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P/N 011200  
**INSTRUCTIONS**

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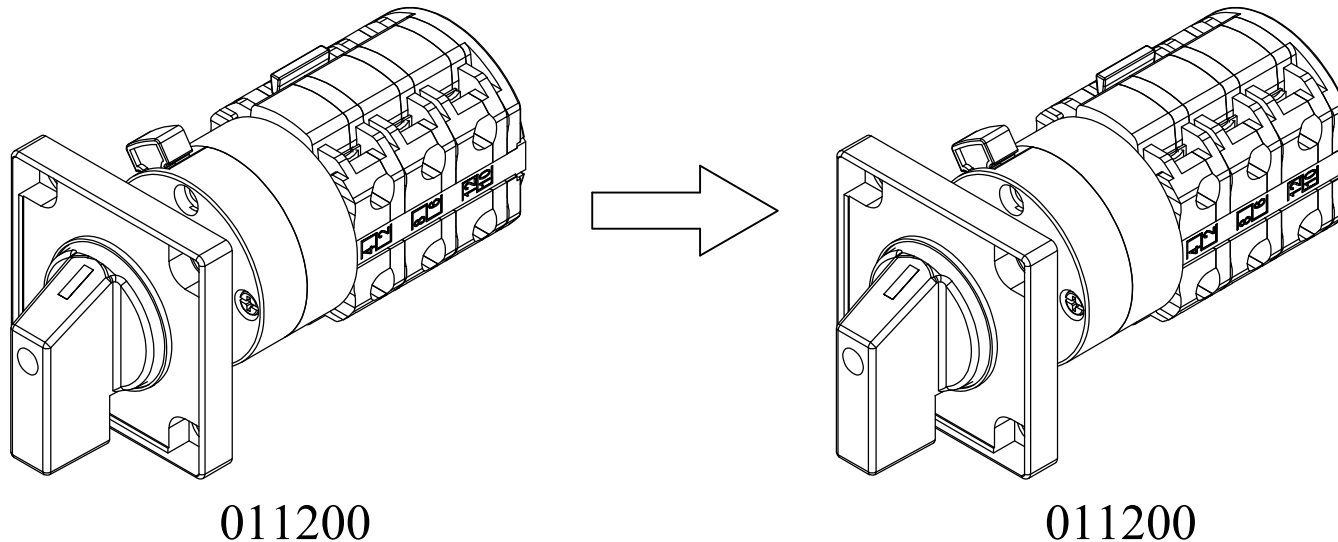
**610 SHEARMASTER**

FEBRUARY 2022

# 011200 Replacement Instructions

The following instructions describe how to replace a Kraus & Neimer cam switch with a direct replacement cam switch on the machine(s) listed below. For machines built prior to February 2022 with Klockner Moeller cam switches, see Page 5.

DISCONNECT POWER TO THE MACHINE BEFORE MODIFICATION.



011200

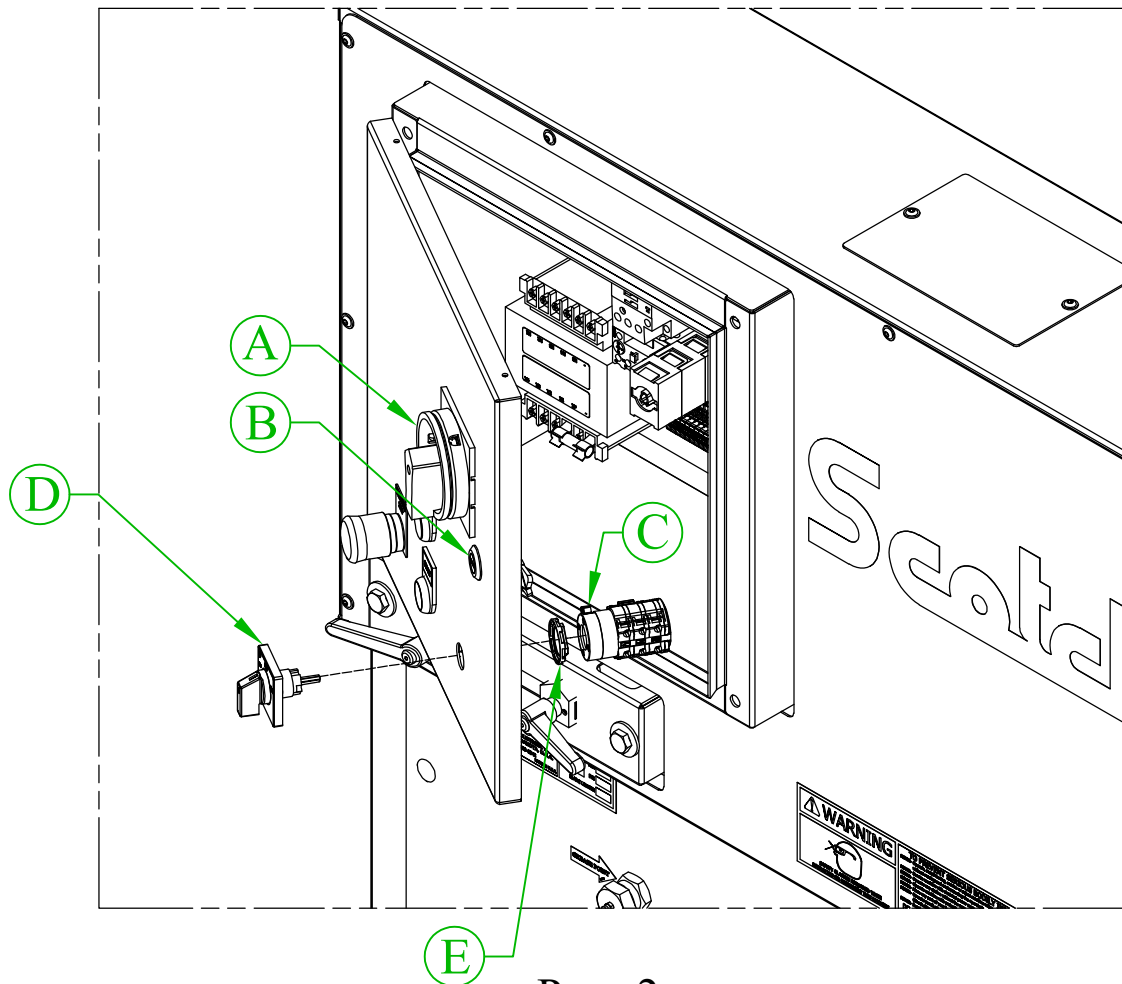
011200

Applies to Serial Numbers:

**610 ShearMaster: 2094A0122 & After**

# Switch Removal

1. Turn the main power disconnect (A) to the OFF position. Open the panel door by turning the lock (B) counter-clockwise.
2. Press the red release handle (C) of the switch and disconnect the switch from the legend holder assembly.
3. Carefully pull the switch back to allow access to the legend holder (D) assembly from the rear.
4. Remove the old legend holder from the panel by unscrewing the nut (E) from the backside.
5. The switch will contain a variety of wires that have printed number labels. The locations of each wire are shown on the following page.
6. Note the location of each wire and remove.

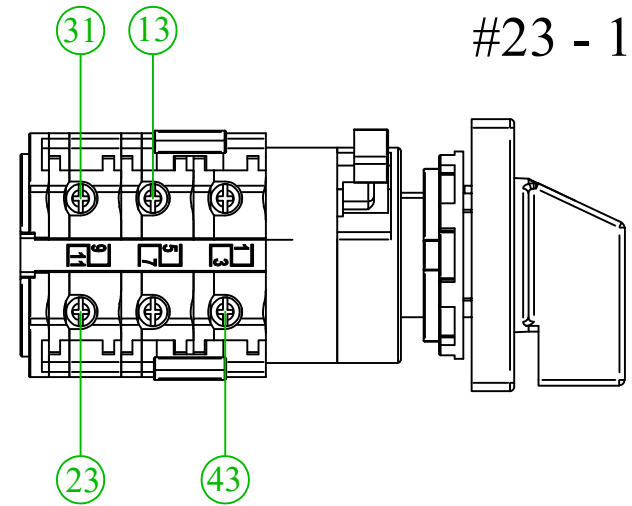


# Switch Replacement

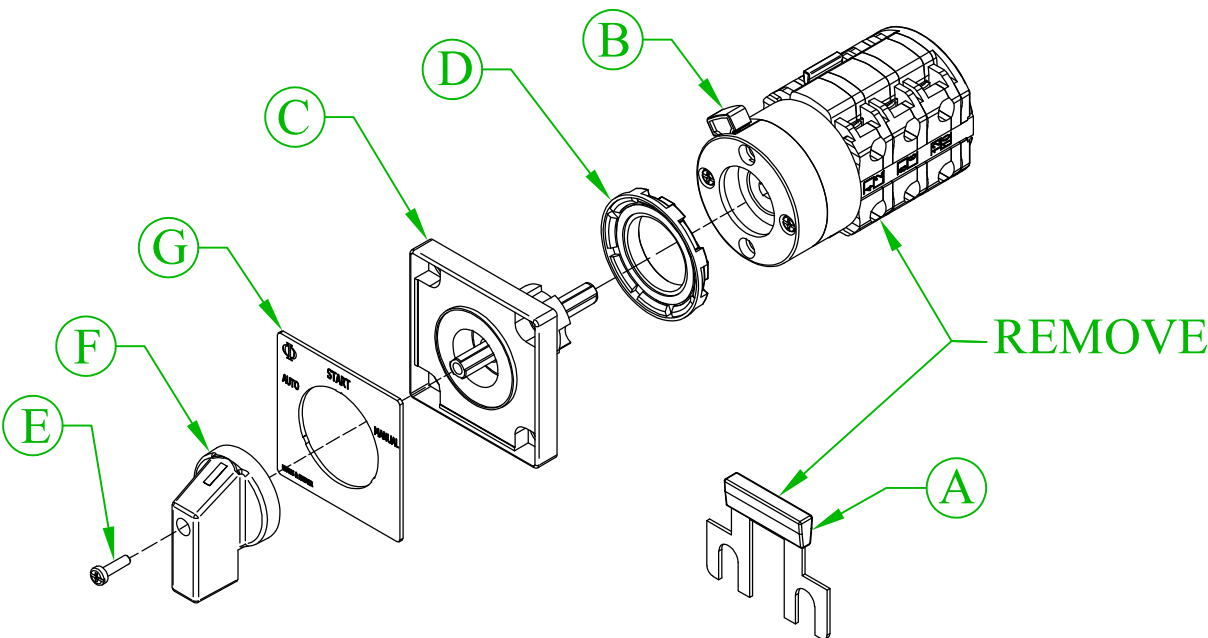
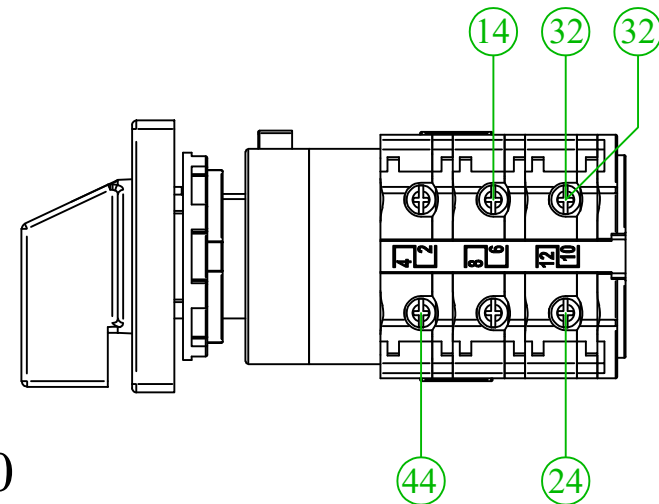
1. REMOVE ALL EXTERNAL JUMPERS (A) SUPPLIED WITH NEW SWITCH.
2. Press the red release handle (B) on the new switch to separate the knob/legend holder from the switch.
3. Install the legend holder (C) into the panel and fasten with nut (D) from backside.
4. Remove the screw (E) retaining the knob. Remove knob (F).
5. Install the legend plate (G) sold separately (P/N 011216). Re-install knob.
6. Wire the new switch as shown to the right.
7. Align the switch with the stem of the knob, and press the switch onto the knob assembly. The arrow on the back of the switch will be pointing upwards. When aligned, the switch will snap into place.

#43 - 3  
 #13 - 5  
 #31 - 9  
 #23 - 11

LEFT VIEW

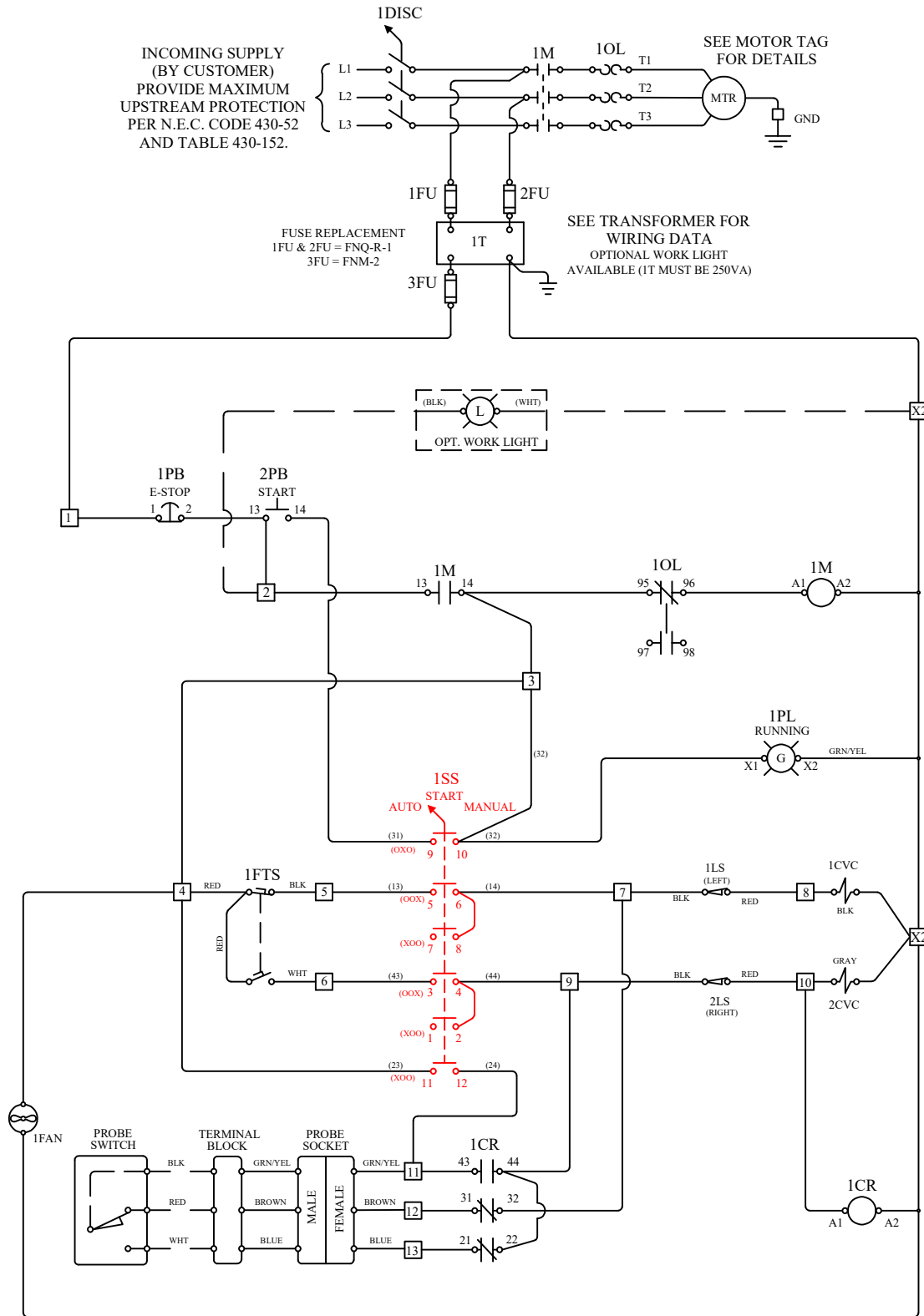


RIGHT VIEW



#44 - 4  
 #14 - 6  
 #32 - 10  
 #24 - 12

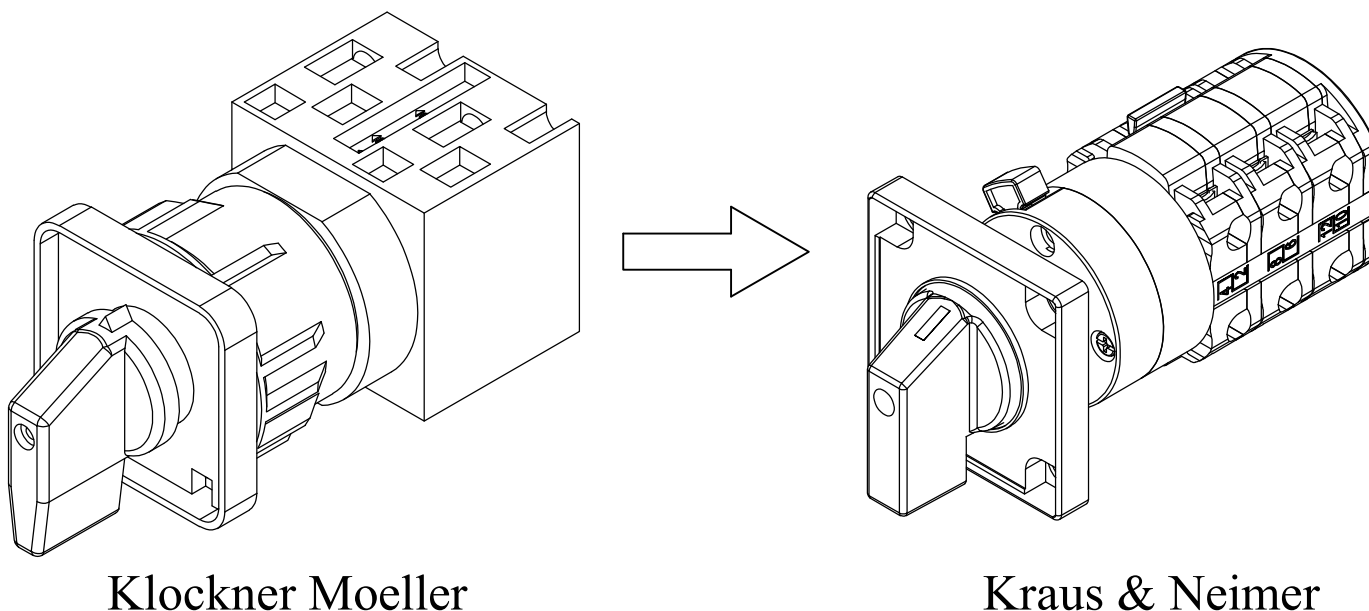
# Replacement Diagram



# 011200 Retrofit Instructions

The following instructions describe how to replace a Klockner Moeller cam switch (left) with a Kraus & Neimer cam switch (right) on the machine(s) listed below.

**DISCONNECT POWER TO THE MACHINE BEFORE MODIFICATION.**



Applies to Serial Numbers:  
**610 ShearMaster: 2093A0921 & Prior**

# Switch Differences

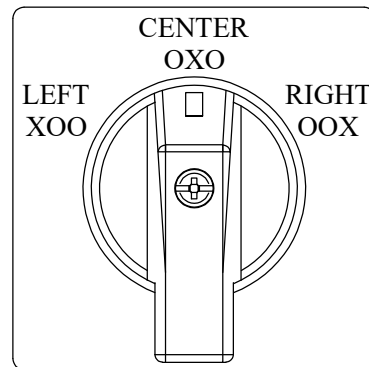
The key difference between the Klockner Moeller switches (011868) and the Kraus & Neimer switches (011200) are the contact numbers and internal jumpers.

The charts below show the difference in contact closures and jumpers.

## KLOCKNER MOELLER

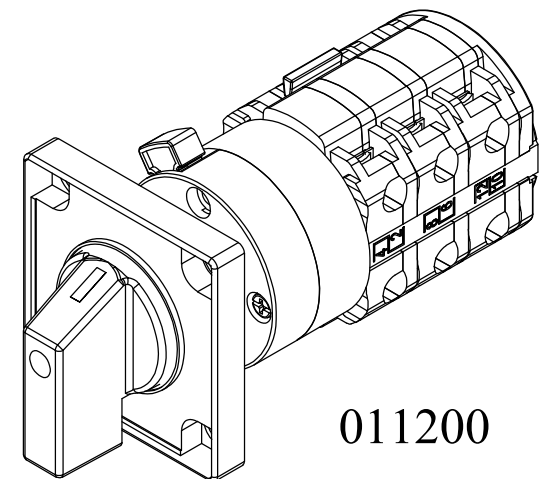
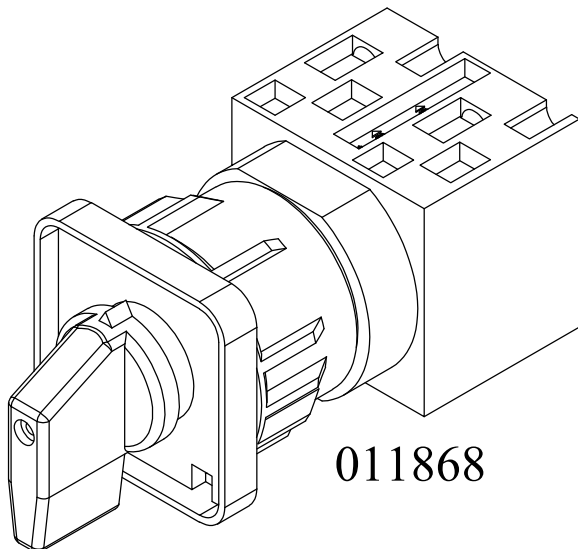
CONTACT	CLOSURE
1 - 2	XOO
3 - 4	XOO
5 - 6	OXO
7 - 8	OOX
9 - 10	OOX
11 - 12	N/A
REMOVABLE JUMPERS	1 - 7
	2 - 10
	3 - 9
	4 - 8

## CLOSURES



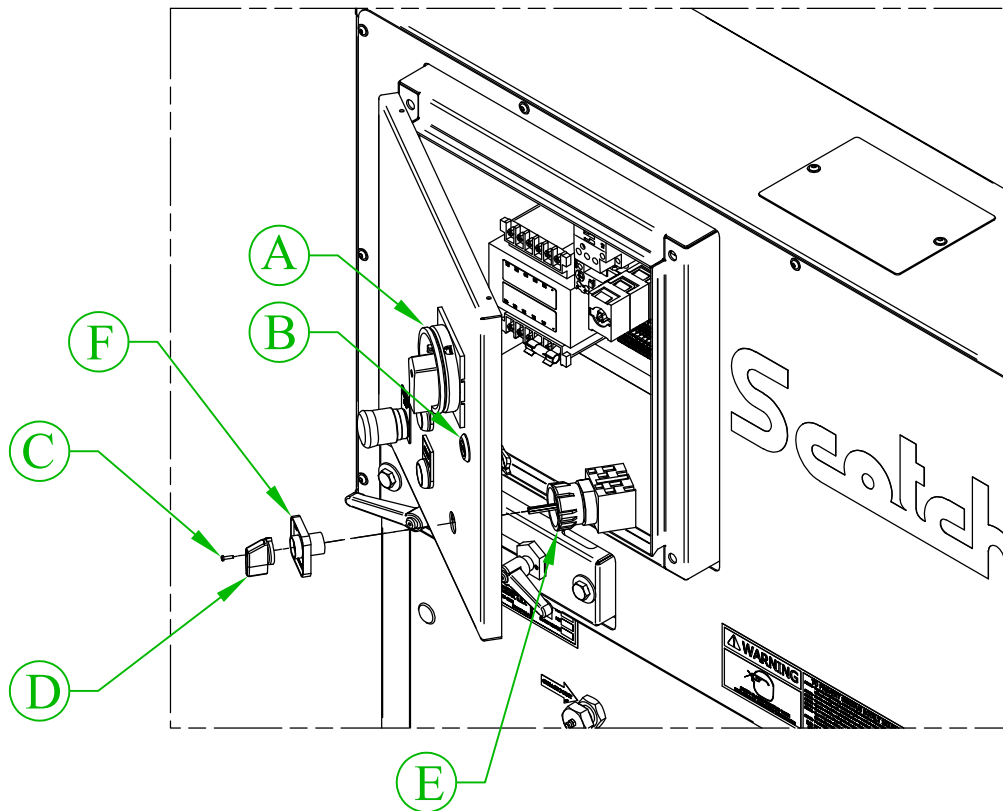
## KRAUS & NEIMER

CONTACT	CLOSURE
1 - 2	XOO
3 - 4	OOX
5 - 6	OOX
7 - 8	XOO
9 - 10	OXO
11 - 12	XOO
PERMANENT JUMPERS	2 - 4
	6 - 8
REMOVABLE JUMPERS	1 - 5
	3 - 7

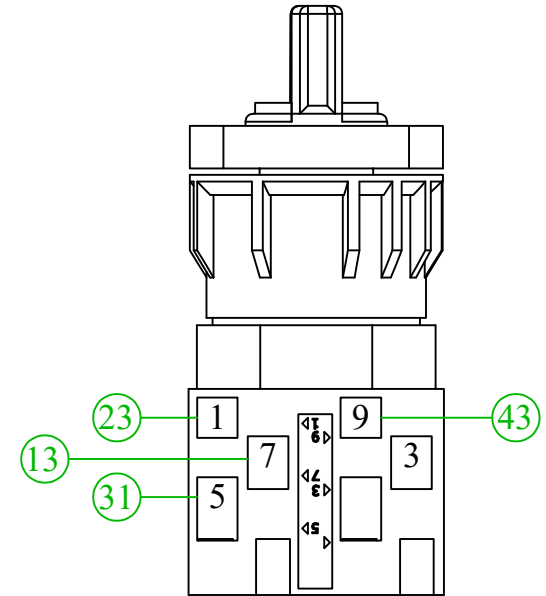


# Switch Removal

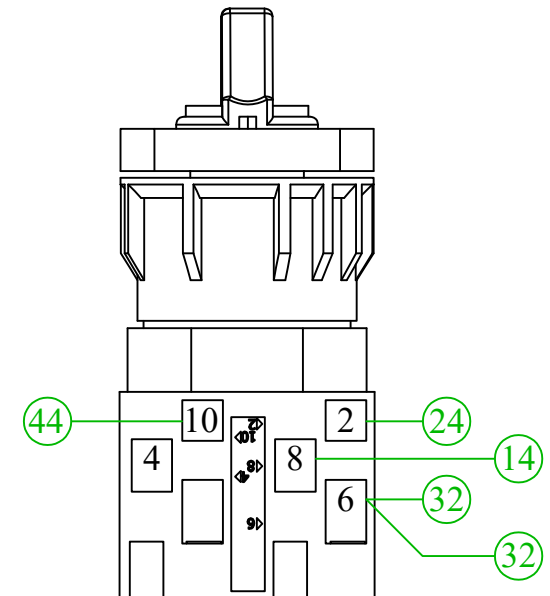
1. Turn the main power disconnect (A) to the OFF position. Open the panel door by turning the lock (B) counter-clockwise.
2. Loosen the screw (C) retaining the knob. Remove knob (D).
3. Unscrew the large nut (E) of the cam switch from the back side of the panel.
4. Remove the legend plate holder (F) from the panel.
5. Pull the switch back to allow access to the wires.
6. The switch will contain a variety of wires that have printed number labels. The locations of each wire are shown to the right.
7. Note the location of each wire and remove.



BOTTOM VIEW



TOP VIEW



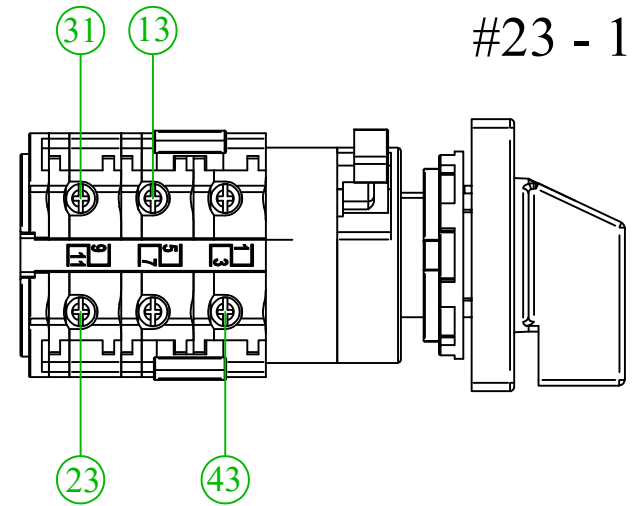


# Switch Replacement

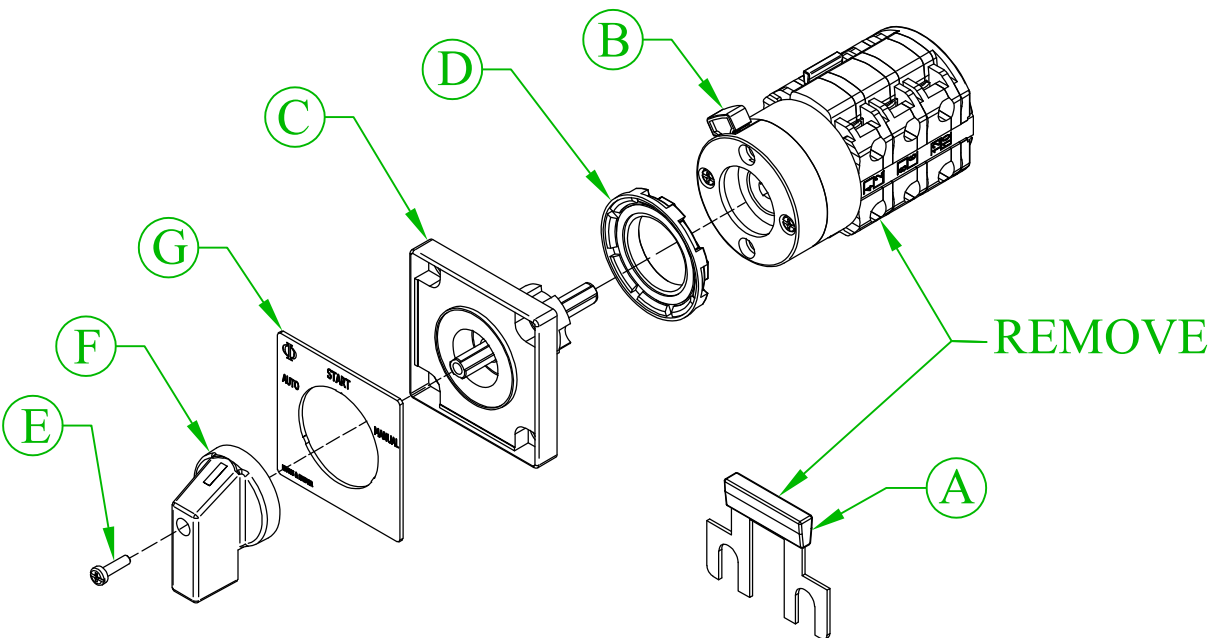
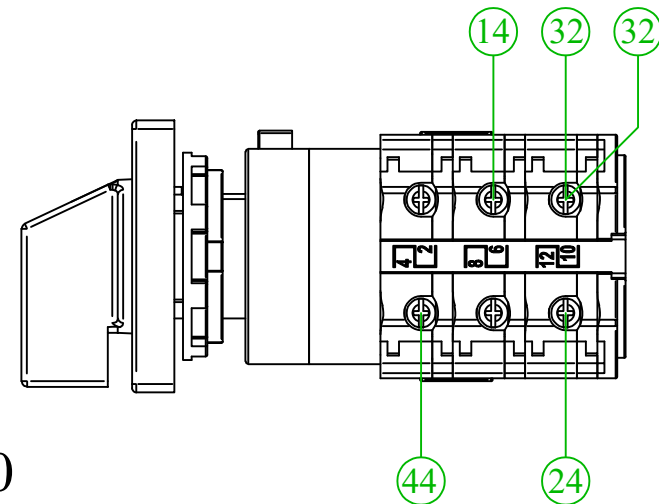
1. REMOVE ALL EXTERNAL JUMPERS (A) SUPPLIED WITH NEW SWITCH.
2. Press the red release handle (B) on the new switch to separate the knob/legend holder from the switch.
3. Install the legend holder (C) into the panel and fasten with nut (D) from backside.
4. Remove the screw (E) retaining the knob. Remove knob (F).
5. Install the legend plate (G) sold separately (P/N 011216). Re-install knob.
6. Wire the new switch as shown to the right. NOTE THE NUMBERS ON THE NEW SWITCH DO NOT CORRESPOND WITH THE OLD SWITCH.
7. Align the switch with the stem of the knob, and press the switch onto the knob assembly. The arrow on the back of the switch will be pointing upwards. When aligned, the switch will snap into place.

#43 - 3  
 #13 - 5  
 #31 - 9  
 #23 - 11

LEFT VIEW



RIGHT VIEW



#44 - 4  
 #14 - 6  
 #32 - 10  
 #24 - 12

# Retrofit Diagram

