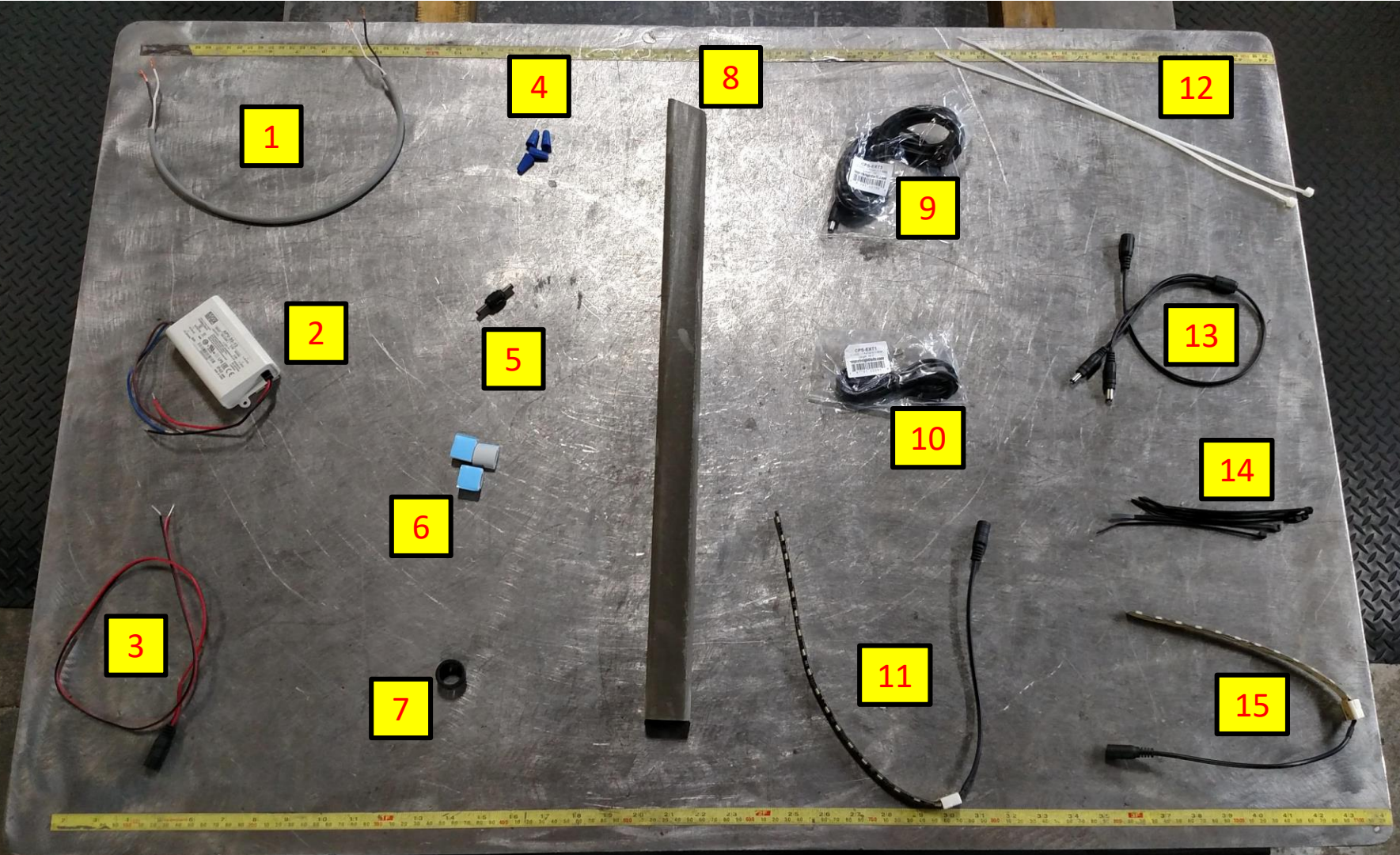


P/N 090523 – LED LIGHT D085 RETROFIT KIT INSTRUCTIONS





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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	4	145005	SMALL BLUE WIRE NUT
5	1	090506	MALE-MALE CONNECTOR
6	3	011713	LATCHING CLIP
7	2	158003	#3104 SNAP BUSHING
8	24 IN.	011715	CONDUIT CHANNEL
9	1	090502	3 METER EXTENSION
10	1	090503	1 METER EXTENSION
11	1	090543	18 LED BULB STRIP (12 IN.)
12	2	045635	14" CABLE TIE AS
13	1	090505	2-WAY SPLITTER
14	6	660505	BLACK NYLON CABLE TIE
15	1	090542	12 LED BULB STRIP (8 IN.)

BASIC CONSIDERATIONS

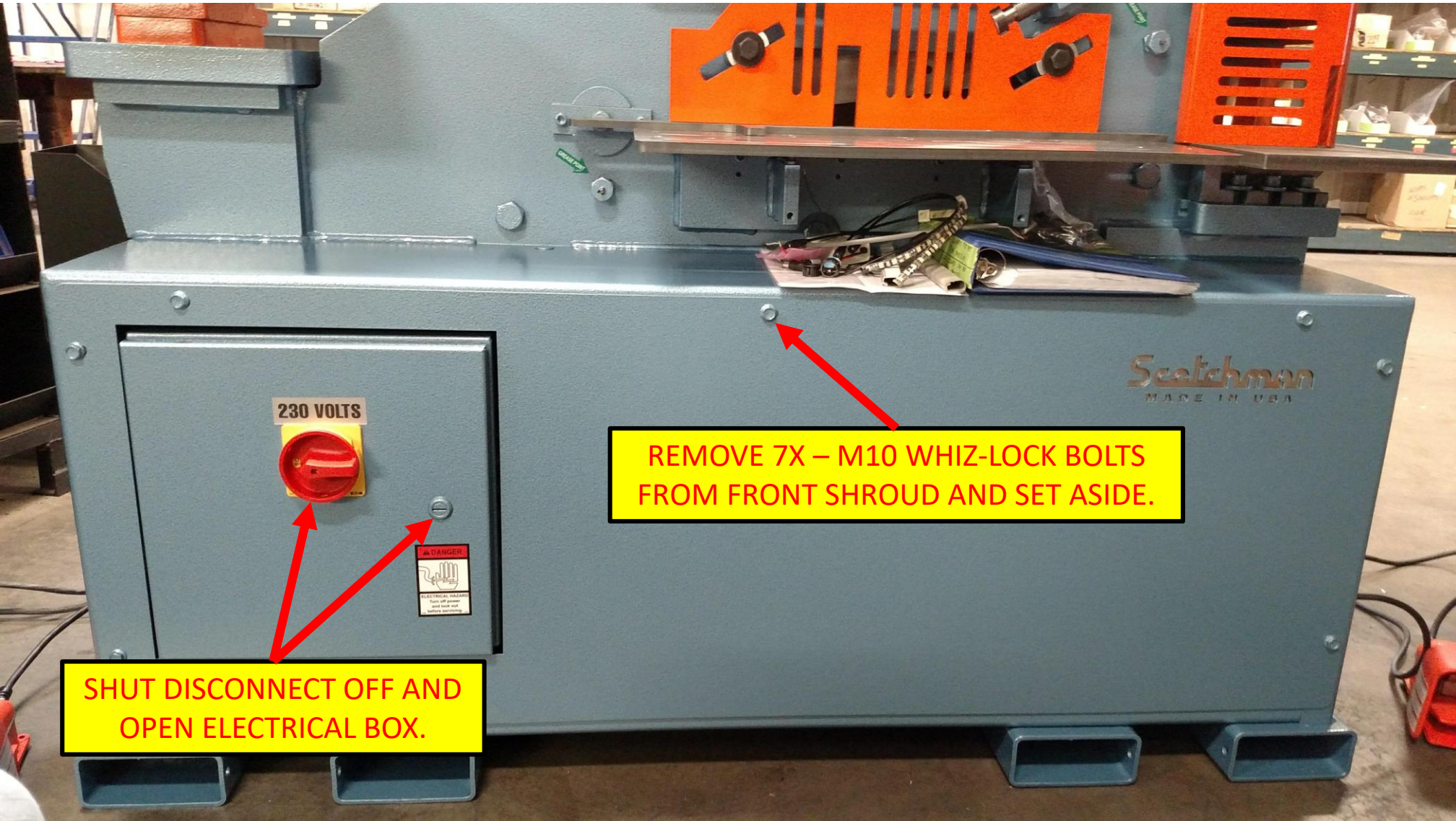
- Please read the instructions **FULLY** before attempting to install the product.
- Make sure to unplug the machine from its electrical source and perform any necessary lockout/tagout procedures.
- If the old worklight is installed, it will be necessary to remove the cord from the base. The light can 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 32](#)); Punch ([Page 37](#))



230 VOLTS



REMOVE 7X – M10 WHIZ-LOCK BOLTS FROM FRONT SHROUD AND SET ASIDE.

SHUT DISCONNECT OFF AND OPEN ELECTRICAL BOX.

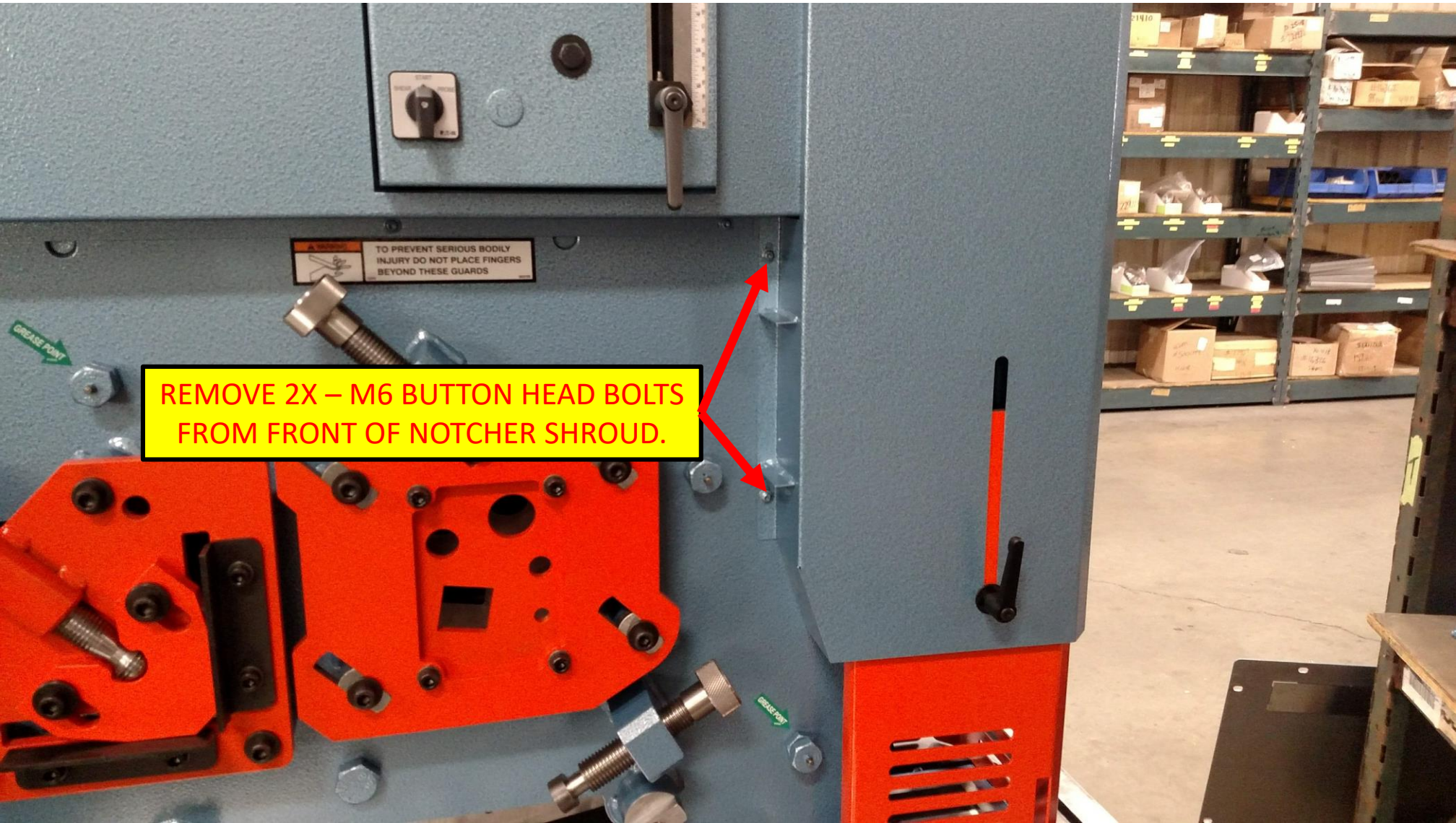
Scotchman
MADE IN USA



REMOVE 2X - M16 HEX HEAD BOLTS AND WASHERS AND SET HOLDDOWN OFF TO THE SIDE.



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

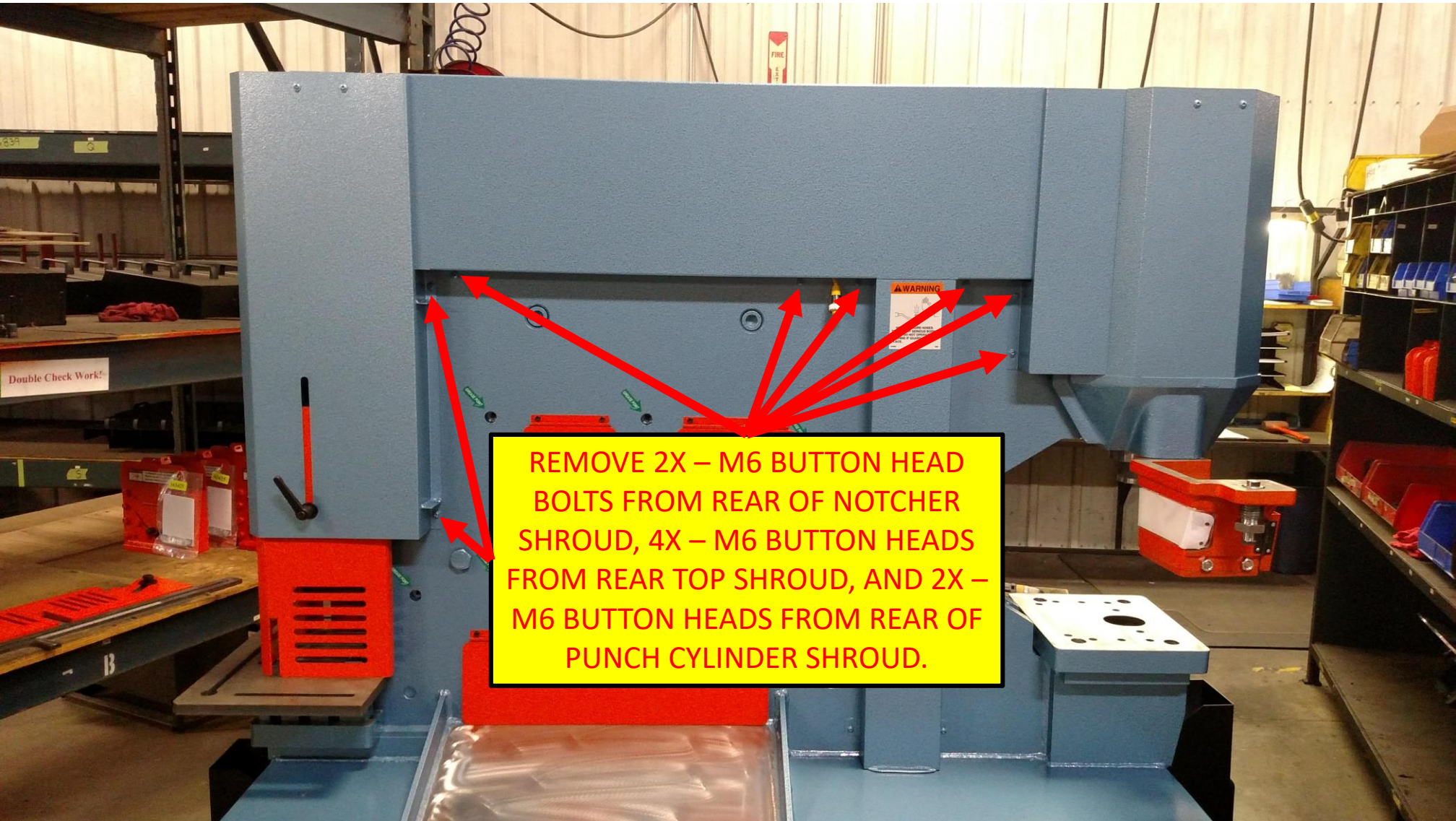


REMOVE 2X - M6 BUTTON HEAD BOLTS FROM FRONT OF NOTCHER SHROUD.

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

GREASE POINT

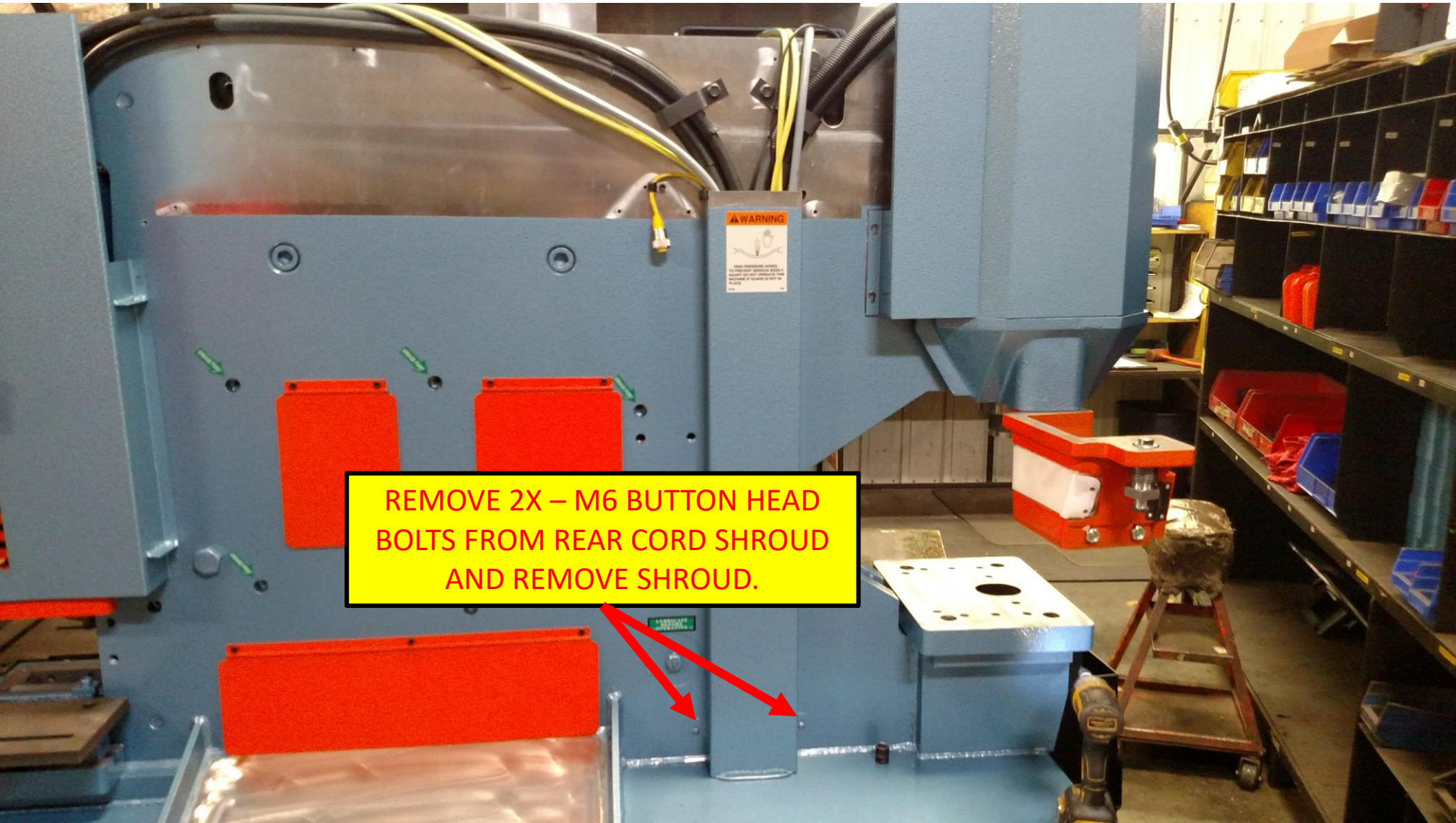
GREASE POINT



REMOVE 2X – M6 BUTTON HEAD BOLTS FROM REAR OF NOTCHER SHROUD, 4X – M6 BUTTON HEADS FROM REAR TOP SHROUD, AND 2X – M6 BUTTON HEADS FROM REAR OF PUNCH CYLINDER SHROUD.



REMOVE 2X – M6 BUTTON HEAD BOLTS
FROM TOP OF TOP REAR SHROUD.
REMOVE REAR TOP SHROUD AND
NOTCHER SHROUD (IF NECESSARY).



REMOVE 2X - M6 BUTTON HEAD BOLTS FROM REAR CORD SHROUD AND REMOVE SHROUD.

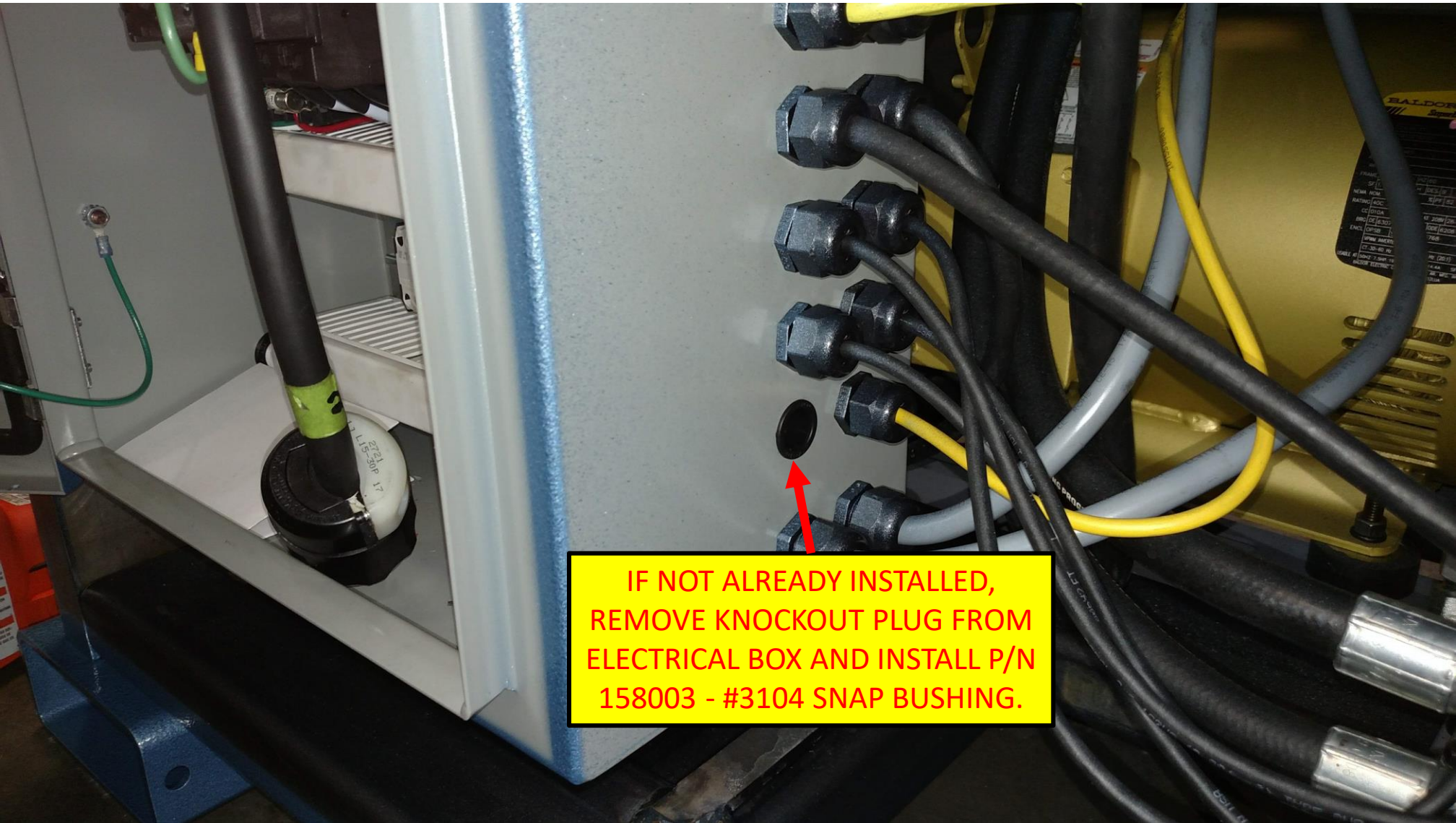
GREASE POINT
010100



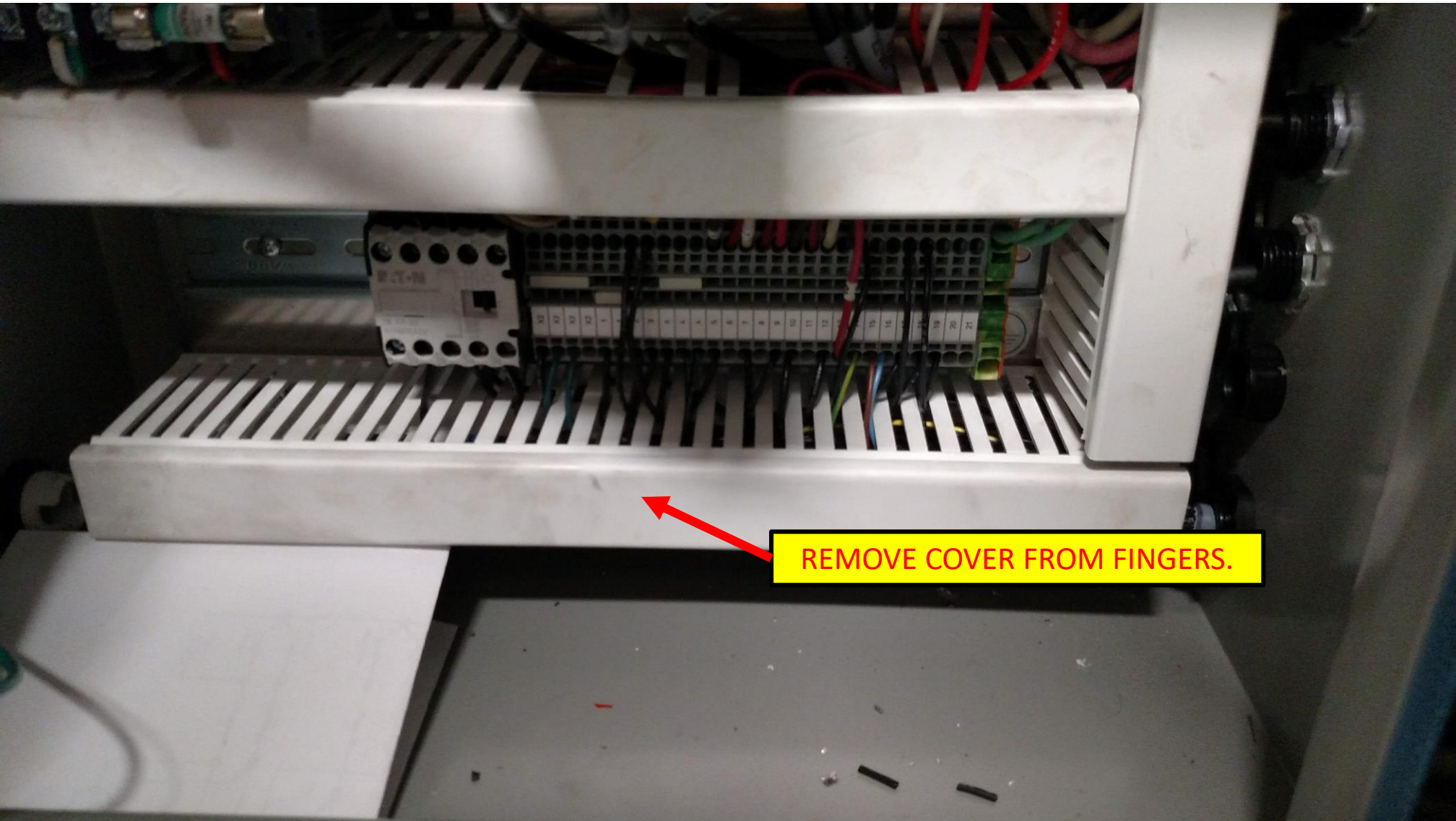
REMOVE STEEL HOLE PLUG
FROM TOP OF BASE.



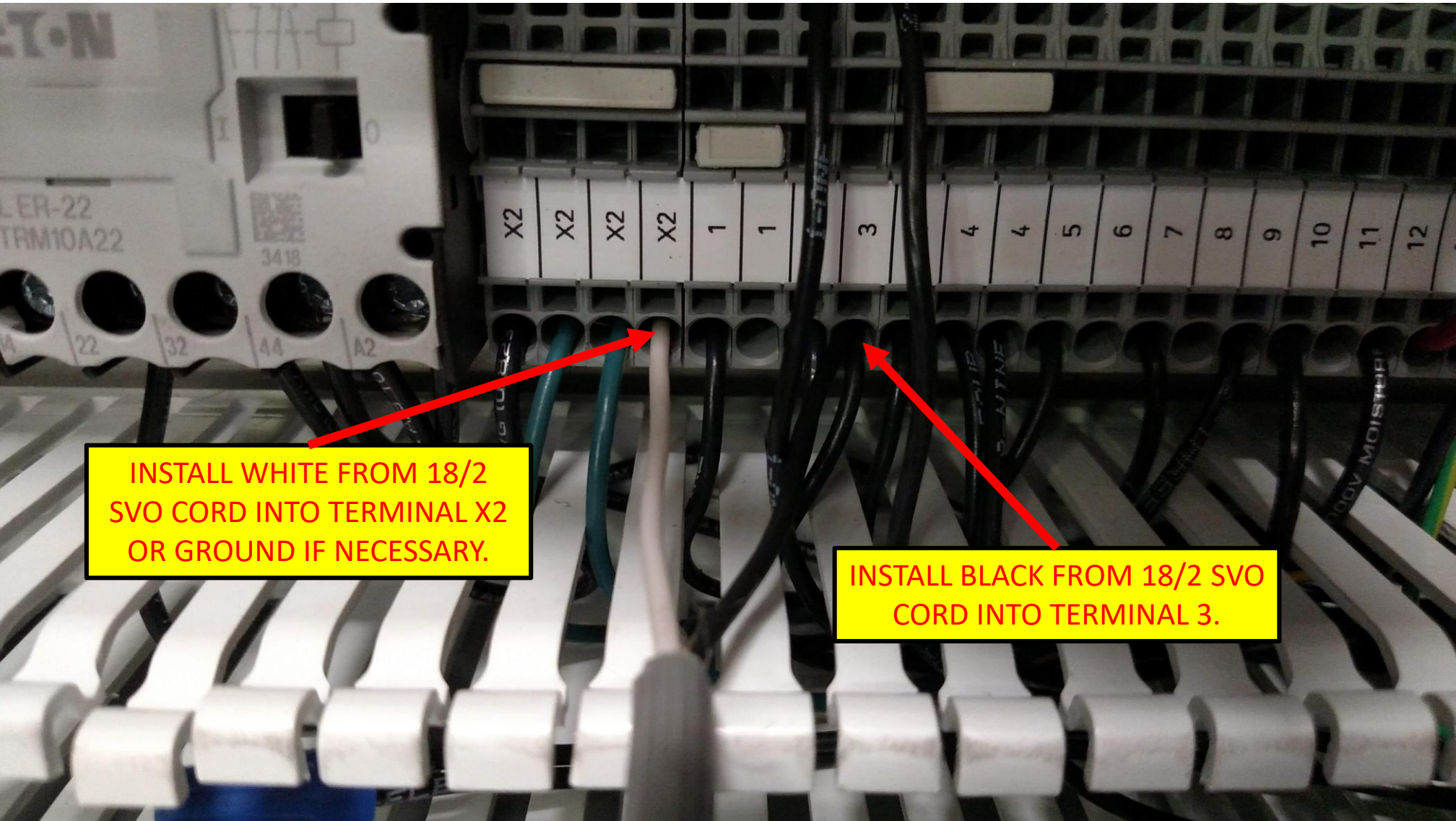
INSTALL P/N 158003 -
#3104 SNAP BUSHING.



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.

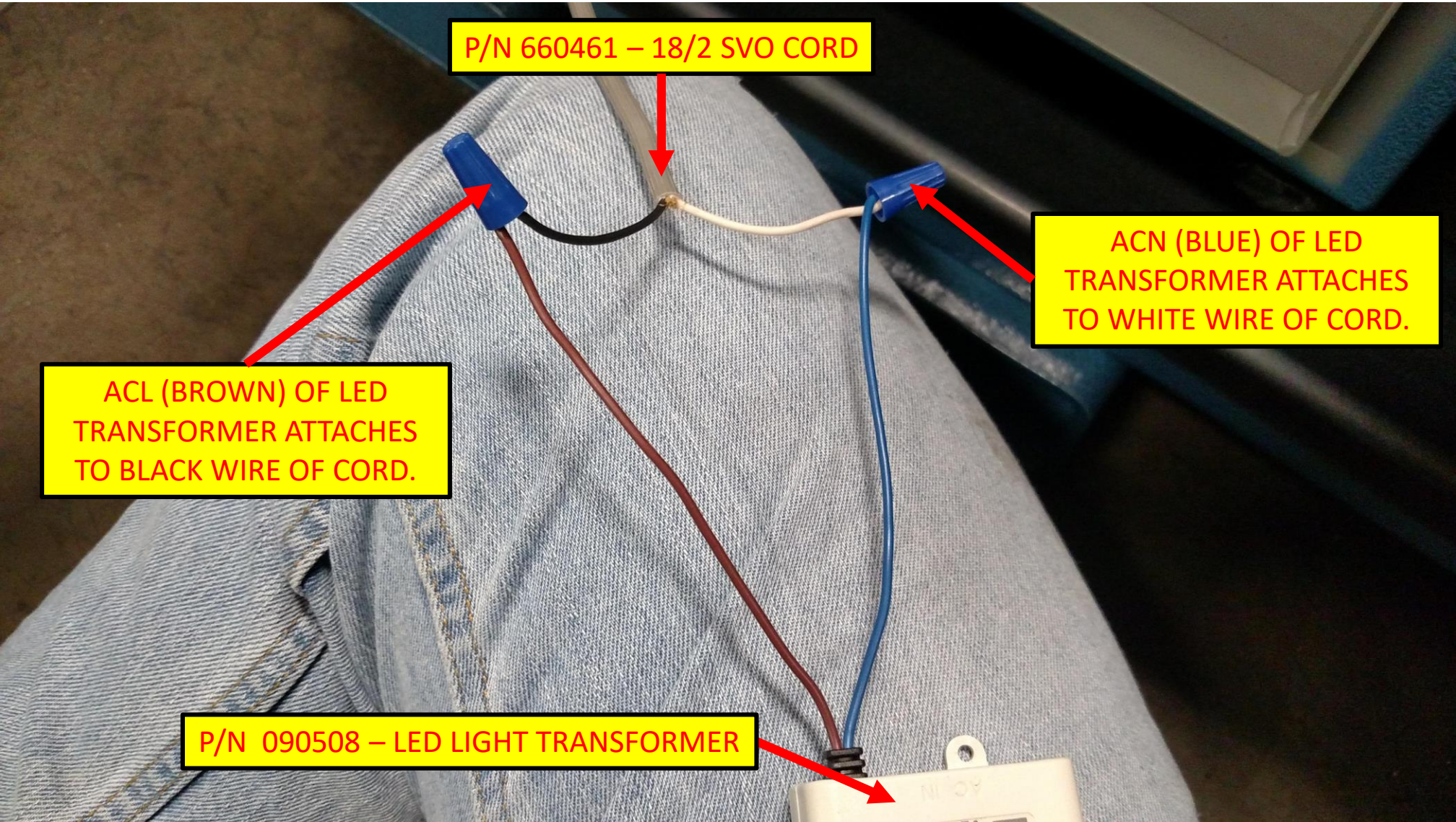
INSTALL BLACK FROM 18/2 SVO CORD INTO TERMINAL 3.

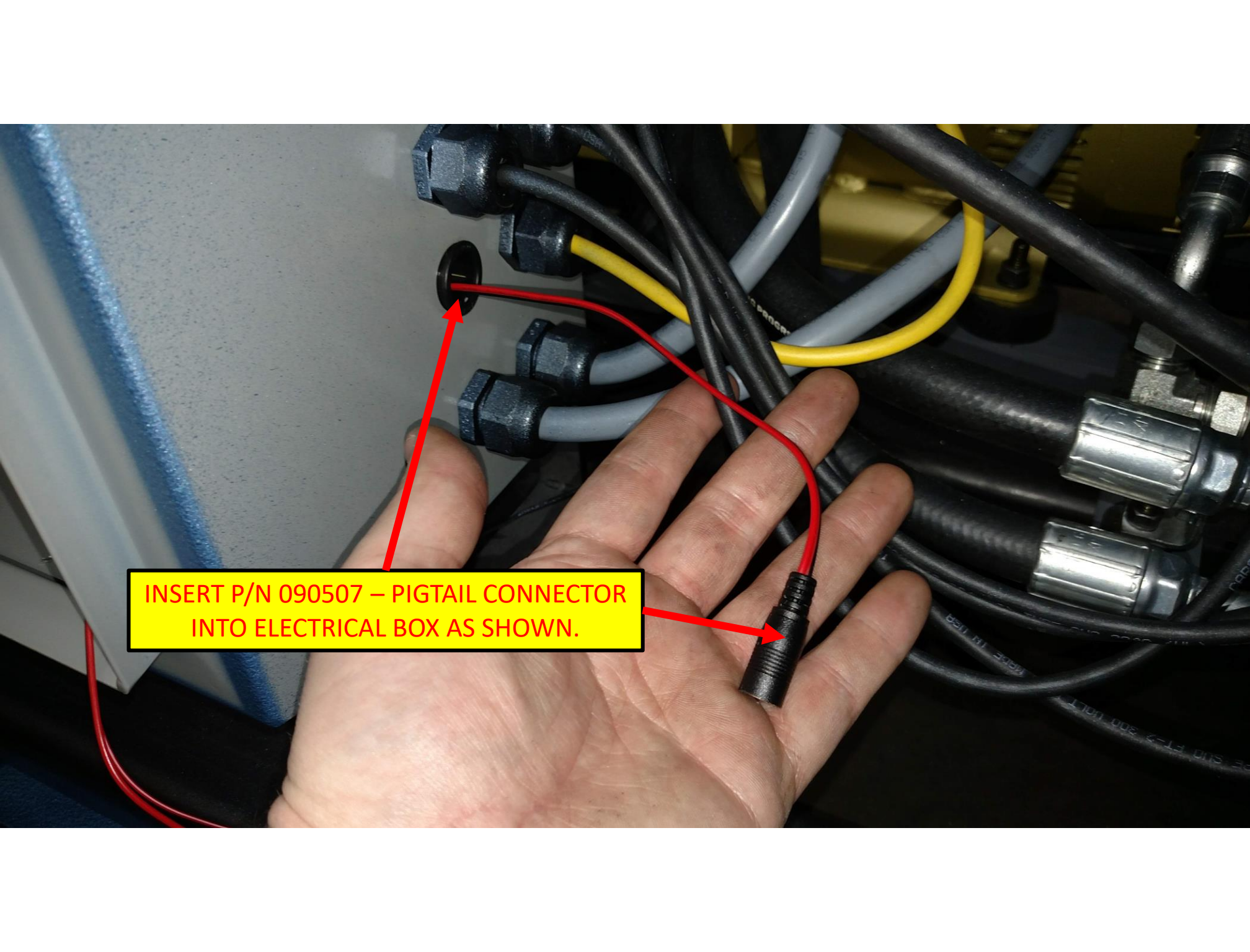
P/N 660461 – 18/2 SVO CORD

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

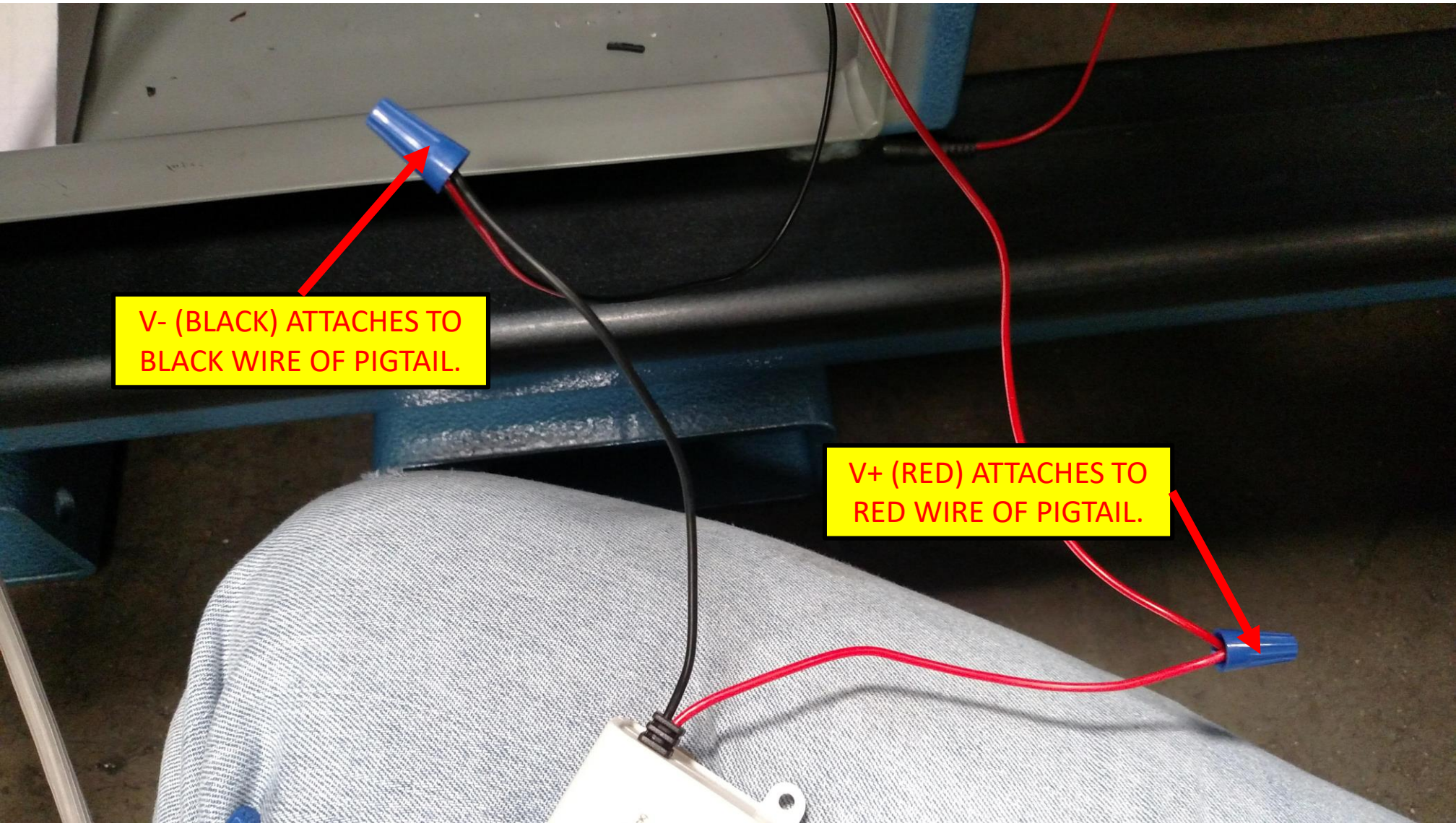
ACN (BLUE) OF LED TRANSFORMER ATTACHES TO WHITE WIRE OF CORD.

P/N 090508 – LED LIGHT TRANSFORMER





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



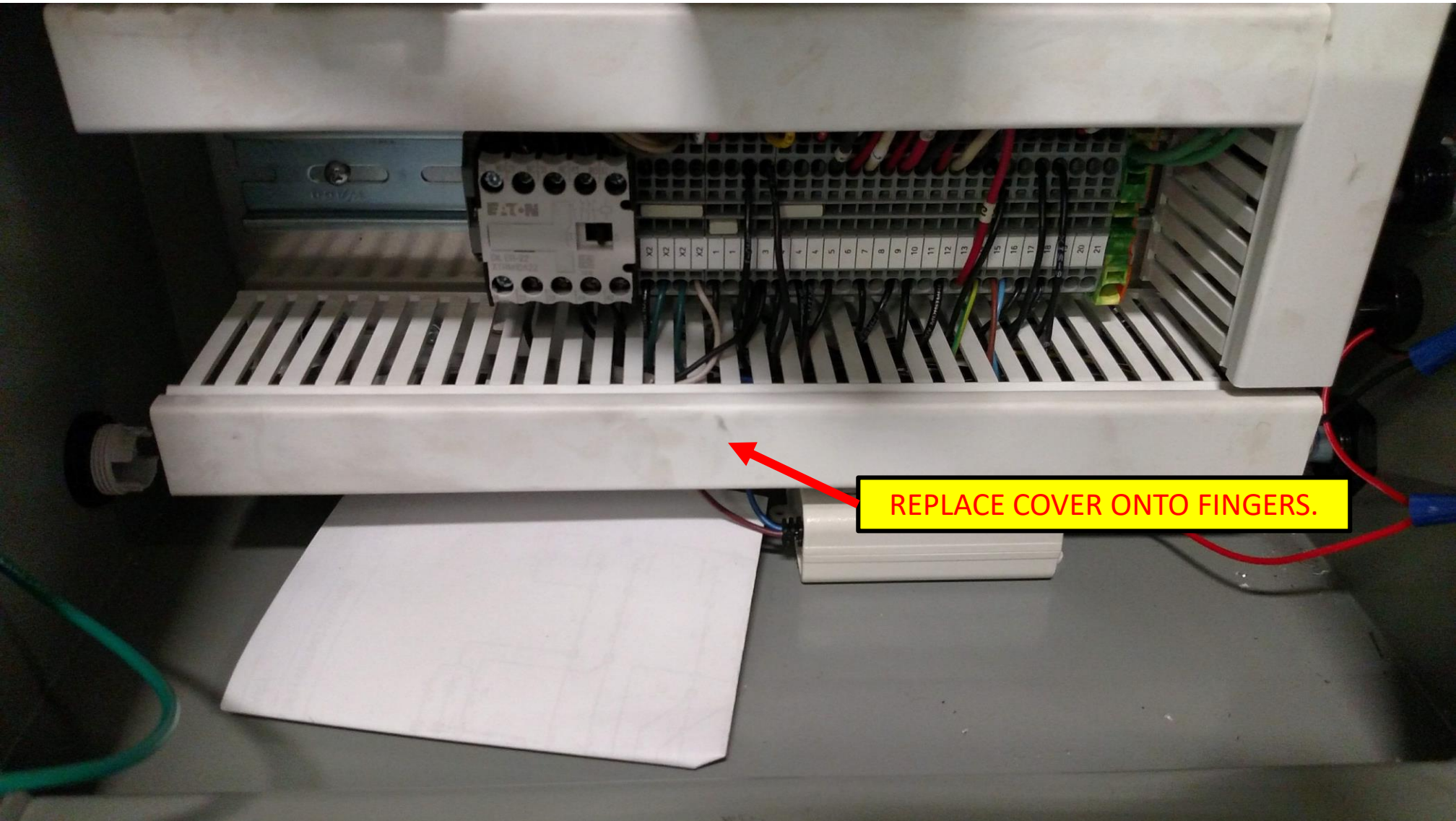
V- (BLACK) ATTACHES TO
BLACK WIRE OF PIGTAIL.

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

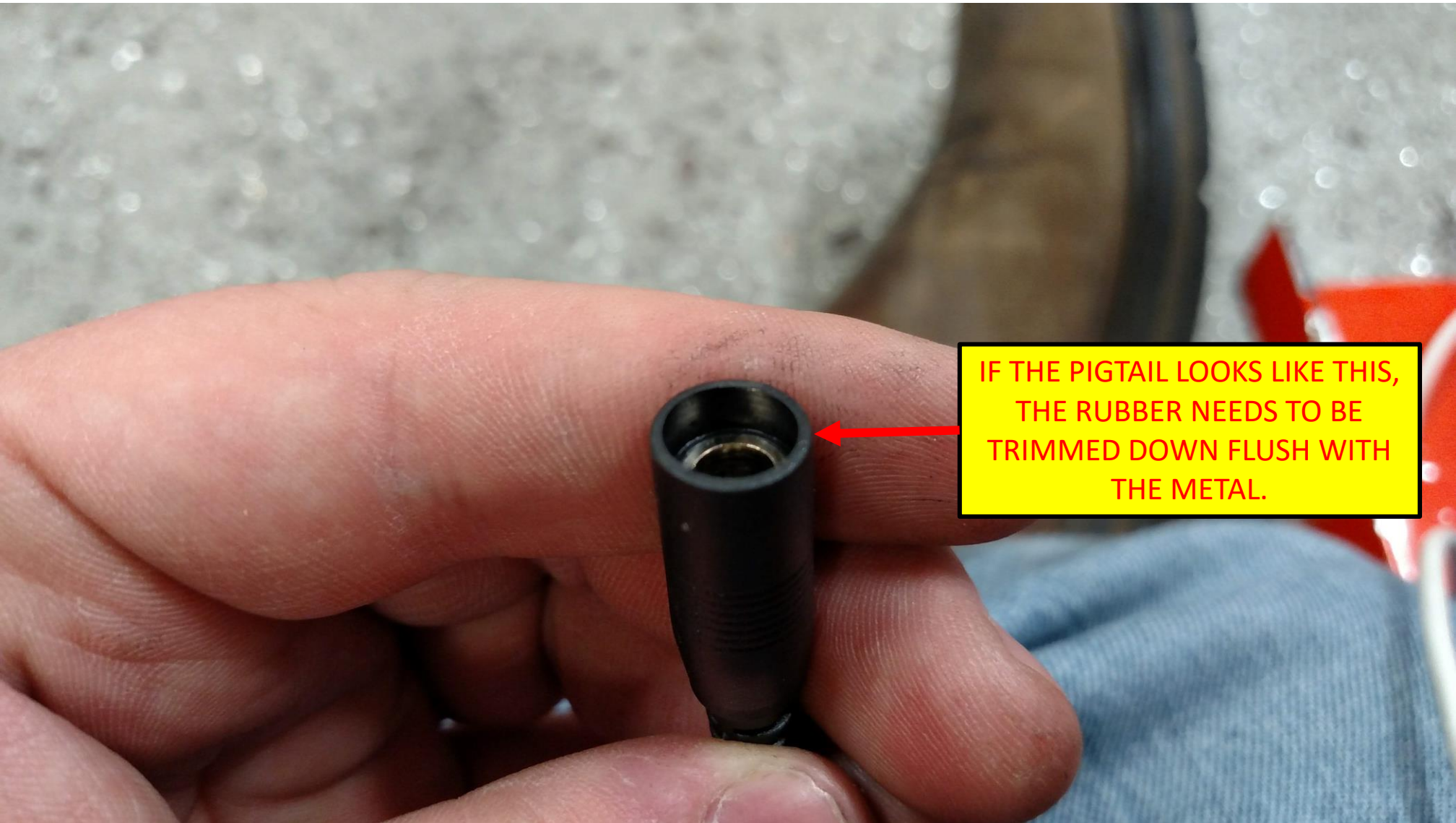


TUCK THE WIRES AND CORD AS SHOWN.

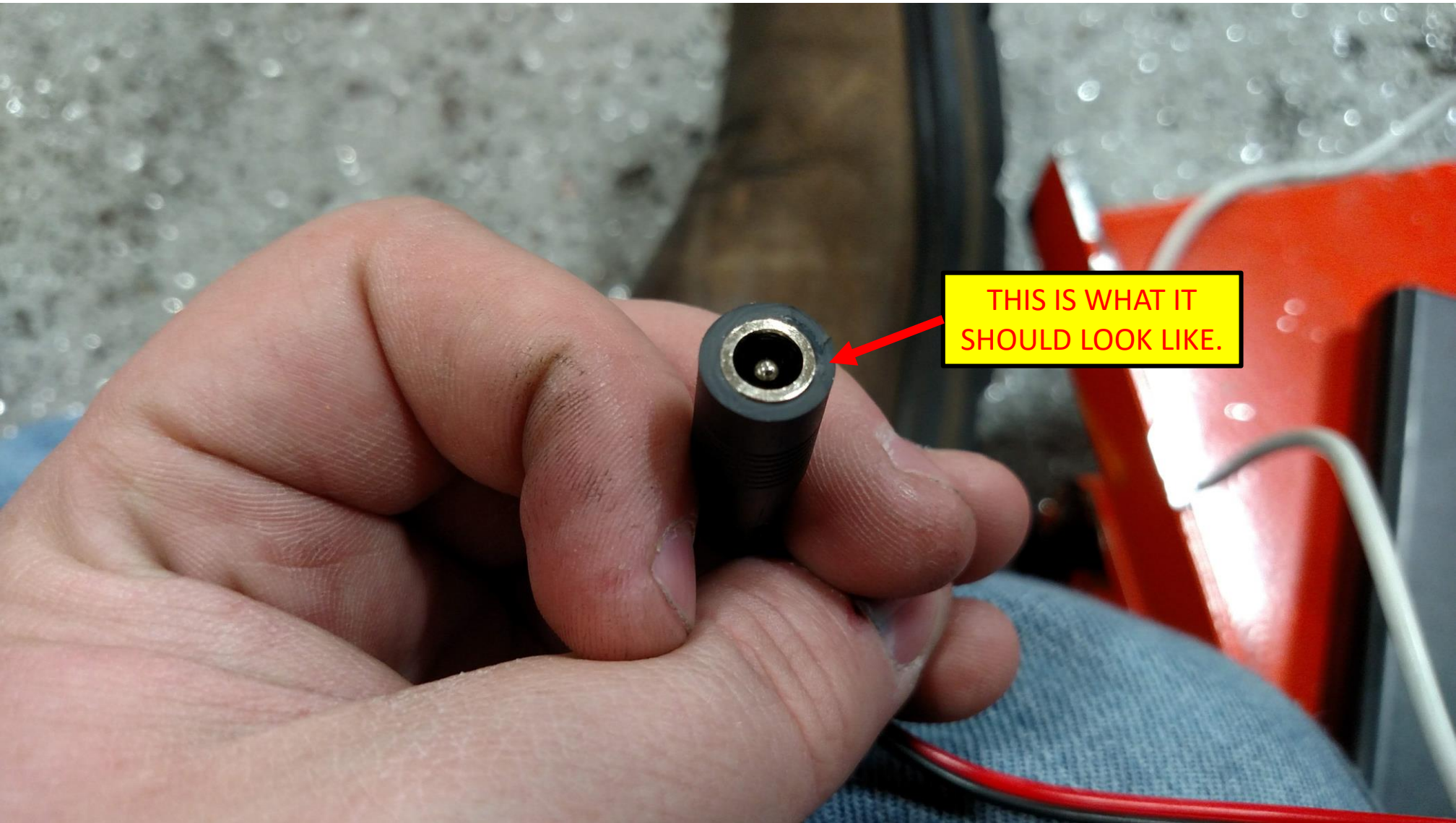
PEEL THE TAPE BACKING OFF FROM P/N 090508 – LED LIGHT TRANSFORMER AND APPLY AS SHOWN.



REPLACE COVER ONTO FINGERS.



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



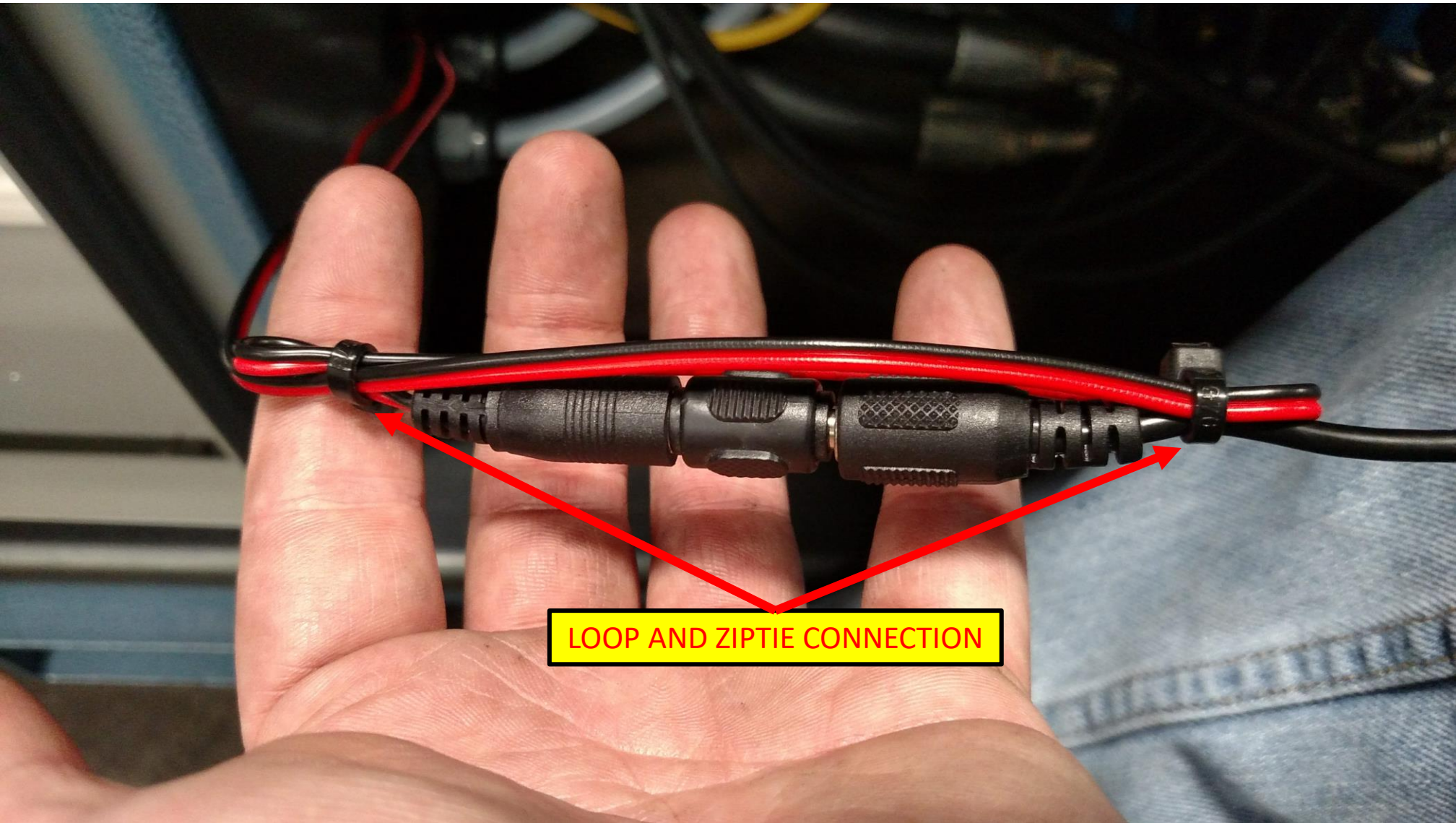
THIS IS WHAT IT
SHOULD LOOK LIKE.

P/N 090506 – MALE-MALE CONNECTOR



P/N 090505 – 2-WAY SPLITTER



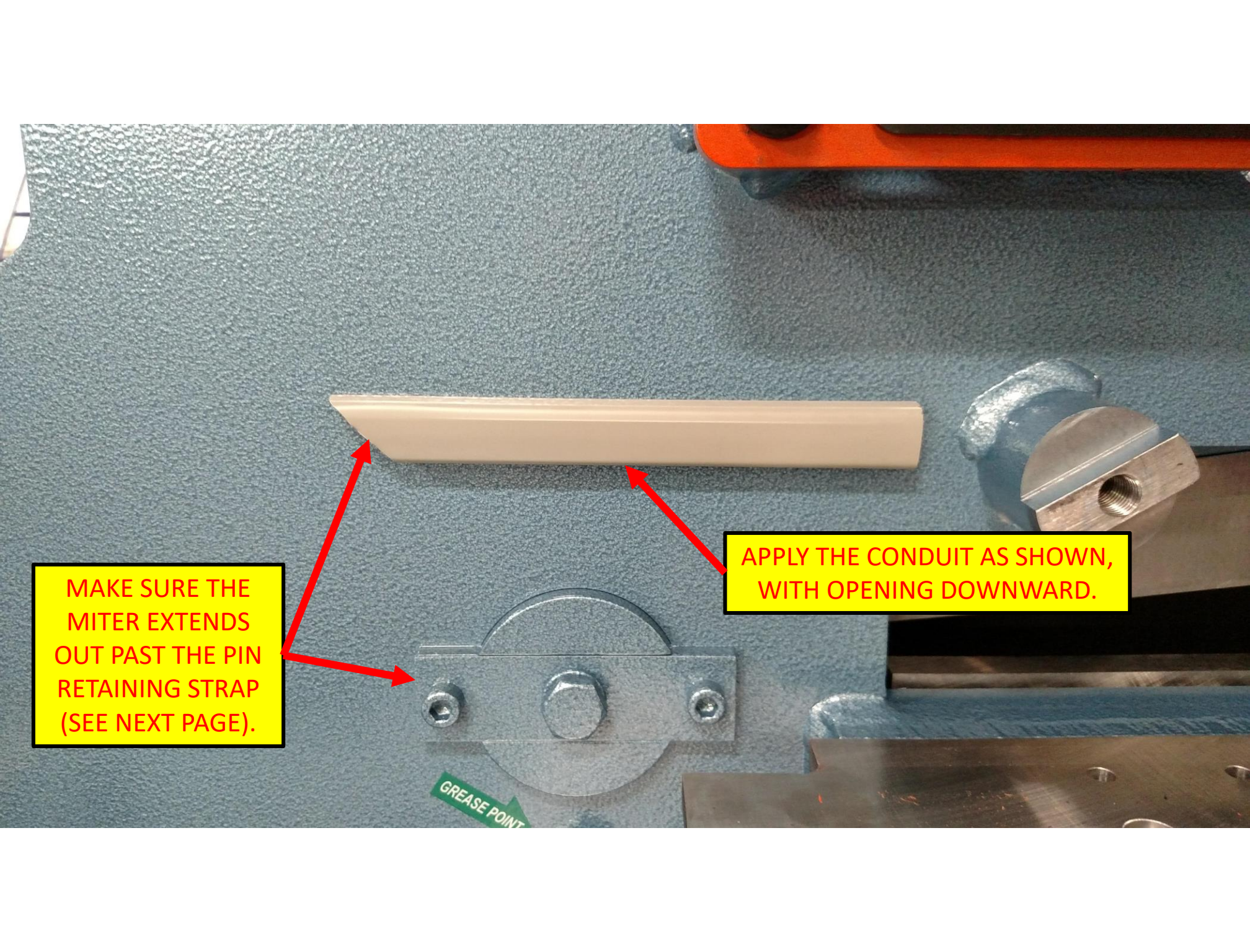


LOOP AND ZIPTIE CONNECTION



≈ 9 IN.

CUT THE CONDUIT PROVIDED AT ≈ 9 INCHES WITH A 45° MITER. MAKE SURE THE OPENING OF THE CONDUIT IS ON THE SHORT SIDE OF THE CUT.



MAKE SURE THE MITER EXTENDS OUT PAST THE PIN RETAINING STRAP (SEE NEXT PAGE).

APPLY THE CONDUIT AS SHOWN, WITH OPENING DOWNWARD.

GREASE POINT

CUT ANOTHER PIECE OF CONDUIT AT \approx 10 INCHES WITH A 45° MITER. MAKE SURE THE OPENING OF THE CONDUIT IS ON THE SHORT SIDE OF THE CUT.

\approx 10 IN.

APPLY THE CONDUIT AS SHOWN, WITH OPENING INWARD.

GREASE POINT

**MAKE A SMALL MARK IN THE MIDDLE
OF P/N 090543 – 18 LED BULB STRIP
(12 IN.) WITH A SHARPIE.**

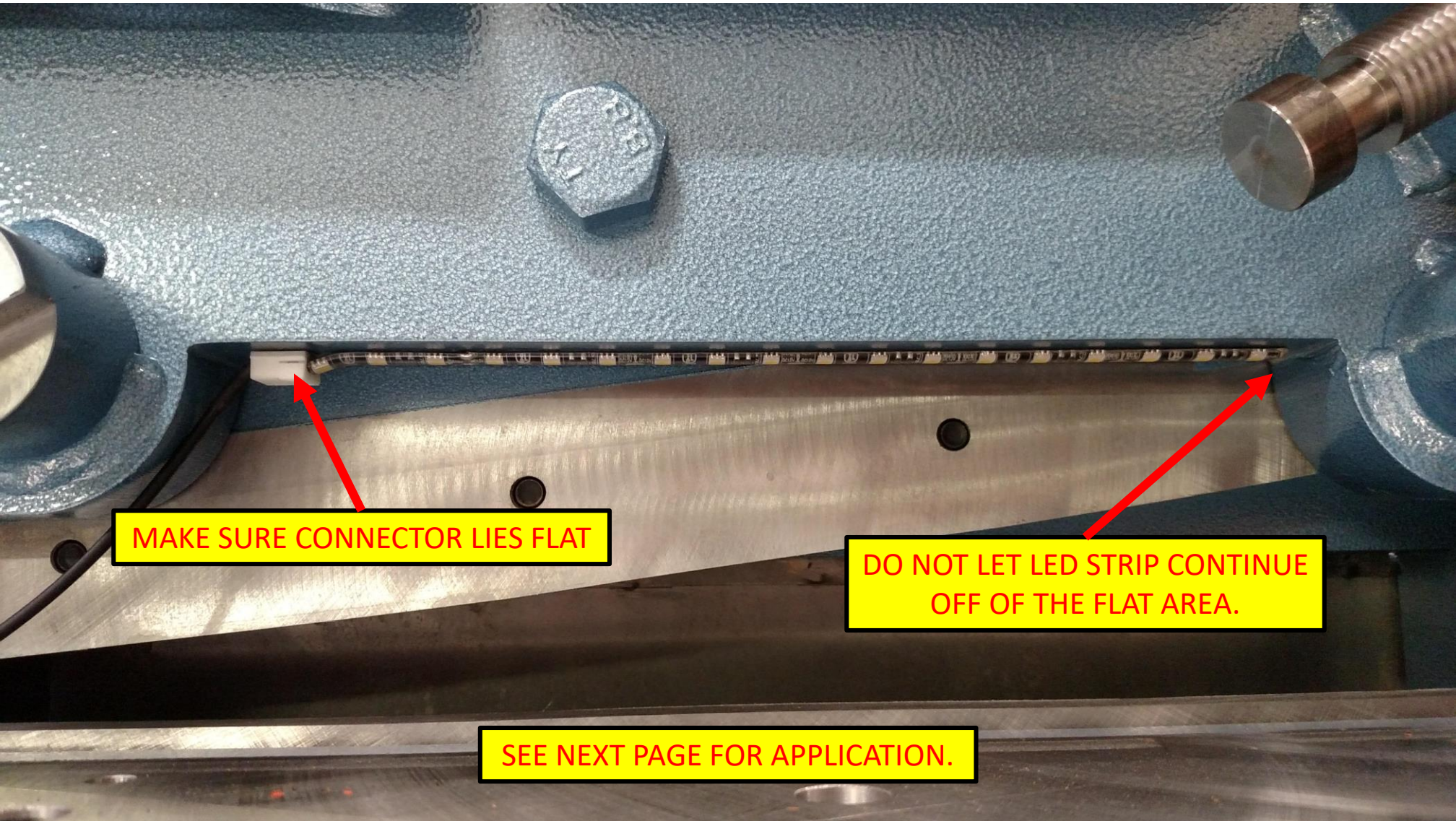




NOTE: BEFORE APPLYING THE LED STRIP, IT IS VERY IMPORTANT TO CLEAN THE SURFACE AS DETAILED [HERE](#).

CLEAN UNDERSIDE.

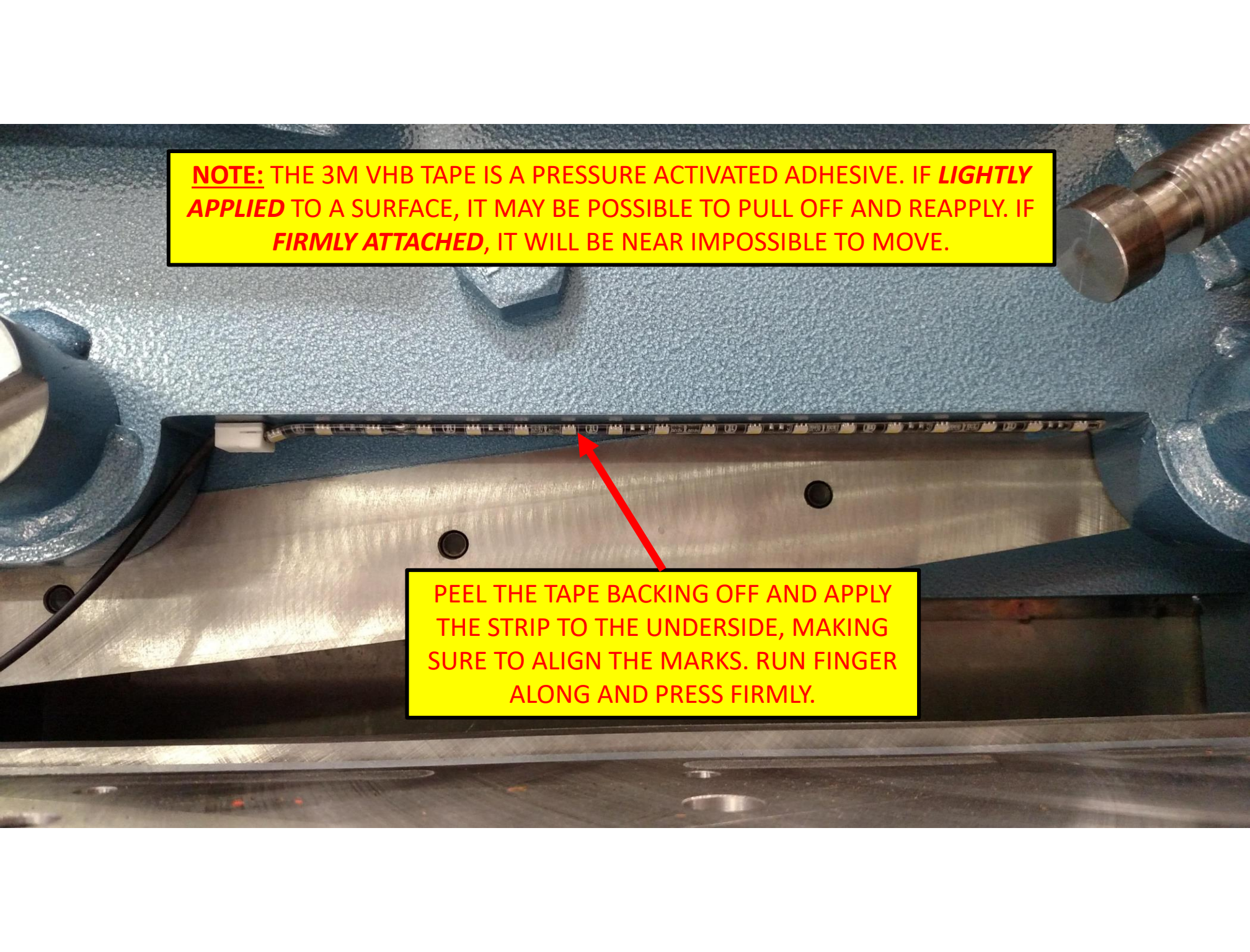
HOLD THE STRIP UP WITH THE PLASTIC CONNECTOR (ON LEFT) FLAT AGAINST THE UNDERSIDE OF THE FRAME. MAKE A SMALL MARK THAT CORRESPONDS WITH THE MARK ON THE STRIP. IT MAY BE SLIGHTLY OFF-CENTER.



MAKE SURE CONNECTOR LIES FLAT

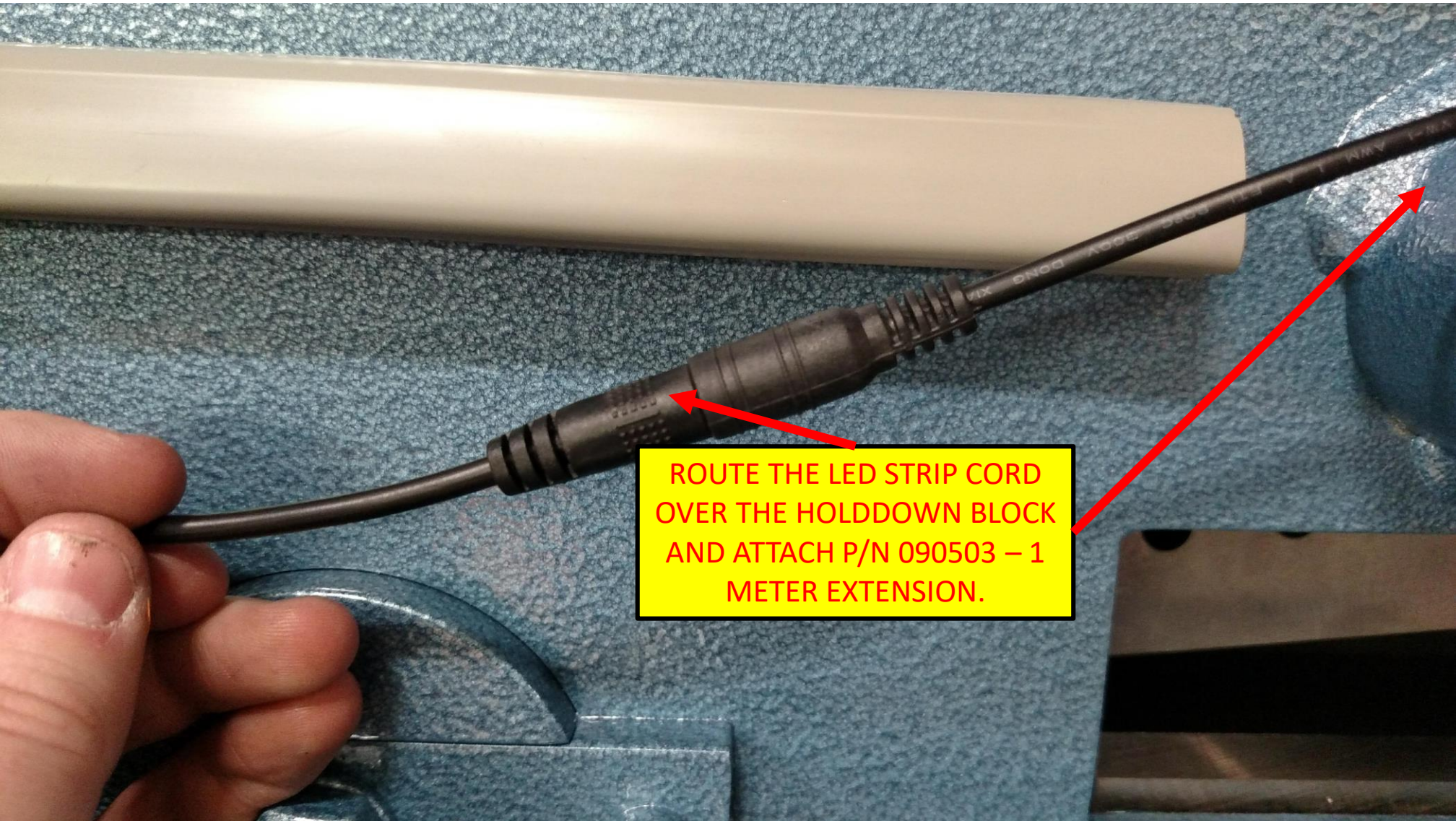
DO NOT LET LED STRIP CONTINUE OFF OF THE FLAT AREA.

SEE NEXT PAGE FOR APPLICATION.

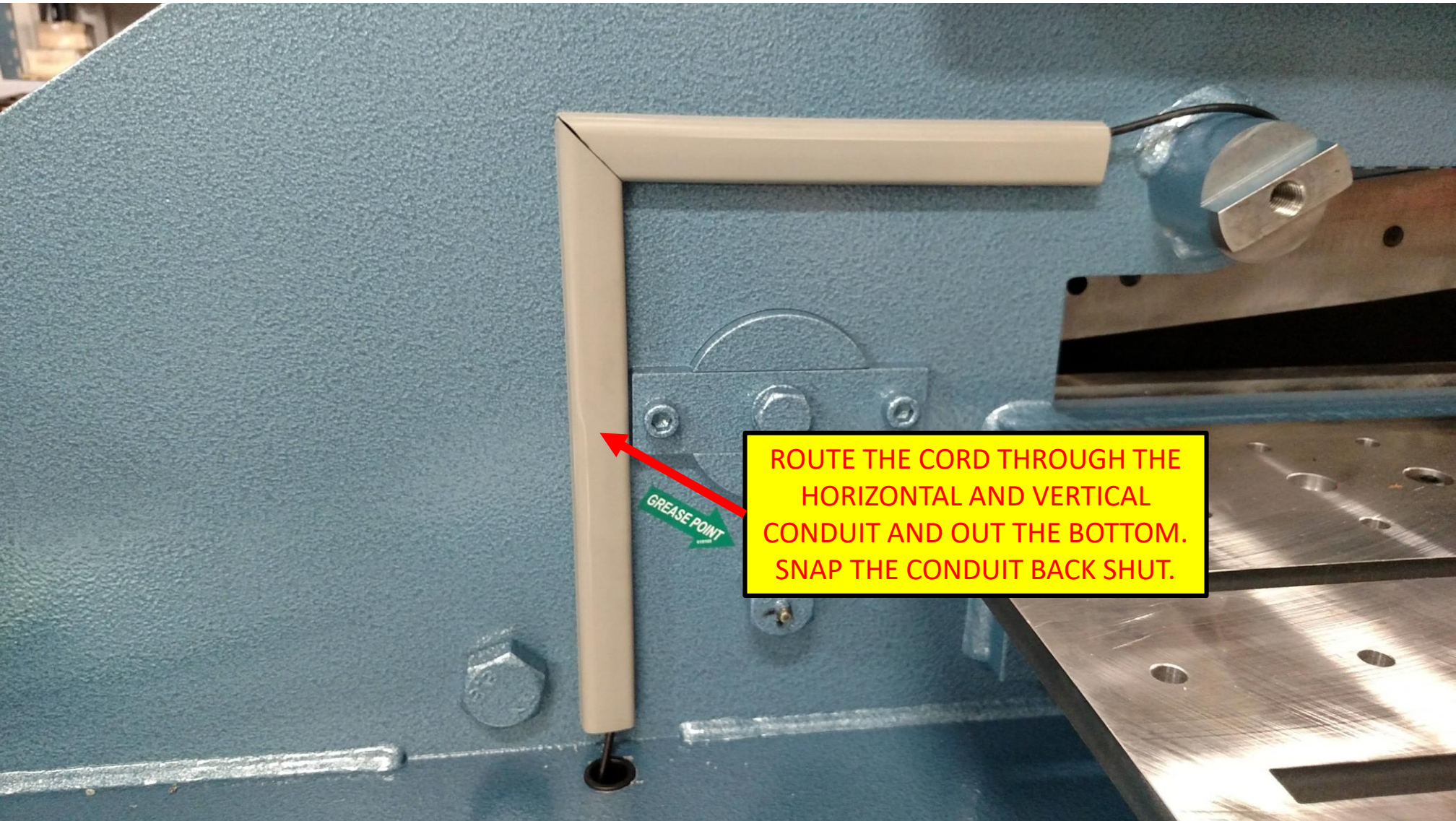


NOTE: THE 3M VHB TAPE IS A PRESSURE ACTIVATED ADHESIVE. IF **LIGHTLY APPLIED** TO A SURFACE, IT MAY BE POSSIBLE TO PULL OFF AND REAPPLY. IF **FIRMLY ATTACHED**, IT WILL BE NEAR IMPOSSIBLE TO MOVE.

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



ROUTE THE LED STRIP CORD
OVER THE HOLDDOWN BLOCK
AND ATTACH P/N 090503 - 1
METER EXTENSION.



ROUTE THE CORD THROUGH THE HORIZONTAL AND VERTICAL CONDUIT AND OUT THE BOTTOM. SNAP THE CONDUIT BACK SHUT.

GREASE POINT




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](#).

A hand is holding a black LED strip with 12 yellow LEDs. The strip is connected to a black cable that has a white connector at one end and a black connector at the other. The background is a grey concrete floor.

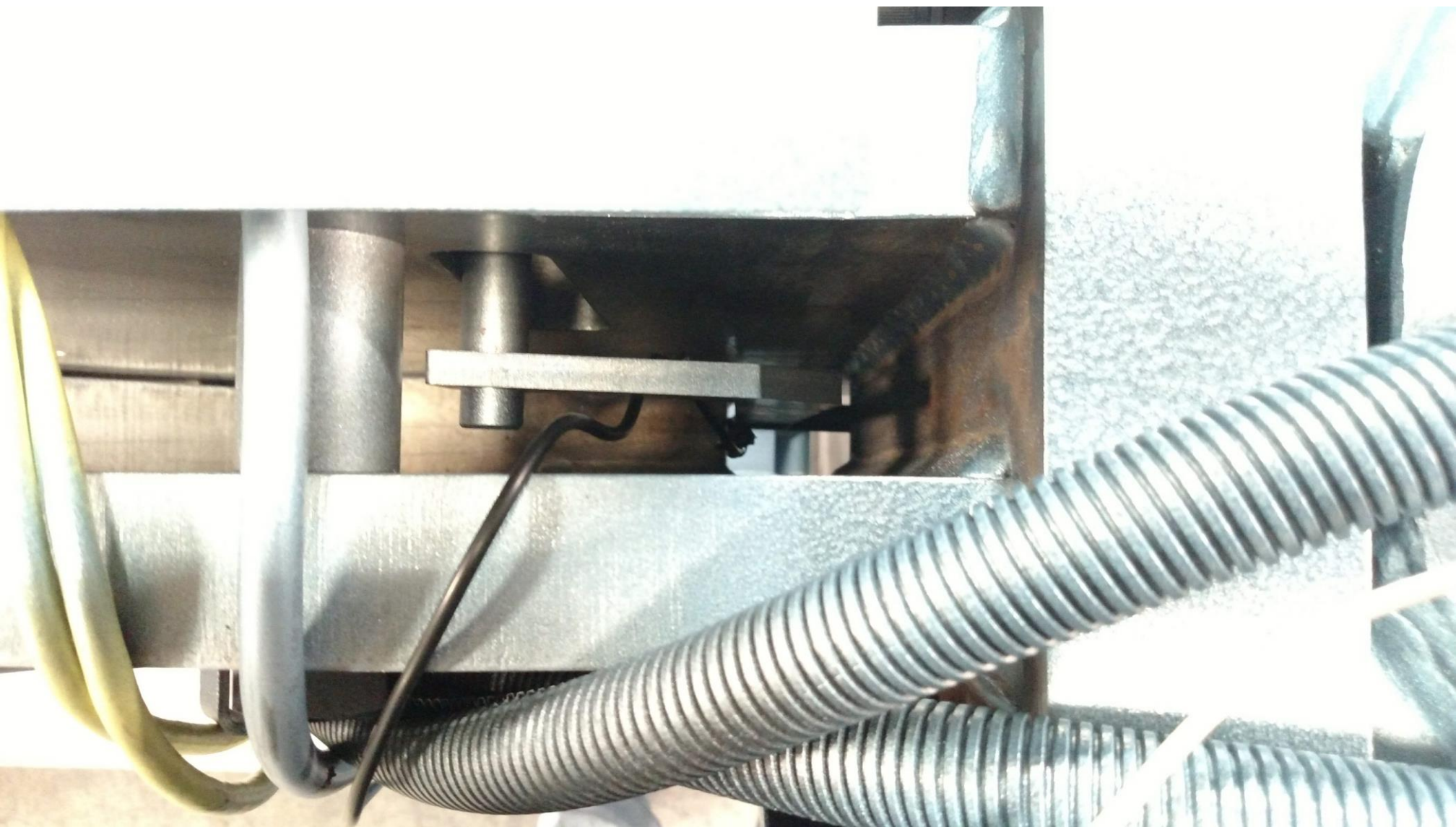
P/N 090542 – 12 LED
BULB STRIP (8 IN.).

ATTACH P/N 090502 – 3 METER
EXTENSION CORD TO STRIP.



FEED 3 METER EXTENSION
CORD UP/DOWN BETWEEN
FRAMES. KEEP ON REAR SIDE
OF STROKE BAR.

REAR

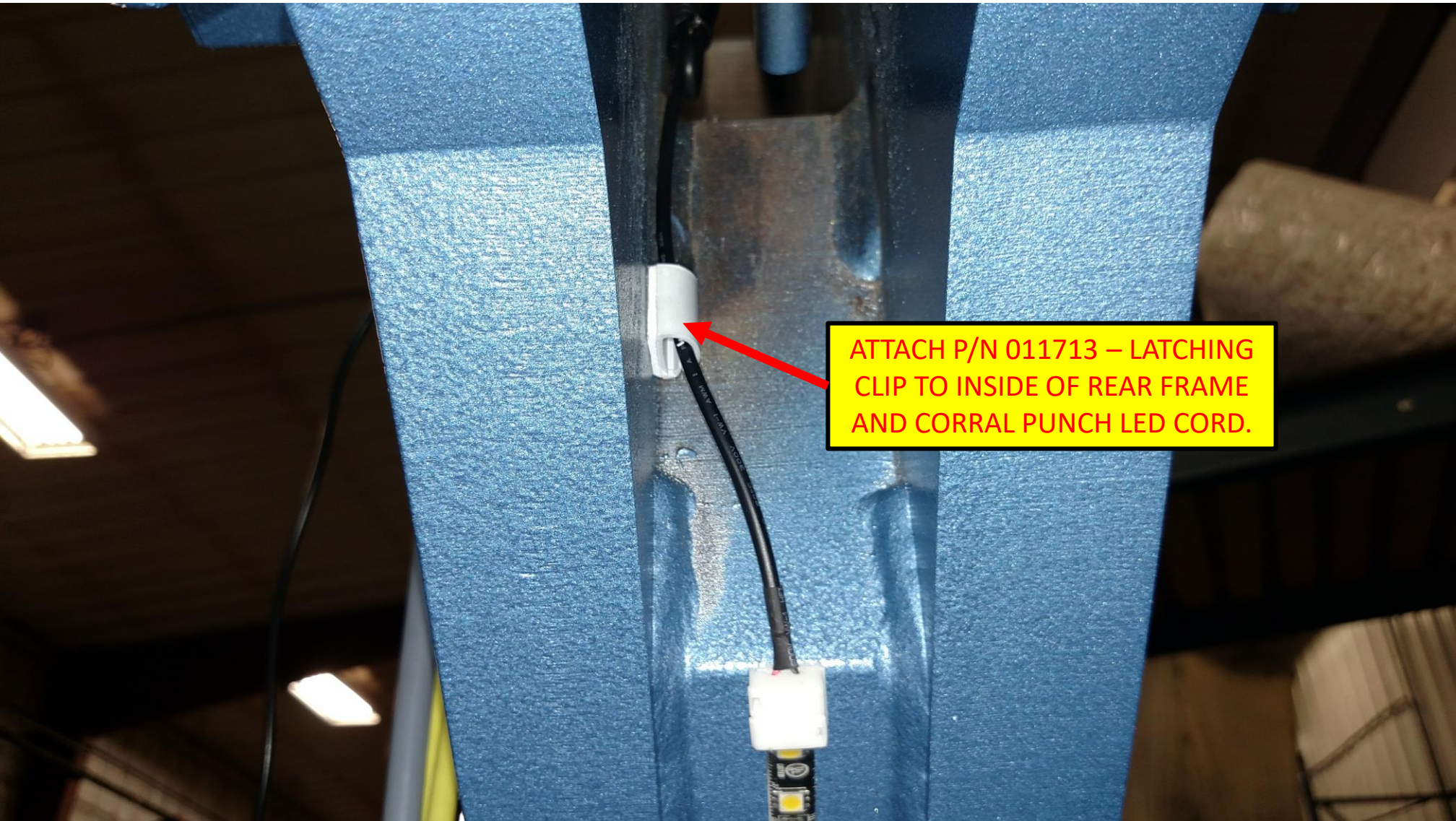




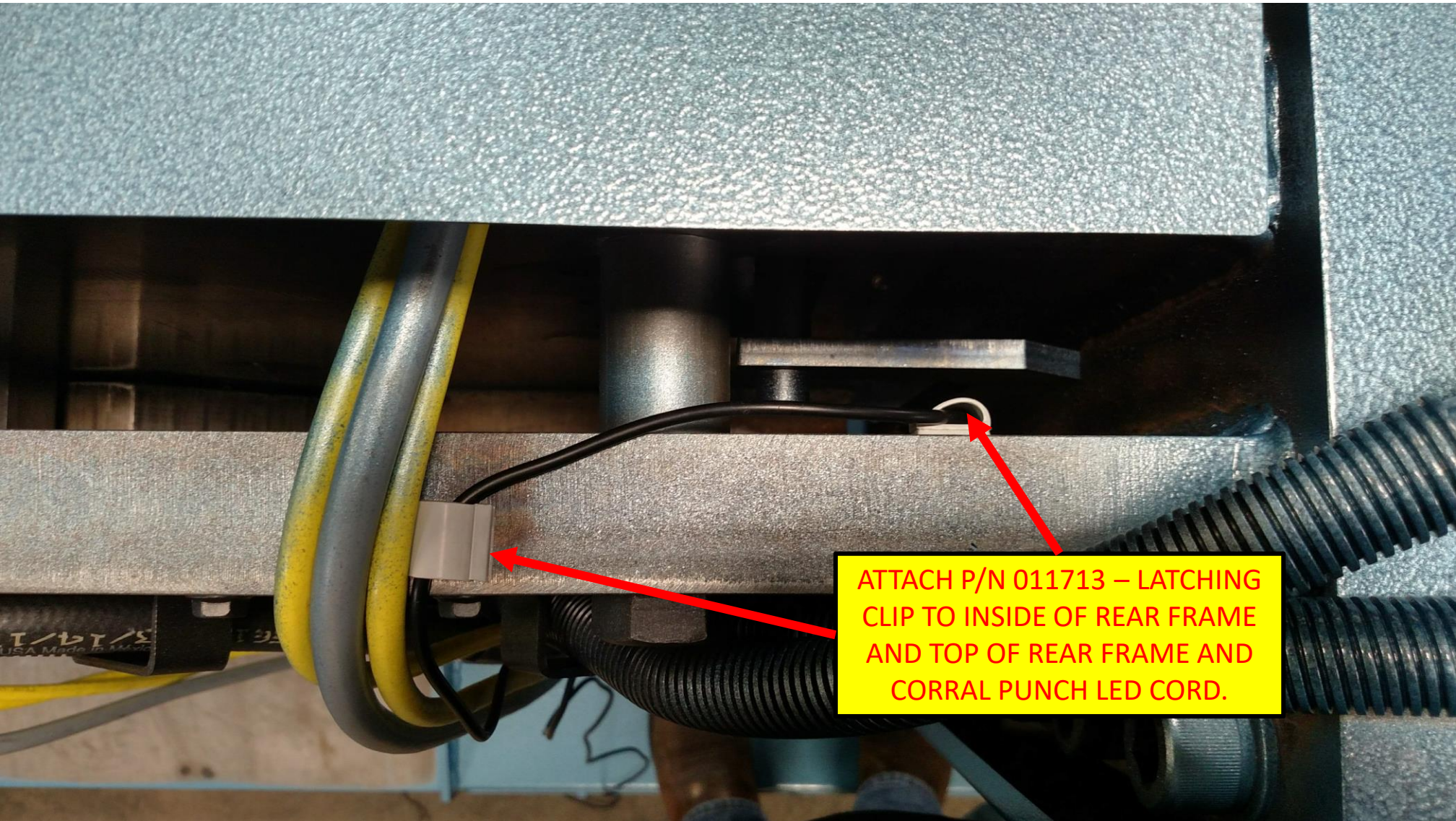
ALIGN TOP OF STRIP WITH
TOP OF THROAT BRACE.

REMOVE TAPE
BACKING AND APPLY
STRIP. PRESS FIRMLY.

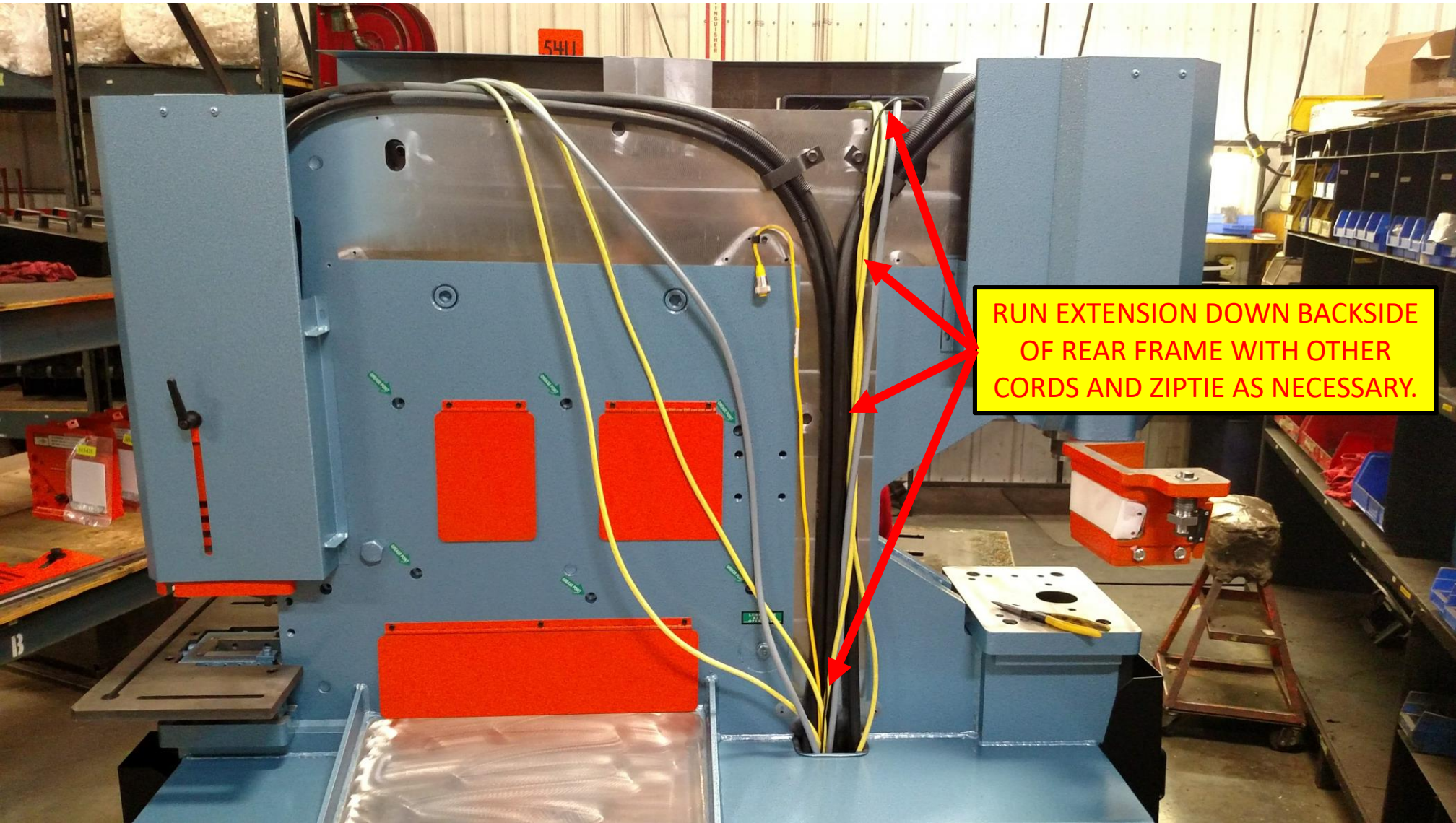
NOTE: THE 3M VHB TAPE IS A PRESSURE ACTIVATED ADHESIVE. IF **LIGHTLY APPLIED** TO A SURFACE, IT MAY BE POSSIBLE TO PULL OFF AND REAPPLY. IF **FIRMLY ATTACHED**, IT WILL BE NEAR IMPOSSIBLE TO MOVE.



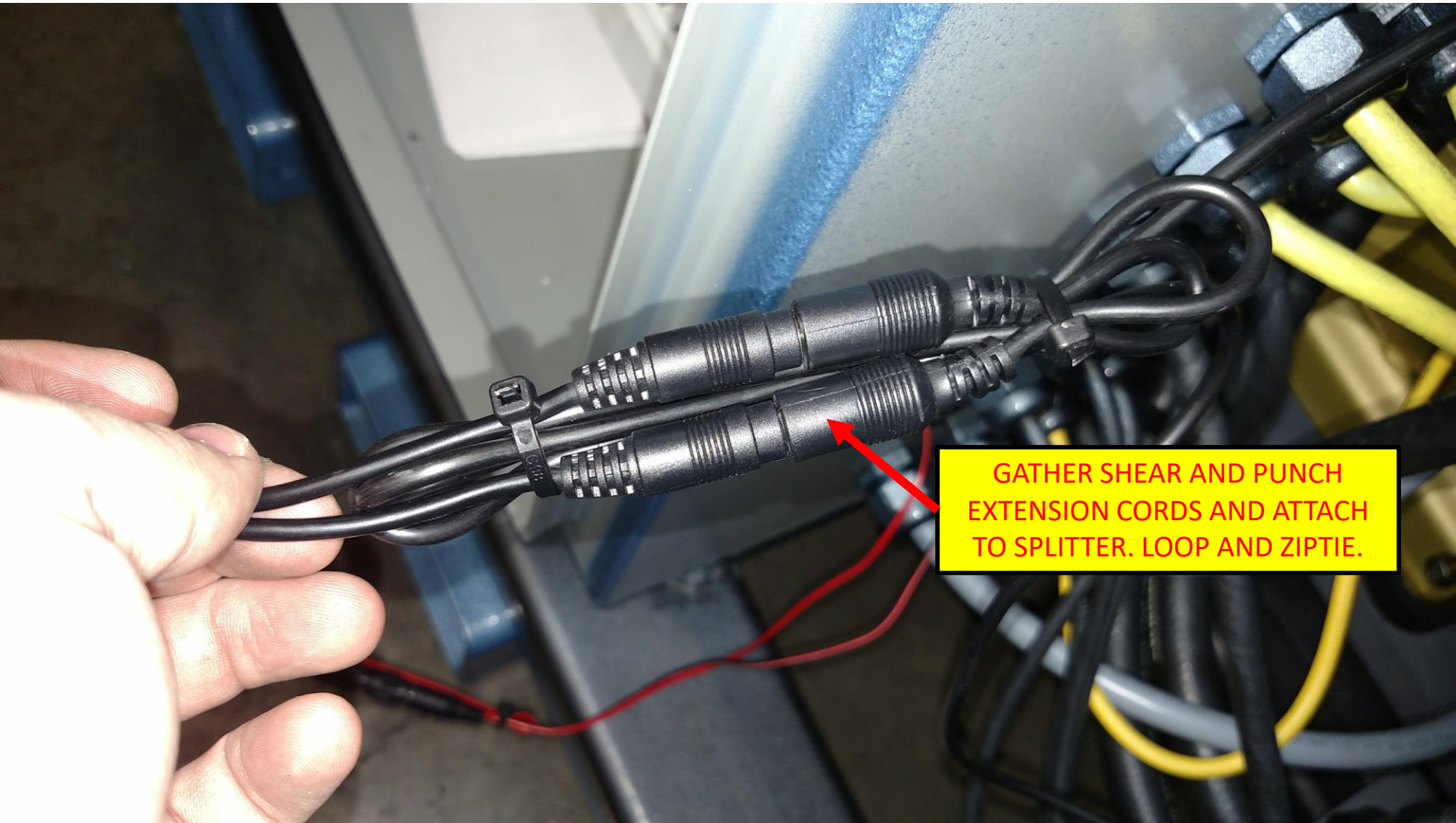
**ATTACH P/N 011713 – LATCHING
CLIP TO INSIDE OF REAR FRAME
AND CORRAL PUNCH LED CORD.**



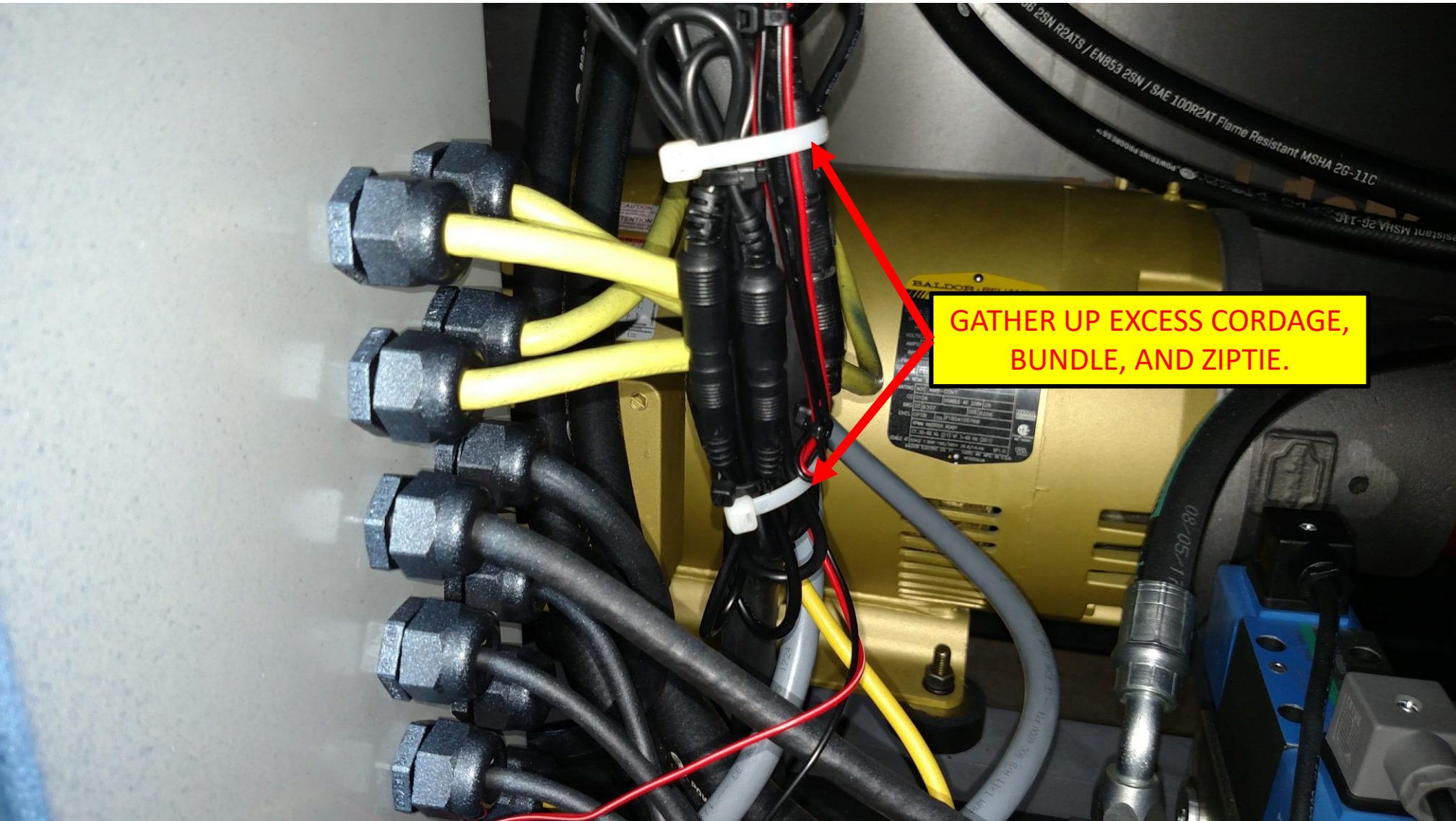
ATTACH P/N 011713 - LATCHING CLIP TO INSIDE OF REAR FRAME AND TOP OF REAR FRAME AND CORRAL PUNCH LED CORD.



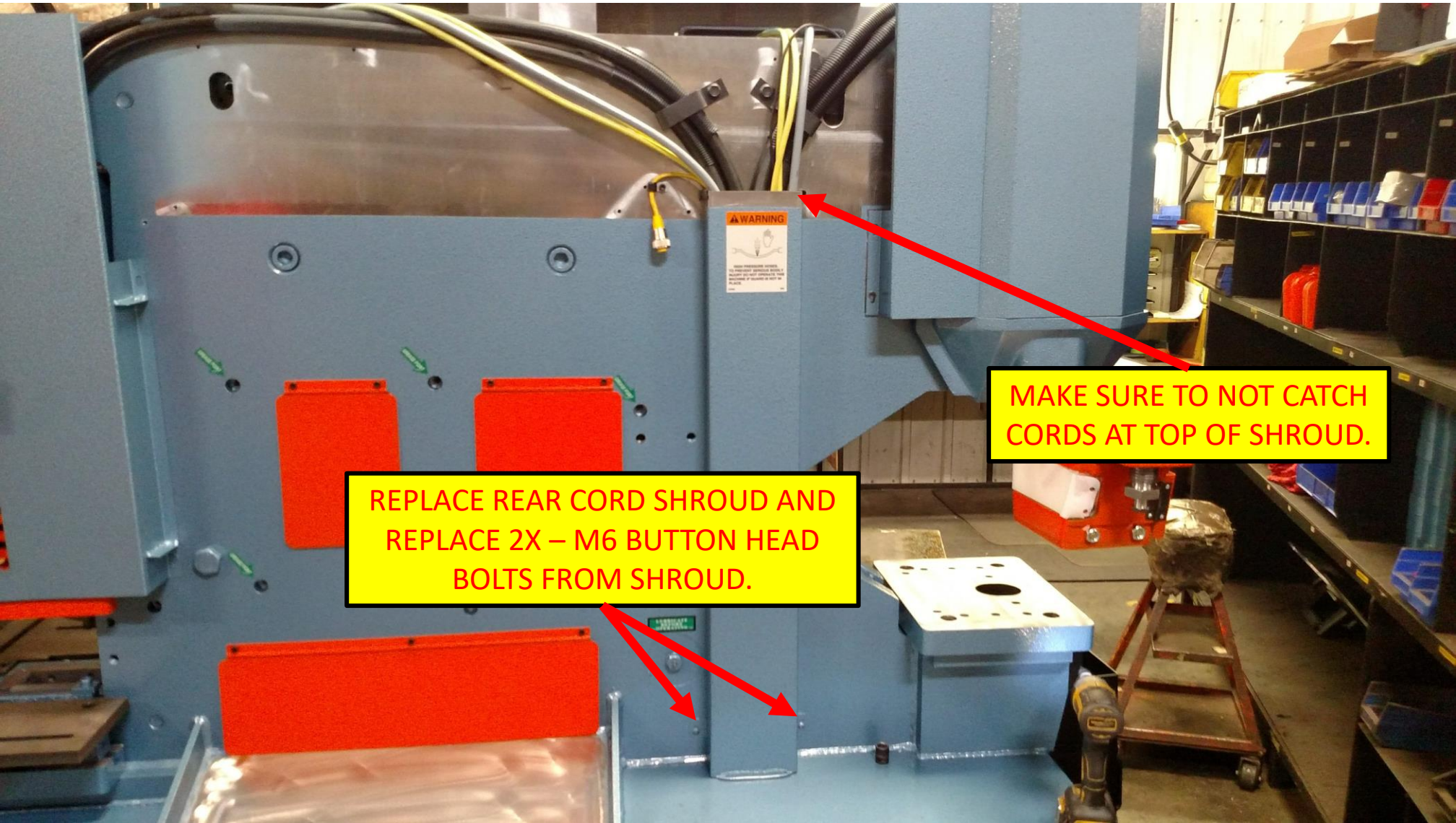
RUN EXTENSION DOWN BACKSIDE OF REAR FRAME WITH OTHER CORDS AND ZIPTIE AS NECESSARY.



**GATHER SHEAR AND PUNCH
EXTENSION CORDS AND ATTACH
TO SPLITTER. LOOP AND ZIPTIE.**




**GATHER UP EXCESS CORDAGE,
BUNDLE, AND ZIPTIE.**



REPLACE REAR CORD SHROUD AND
REPLACE 2X – M6 BUTTON HEAD
BOLTS FROM SHROUD.

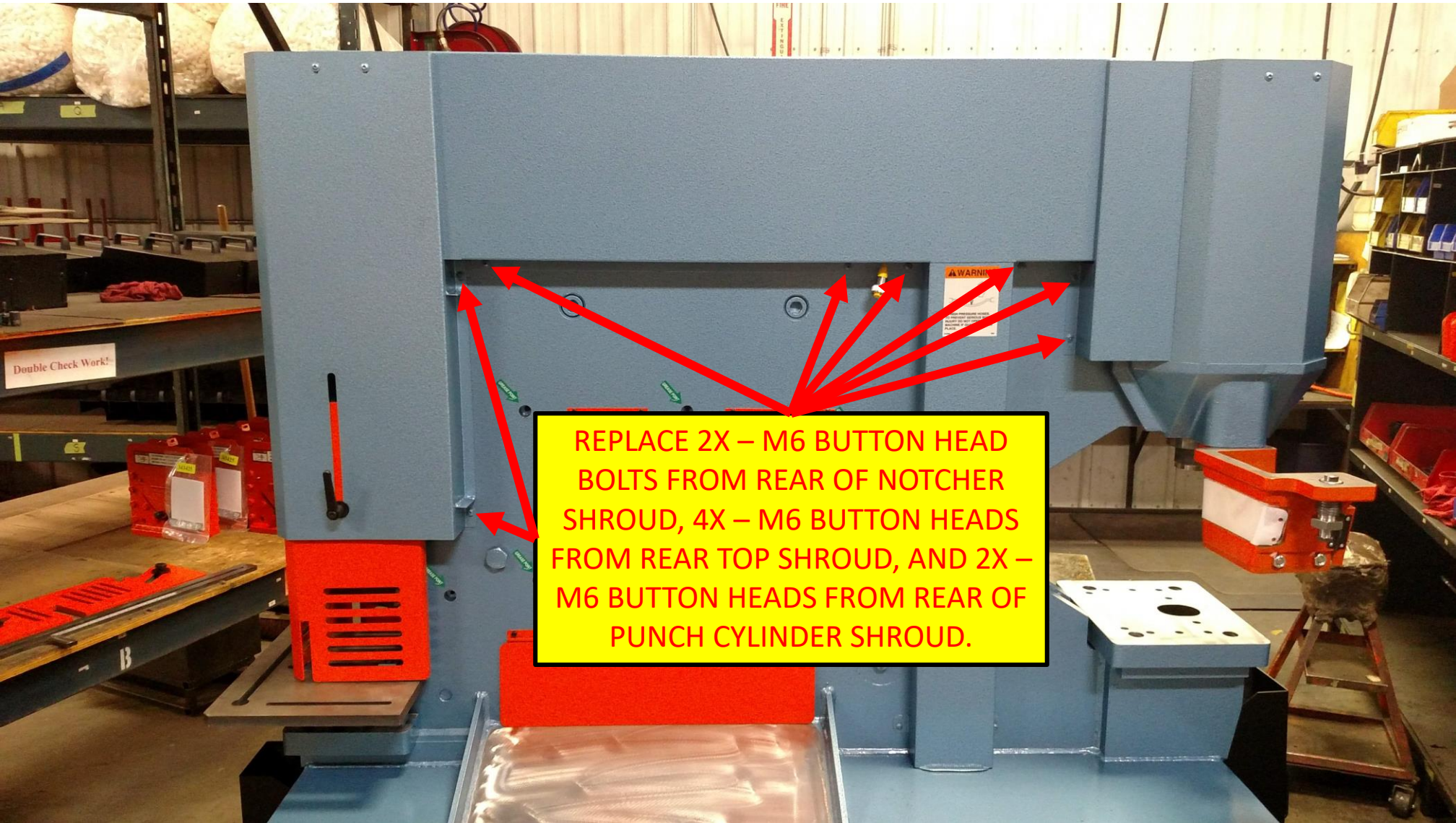
MAKE SURE TO NOT CATCH
CORDS AT TOP OF SHROUD.



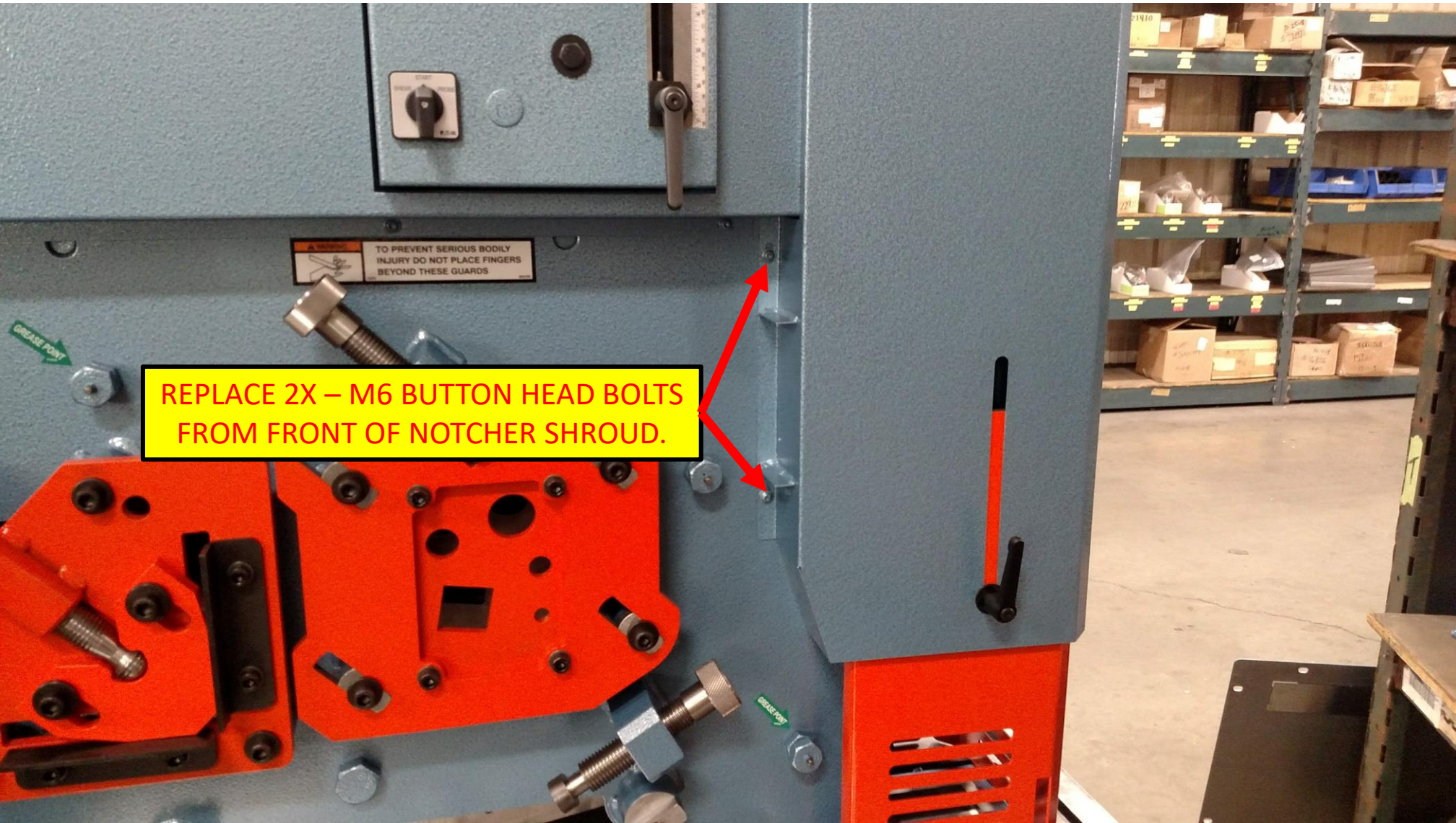
REPLACE REAR TOP SHROUD AND
NOTCHER SHROUD (IF REMOVED). TAKE
CARE TO FEED ELECTRIC BACKGUAGE CORD
THROUGH HOLE IN REAR TOP COVER.



**REPLACE 2X – M6 BUTTON HEAD BOLTS
FROM TOP OF TOP REAR SHROUD.**



REPLACE 2X – M6 BUTTON HEAD BOLTS FROM REAR OF NOTCHER SHROUD, 4X – M6 BUTTON HEADS FROM REAR TOP SHROUD, AND 2X – M6 BUTTON HEADS FROM REAR OF PUNCH CYLINDER SHROUD.

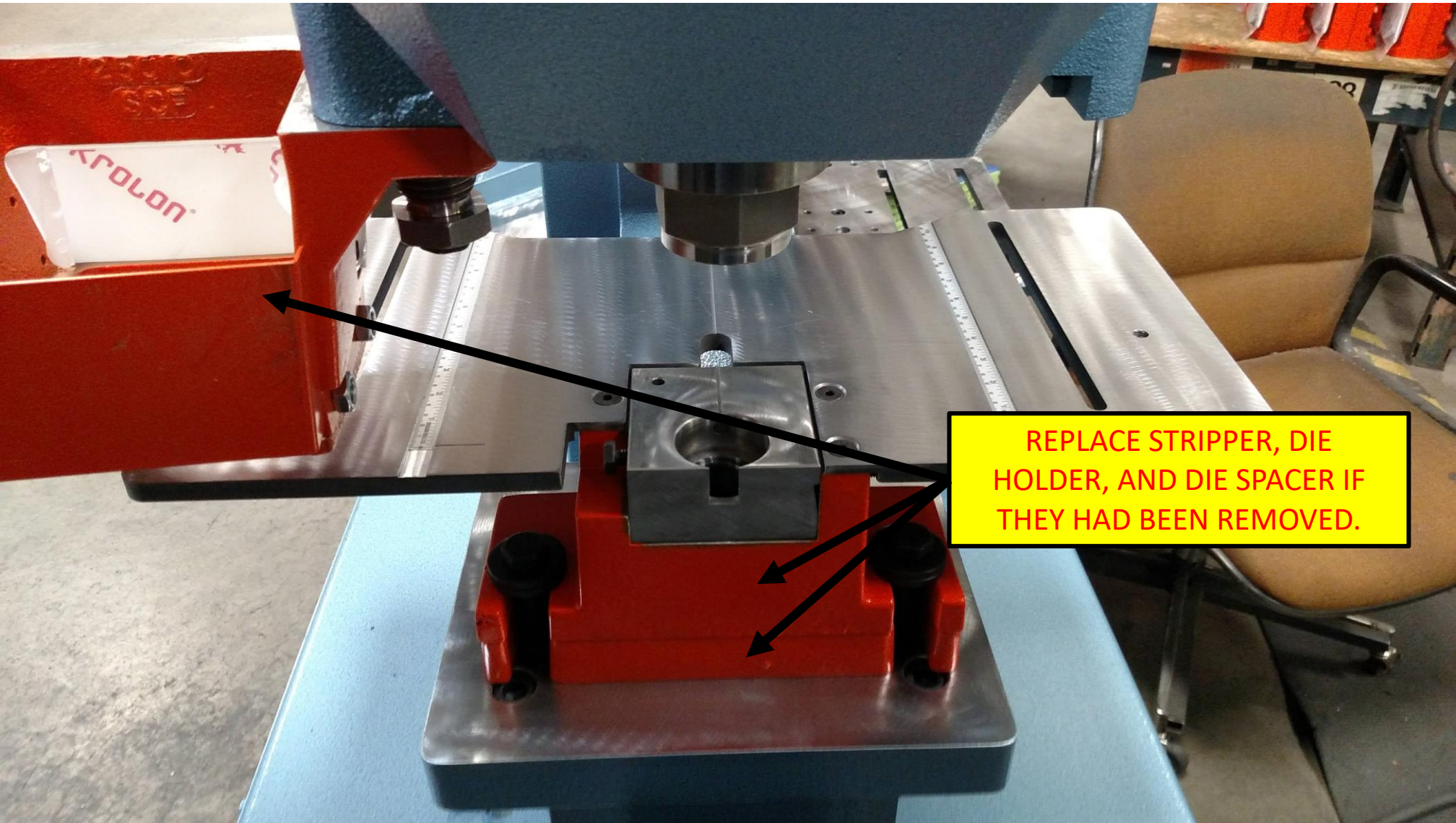


REPLACE 2X - M6 BUTTON HEAD BOLTS FROM FRONT OF NOTCHER SHROUD.

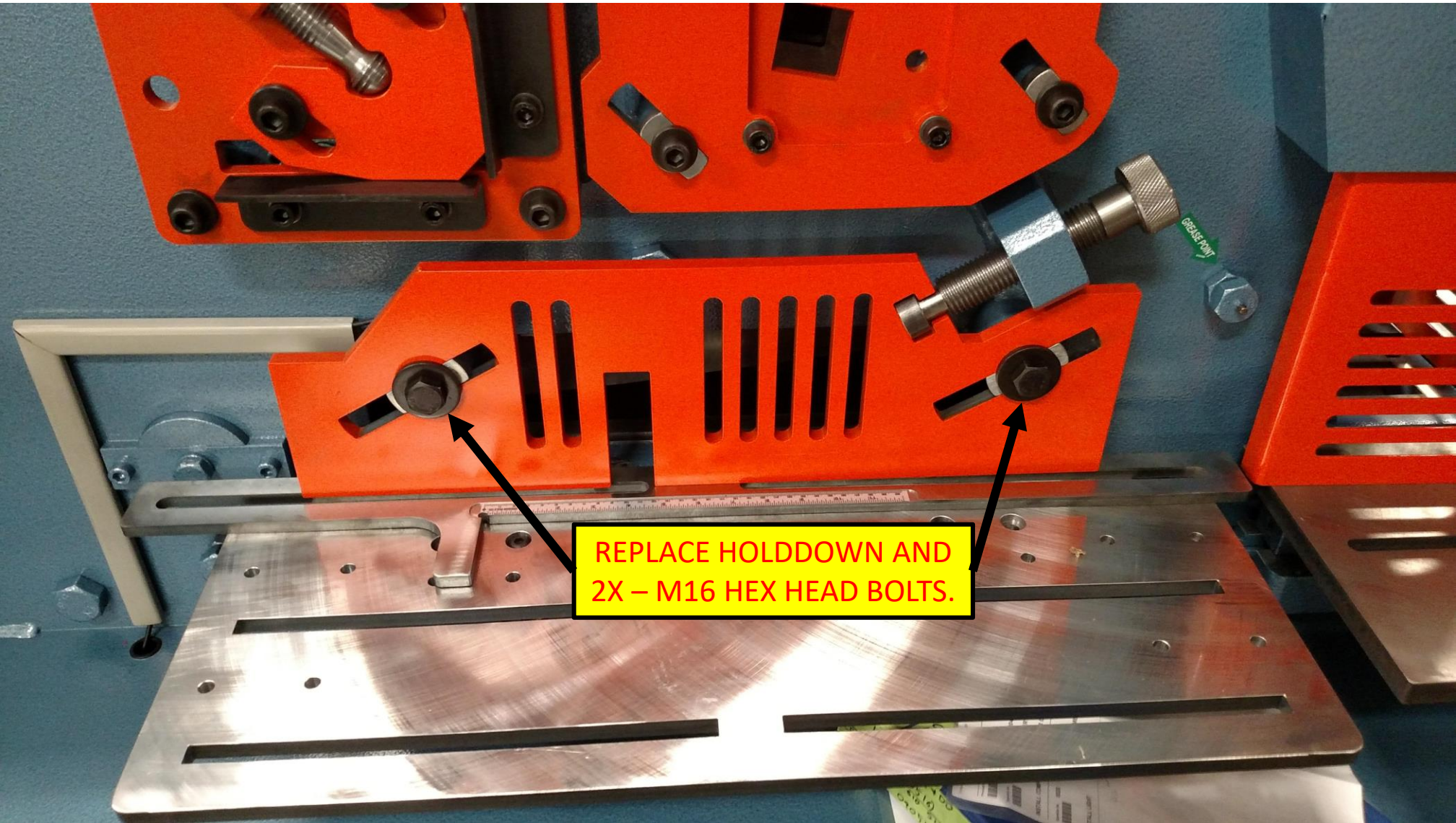
TO PREVENT SERIOUS BODILY INJURY DO NOT PLACE FINGERS BEYOND THESE GUARDS

GREASE POINT

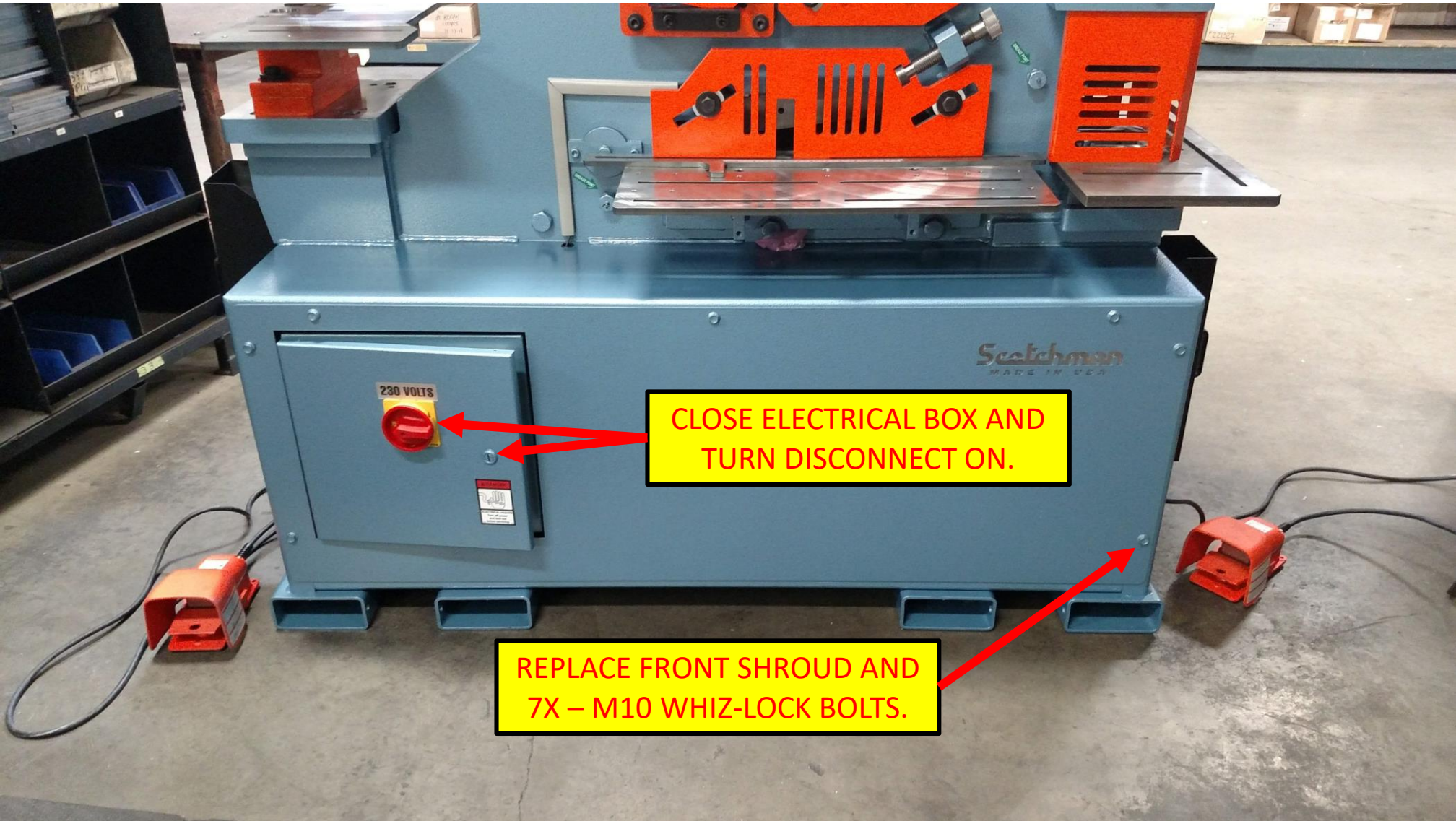
GREASE POINT



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




REPLACE HOLDDOWN AND
2X - M16 HEX HEAD BOLTS.



CLOSE ELECTRICAL BOX AND
TURN DISCONNECT ON.

REPLACE FRONT SHROUD AND
7X – M10 WHIZ-LOCK BOLTS.



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

