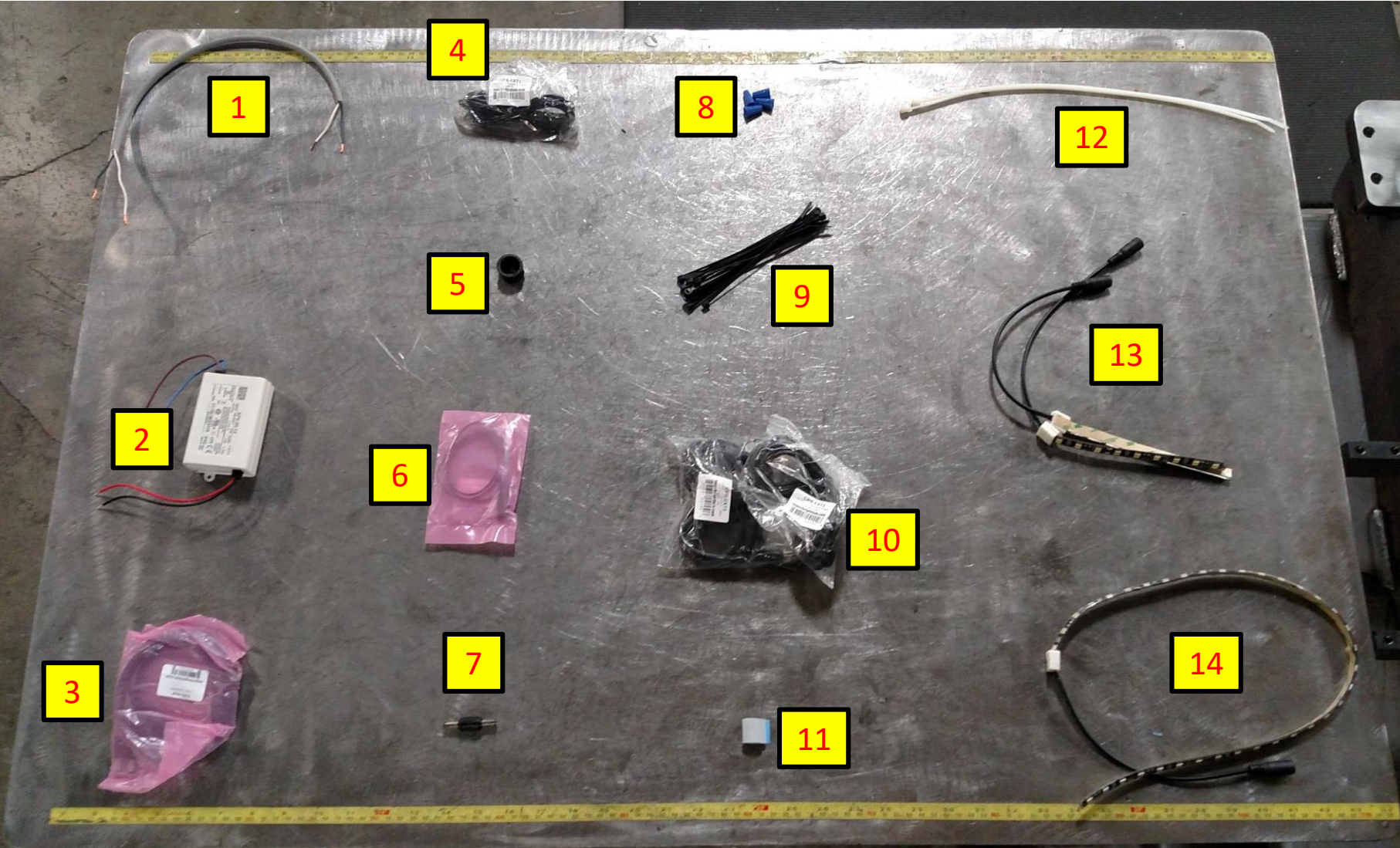


P/N 090517 – LED LIGHTS DO 70/95 MACHINES





1

4

8

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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	158003	#3104 SNAP BUSHING
6	1	090509	4-WAY SPLITTER
7	1	090506	MALE-MALE CONNECTOR
8	4	145005	SMALL BLUE WIRE NUT
9	14	660505	BLACK NYLON CABLE TIE
10	2	090502	3 METER EXTENSION
11	1	011713	LATCHING CLIP
12	2	045635	14" CABLE TIE AS
13	2	090541	9 LED BULB STRIP (6 IN.)
14	1	090545	36 LED BULB STRIP (24 IN.)

BASIC CONSIDERATIONS

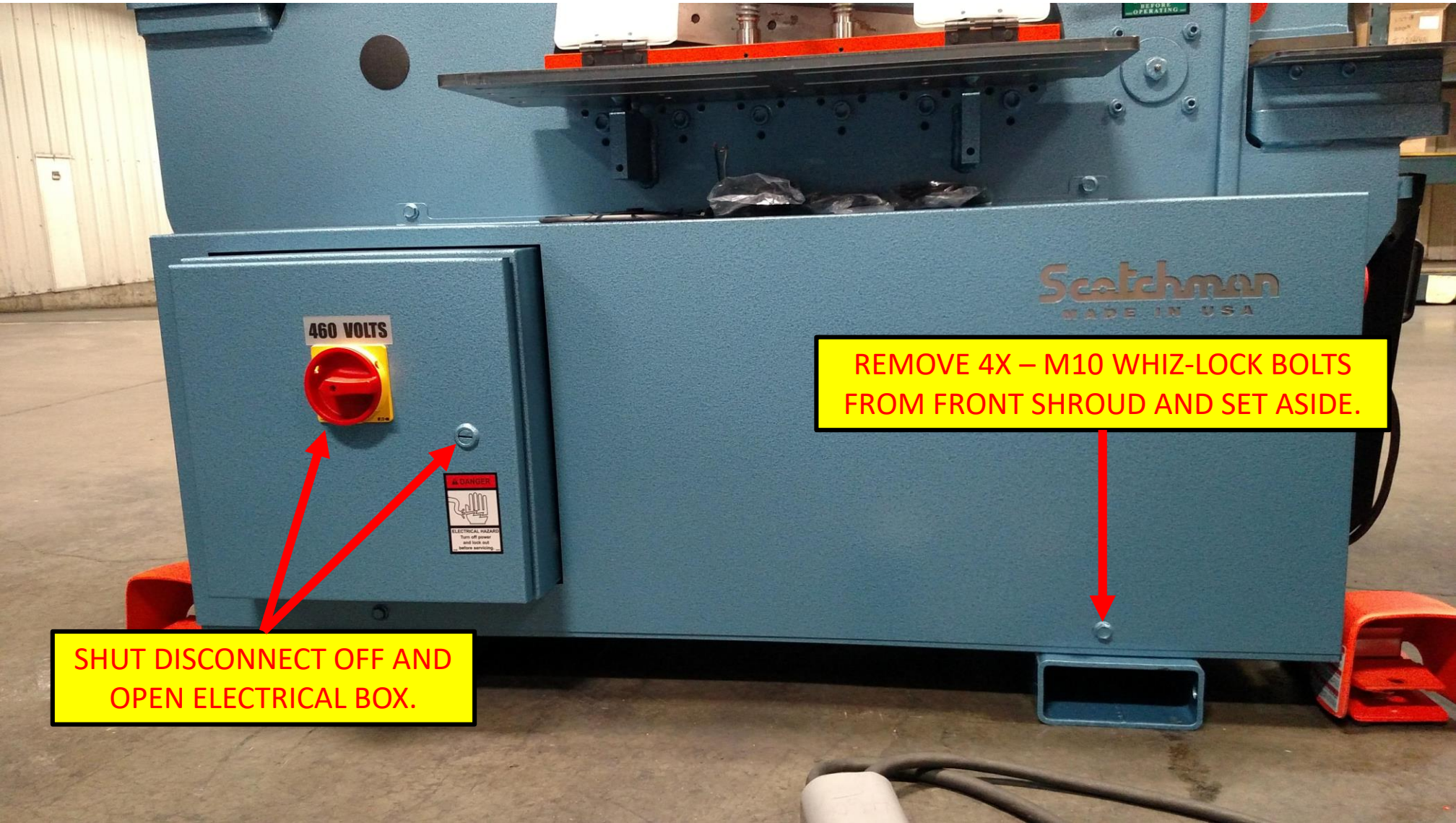
- Please read the instructions **FULLY** before attempting to install the product.
- Make sure to unplug the machine from its electrical source and perform any necessary lockout/tagout procedures.
- If the old worklight is installed, it will be necessary to remove the cord from the base. The light can 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 32](#))



460 VOLTS

Scotchman
MADE IN USA

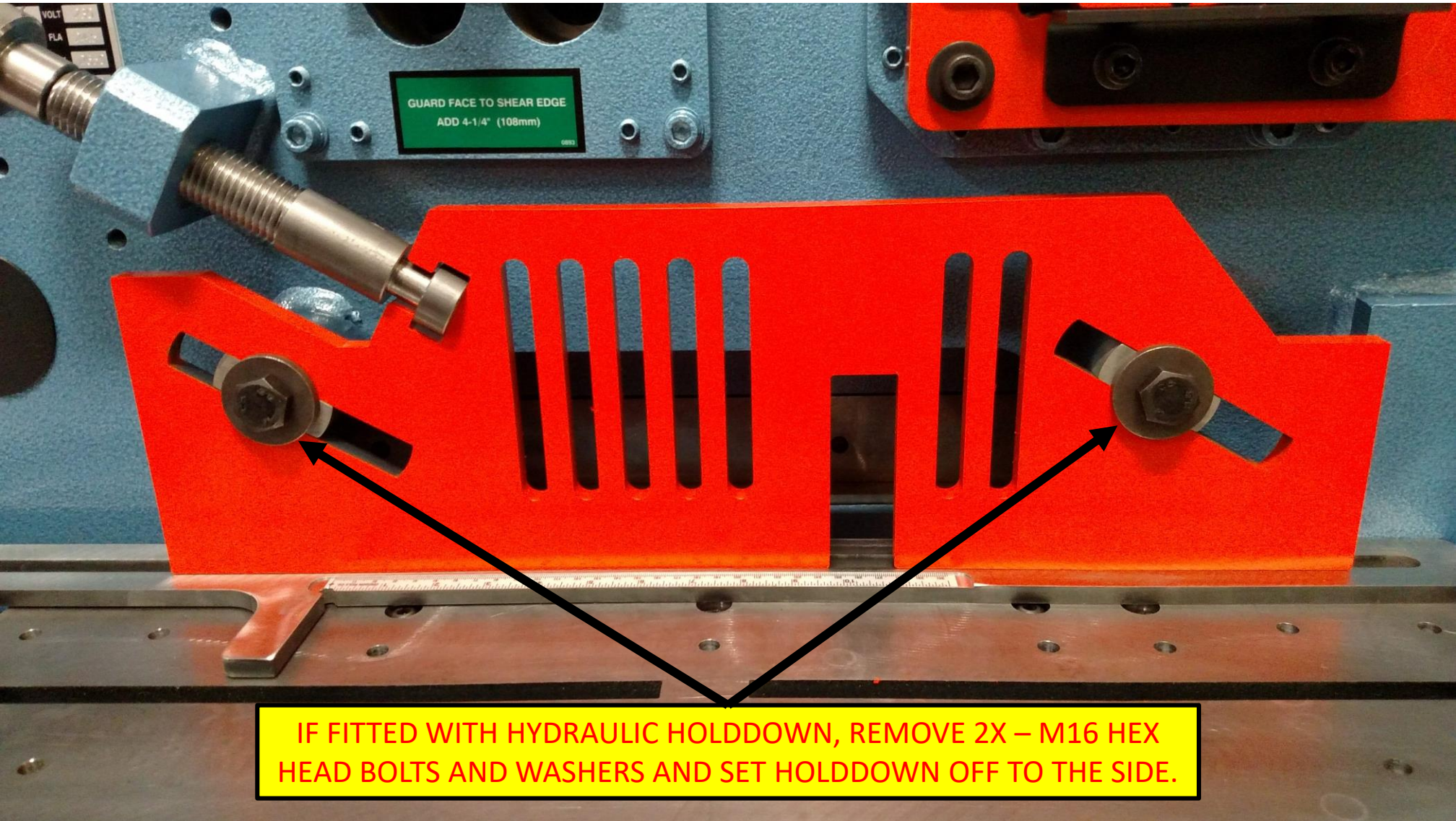
REMOVE 4X – M10 WHIZ-LOCK BOLTS
FROM FRONT SHROUD AND SET ASIDE.

SHUT DISCONNECT OFF AND
OPEN ELECTRICAL BOX.

SEE NEXT PAGE FOR
HYDRAULIC HOLDDOWN.



SCREW HOLDDOWN TO SHEAR TABLE,
REMOVE 4X – M12 SOCKET HEAD BOLTS,
AND SET HOLDDOWN OFF TO THE SIDE.



GUARD FACE TO SHEAR EDGE
ADD 4-1/4" (108mm)

IF FITTED WITH HYDRAULIC HOLDDOWN, REMOVE 2X – M16 HEX HEAD BOLTS AND WASHERS 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 THIS GUARD**

07H 16247
65/90/120-R
FIBRO-BK
90/120-RS

26727

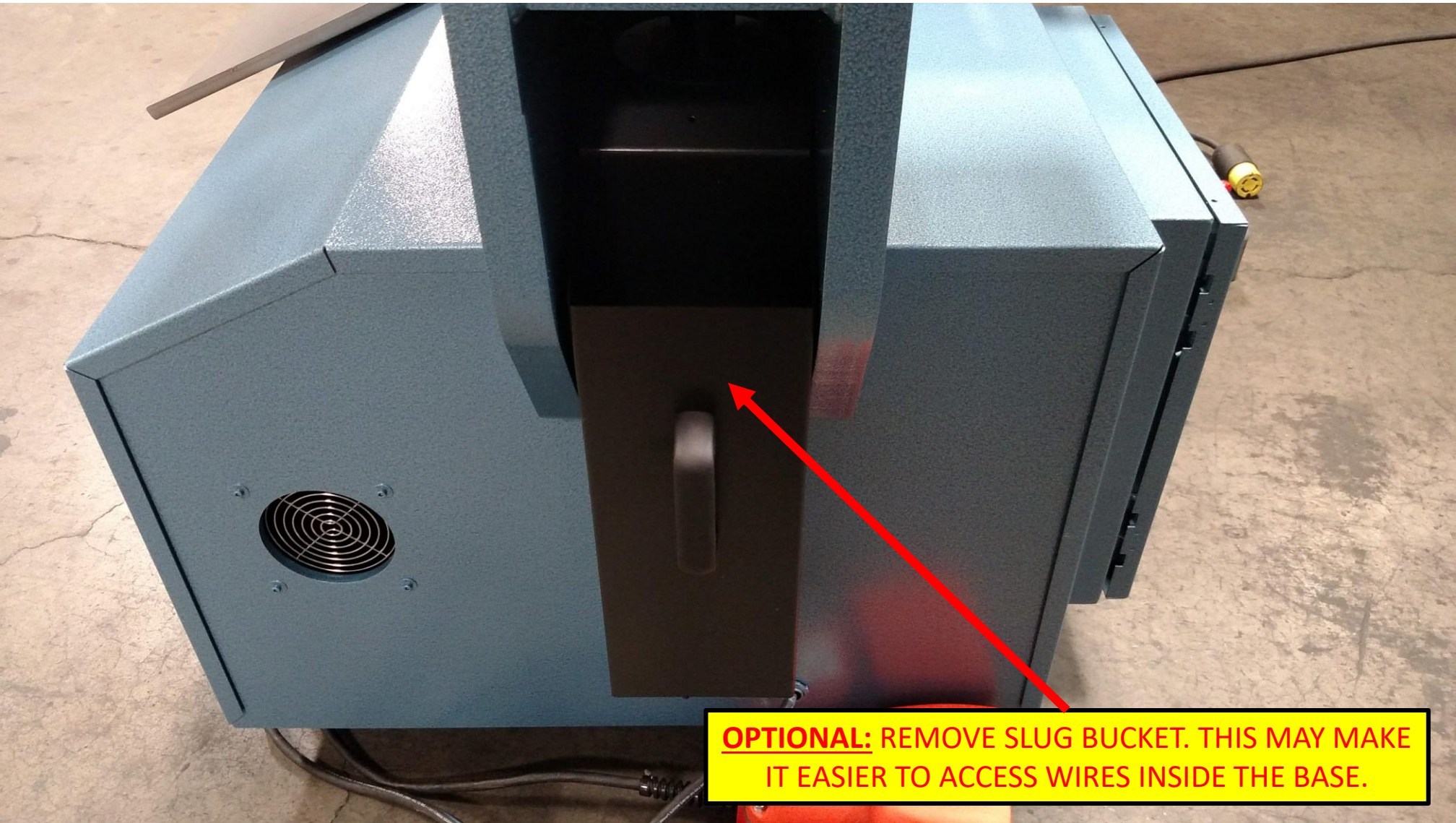
**WHEN MITERING
DO NOT EXCEED
3 X 3 X 1/4**

R
LE
EAR
87" - 800000
M24
MOTOR
OTCHER
3"X3"X1/2"
E SHEAR
90°/120°
18/100L12000

H.P.	VOLT
KV	FLA
PH	PSI

BLADE LENGTH

WARNING
TO PREVENT SERIOUS BODILY INJURY
NEVER: Operate, install, loading, service or adjust machine without proper instructions and without reading and understanding the operator's manual and safety film.
NEVER: Service machine with electrical power connected.
NEVER: Operate any station without the respective strippers or hold-downs in place.
NEVER: Operate machine with protruding guards removed.
NEVER: Place any part of your body under blade, punch or moving members.
NEVER: Operate punch station without checking the punch to die alignment and tightness. (Check alignment and tightness daily).
NEVER: Punch soft metals, punch or shear unknown materials, side load press brakes.
DO NOT REMOVE THIS SIGN FROM THIS MACHINE
FOR MORE INFORMATION CONTACT SCOTCHMAN INDUSTRIES INC. AT
1-800-843-8844



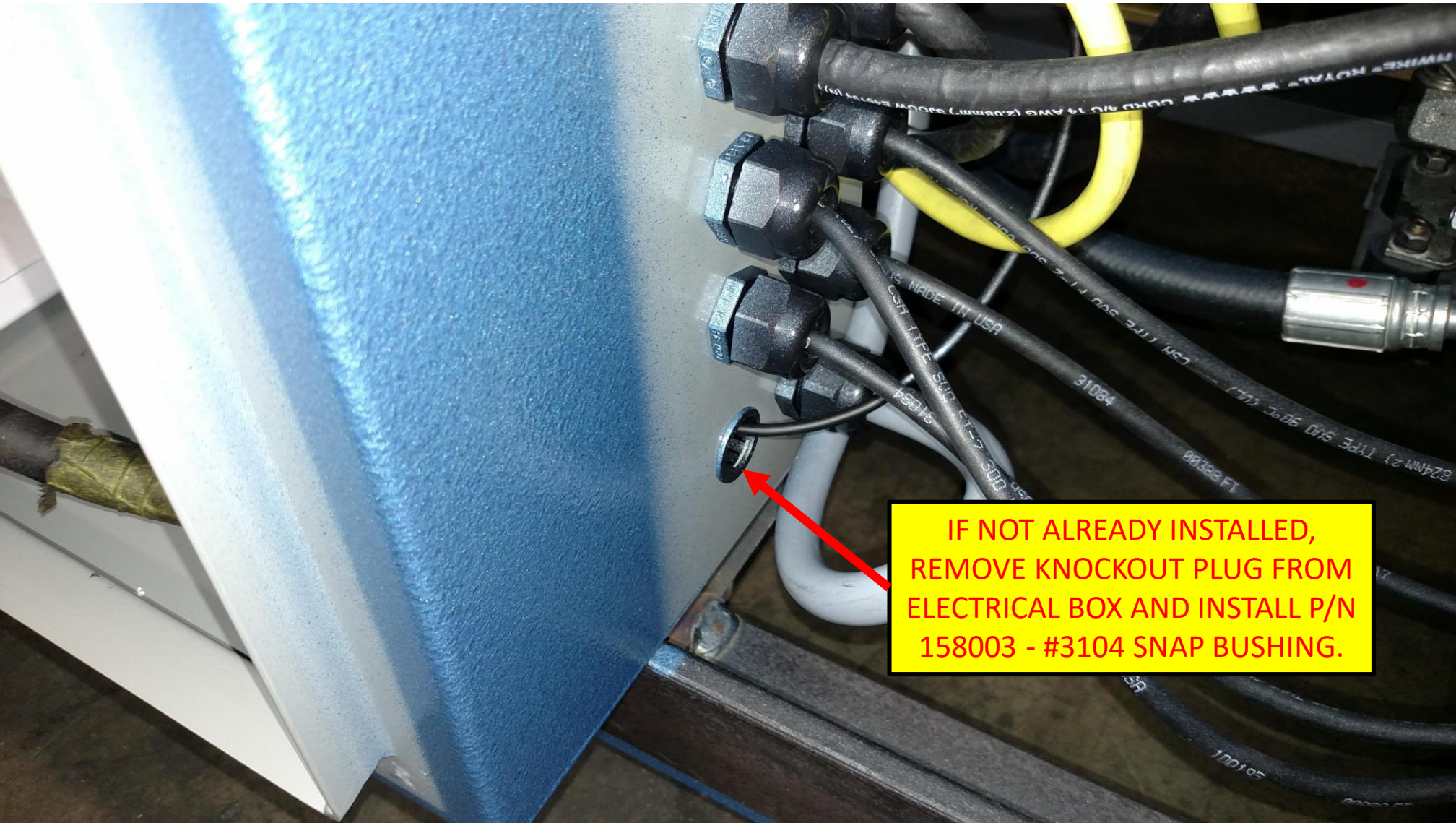
OPTIONAL: REMOVE SLUG BUCKET. THIS MAY MAKE IT EASIER TO ACCESS WIRES INSIDE THE BASE.



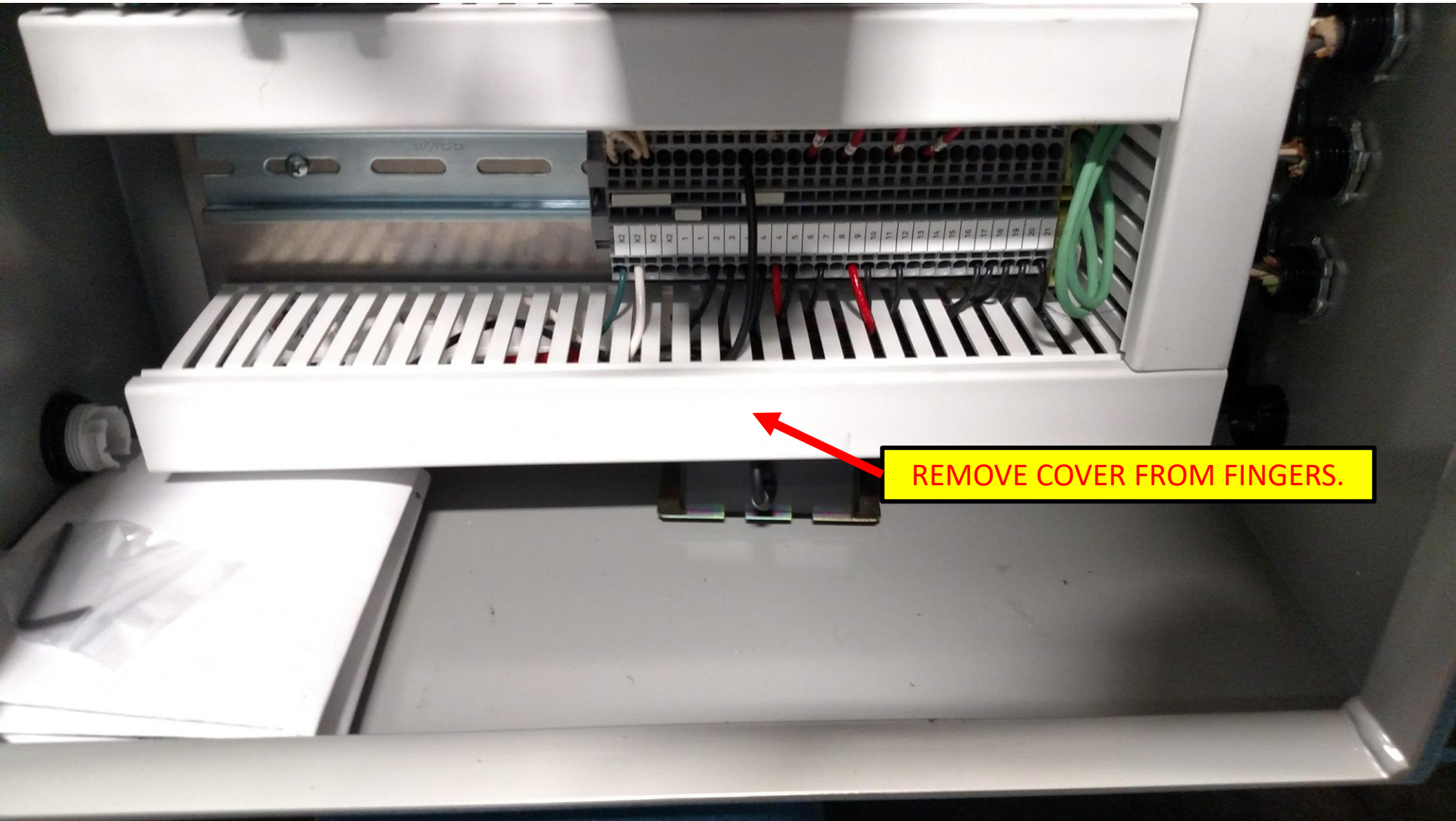
GREASE POINT

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

OPTIONAL: SWING STRIPPER OUT
AND REMOVE 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.



REMOVE COVER FROM FINGERS.

INSTALL WHITE FROM 18/2
SVO CORD INTO TERMINAL X2
OR GROUND IF NECESSARY.

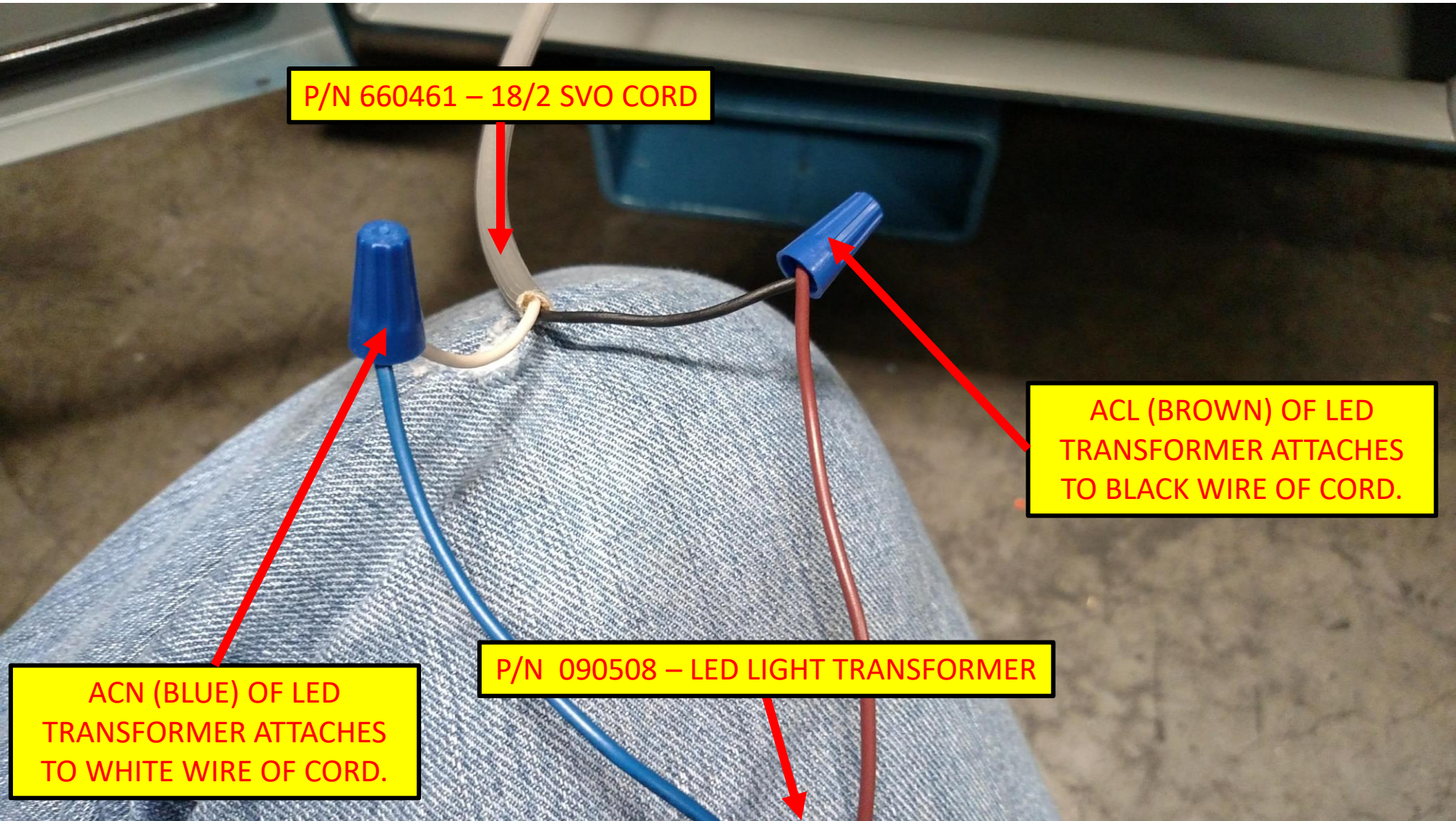
INSTALL BLACK FROM 18/2 SVO
CORD INTO TERMINAL 3.

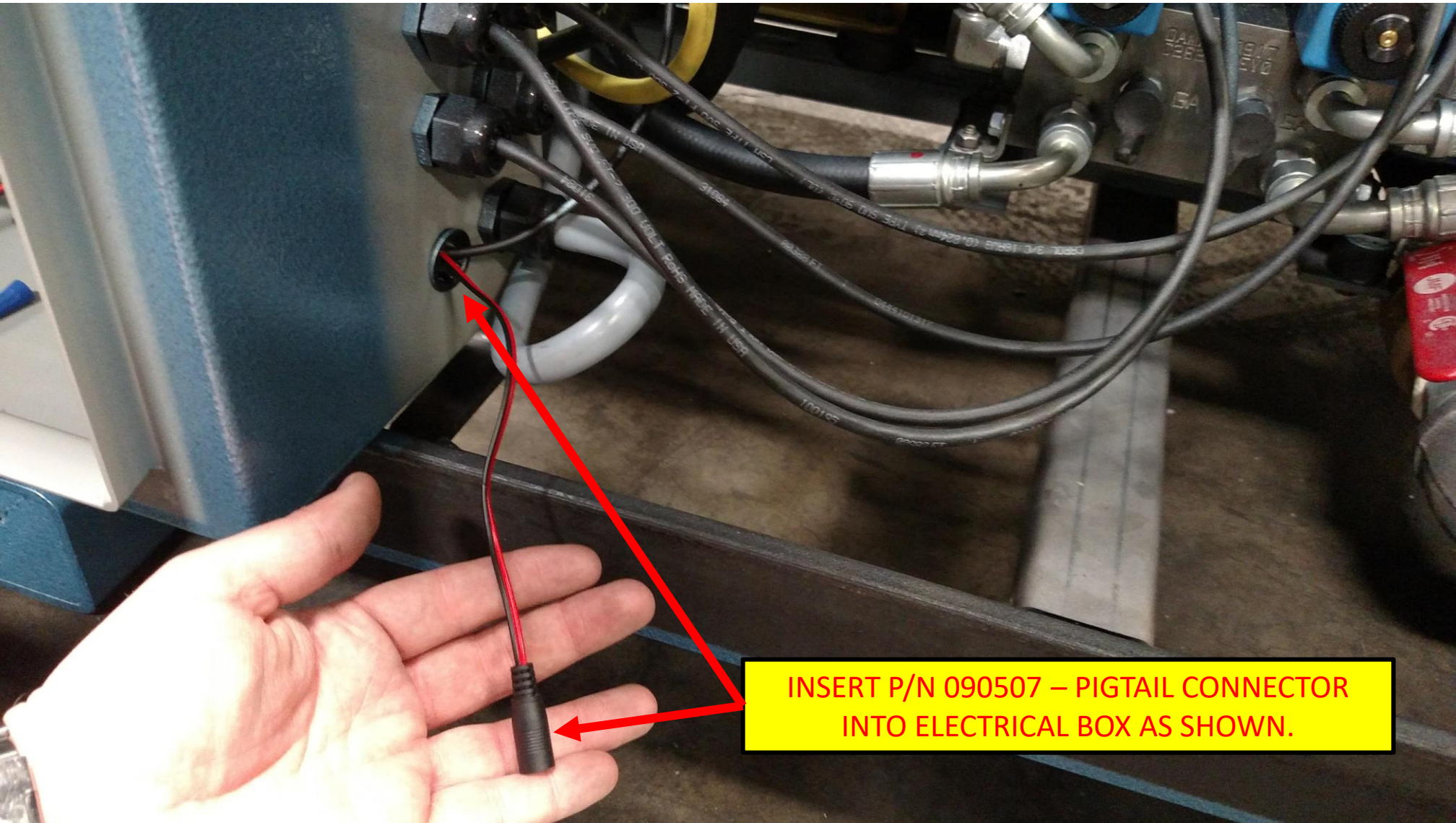
P/N 660461 – 18/2 SVO CORD

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

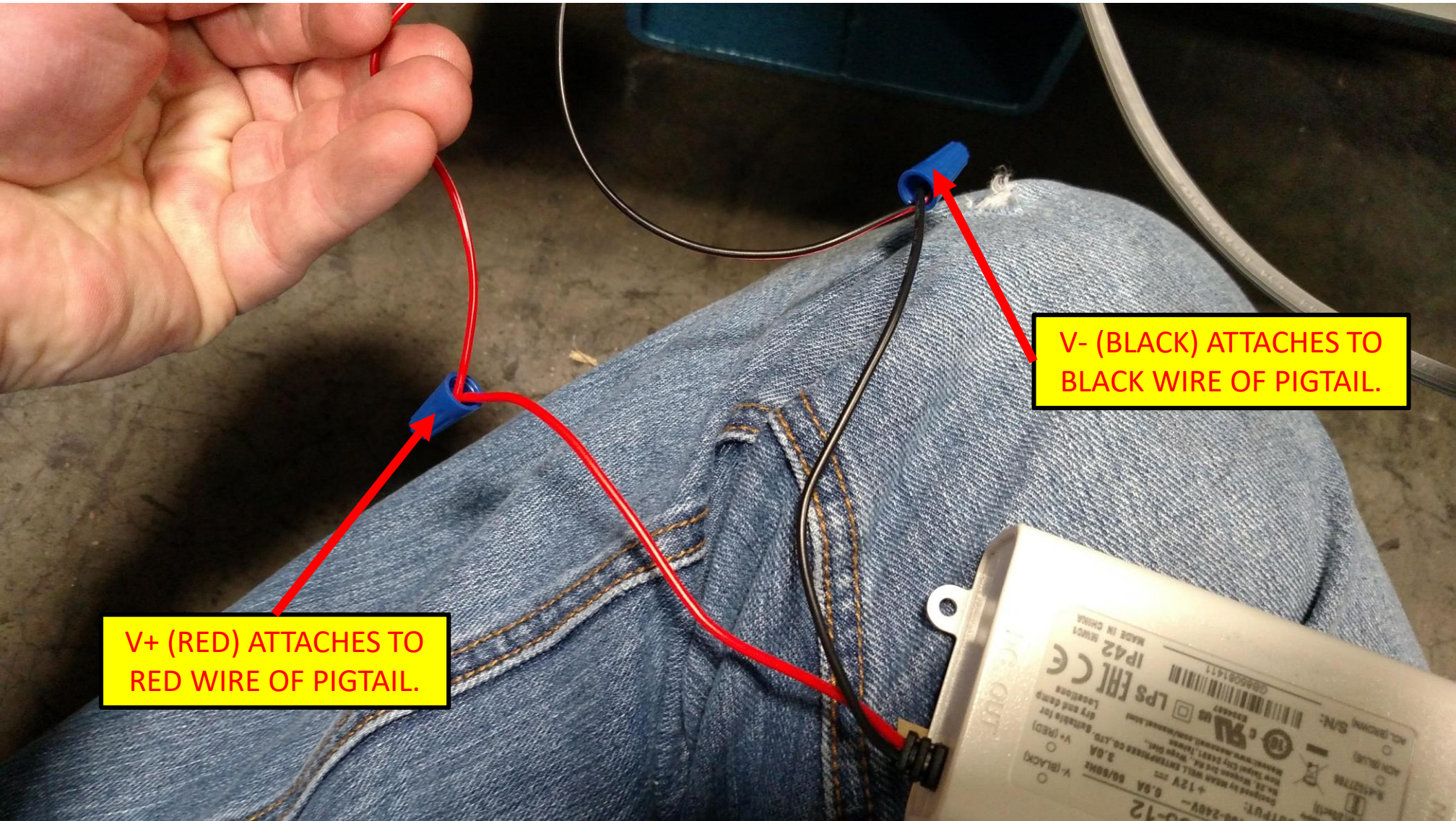
ACN (BLUE) OF LED
TRANSFORMER ATTACHES
TO WHITE WIRE OF CORD.

P/N 090508 – LED LIGHT TRANSFORMER





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



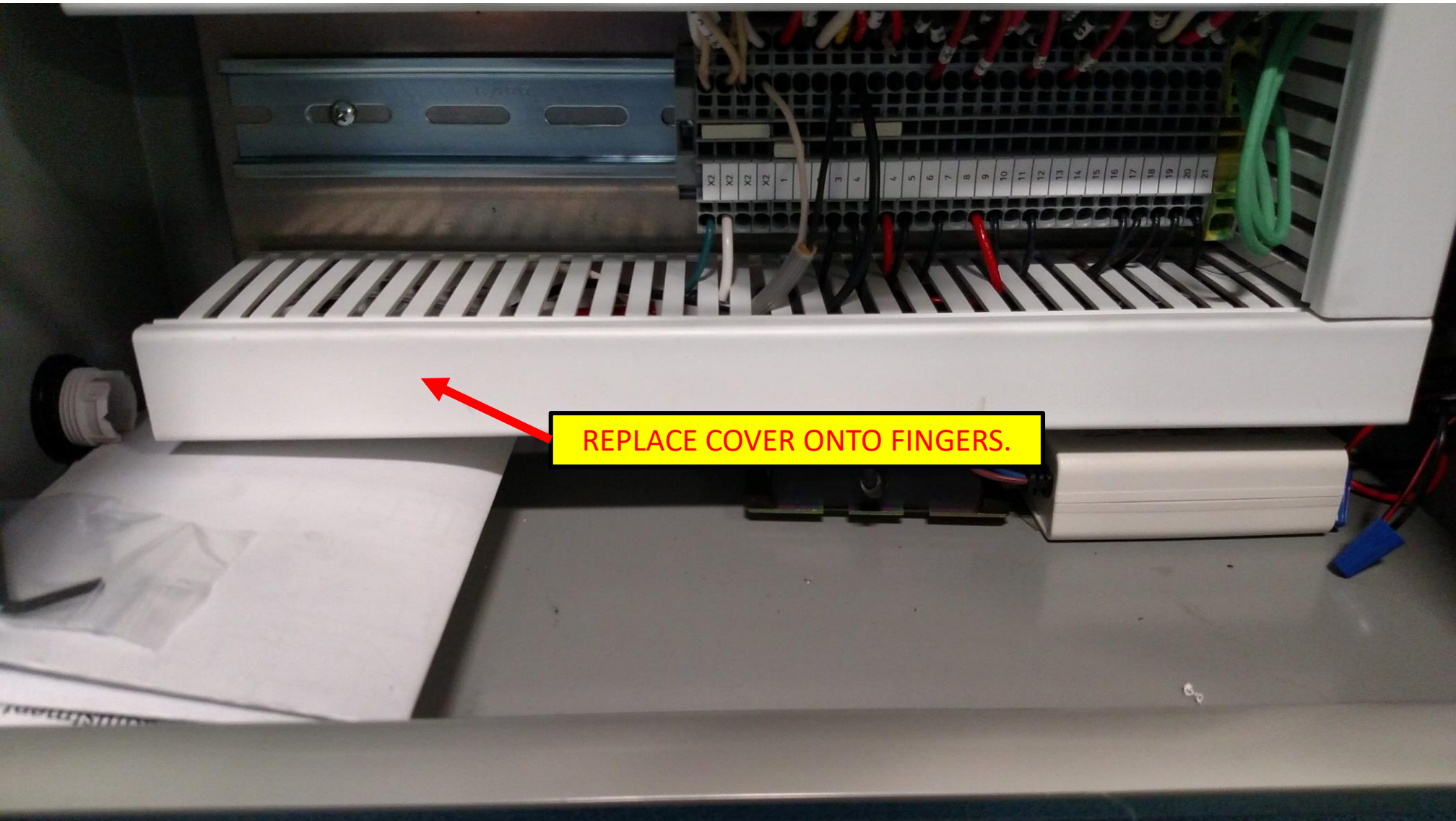
V+ (RED) ATTACHES TO RED WIRE OF PIGTAIL.

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



TUCK THE WIRES AND CORD AS SHOWN.

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



REPLACE COVER ONTO FINGERS.



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



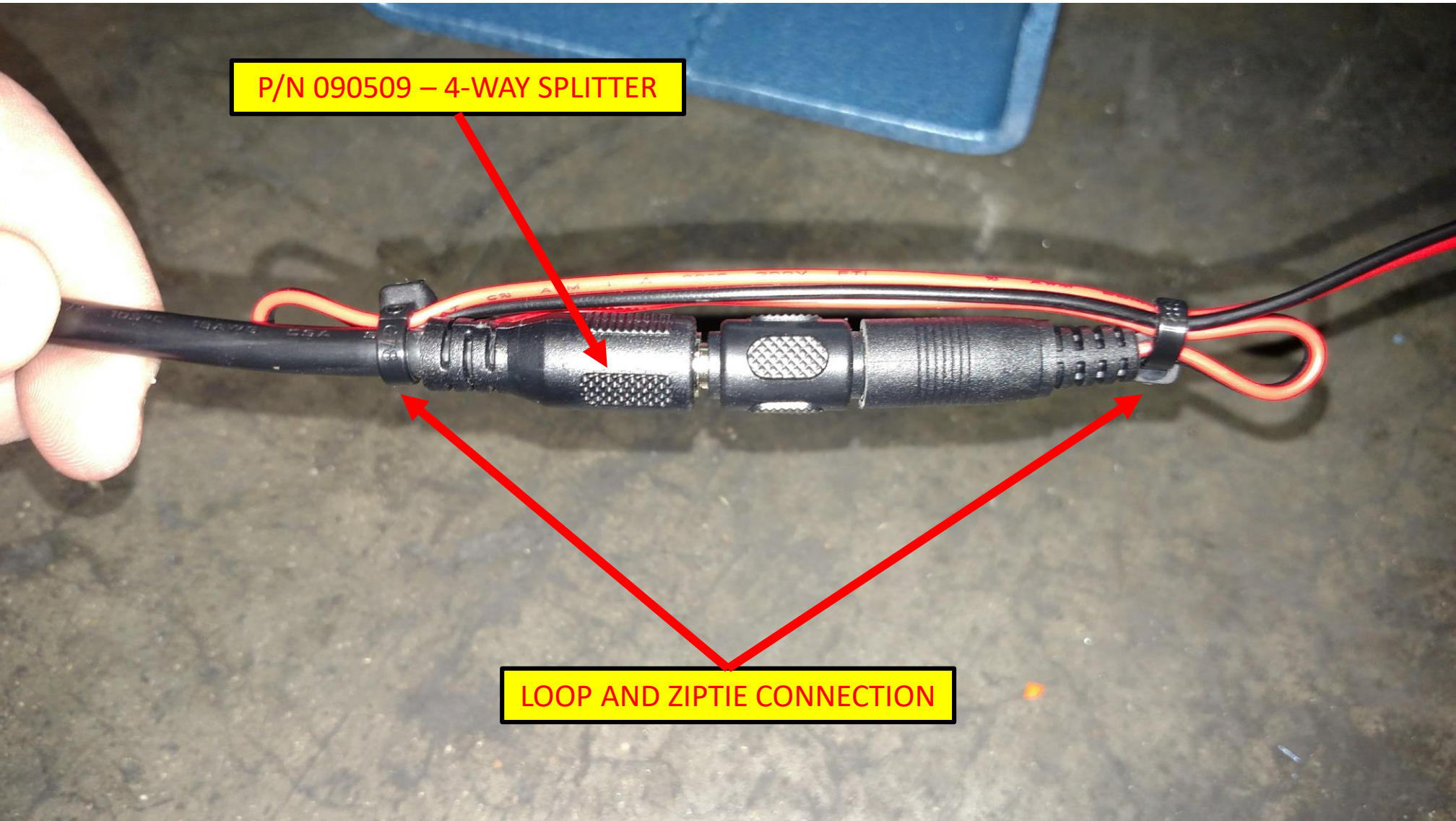
THIS IS WHAT IT SHOULD LOOK LIKE.

P/N 090506 – MALE-MALE CONNECTOR

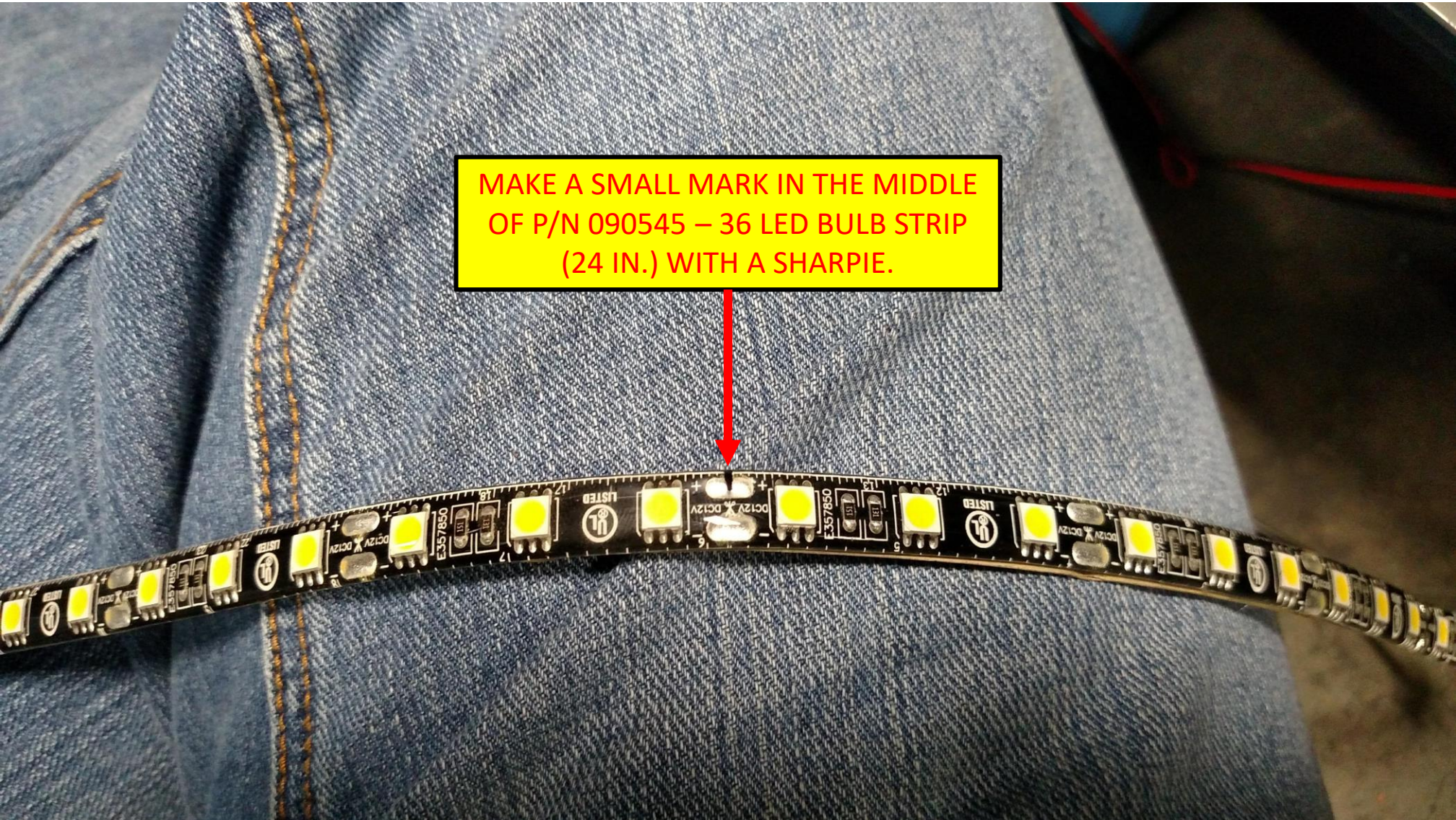


P/N 090509 – 4-WAY SPLITTER

LOOP AND ZIPTIE CONNECTION



MAKE A SMALL MARK IN THE MIDDLE
OF P/N 090545 – 36 LED BULB STRIP
(24 IN.) WITH A SHARPIE.



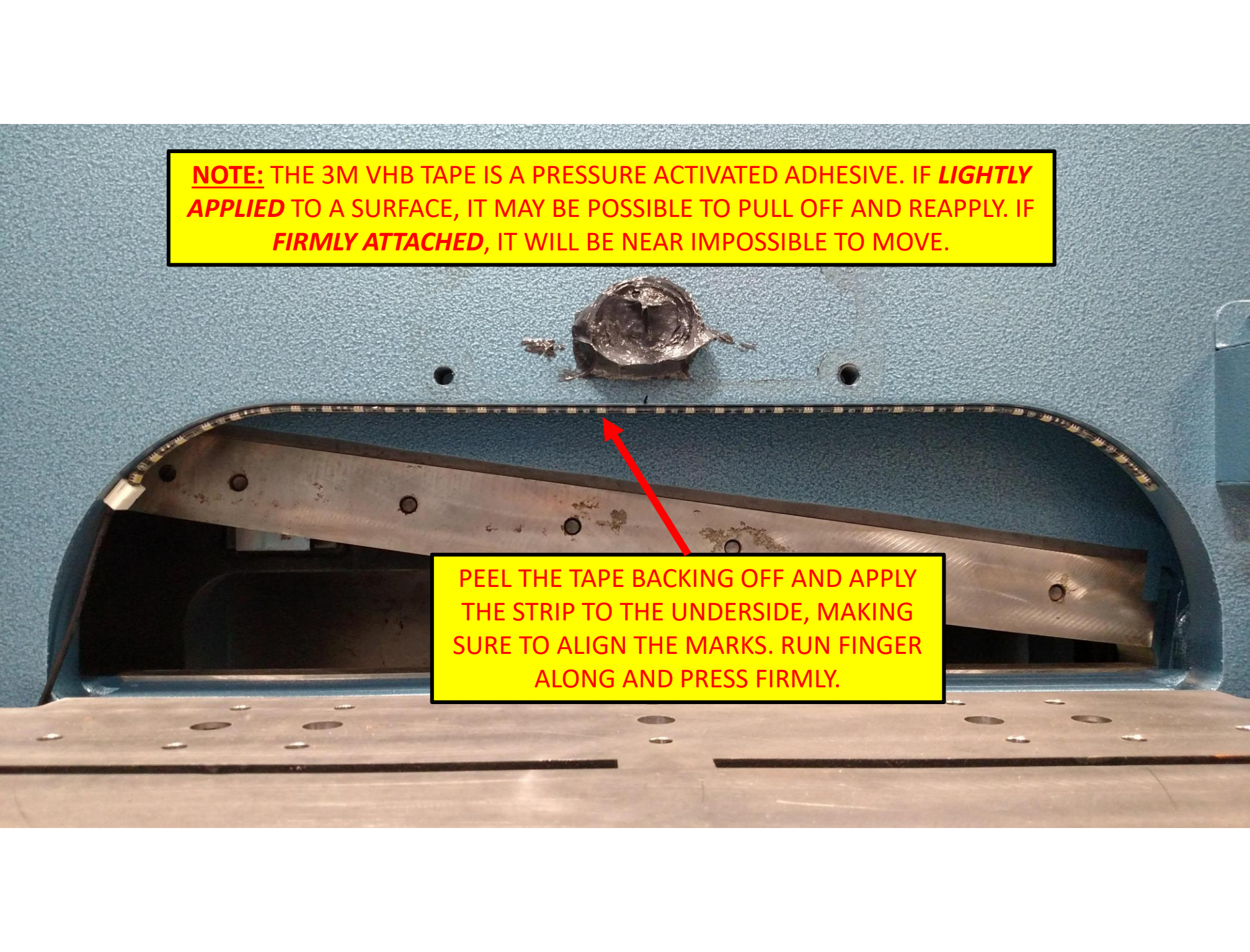
NOTE: BEFORE APPLYING THE LED STRIP, IT IS VERY IMPORTANT TO CLEAN THE SURFACE AS DETAILED [HERE](#).

CLEAN UNDERSIDE.

THIS CURVE MAY BE DIFFERENT ON YOUR MACHINE. THAT IS OKAY.

HOLD THE STRIP UP WITH THE PLASTIC CONNECTOR (ON LEFT) AGAINST THE FRAME. MAKE A SMALL MARK IN THE CENTER OF THE FRAME THAT CORRESPONDS WITH THE MARK ON THE STRIP (SEE NEXT PAGE).

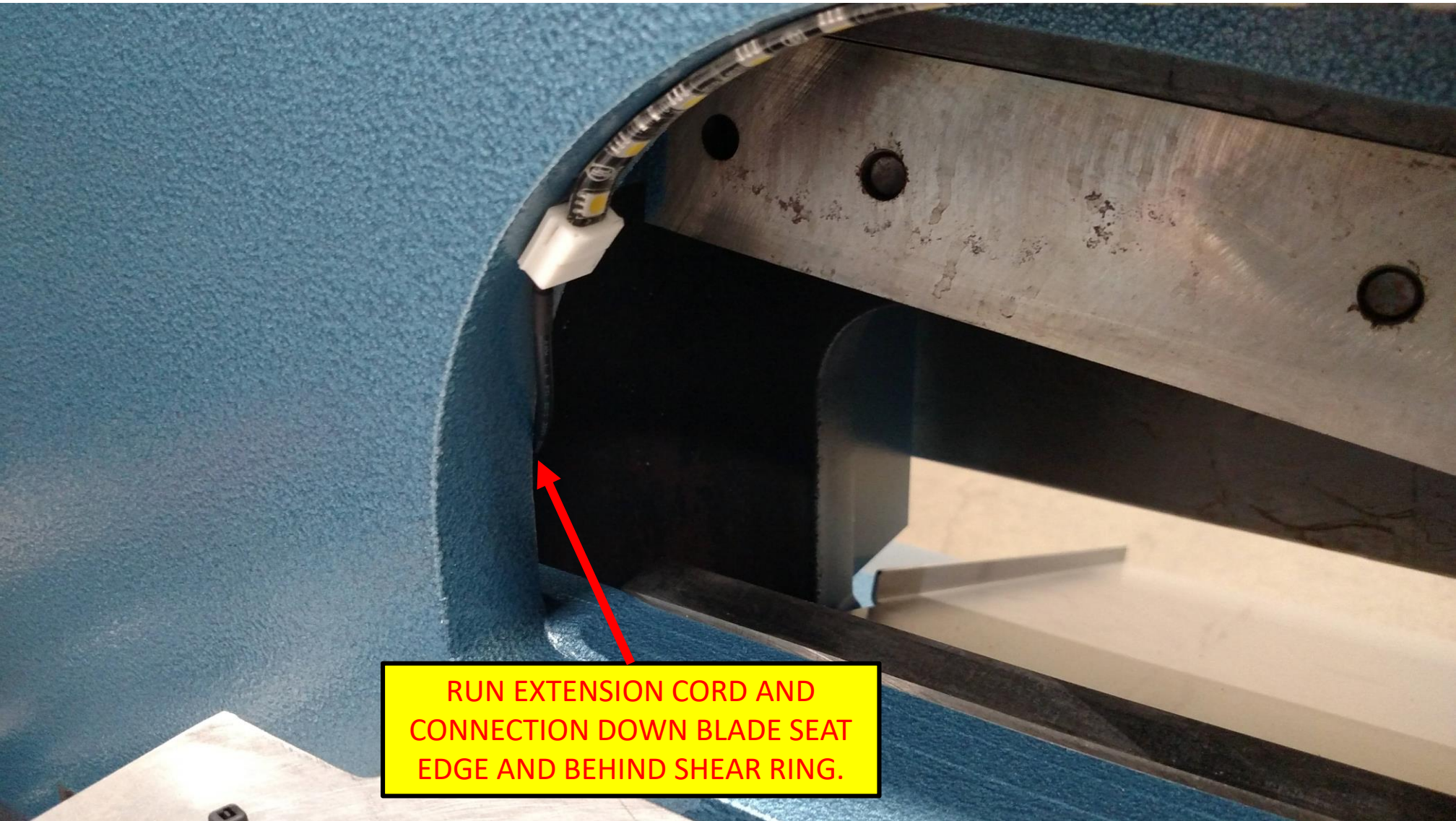
NOTE: THE 3M VHB TAPE IS A PRESSURE ACTIVATED ADHESIVE. IF **LIGHTLY APPLIED** TO A SURFACE, IT MAY BE POSSIBLE TO PULL OFF AND REAPPLY. IF **FIRMLY ATTACHED**, IT WILL BE NEAR IMPOSSIBLE TO MOVE.



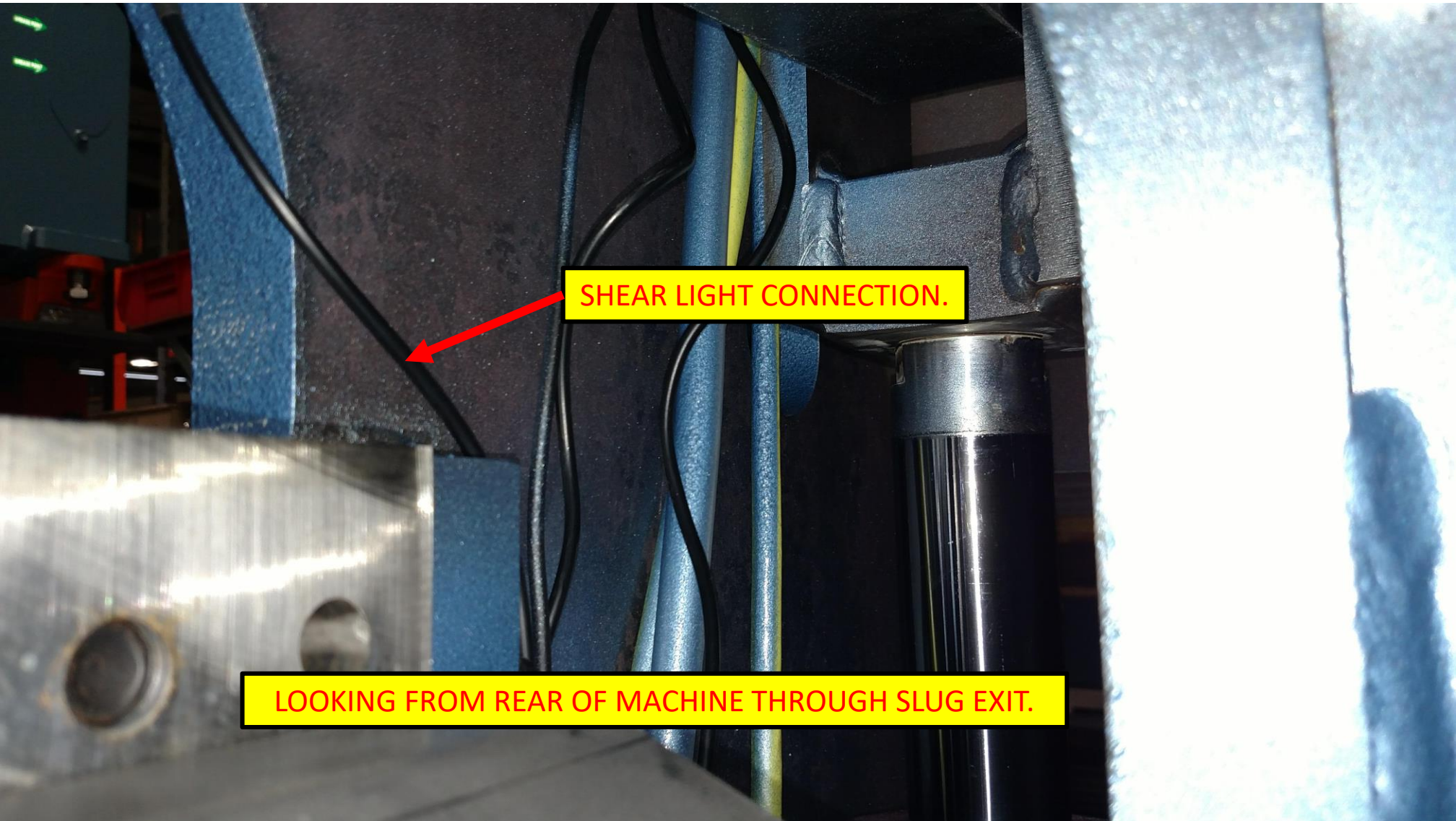
PEEL THE TAPE BACKING OFF AND APPLY THE STRIP TO THE UNDERSIDE, MAKING SURE TO ALIGN THE MARKS. RUN FINGER ALONG AND PRESS FIRMLY.

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



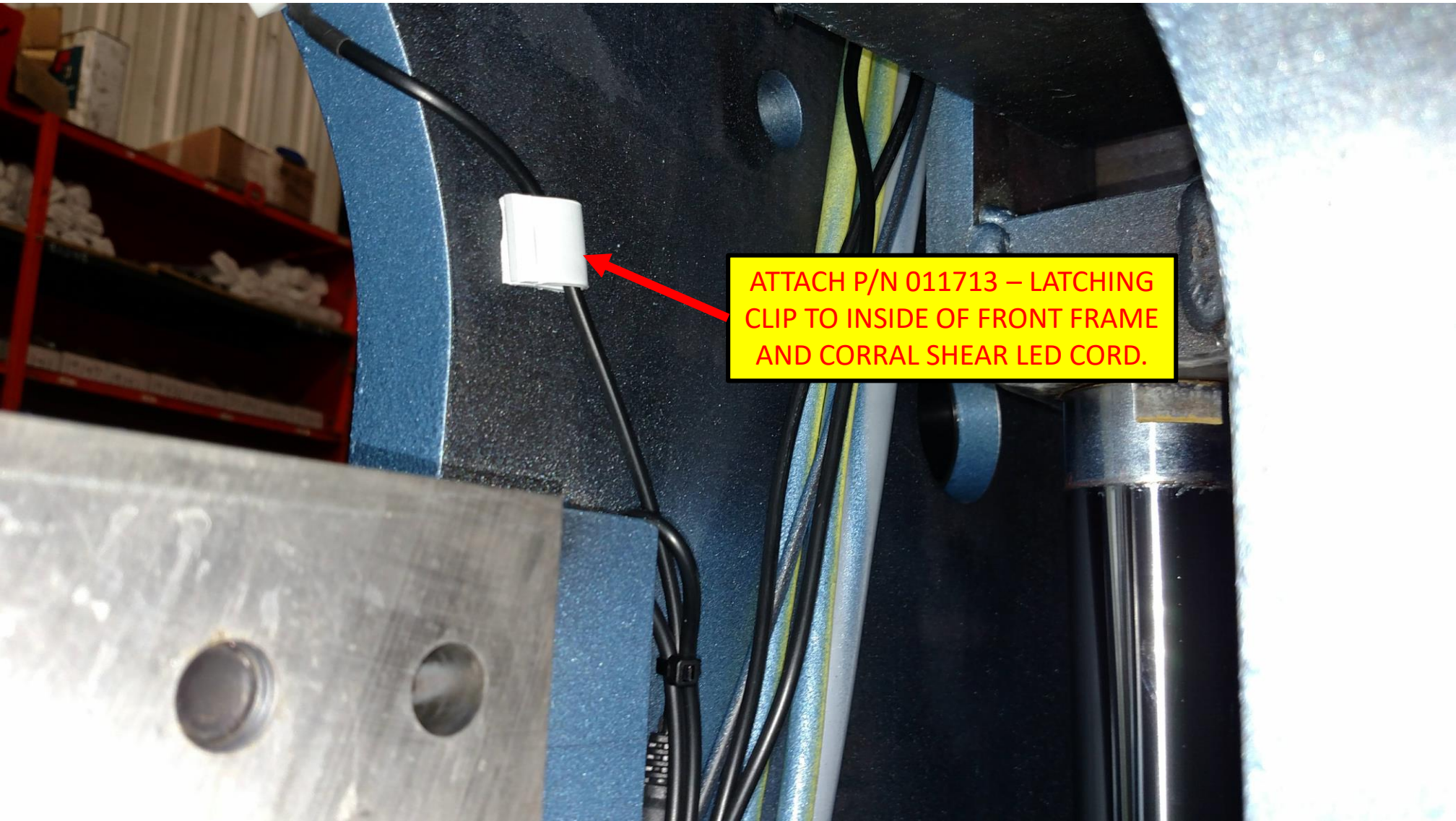


**RUN EXTENSION CORD AND
CONNECTION DOWN BLADE SEAT
EDGE AND BEHIND SHEAR RING.**

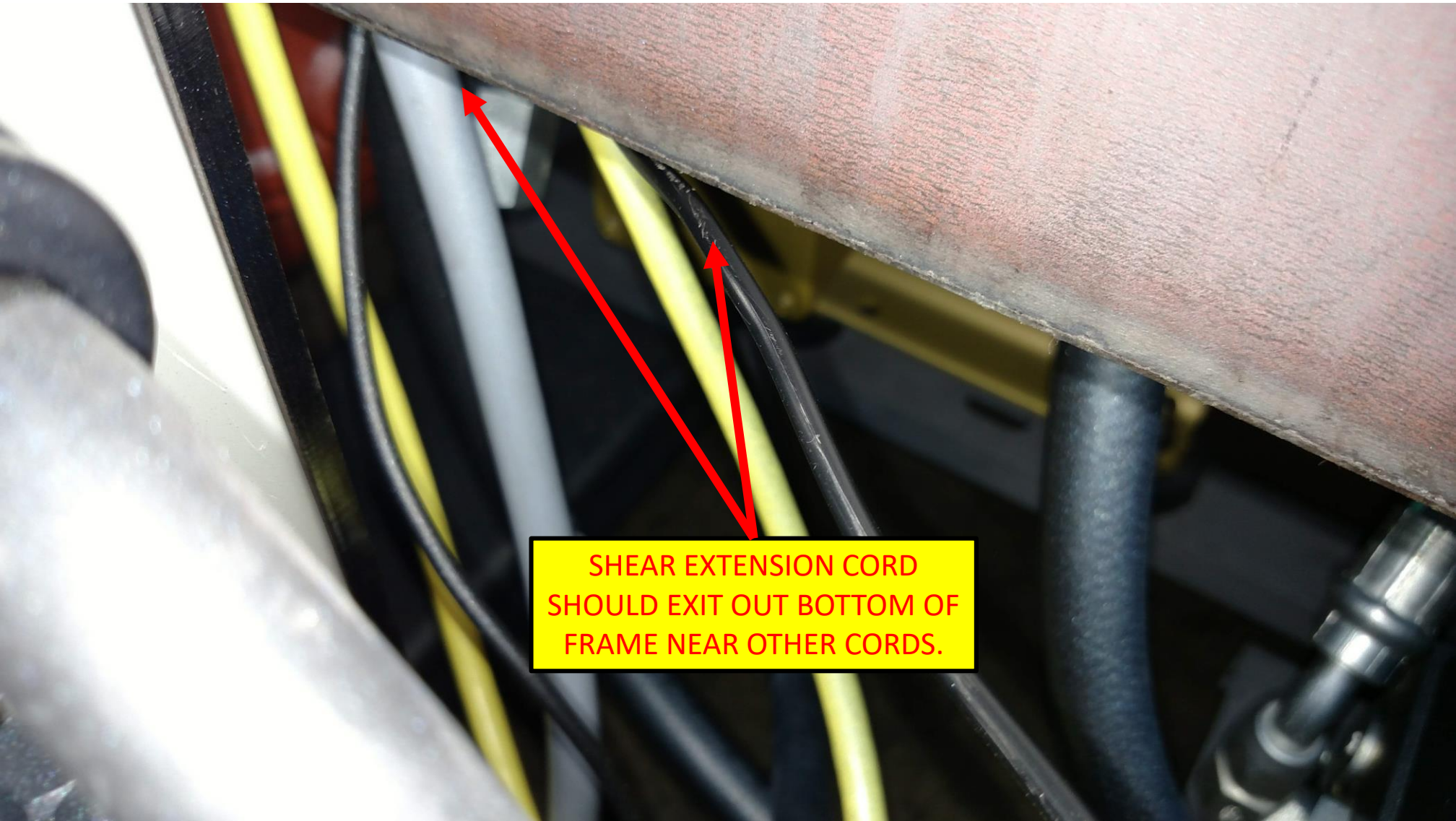


SHEAR LIGHT CONNECTION.

LOOKING FROM REAR OF MACHINE THROUGH SLUG EXIT.



ATTACH P/N 011713 - LATCHING CLIP TO INSIDE OF FRONT FRAME AND CORRAL SHEAR LED CORD.



SHEAR EXTENSION CORD
SHOULD EXIT OUT BOTTOM OF
FRAME NEAR OTHER CORDS.




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 STRIP WITH
TOP OF THROAT BRACE.**

**REMOVE TAPE
BACKING AND APPLY 2X
– P/N 090541 – 9 LED
BULB STRIP (6 IN.).
PRESS FIRMLY.**

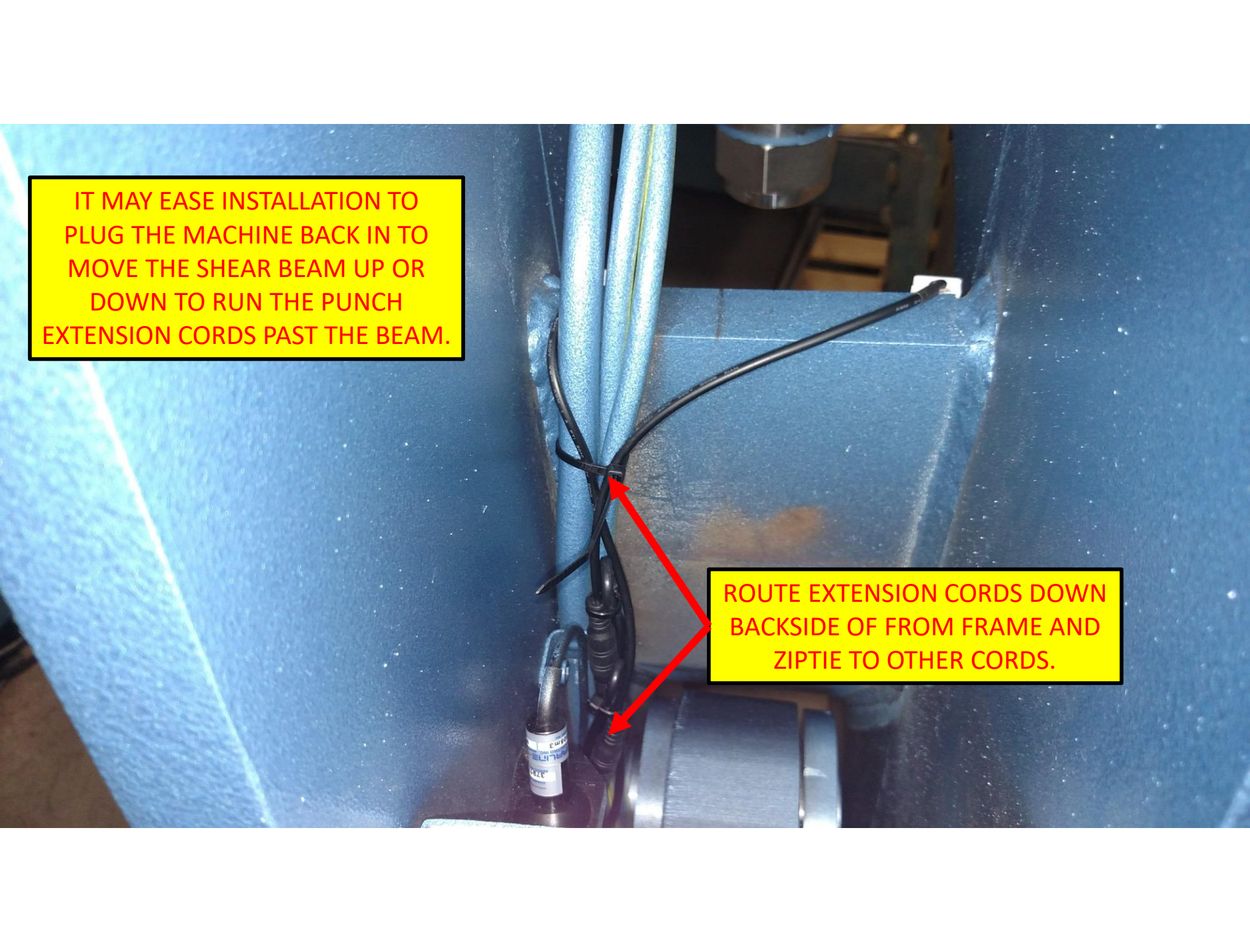


NOTE: THE 3M VHB TAPE IS A PRESSURE ACTIVATED ADHESIVE. IF *LIGHTLY APPLIED* TO A SURFACE, IT MAY BE POSSIBLE TO PULL OFF AND REAPPLY. IF *FIRMLY ATTACHED*, IT WILL BE NEAR IMPOSSIBLE TO MOVE.



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.



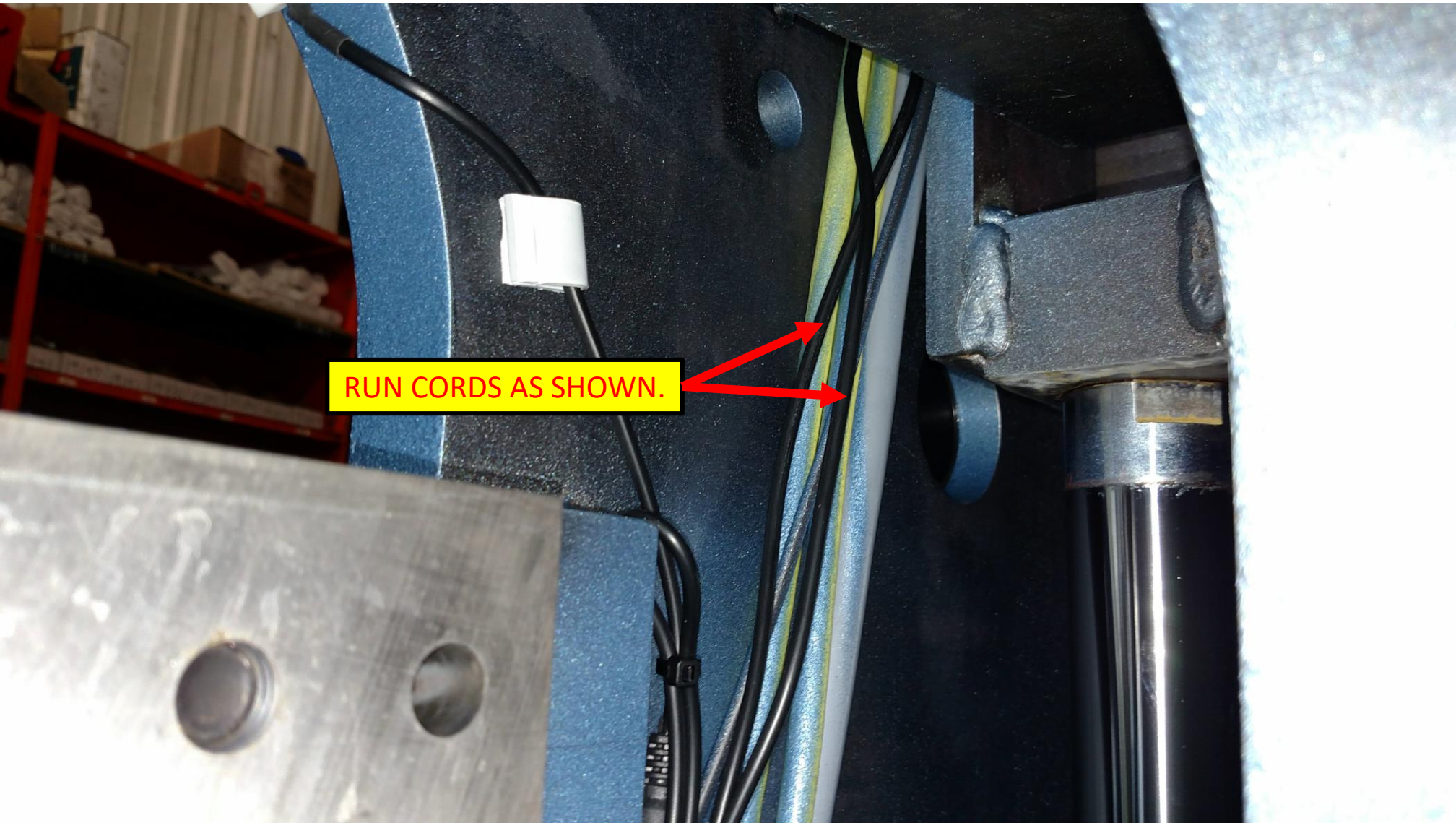
IT MAY EASE INSTALLATION TO
PLUG THE MACHINE BACK IN TO
MOVE THE SHEAR BEAM UP OR
DOWN TO RUN THE PUNCH
EXTENSION CORDS PAST THE BEAM.

ROUTE EXTENSION CORDS DOWN
BACKSIDE OF FROM FRAME AND
ZIPTIE TO OTHER CORDS.

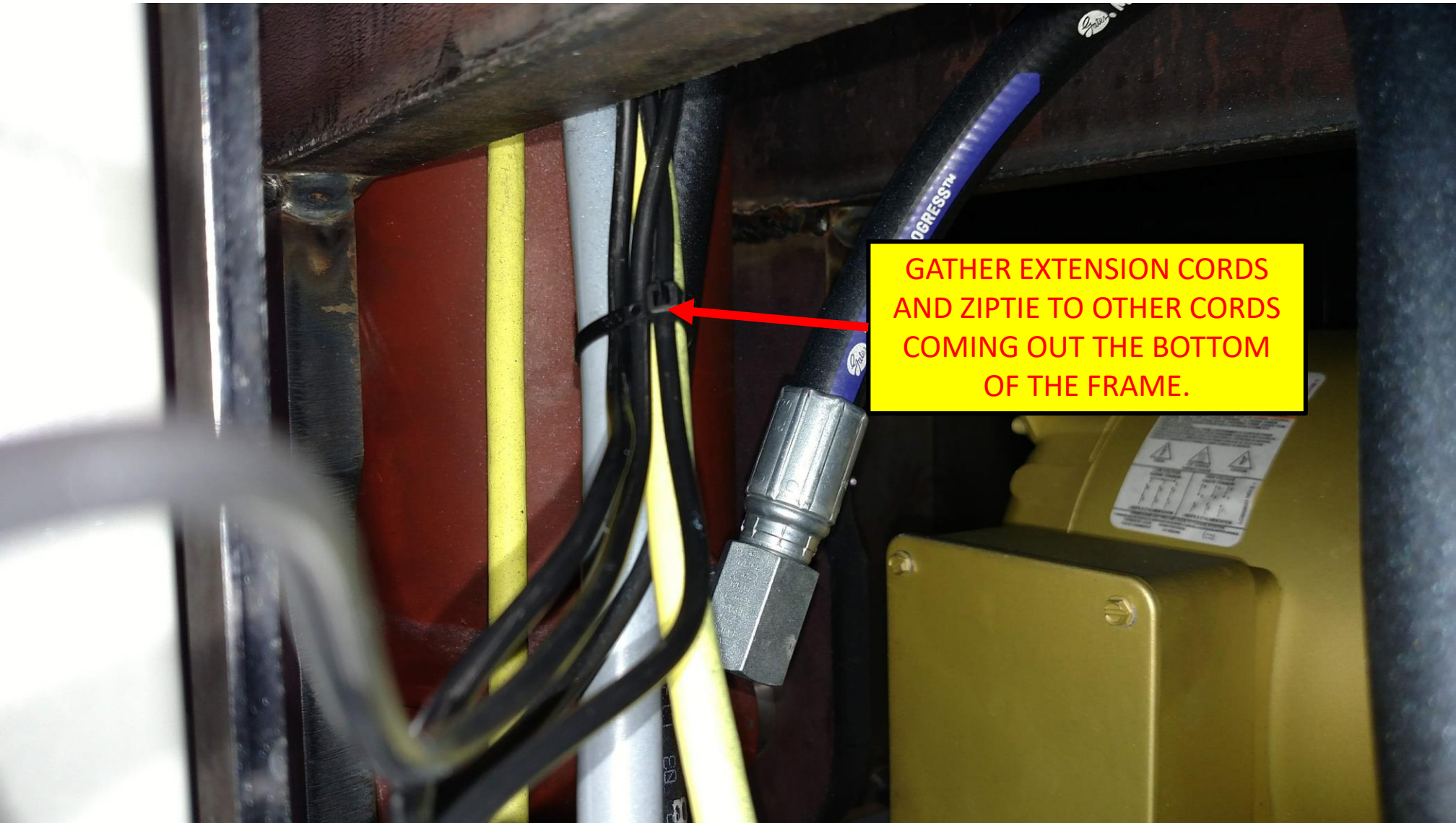
A close-up photograph of a machine's internal components. A laser light sensor is mounted on a metal plate. A red arrow points from a yellow text box to the sensor. Another red arrow points from a second yellow text box to a bundle of black and yellow wires. The machine's surface is blue-painted metal.

LASER LIGHT. YOUR MACHINE MAY NOT HAVE IT INSTALLED.

RUN CORDS AS SHOWN.

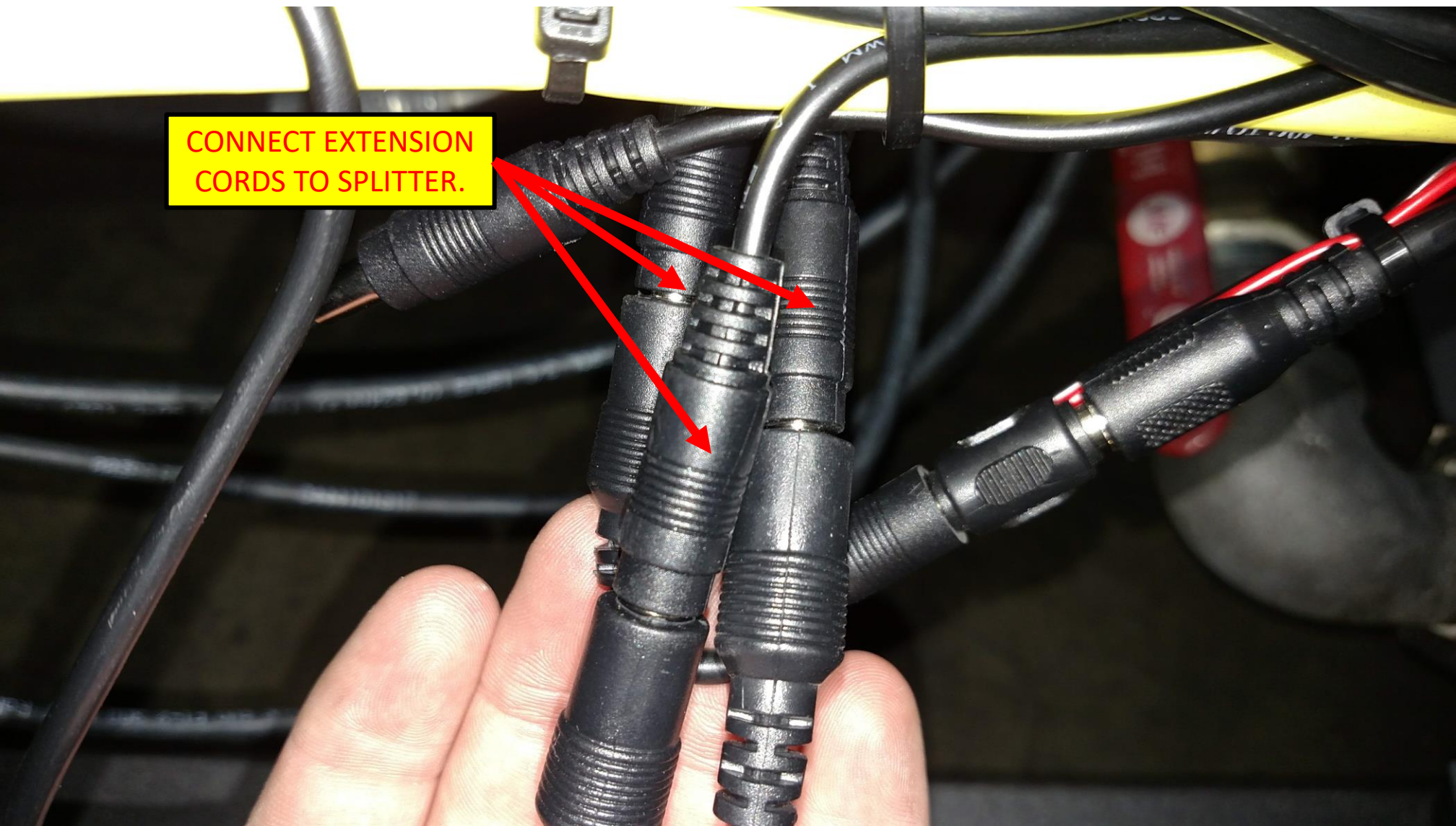


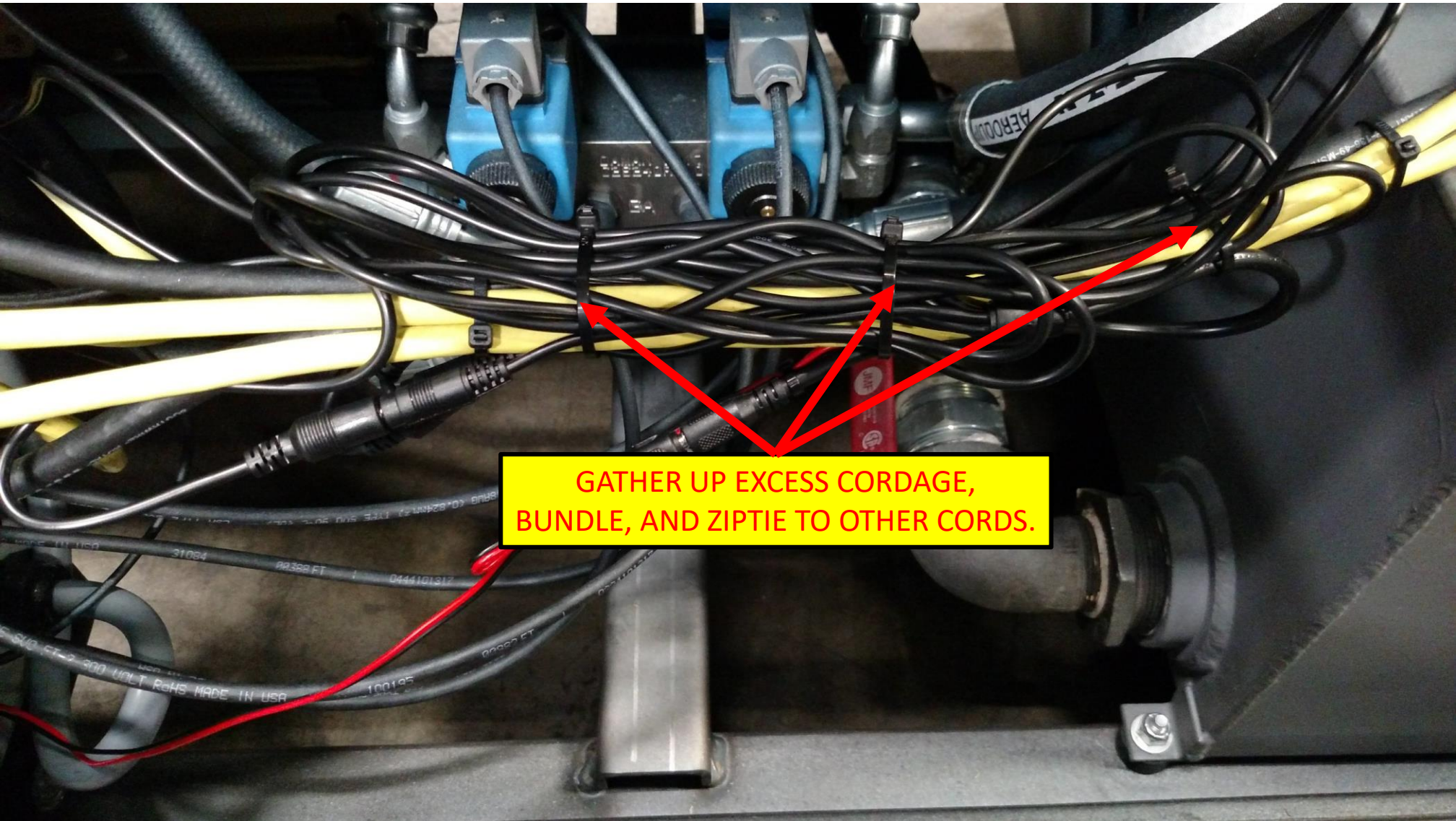
RUN CORDS AS SHOWN.



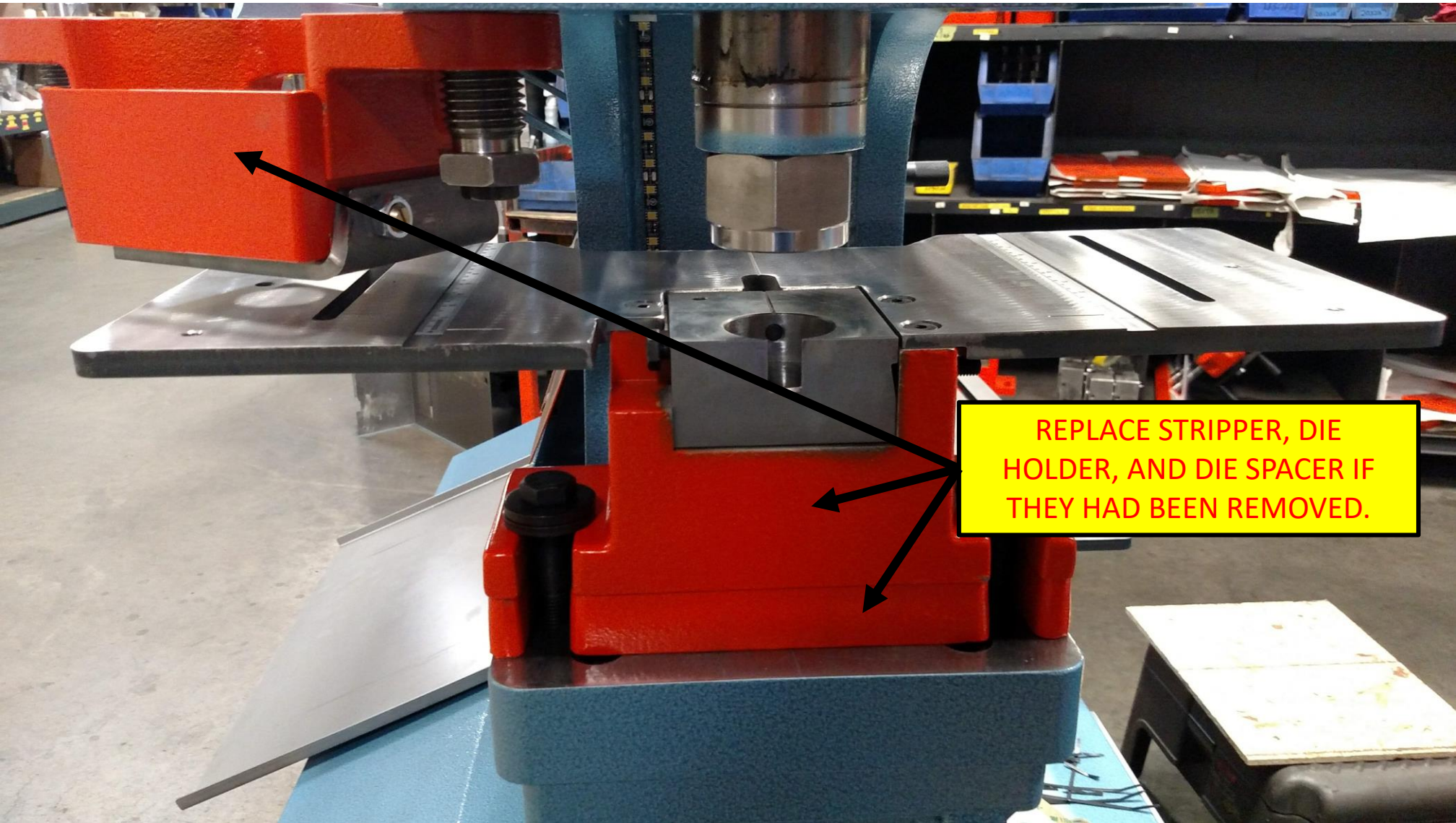
**GATHER EXTENSION CORDS
AND ZIPTIE TO OTHER CORDS
COMING OUT THE BOTTOM
OF THE FRAME.**

CONNECT EXTENSION
CORDS TO SPLITTER.





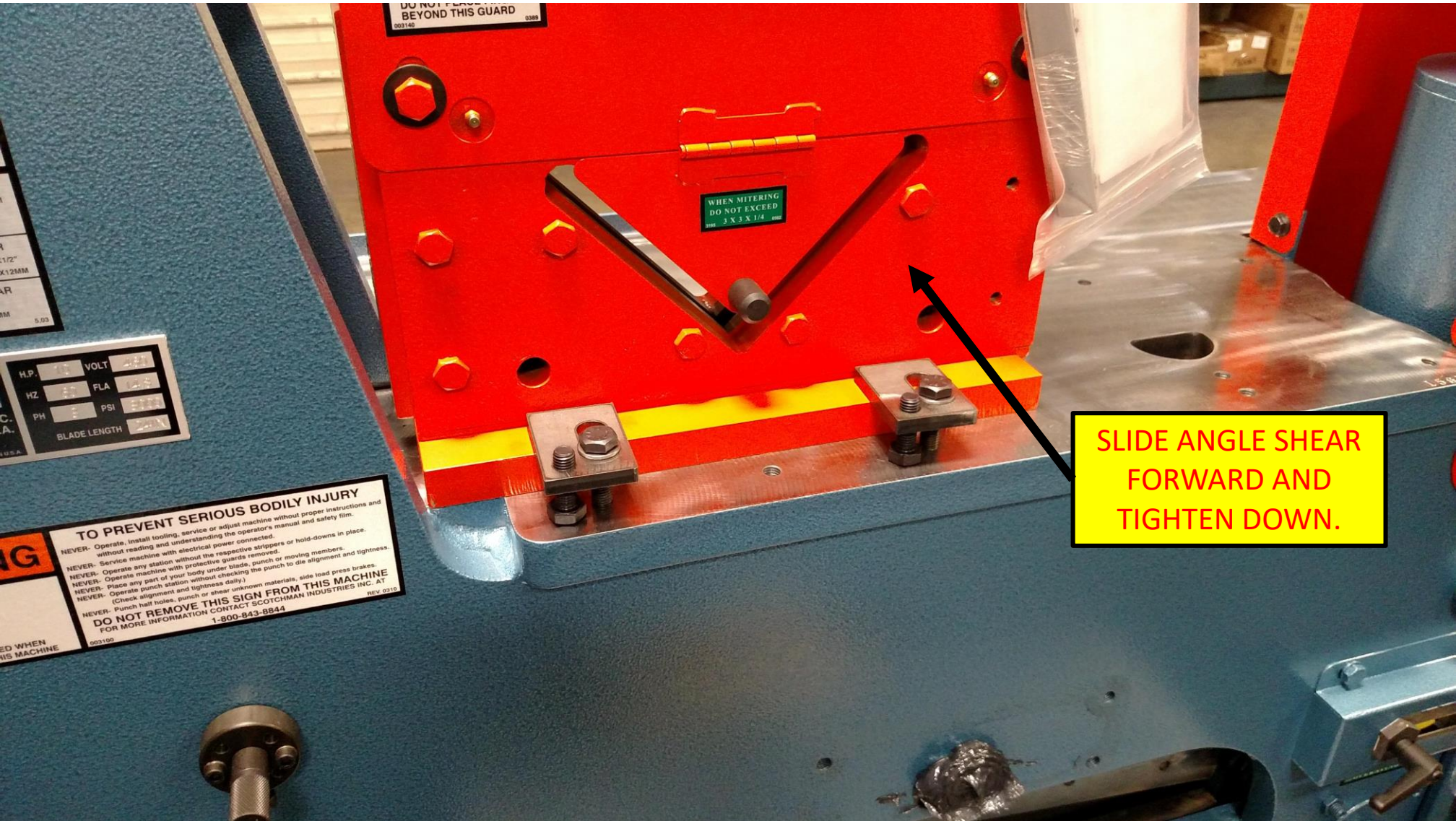
**GATHER UP EXCESS CORDAGE,
BUNDLE, AND ZIPTIE TO OTHER CORDS.**



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

**REPLACE PUNCH SLUG
BUCKET IF REMOVED.**





DO NOT PLACE HANDS BEYOND THIS GUARD
003140 0389

WHEN MITERING
DO NOT EXCEED
3 X 3 X 1/4

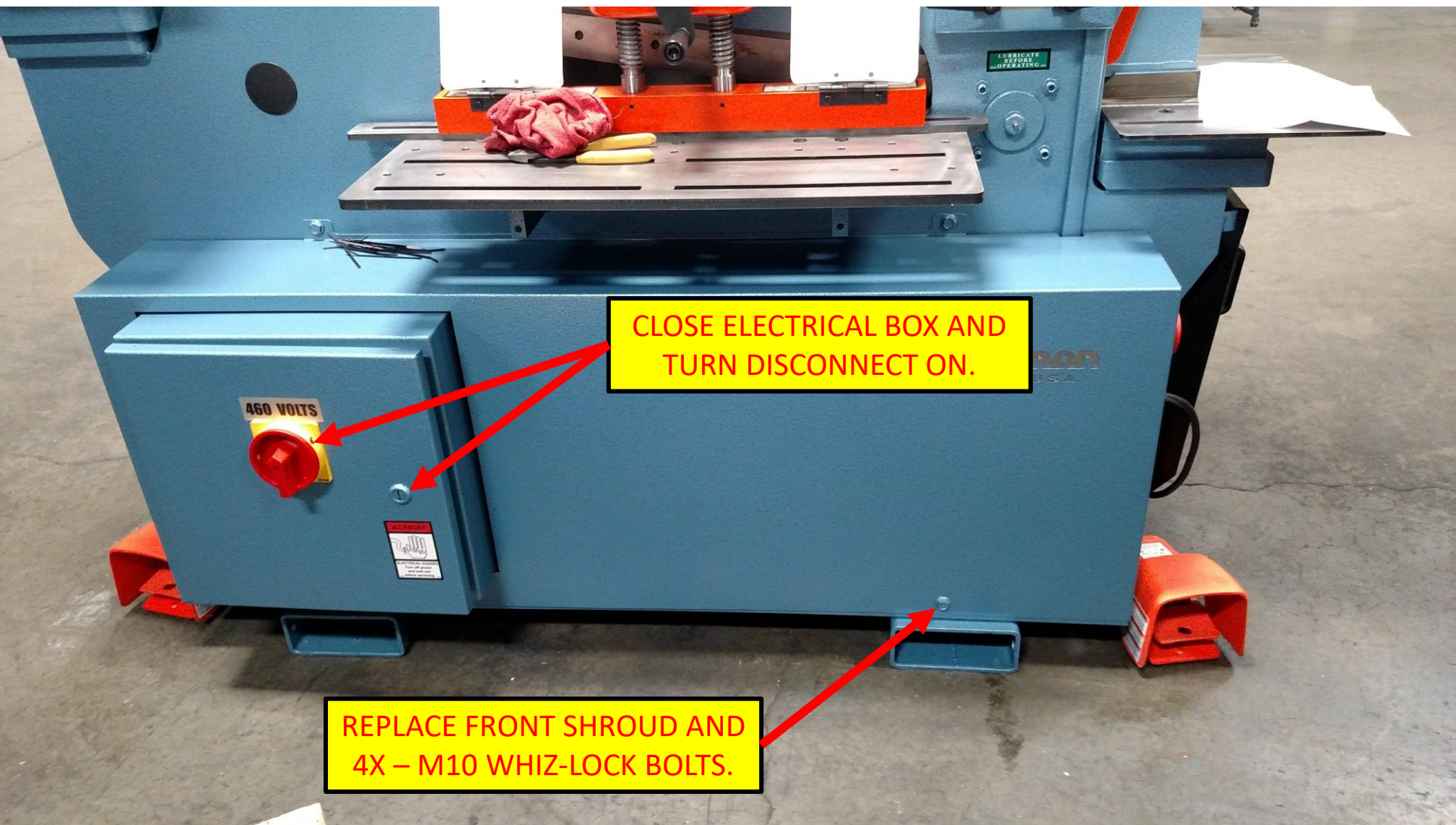
SLIDE ANGLE SHEAR
FORWARD AND
TIGHTEN DOWN.

H.P. VOLT
HZ FLA
PH PSI
BLADE LENGTH

TO PREVENT SERIOUS BODILY INJURY
NEVER- Operate, install tooling, service or adjust machine without proper instructions and without reading and understanding the operator's manual and safety film.
NEVER- Operate machine with electrical power connected.
NEVER- Operate machine without the respective strippers or hold-downs in place.
NEVER- Operate any station with protective guards removed.
NEVER- Operate machine with punch or moving members.
NEVER- Place any part of your body under blade, punch or die alignment and tightness.
NEVER- Operate punch station without checking the punch to die alignment and tightness.
NEVER- Operate punch station without checking the punch to die alignment and tightness.
NEVER- Punch holes, punch or shear unknown materials, side load press brake.
NEVER- Punch half holes, punch or shear unknown materials, side load press brake.
DO NOT REMOVE THIS SIGN FROM THIS MACHINE
FOR MORE INFORMATION CONTACT SCOTCHMAN INDUSTRIES INC. AT 1-800-843-B844
REV 0310

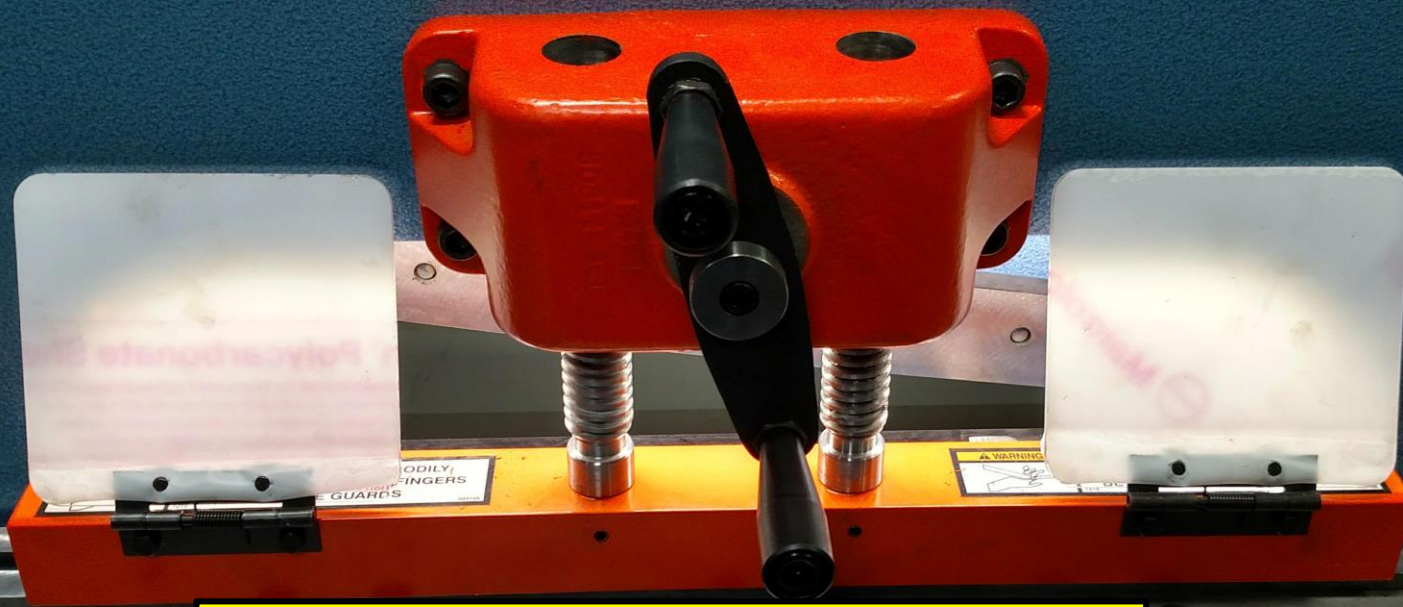


REPLACE HOLDDOWN AND 4X – M12
SOCKET HEAD BOLTS (OR 2X – M16 HEX
HEAD BOLTS FOR HYDRAULIC HOLDDOWN).



CLOSE ELECTRICAL BOX AND
TURN DISCONNECT ON.

REPLACE FRONT SHROUD AND
4X – M10 WHIZ-LOCK BOLTS.



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

