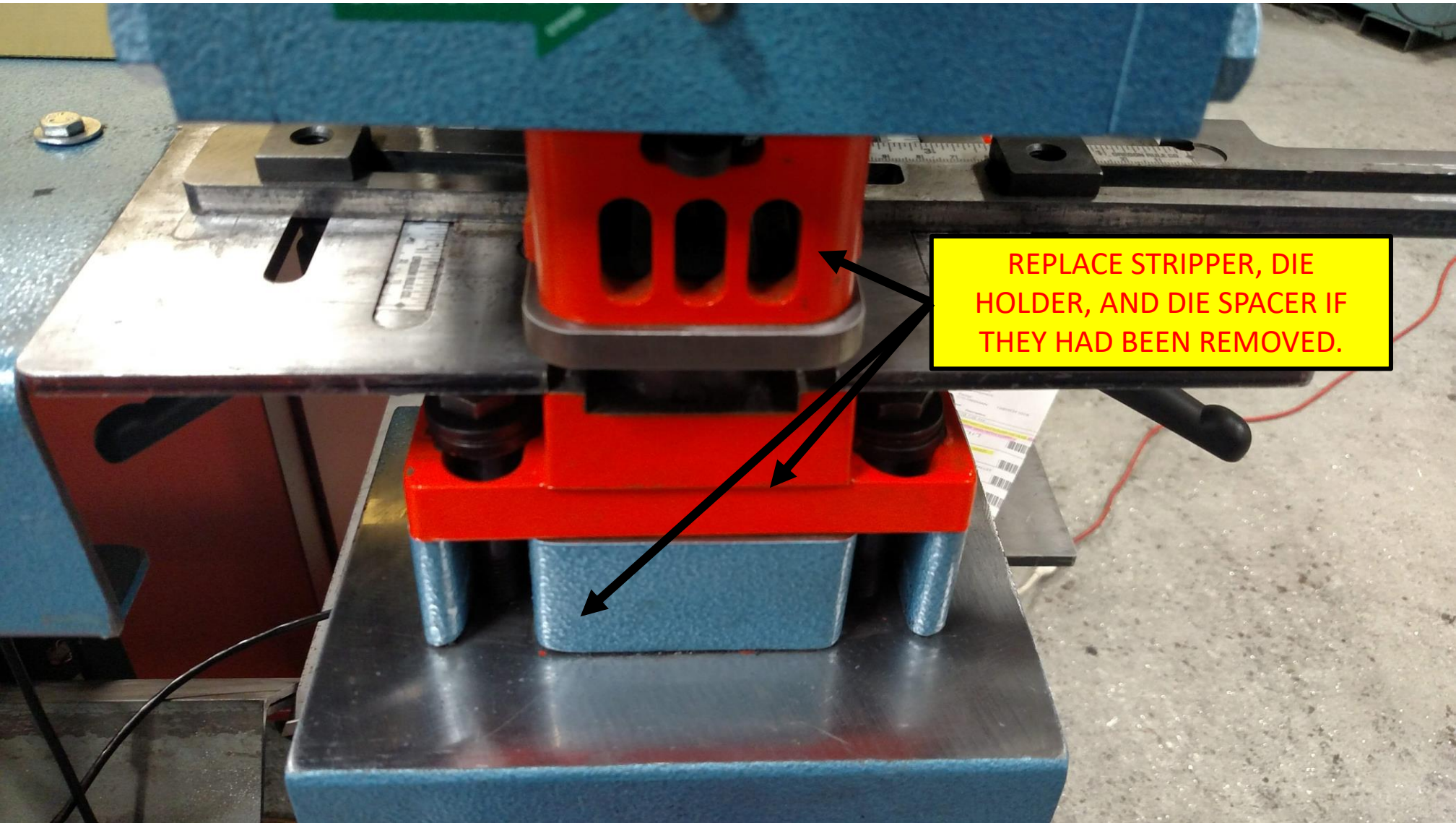


MAKE SURE SPRING IS AS SHOWN.

REPLACE ANGLE SHEAR SLUG CHUTE
AND 2X – M8 WHIZ-LOCK BOLTS.

REPLACE BAR SHEAR DOOR ASS'Y AND
3X – M6 SOCKET HEAD BOLTS.

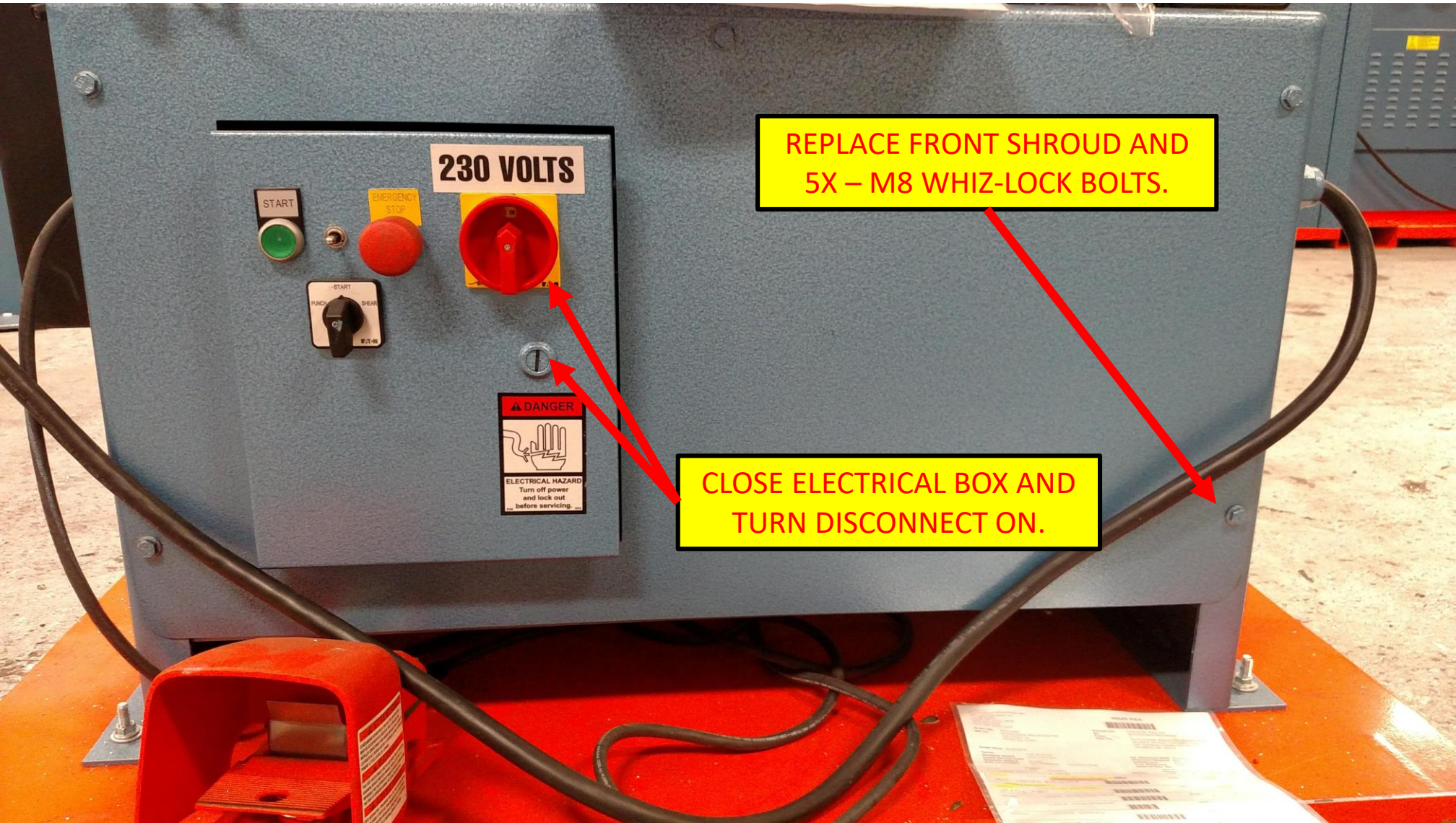




REPLACE STRIPPER, DIE
HOLDER, AND DIE SPACER IF
THEY HAD BEEN REMOVED.

A photograph of a blue metal machine, possibly a lathe or mill, with a yellow callout box and a red arrow pointing to a hole on the top surface. The machine has a blue painted metal body with a dark brown top section. The floor is concrete, and there is a red fire extinguisher and a black power cord visible in the background.

REPLACE REAR SHROUD AND 5X – M8 WHIZ-
LOCK BOLTS IF THEY HAD BEEN REMOVED.



230 VOLTS

START

EMERGENCY STOP

START
PUNCH BEAR

⚠ DANGER



ELECTRICAL HAZARD
Turn off power
and lock out
before servicing

**REPLACE FRONT SHROUD AND
5X - M8 WHIZ-LOCK BOLTS.**

**CLOSE ELECTRICAL BOX AND
TURN DISCONNECT ON.**

MODEL: 1112
SERIAL: 1112
SCOTCHMAN INDUSTRIES, INC.
PHILIP, SOUTH DAKOTA, U.S.A.
PH. 605-859-2542
MADE IN U.S.A.
H.P. 2
VOLT 220
HZ 60
FLA 10
PH 2
PSI 2000
BLADE LENGTH 200

SAFETY GLASSES REQUIRED WHEN OPERATING OR OBSERVING THIS MACHINE
DO NOT REMOVE THIS SIGN FROM THIS MACHINE
FOR MORE INFORMATION CONTACT SCOTCHMAN INDUSTRIES INC. AT 1-800-843-8844
003100 REV. 0310

GREASE POINT

LUBRICATE BEFORE OPERATING

REMOVE LOCKOUT/TAGOUT RESTRICTIONS, PLUG INTO ELECTRICAL SOURCE, AND PULL THE E-STOP OUT IF ENGAGED.

WIRE LIGHT
FINAL TEST ASSEMBLY



