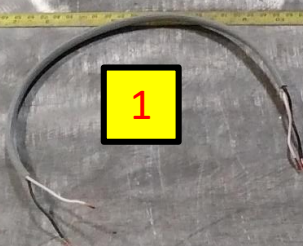


P/N 090515 –LED LIGHT 50ET RETROFIT KIT INSTRUCTIONS





1



4



7



11



2



5



8



12



3



9



13



6



10



14

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 | 1 | 090503 | 1 METER EXTENSION |
| 5 | 1 | 090505 | 2-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 | 1 | 090502 | 3 METER EXTENSION |
| 11 | 1 | 090544 | 21 LED BULB STRIP (14 IN.) |
| 12 | 1 | 090542 | 12 LED BULB STRIP (8 IN.) |
| 13 | 5 | 011713 | LATCHING CLIP |
| 14 | 8 | 660505 | BLACK NYLON CABLE TIE |

BASIC CONSIDERATIONS

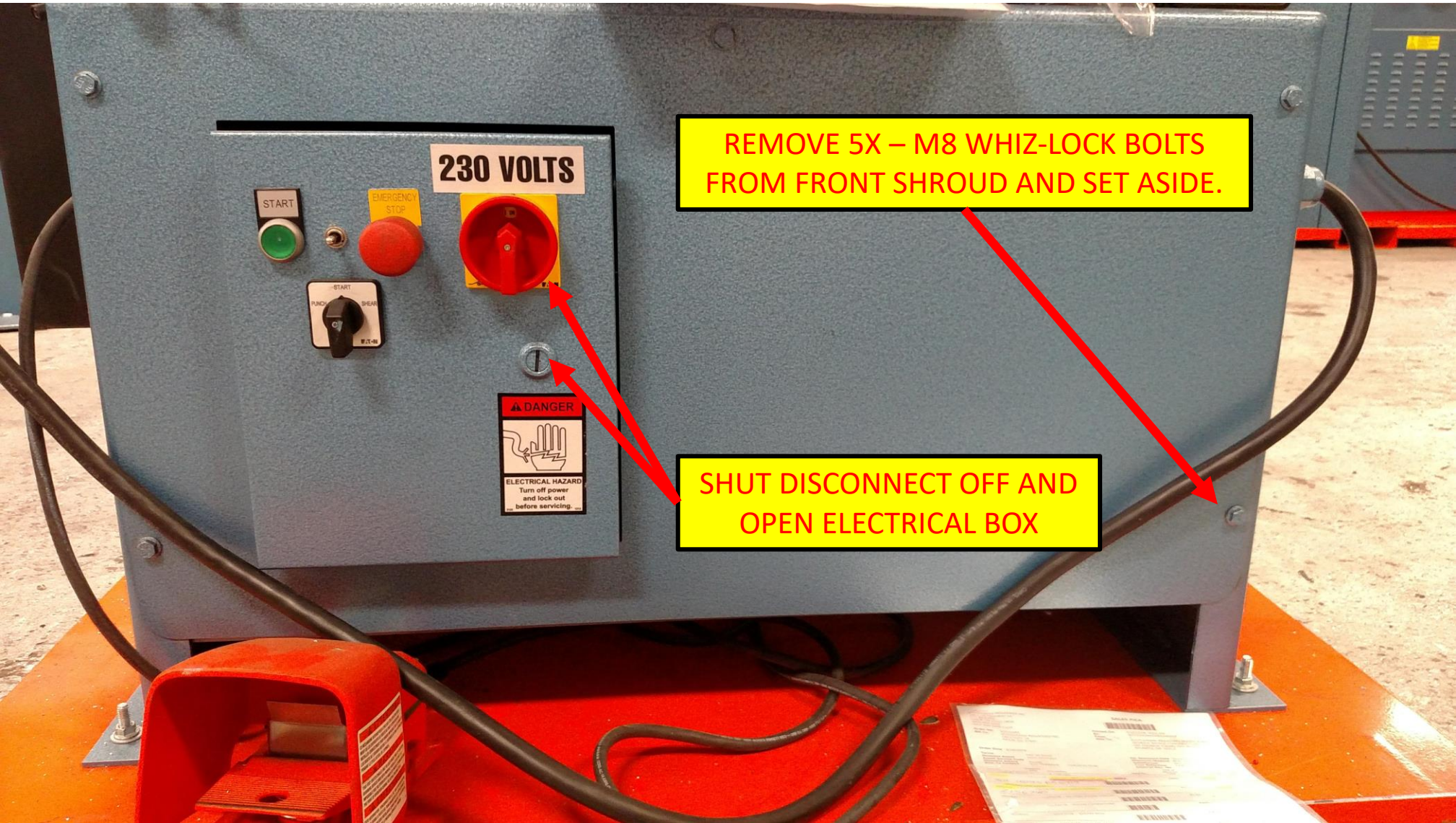
- Please read the instructions **FULLY** before attempting to install the product.
- Make sure to unplug the machine from its electrical source and perform any necessary lockout/tagout procedures.
- If the old worklight is installed, it will be necessary to remove the cord from the base. The light can 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:

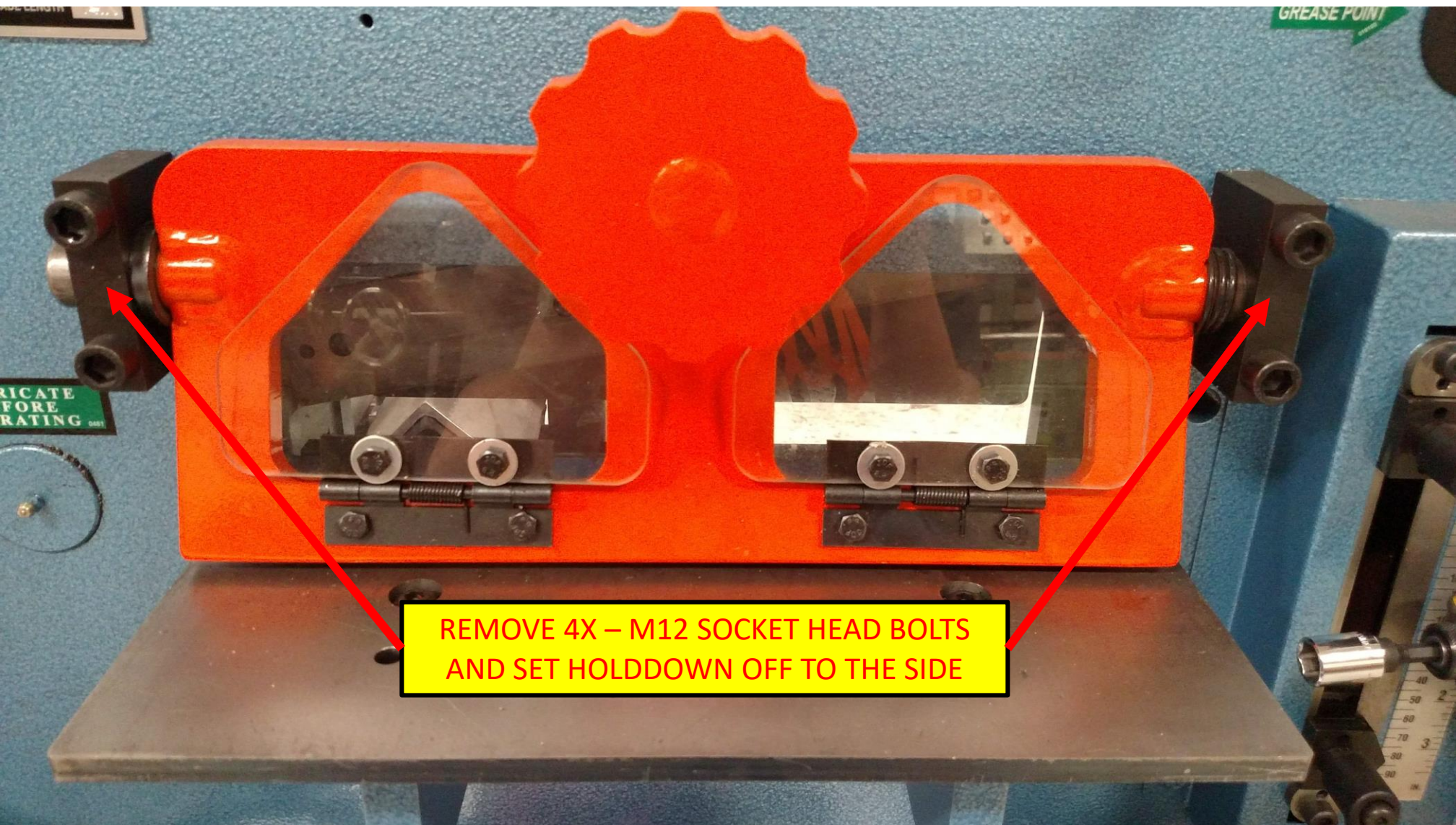


- Back to Shear ([Page 25](#)); Punch ([Page 30](#))




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

SHUT DISCONNECT OFF AND OPEN ELECTRICAL BOX



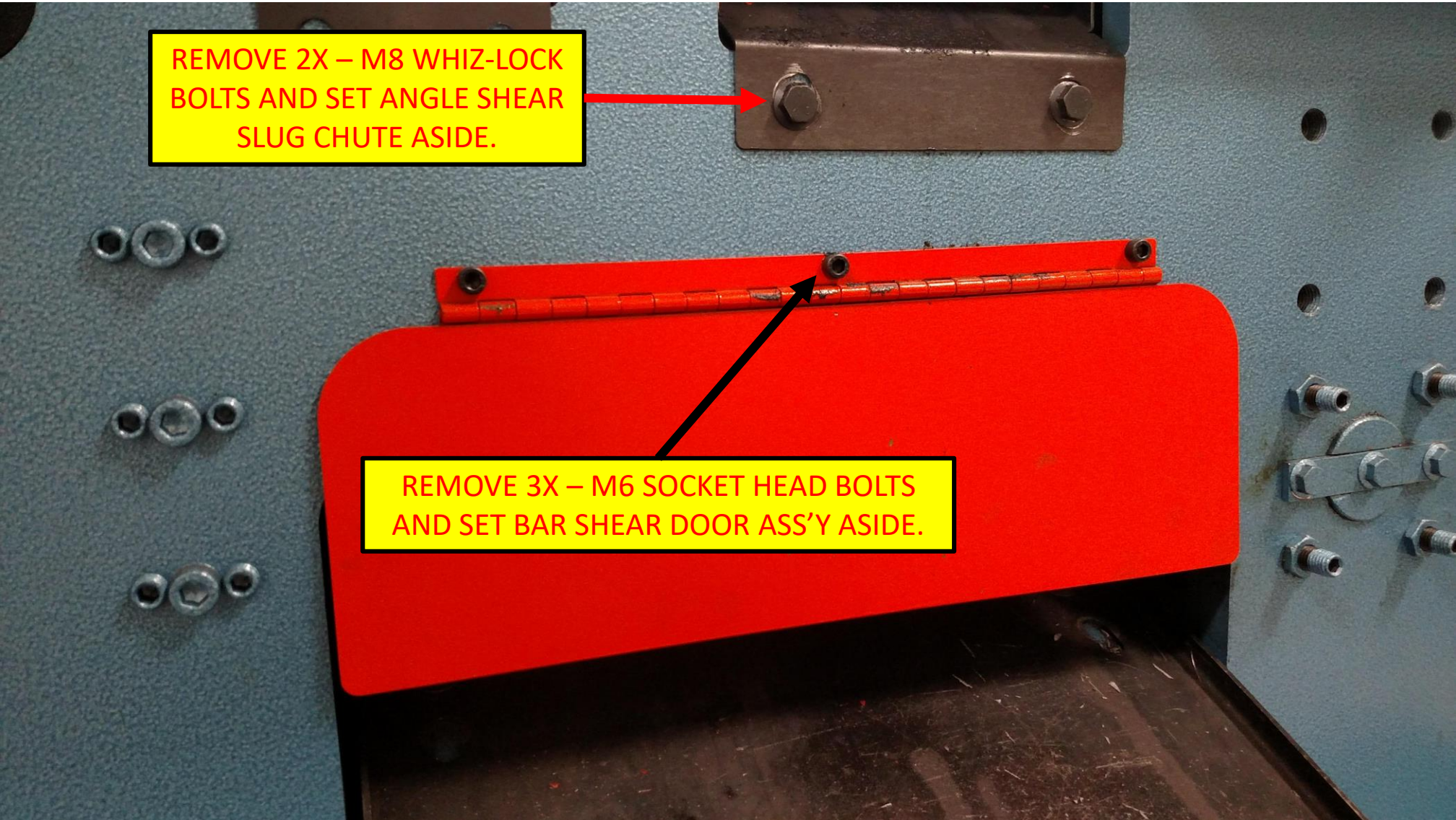
REMOVE 4X - M12 SOCKET HEAD BOLTS
AND SET HOLDDOWN OFF TO THE SIDE



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.





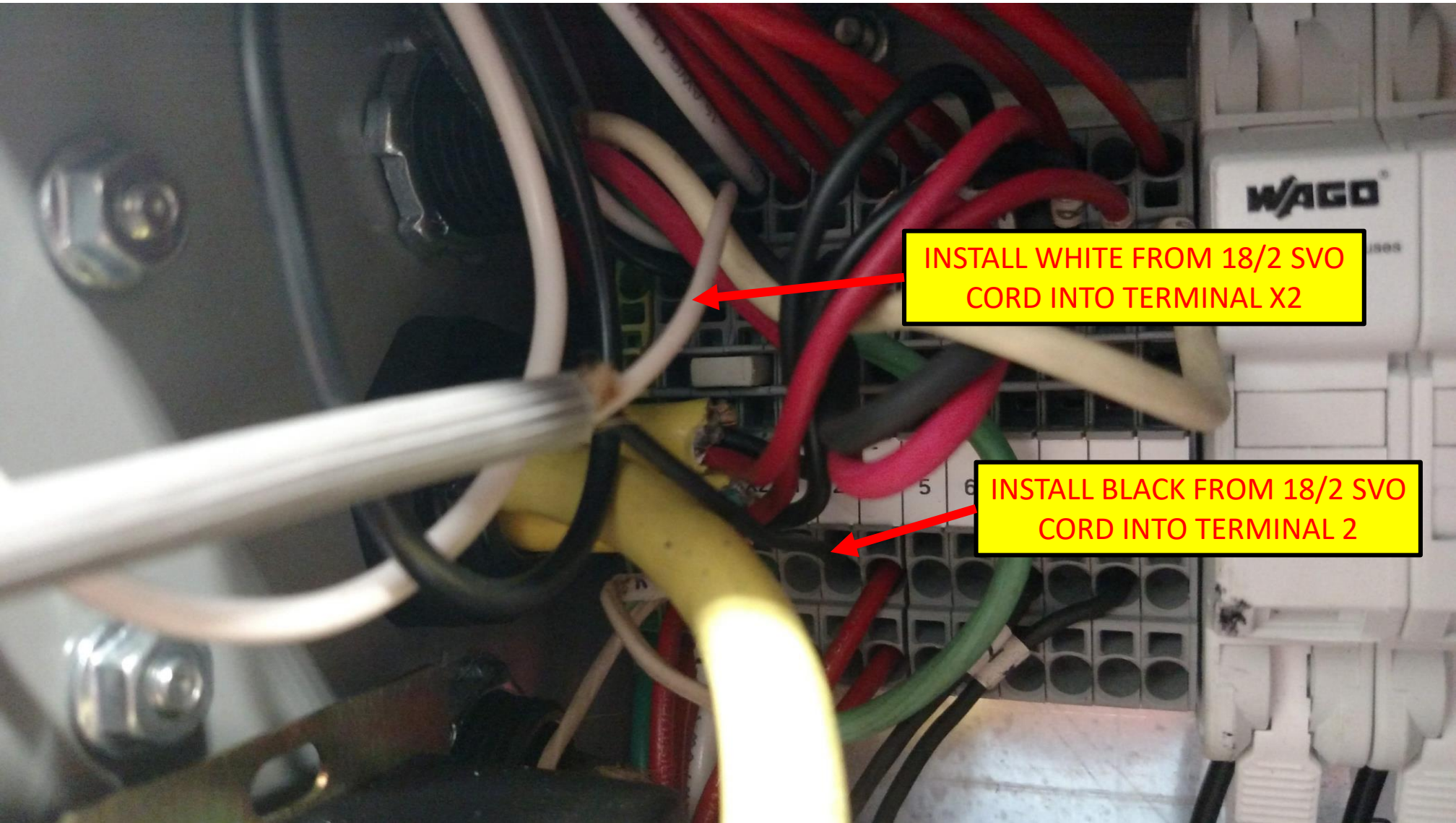
REMOVE 4X - M8 HEX HEAD
BOLTS AND SET NOTCHER
SLUG CHUTE ASIDE.

WARNING DO NOT CHANGE OR ADJUST PUNCH/DIE WITHOUT REFERRING TO THE OPERATOR'S MANUAL AND SAFETY FILM. 0300 3110

OPTIONAL: (3X) REMOVE STRIPPERS, STRIPPER CLIPS, DIE HOLDERS, AND DIE SPACERS. THIS WILL MAKE IT EASIER TO INSTALL WIRES ON THE CAROUSEL.



**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

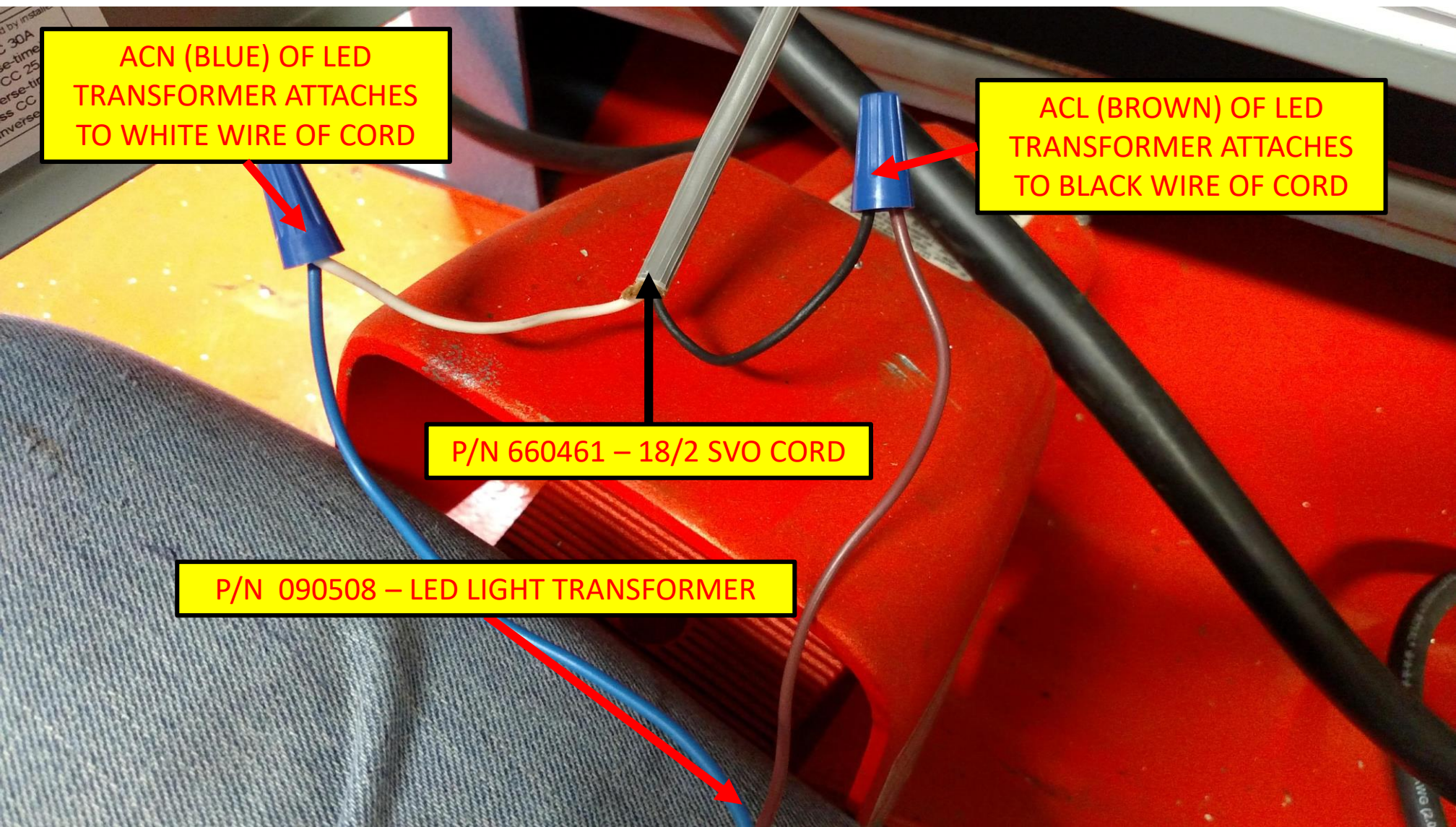
by instal
C 30A
e-time
CC 25
erse-tir
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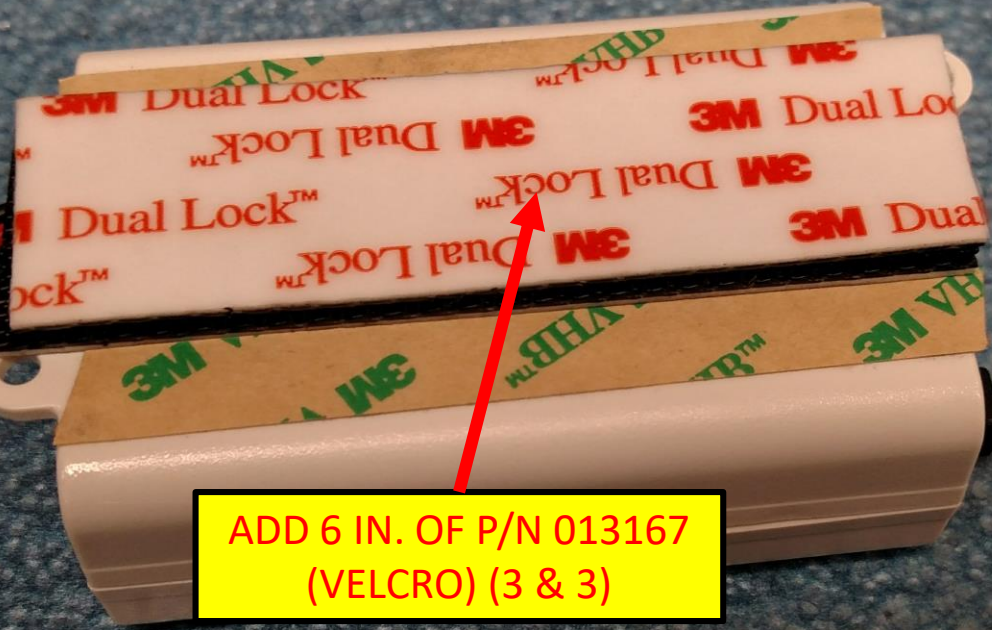
ACN (BLUE) OF LED
TRANSFORMER ATTACHES
TO WHITE WIRE OF CORD

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

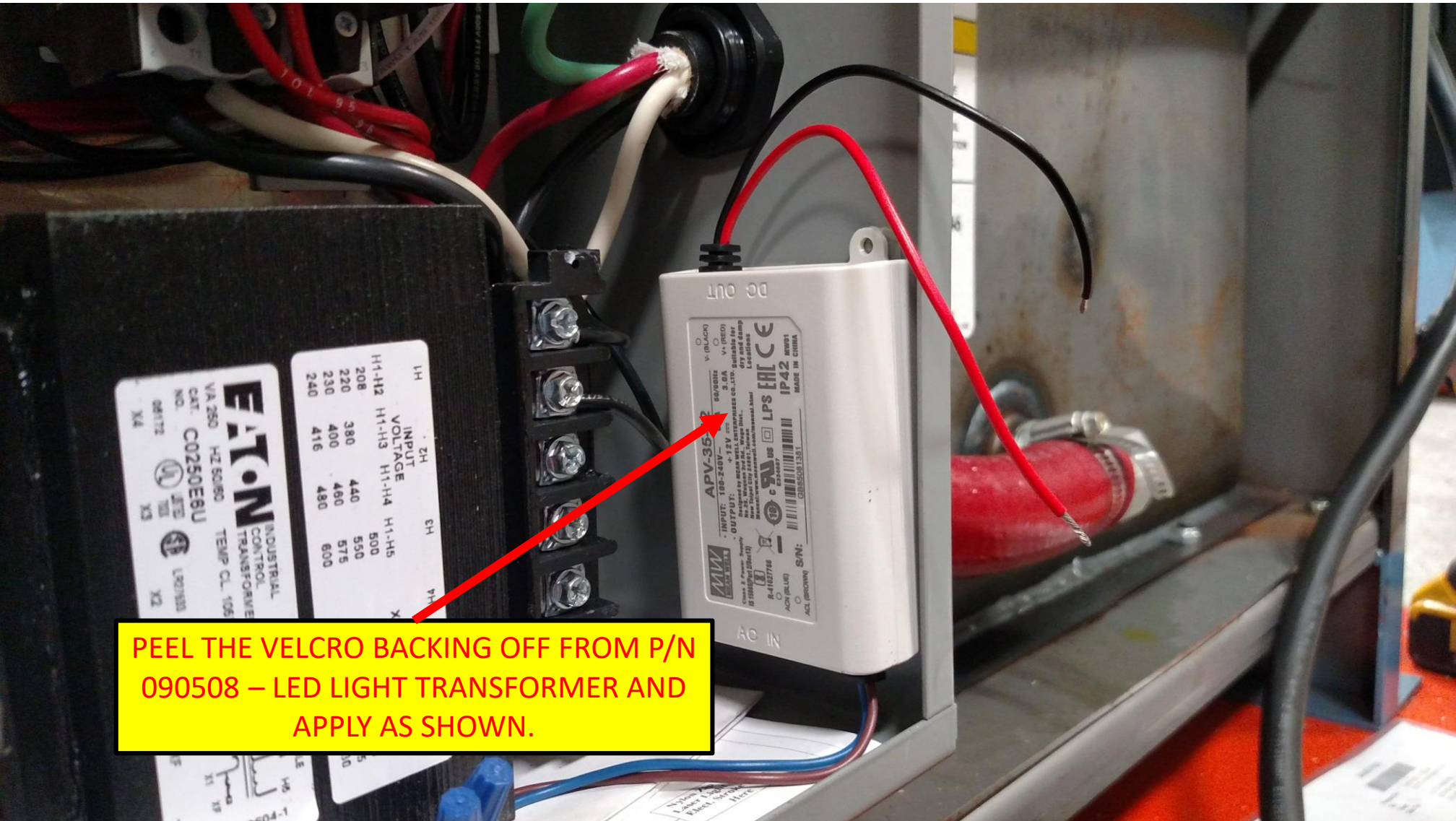
P/N 660461 – 18/2 SVO CORD

P/N 090508 – LED LIGHT TRANSFORMER





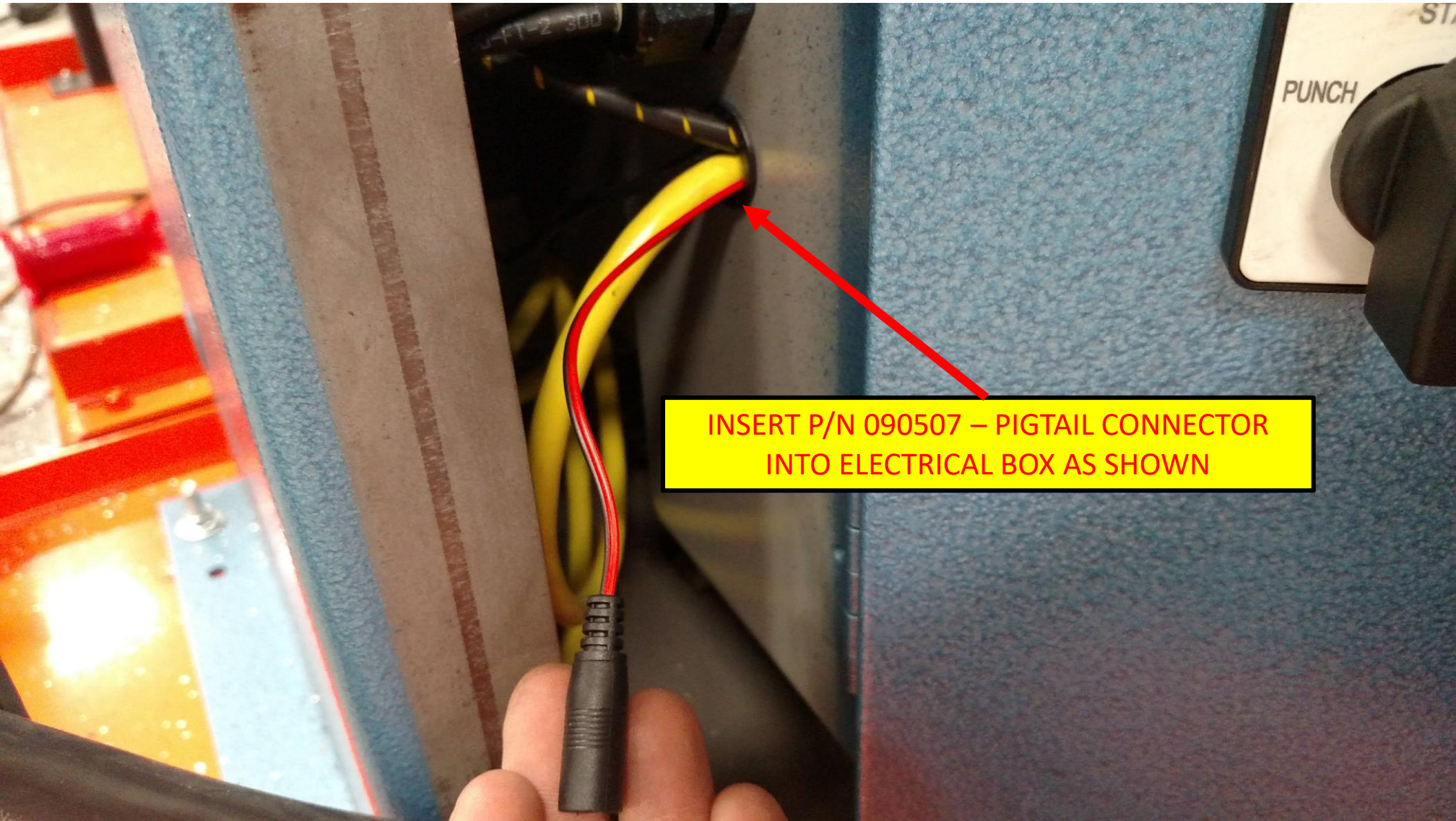
ADD 6 IN. OF P/N 013167
(VELCRO) (3 & 3)



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 TEMP CL. 105
CAT. C0250E6U
NO. 08172
X1 X2 X3 X4

| INPUT VOLTAGE | | H1-H2 | | H1-H3 | | H1-H4 | | H1-H5 | |
|---------------|-----|-------|-----|-------|-----|-------|-----|-------|-----|
| 1H | 2H | 3H | 4H | 1H | 2H | 3H | 4H | 1H | 2H |
| 208 | 220 | 230 | 240 | 380 | 400 | 416 | 440 | 450 | 480 |
| 500 | 550 | 575 | 600 | 480 | 490 | 500 | 550 | 575 | 600 |

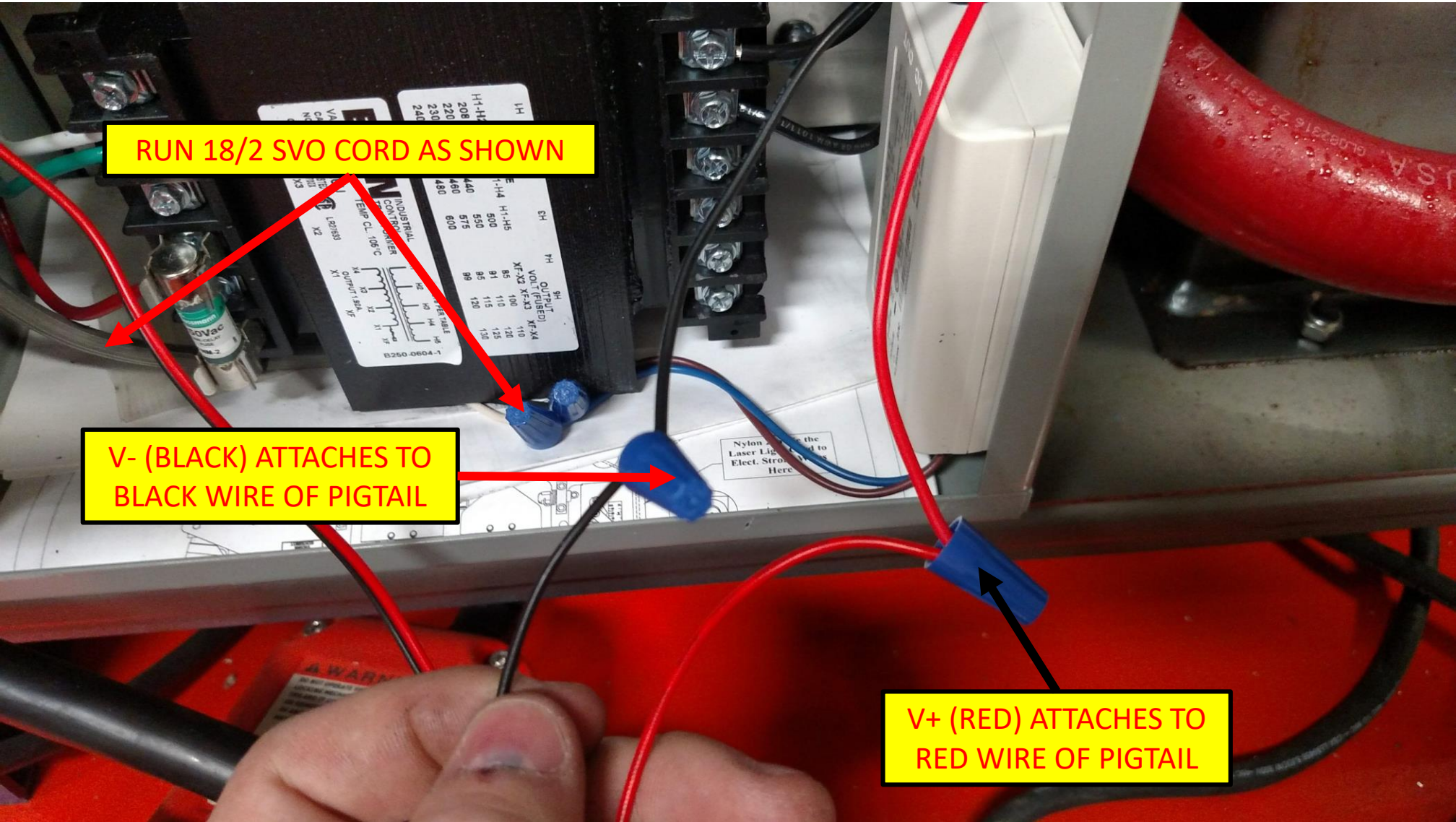


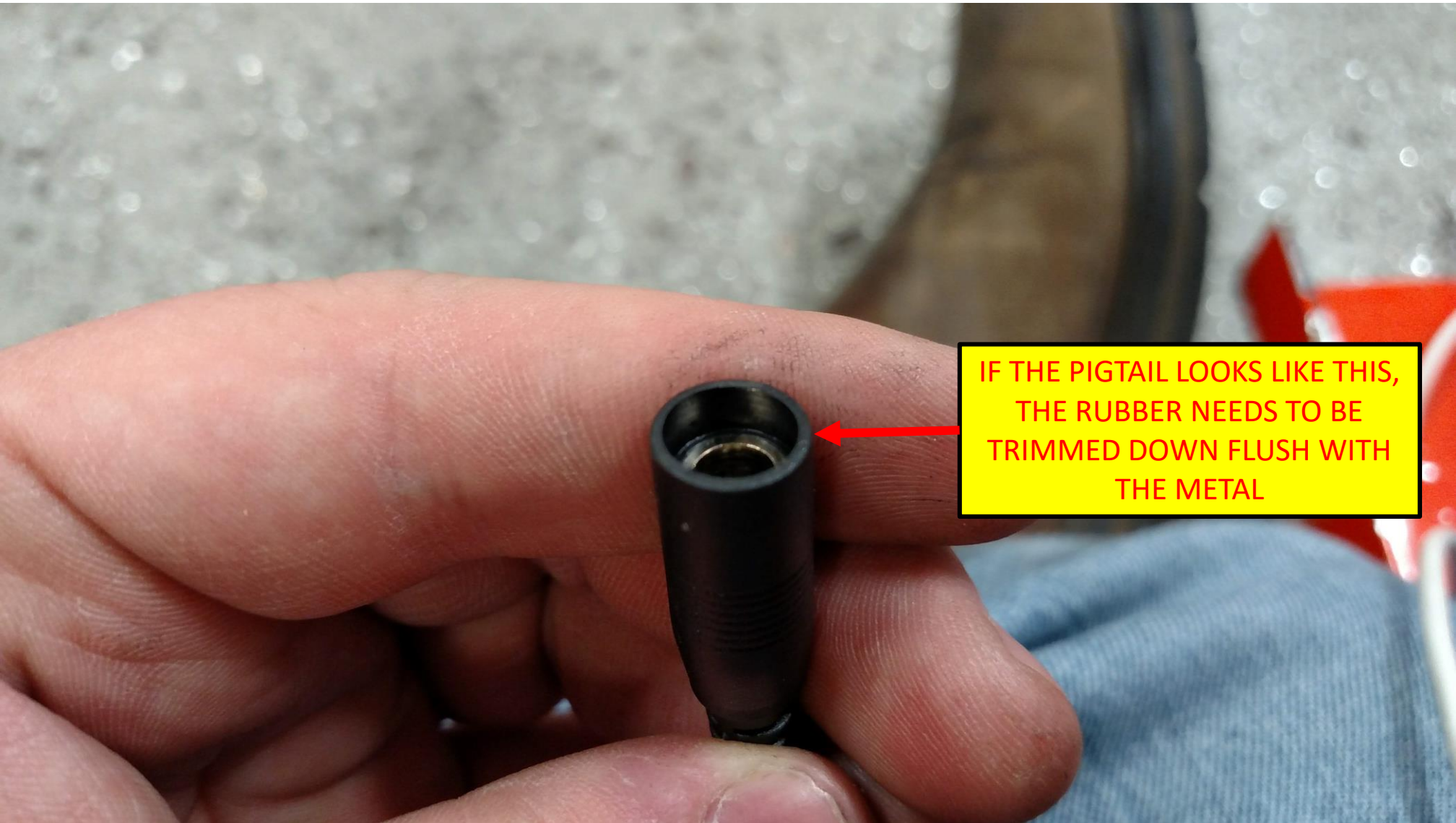
INSERT P/N 090507 - PIGTAIL CONNECTOR
INTO ELECTRICAL BOX AS SHOWN

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





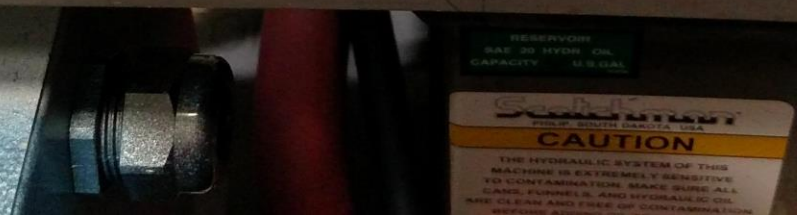
P/N 090505 – 2-WAY SPLITTER



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.

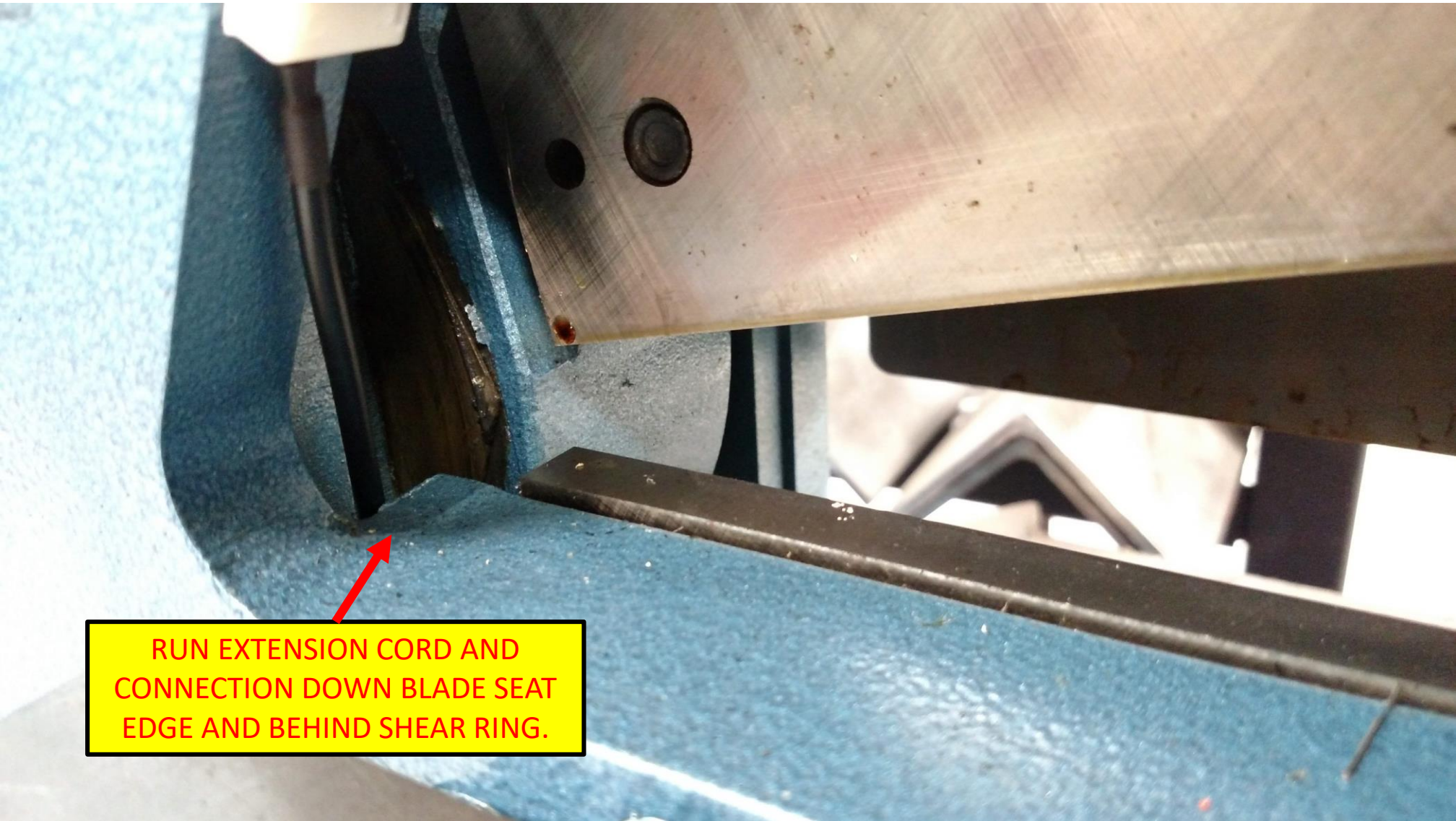
NOTE: THE 3M VHB TAPE IS A PRESSURE ACTIVATED ADHESIVE. IF **LIGHTLY APPLIED** TO A SURFACE, IT MAY BE POSSIBLE TO PULL OFF AND REAPPLY. IF **FIRMLY ATTACHED**, IT WILL BE NEAR IMPOSSIBLE TO MOVE.



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.



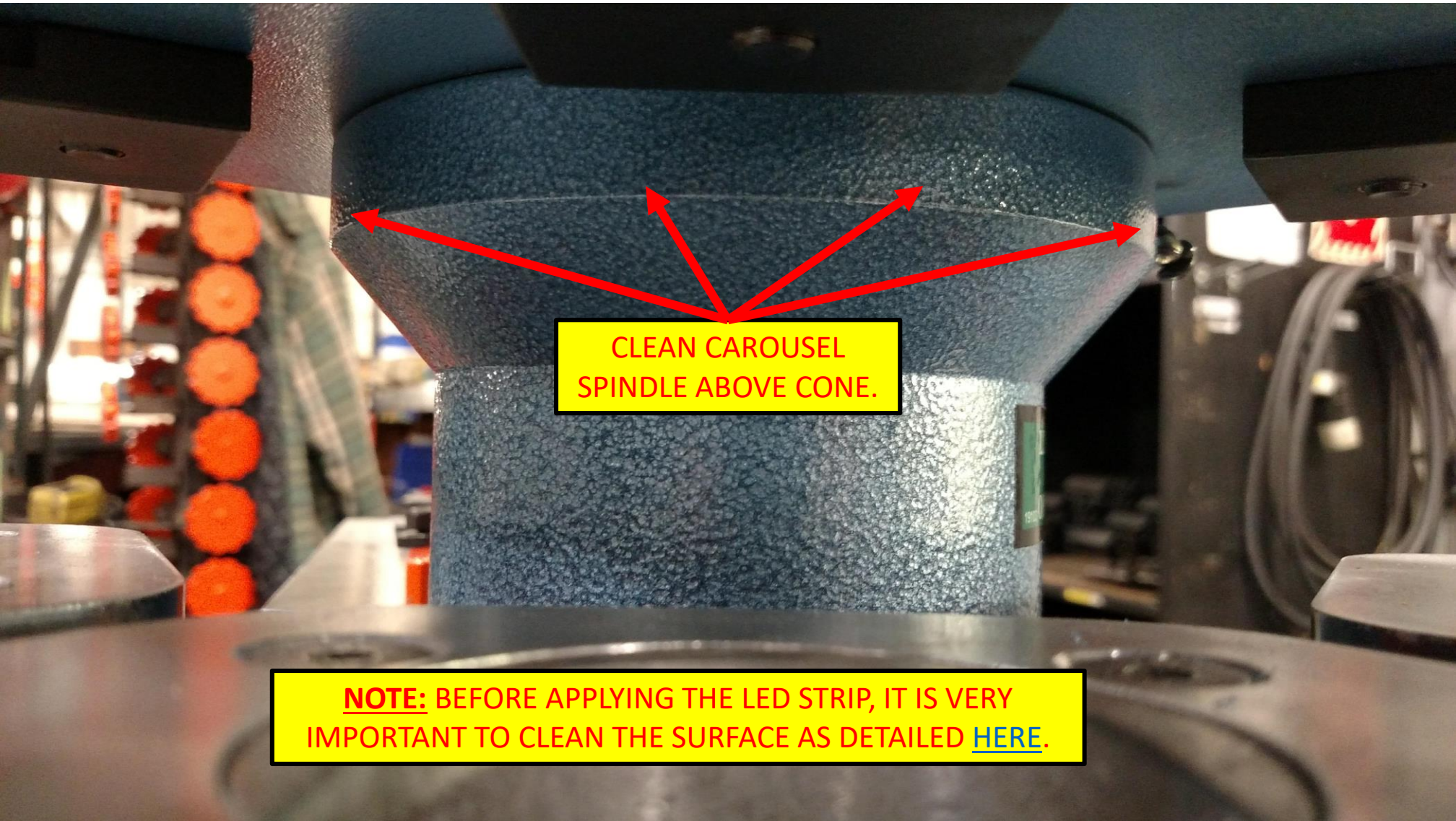


**RUN EXTENSION CORD AND
CONNECTION DOWN BLADE SEAT
EDGE AND BEHIND SHEAR RING.**

VIEWING DOWN FRONT OF MACHINE BETWEEN FRAMES

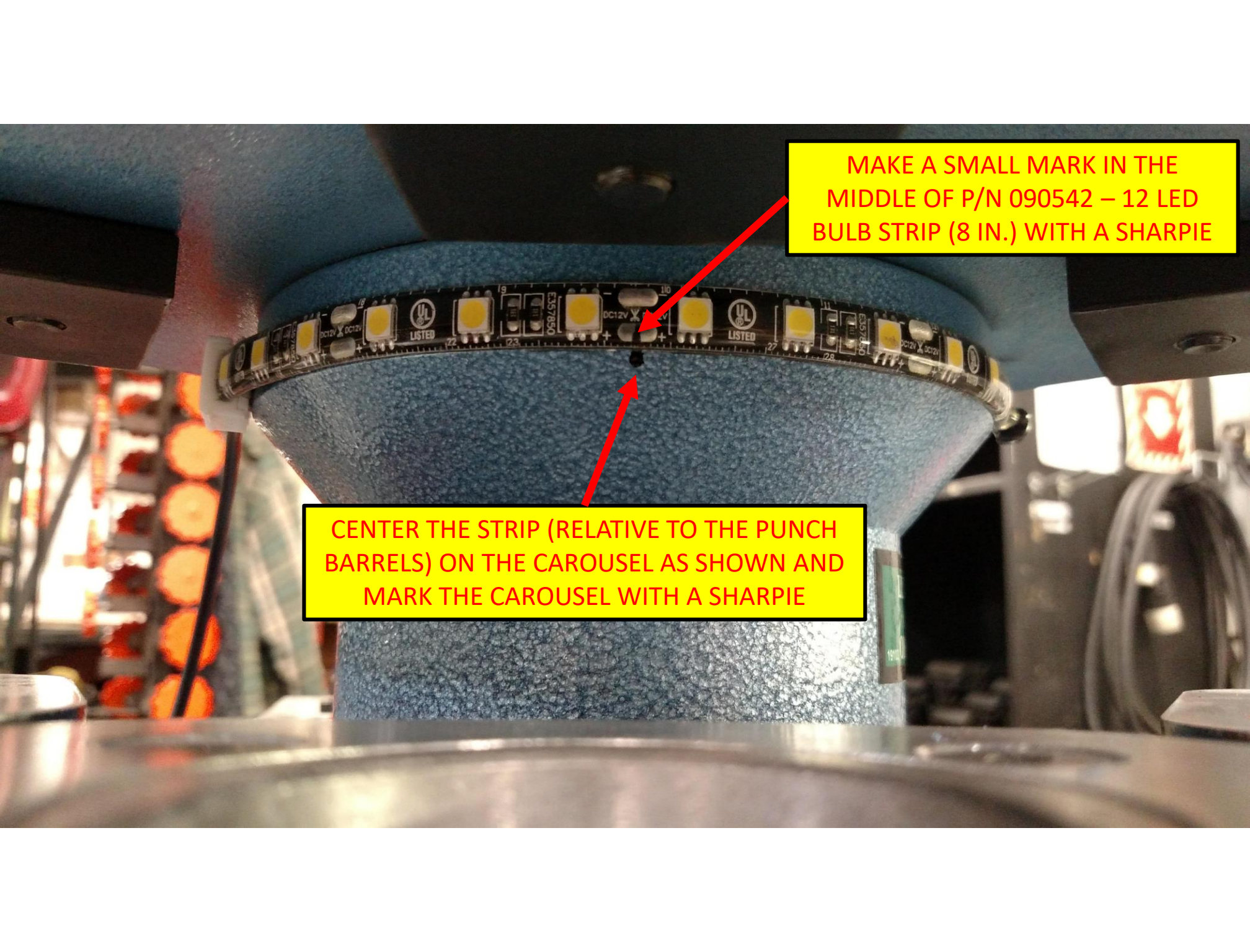
LOOPED AND ZIPTIED CONNECTION





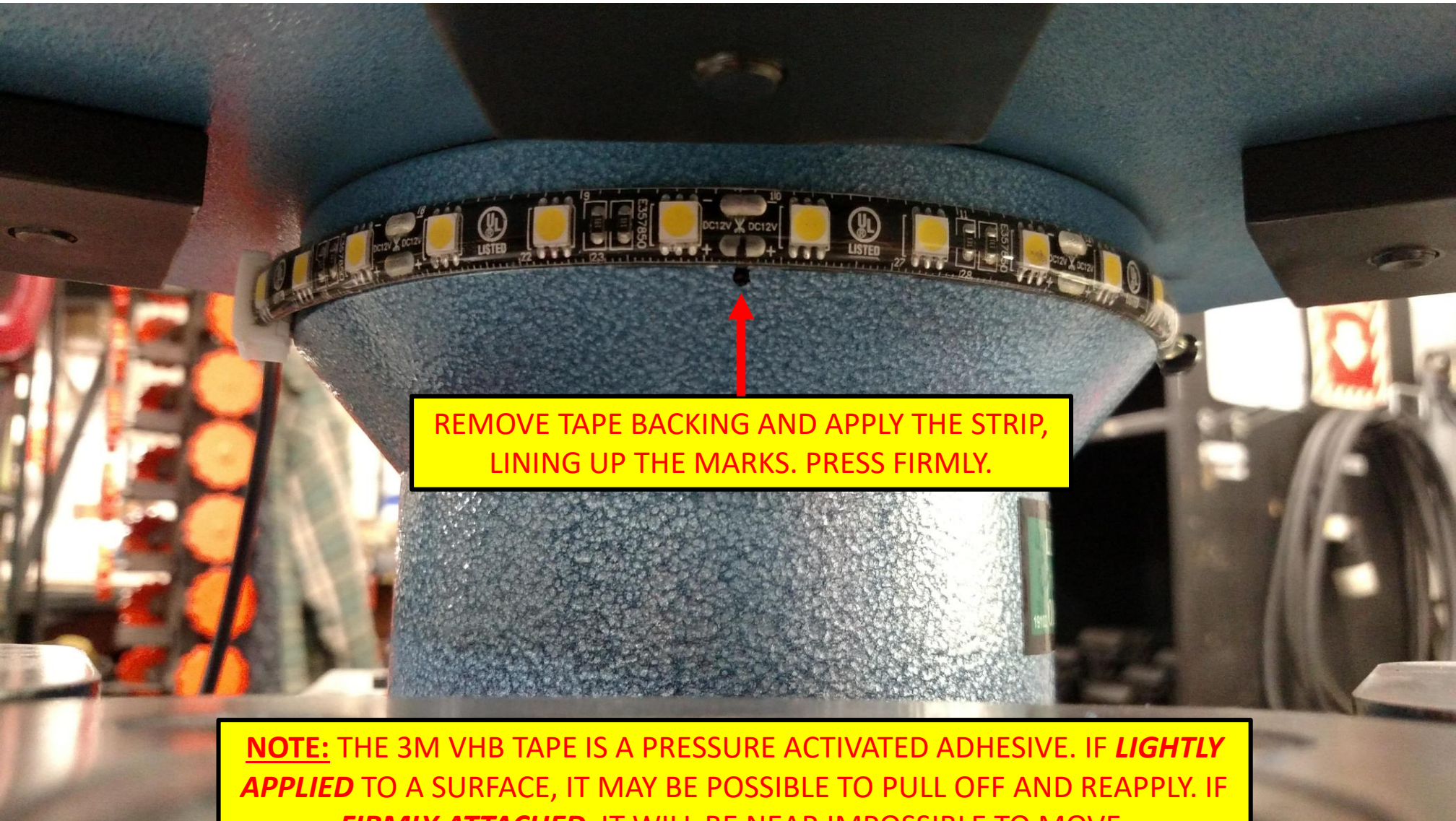
CLEAN CAROUSEL
SPINDLE ABOVE CONE.

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



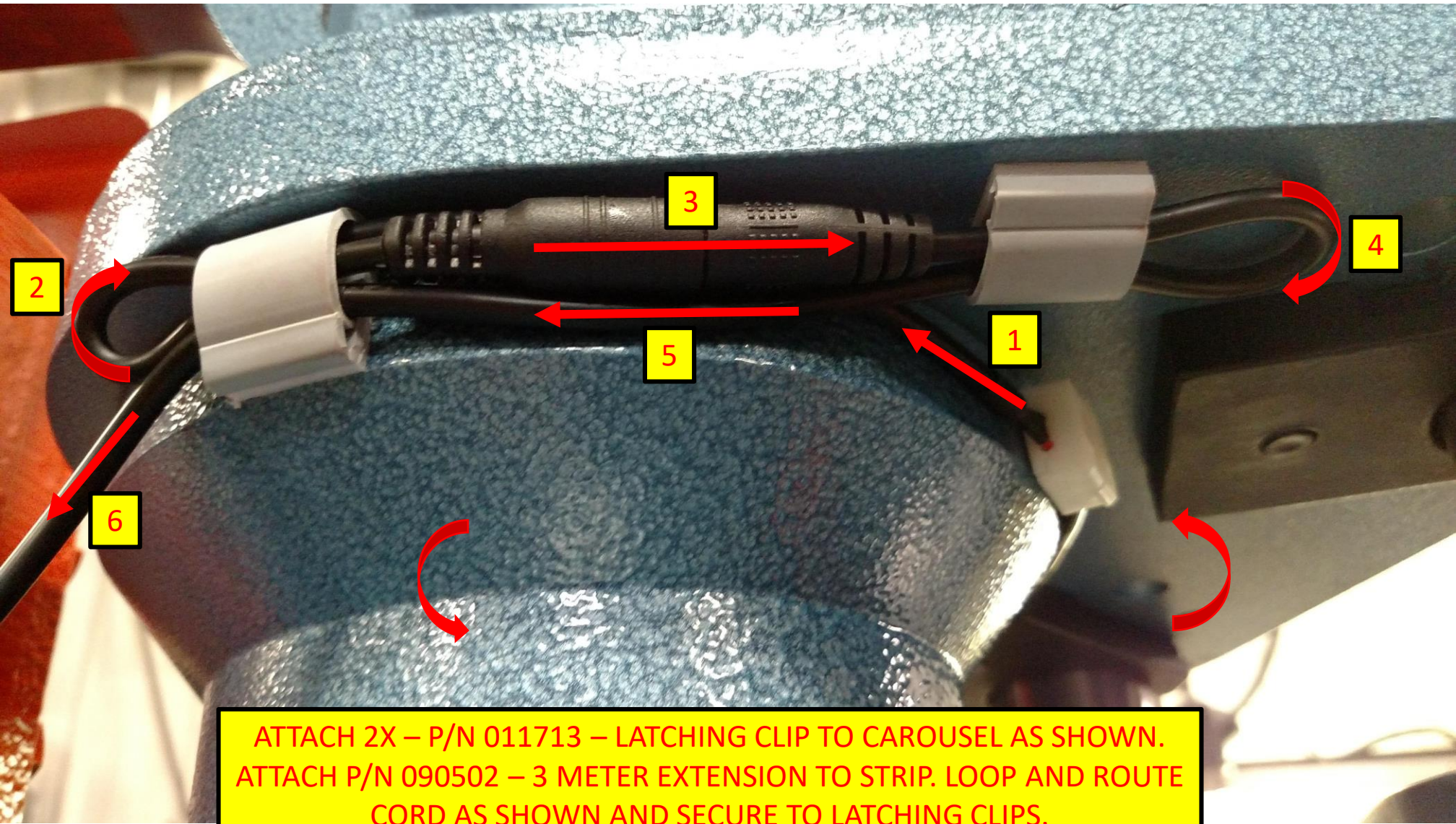
MAKE A SMALL MARK IN THE MIDDLE OF P/N 090542 – 12 LED BULB STRIP (8 IN.) WITH A SHARPIE

CENTER THE STRIP (RELATIVE TO THE PUNCH BARRELS) ON THE CAROUSEL AS SHOWN AND MARK THE CAROUSEL WITH A SHARPIE



REMOVE TAPE BACKING AND APPLY THE STRIP, LINING UP THE MARKS. 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.

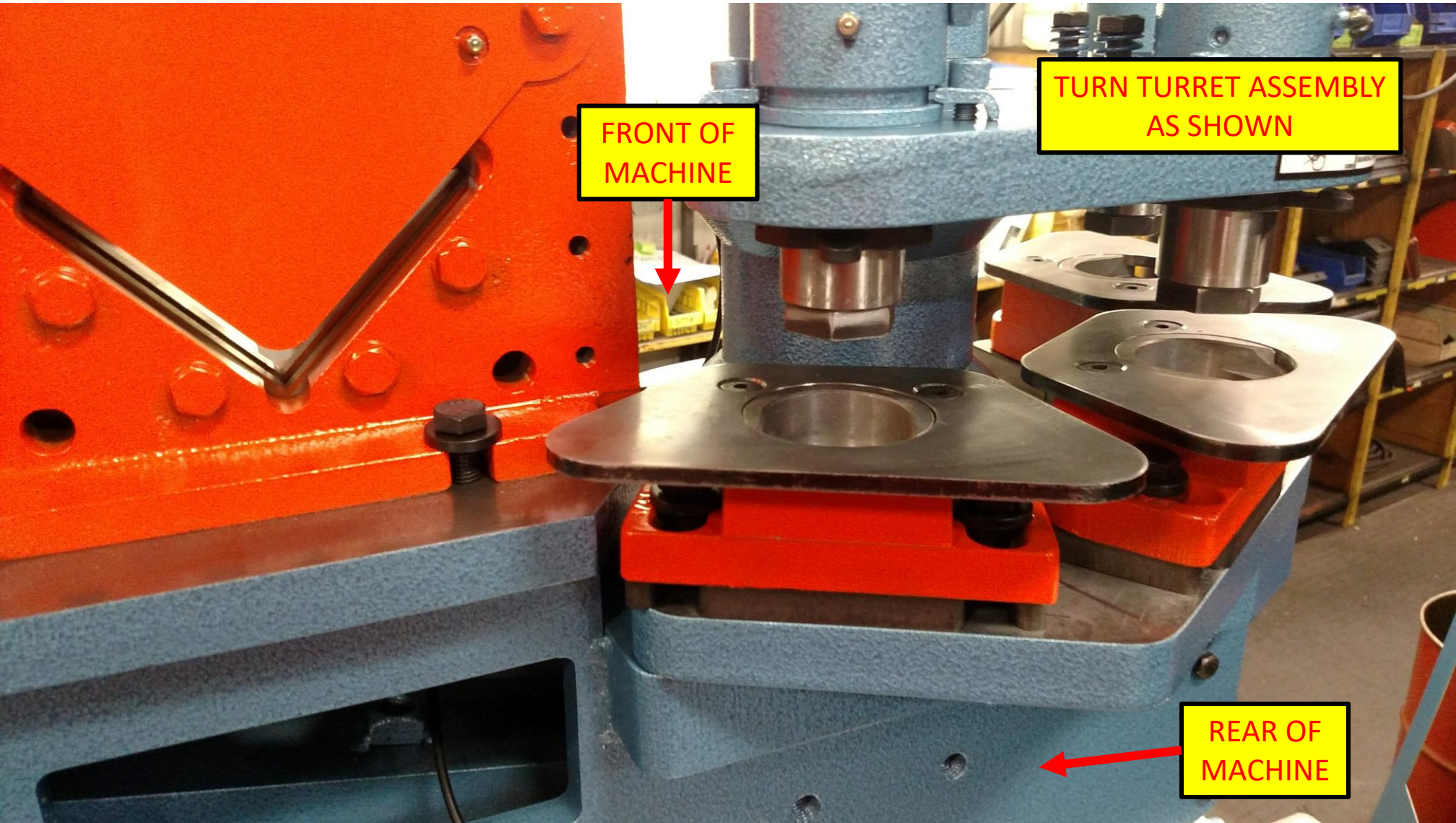


ATTACH 2X – P/N 011713 – LATCHING CLIP TO CAROUSEL AS SHOWN.
ATTACH P/N 090502 – 3 METER EXTENSION TO STRIP. LOOP AND ROUTE
CORD AS SHOWN AND SECURE TO LATCHING CLIPS.



ROUTE CORD AS SHOWN

ATTACH P/N 011713 - LATCHING CLIP TO LOWER PLATE BETWEEN CAROUSEL AND TOOL TABLE AND ROUTE CORD THROUGH AND UNDER THE TOOL TABLE.



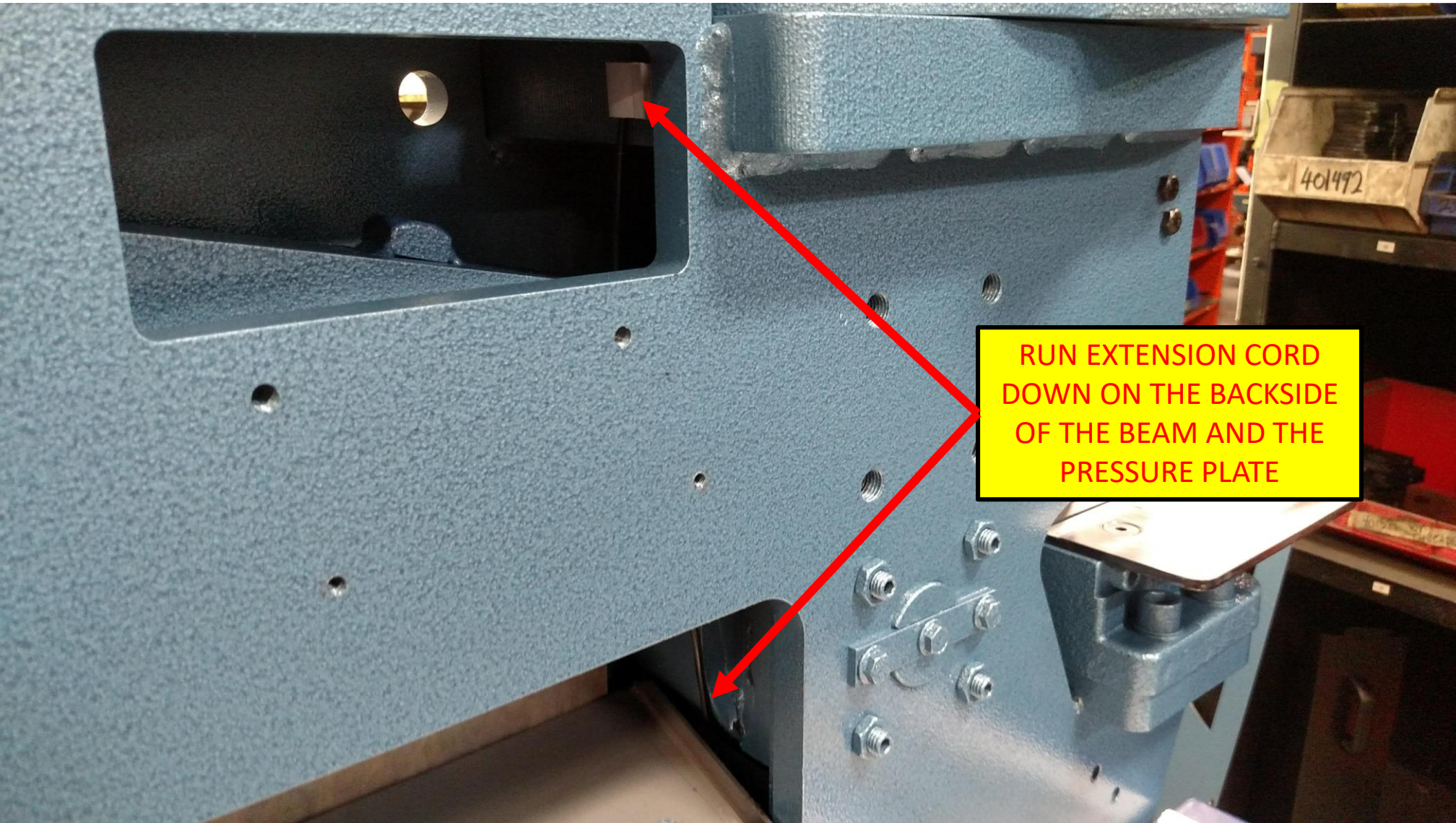
FRONT OF
MACHINE

TURN TURRET ASSEMBLY
AS SHOWN

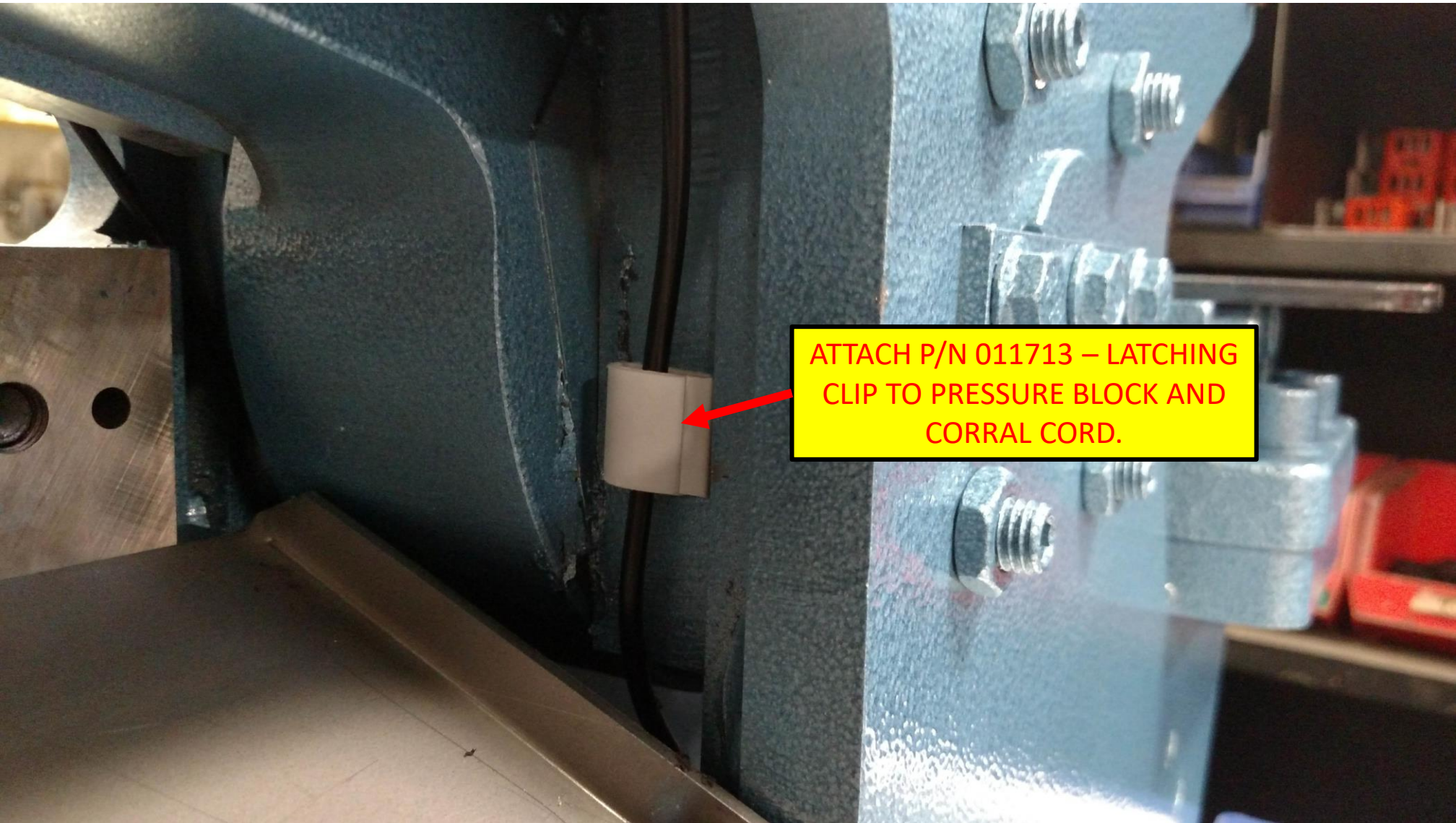
REAR OF
MACHINE



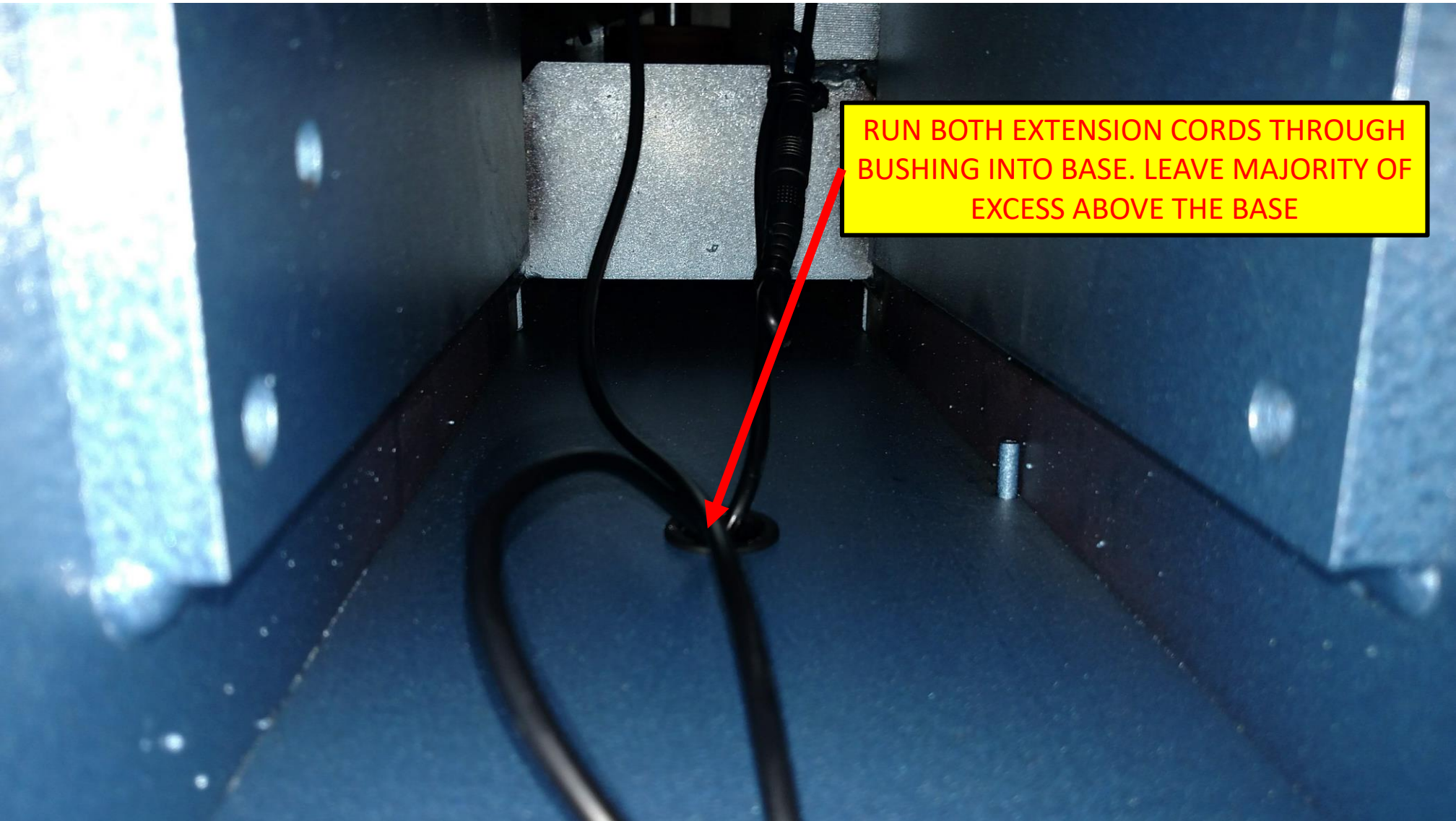
**ATTACH P/N 011713 – LATCHING CLIP TO PUNCH BOLSTER
AS SHOWN. KEEP THE CLIP TOWARDS THE REAR OF THE
MACHINE AND ROUTE THE CORD THROUGH.**



**RUN EXTENSION CORD
DOWN ON THE BACKSIDE
OF THE BEAM AND THE
PRESSURE PLATE**



ATTACH P/N 011713 - LATCHING CLIP TO PRESSURE BLOCK AND CORRAL CORD.

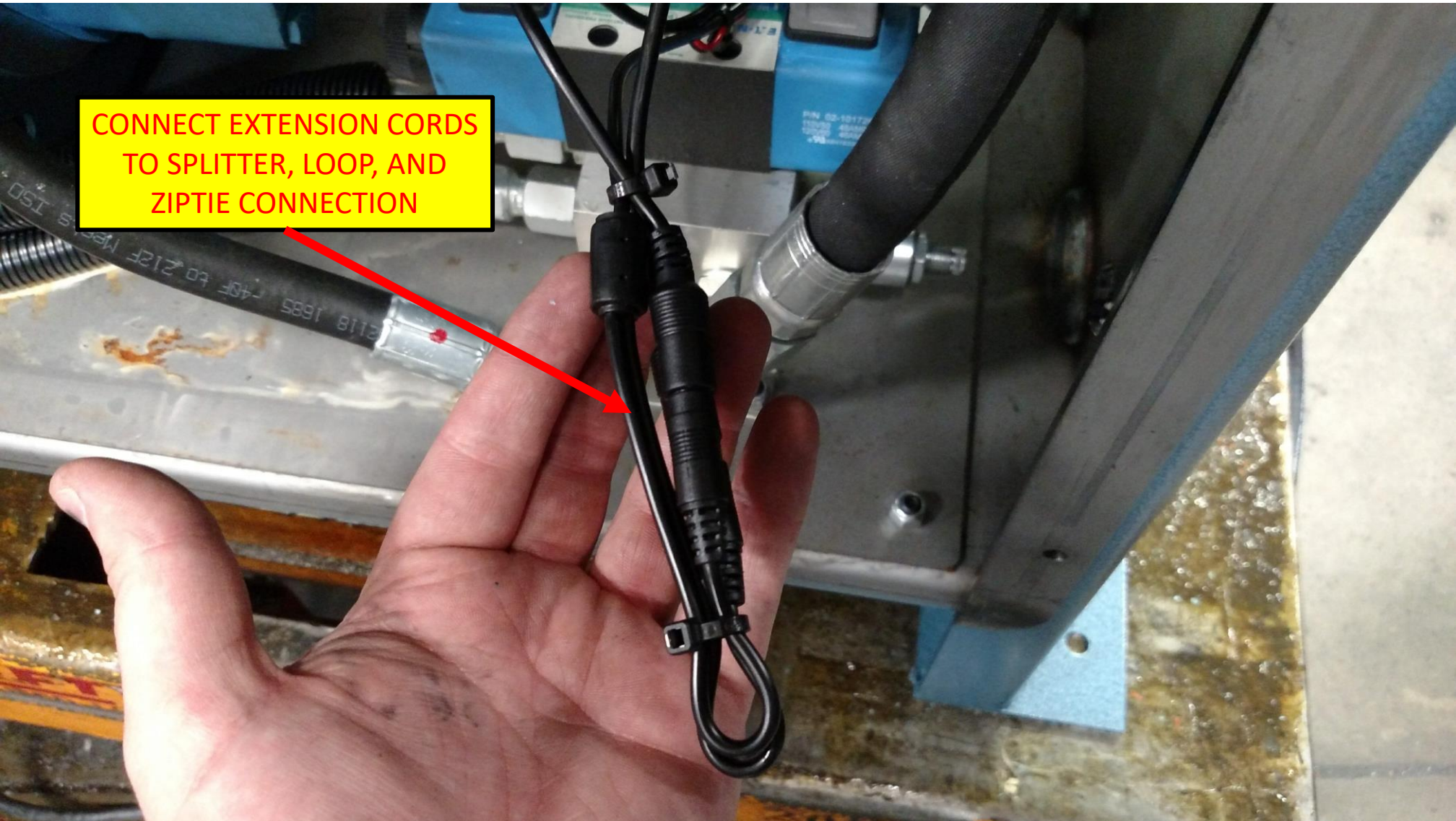


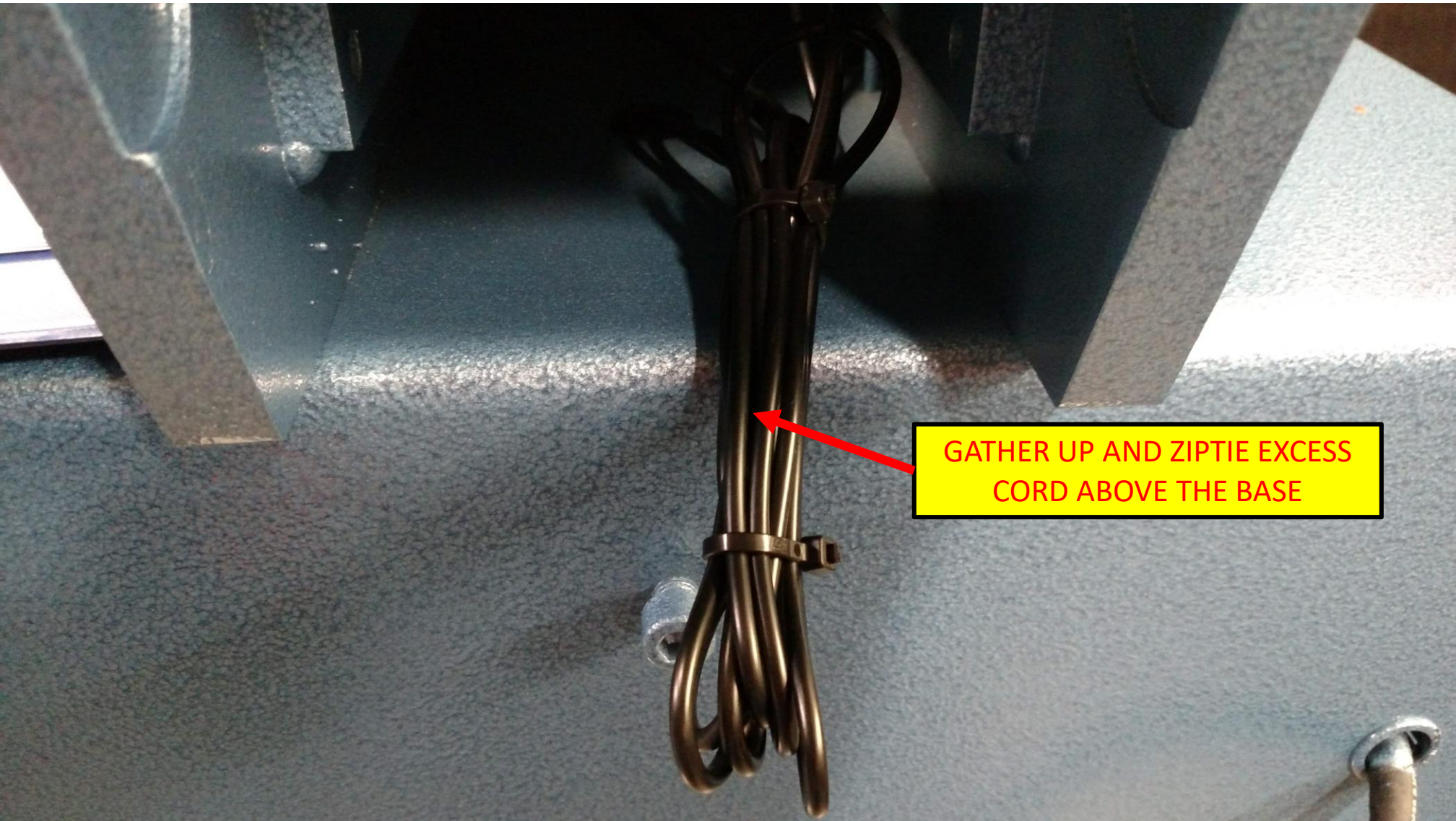
RUN BOTH EXTENSION CORDS THROUGH BUSHING INTO BASE. LEAVE MAJORITY OF EXCESS ABOVE THE BASE



IF THE REAR COVER IS OFF, IT MAY BE EASIER TO CONNECT THE TWO EXTENSION CORDS TO THE 2 – WAY SPLITTER FROM THE BACK.

**CONNECT EXTENSION CORDS
TO SPLITTER, LOOP, AND
ZIPTIE CONNECTION**

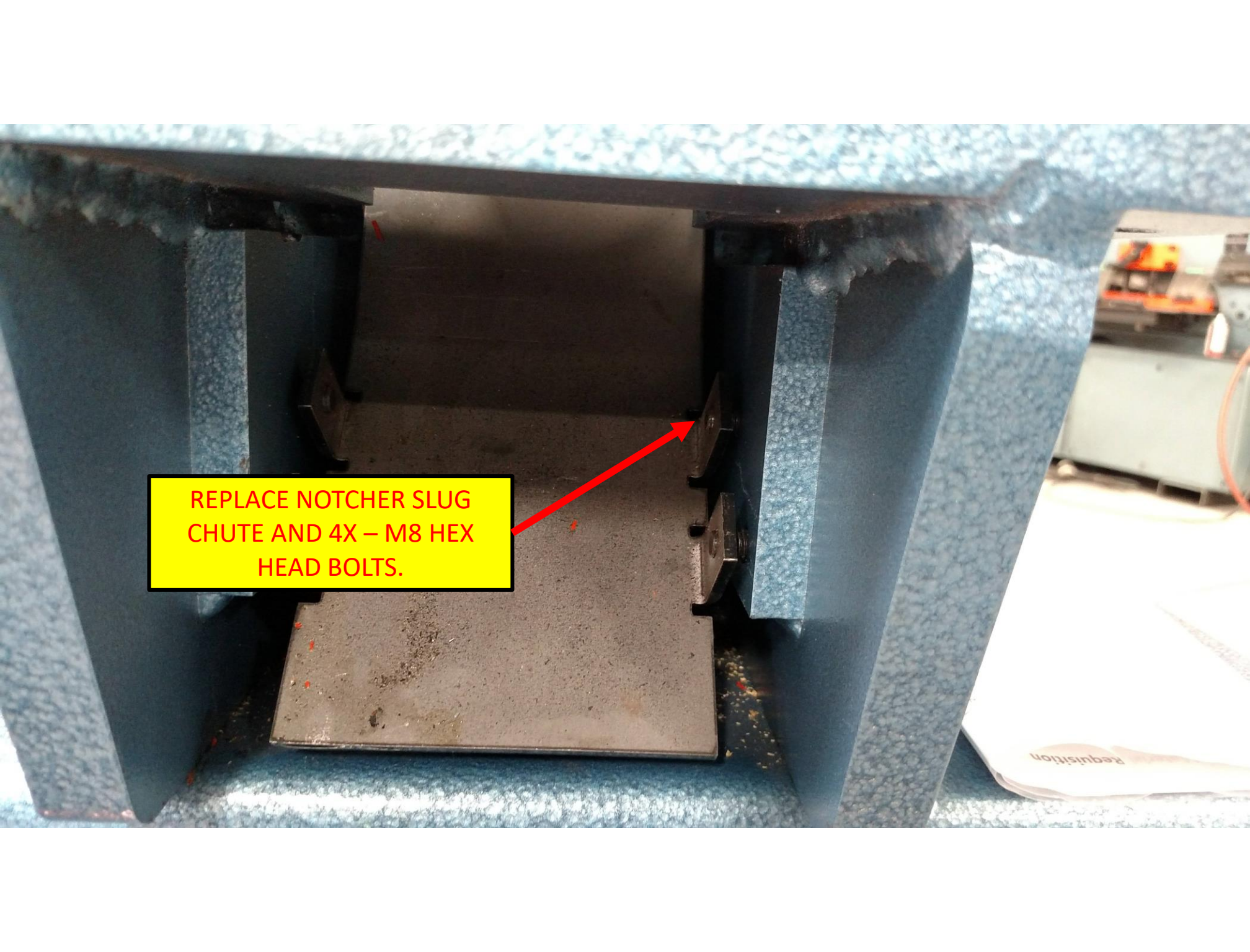




GATHER UP AND ZIPTIE EXCESS
CORD ABOVE THE BASE



PLACE CORD BUNDLE ON TOP OF
BASE AND BEHIND SLUG CHUTES



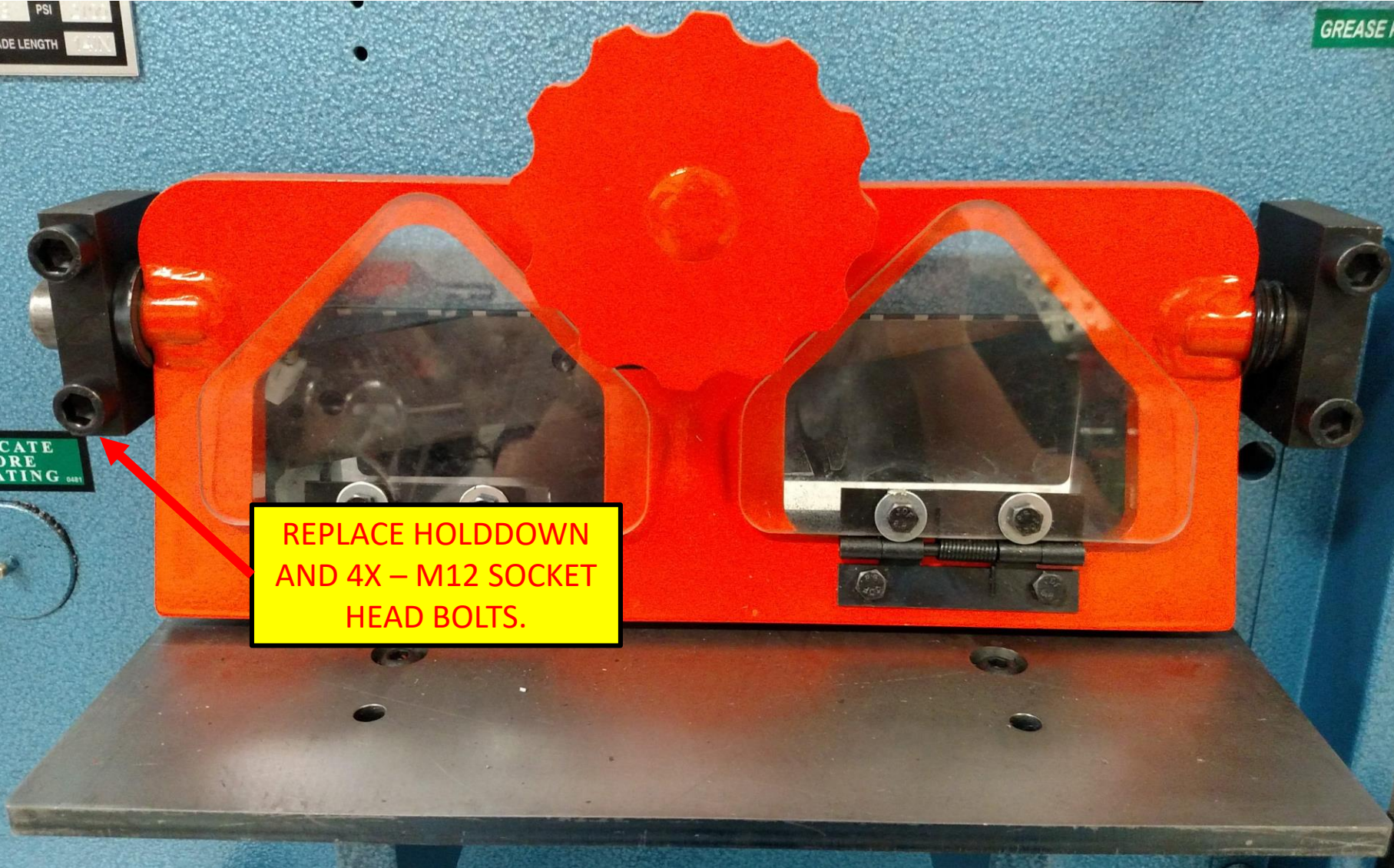
REPLACE NOTCHER SLUG
CHUTE AND 4X – M8 HEX
HEAD BOLTS.

PH PSI
BLADE LENGTH

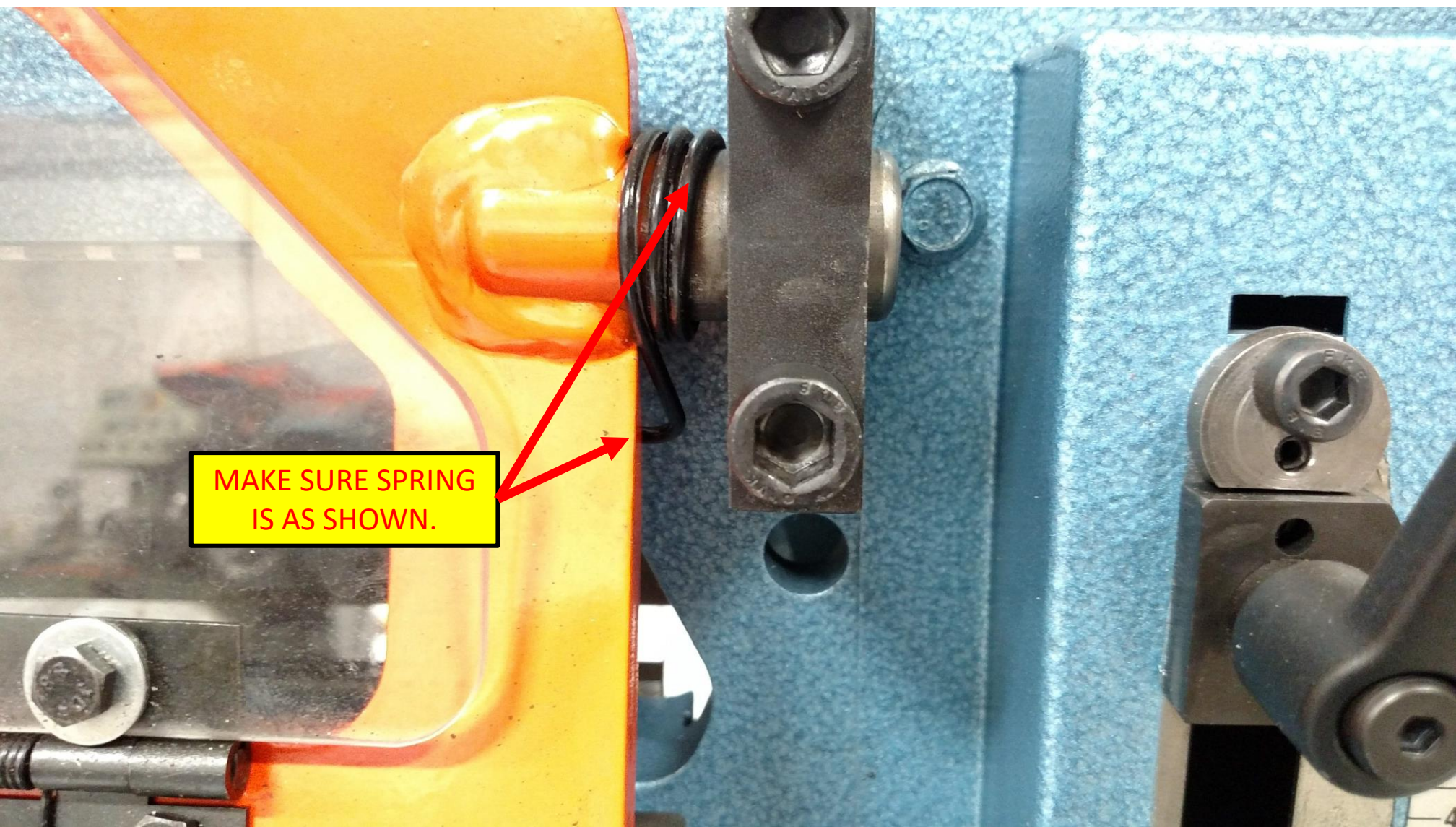
GREASE POINT

LUBRICATE
BEFORE
OPERATING

REPLACE HOLDDOWN
AND 4X – M12 SOCKET
HEAD BOLTS.



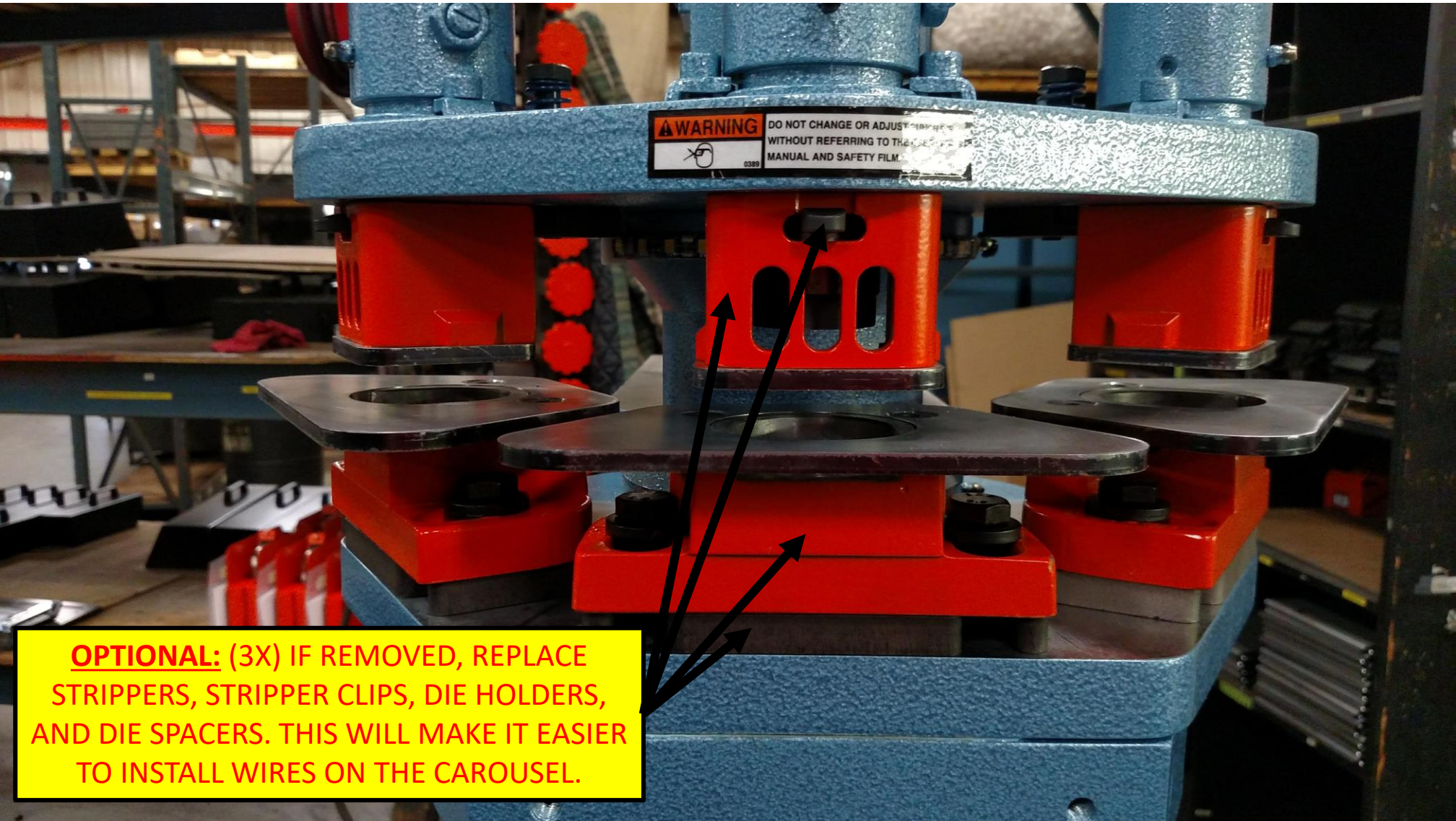
MAKE SURE SPRING IS AS SHOWN.





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

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

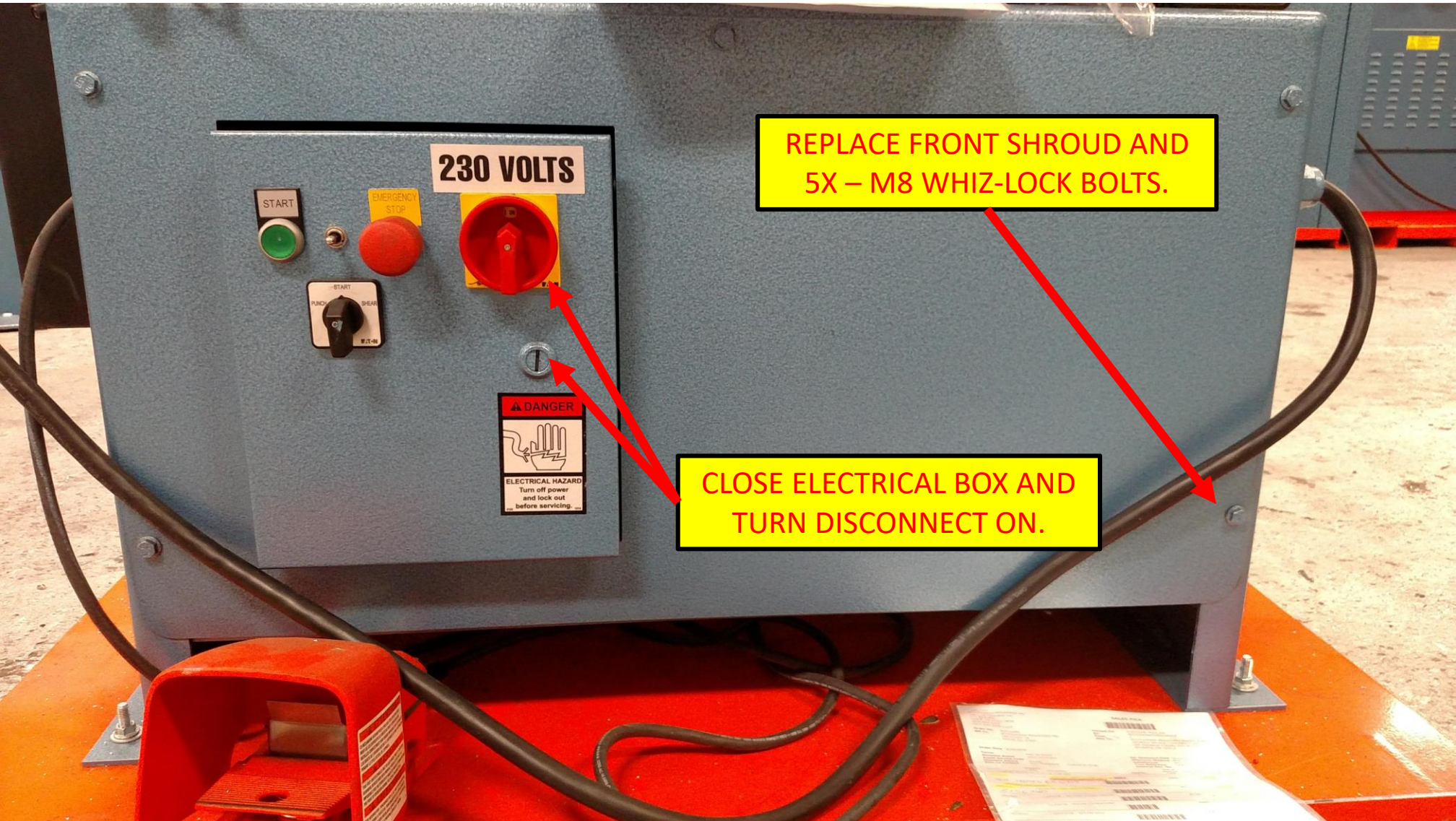


WARNING DO NOT CHANGE OR ADJUST WITHOUT REFERRING TO THE MANUAL AND SAFETY FILM.

OPTIONAL: (3X) IF REMOVED, REPLACE STRIPPERS, STRIPPER CLIPS, DIE HOLDERS, AND DIE SPACERS. THIS WILL MAKE IT EASIER TO INSTALL WIRES ON THE CAROUSEL.

A photograph of a blue metal machine, possibly a lathe or mill, with a yellow text box overlaid. A red arrow points from the text box to a hole on the top surface of the machine. The text box contains the instruction: "REPLACE REAR SHROUD AND 5X - M8 WHIZ-LOCK BOLTS IF THEY HAD BEEN REMOVED." The machine has a blue painted metal body and a dark brown top section. The background shows a concrete floor and a red fire extinguisher.

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



230 VOLTS

START

EMERGENCY STOP

START
PUNCH BEAR

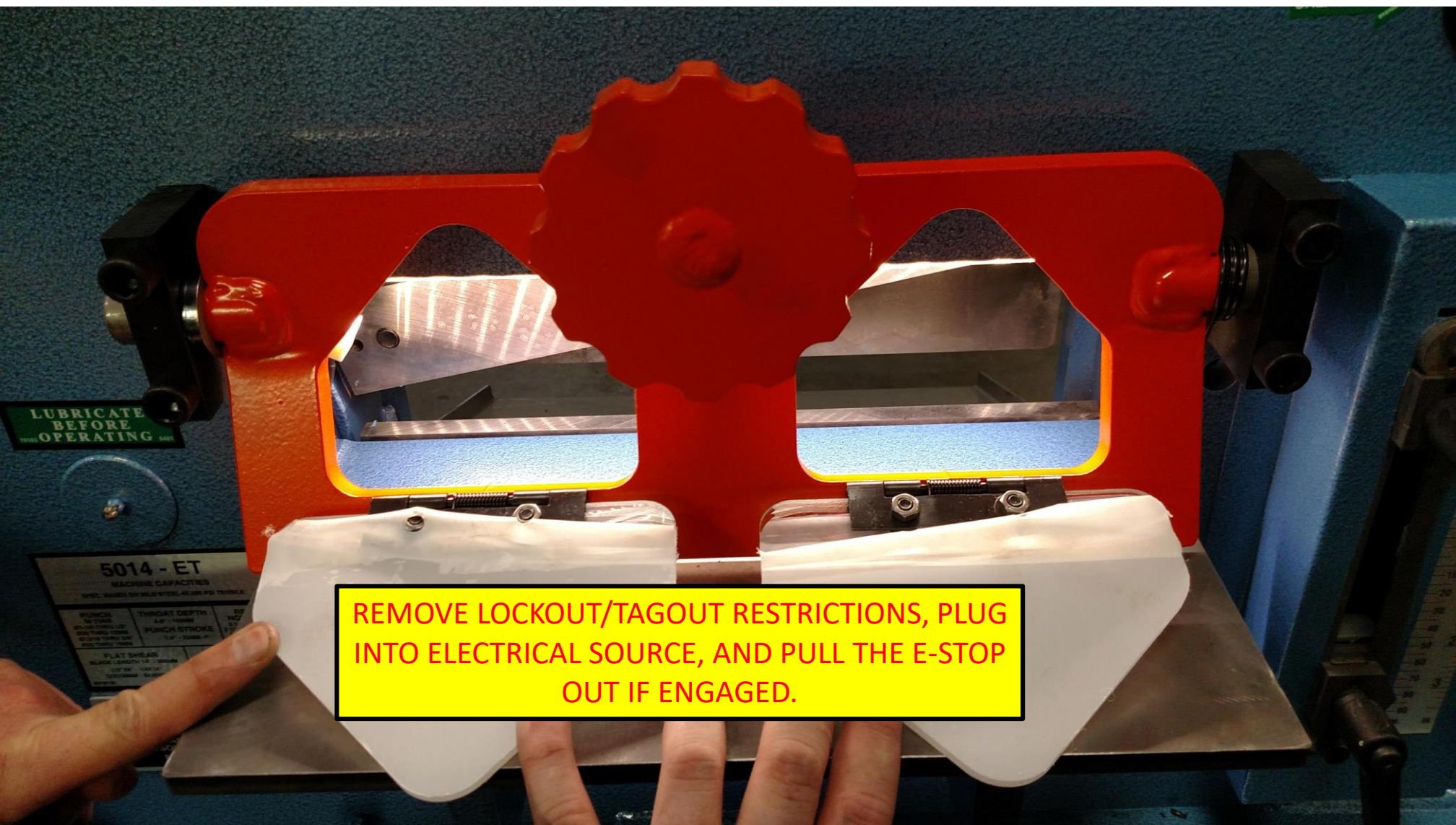
DANGER



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.**



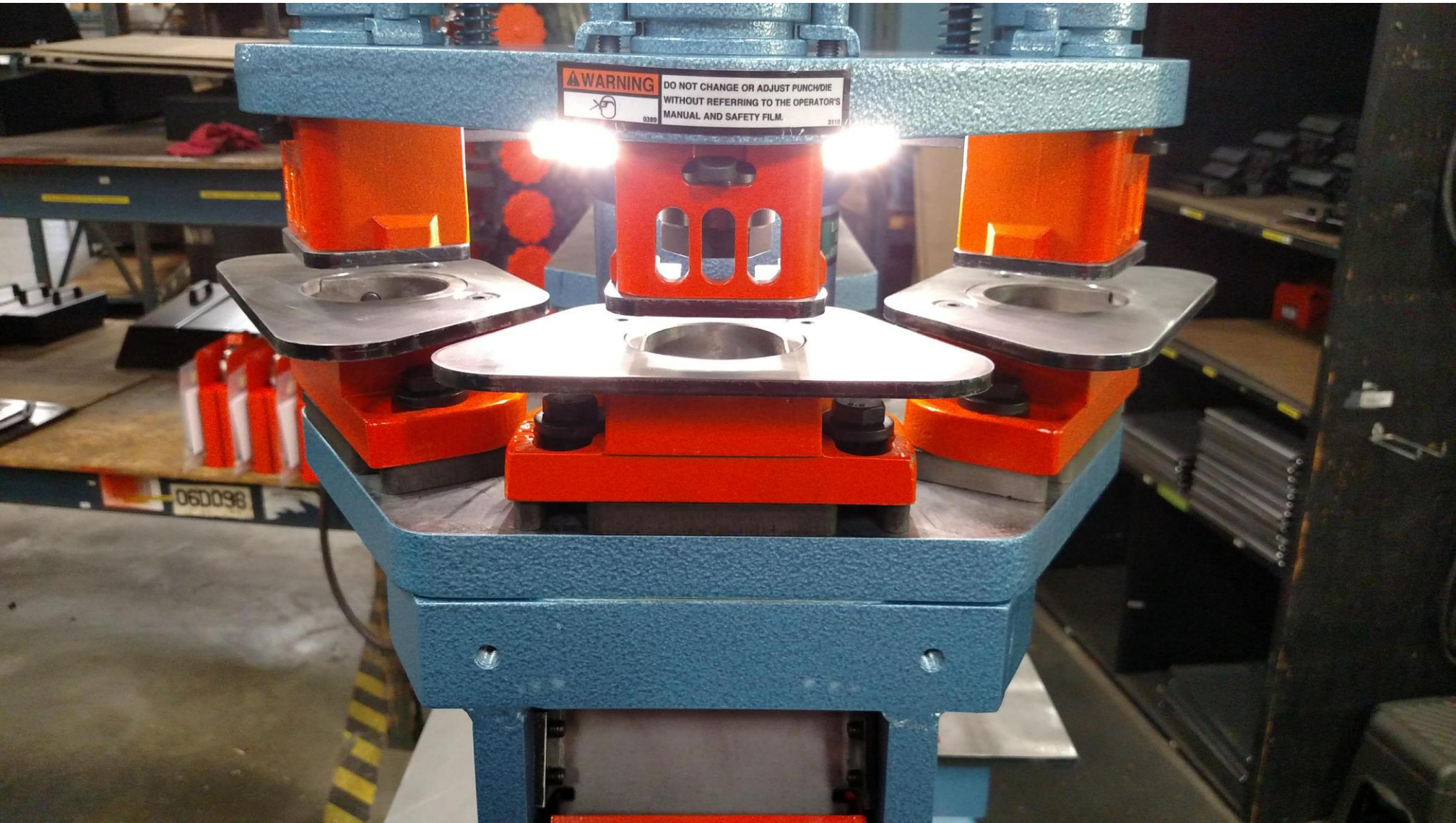
LUBRICATE
BEFORE
OPERATING

5014 - ET
MACHINE CAPACITIES
SPEC. BASED ON MIL-SPEC 45200 PG 2 TABLE

| PUNCH NO. TONS | THROAT DEPTH L.P. INCHES | SP. NO. |
|-------------------|-----------------------------|------------|
| 1000 | 10 | 10 |
| 500 | 5 | 5 |
| 250 | 2.5 | 2.5 |

FLAT SHEAR
BLADE LENGTH 14" SHEAR
107 28 100/14
1000000 500000

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



WARNING DO NOT CHANGE OR ADJUST PUNCH/DIE
WITHOUT REFERRING TO THE OPERATOR'S
MANUAL AND SAFETY FILM.

0309

3110

06D098