



www.scotchman.com

P/N 011200
INSTRUCTIONS

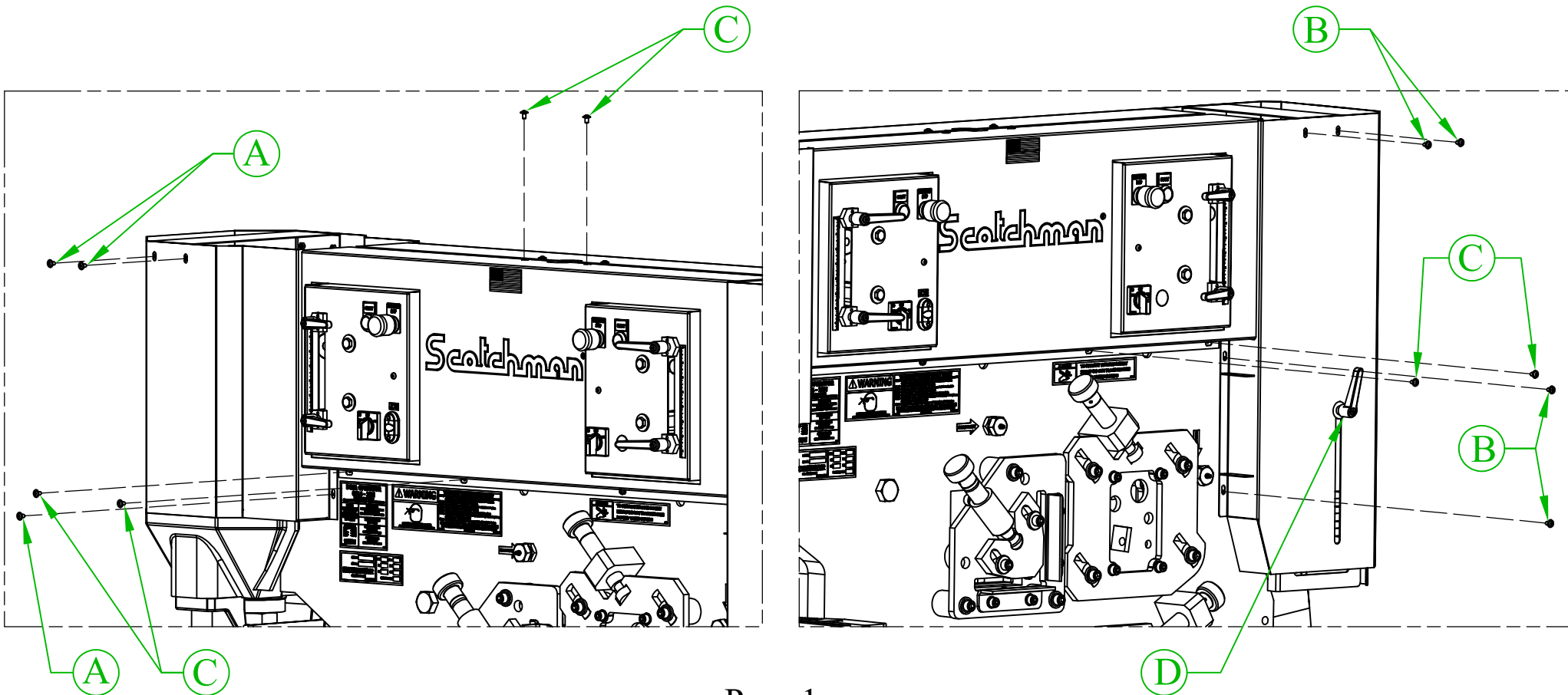
COLOR PRINTING IS RECOMMENDED
FOR DIGITAL COPY CONTACT 1-800-843-8844

DO8514-20M

FEBRUARY 2022

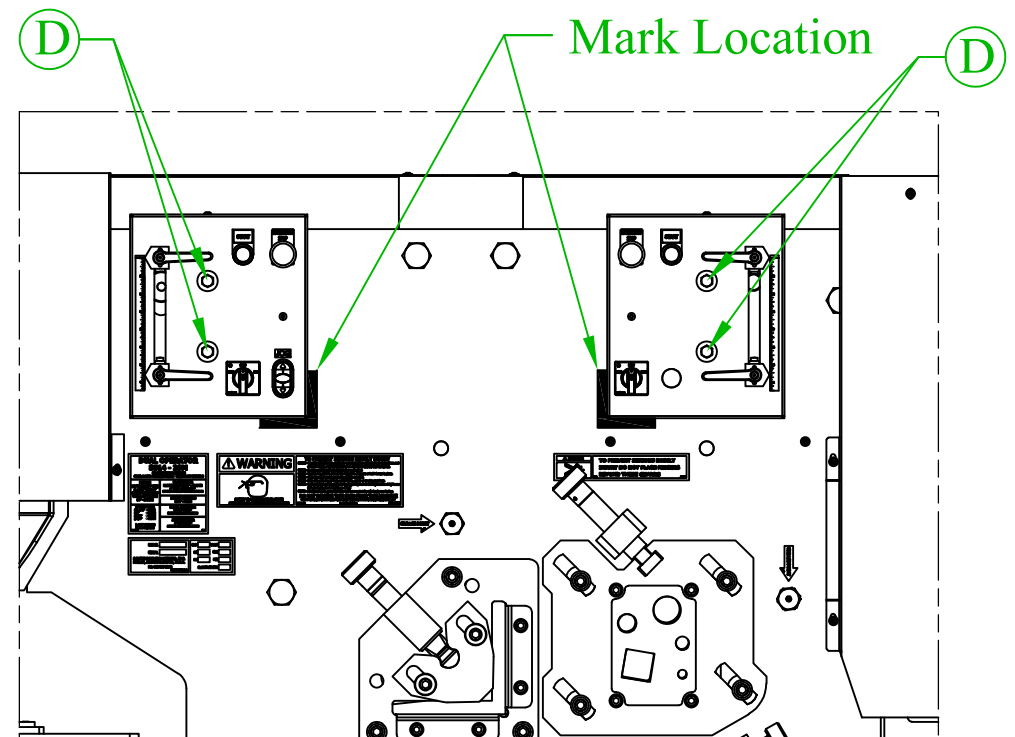
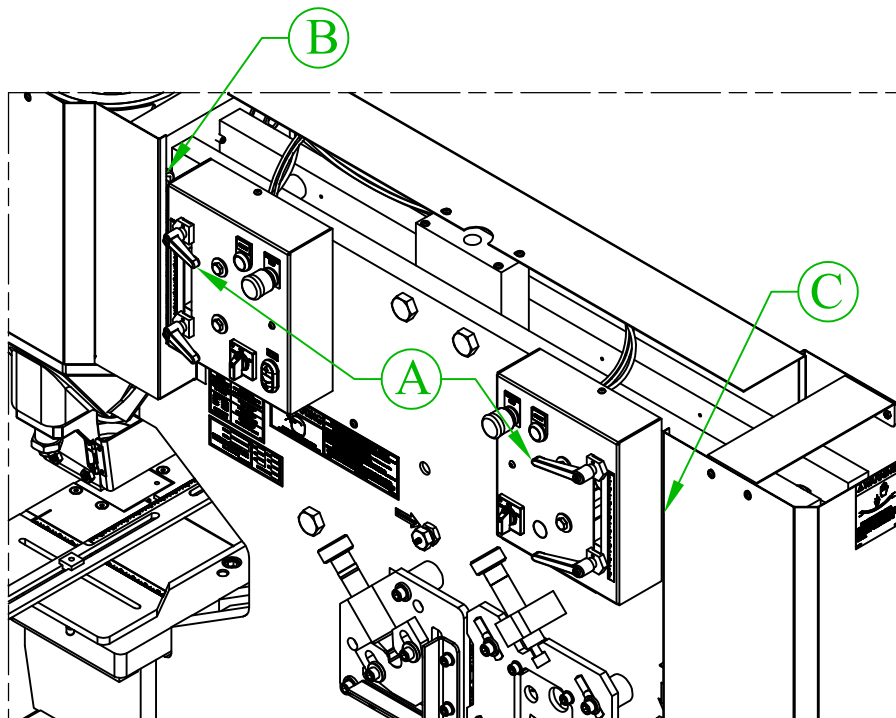
Stroke Control Removal

1. Disconnect power to the machine.
2. Remove the 13 - M6 flange screws retaining the punch cylinder shroud, notcher cylinder shroud, and center shroud on the front side of the machine.
3. The screws are located:
 - 3 - Punch cylinder shroud (A)
 - 4 - Notcher cylinder shroud (B)
 - 6 - Center shroud (C)
4. Remove the jig handle (D) and washer from the notcher guard.



Stroke Control Removal Cont.

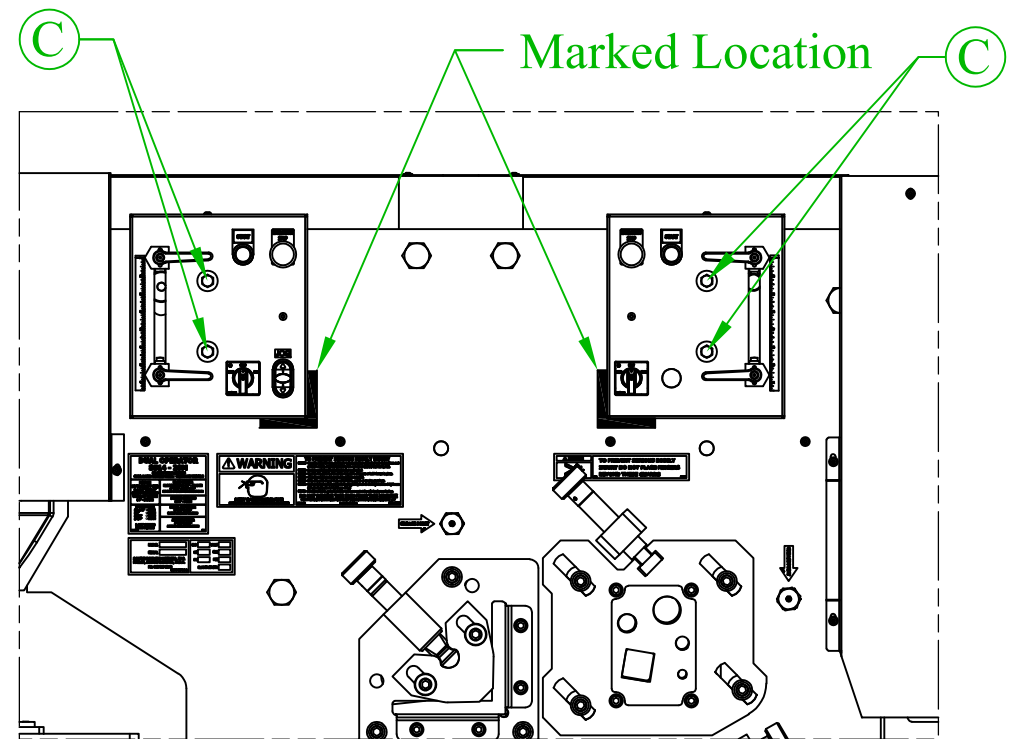
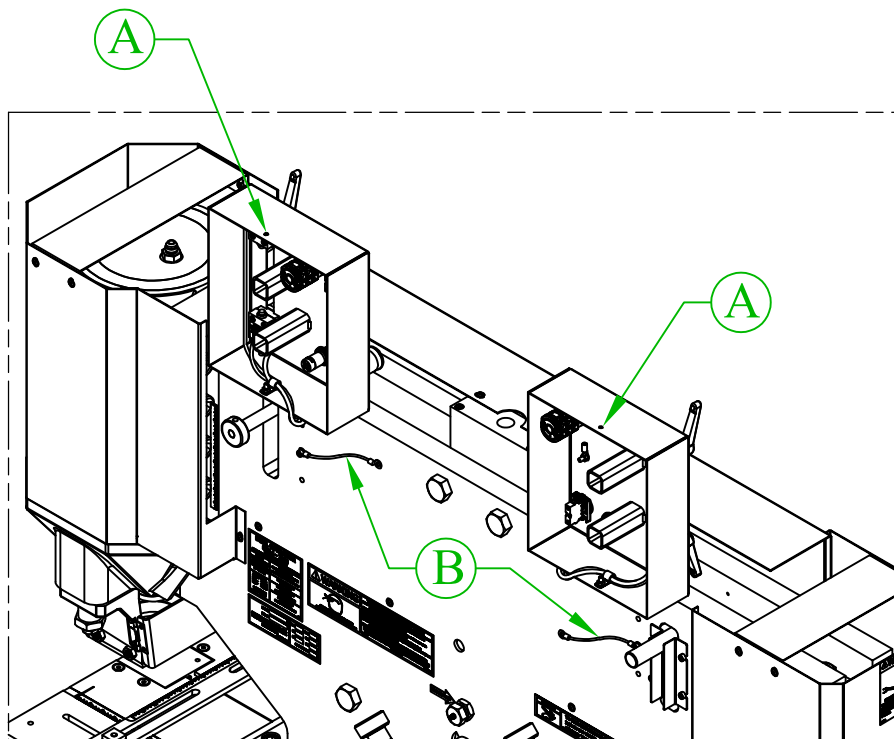
1. Turn the stroke control handles (A) inward so that they are not protruding beyond the outside of the stroke control boxes.
2. Remove the center shroud from the machine.
 - 2.1. It will be necessary to pry the punch shroud (B) and notcher shroud (C) out of the way slightly to allow room for the center shroud to be removed.
 - 2.2. It may also be necessary to loosen the M6 flange screws on the backside of the machine that retain the punch and notcher shrouds to allow for more room.
3. Once the center shroud is removed, mark the location of the stroke control box(es) to be removed with tape or a permanent marker so that it can be returned to its original location later.
4. Remove the two M10 bolts (D) retaining the stroke control(s) to the frame of the machine.



Stroke Control Removal/Replacement

1. Remove the M6 socket head bolt (A) holding the grounding wire(s) (B) to the frame of the machine to allow the stroke control(s) to be turned to a better working position.
2. Tip the stroke control(s) up on top of the machine to allow access to the controls within.
3. After the switch(s) have been replaced, replace the grounding wire(s) and orientate the stroke control(s) back into position
4. Align the stroke control(s) to the original position(s) previously marked, and tighten the two M10 bolts (C) to retain the stroke control(s).
5. Restore power to the machine and test operation.

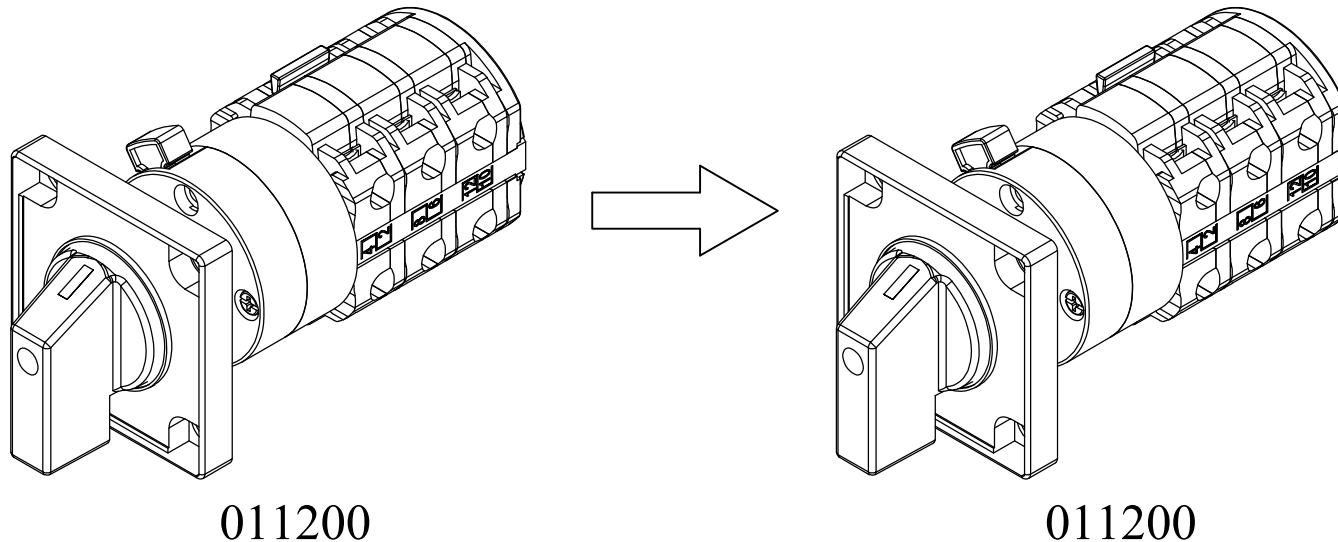
See the remaining pages for switch replacement instructions specific for each application.



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 8. Please follow the instructions specific to the switch being replaced.

DISCONNECT POWER TO THE MACHINE BEFORE MODIFICATION.

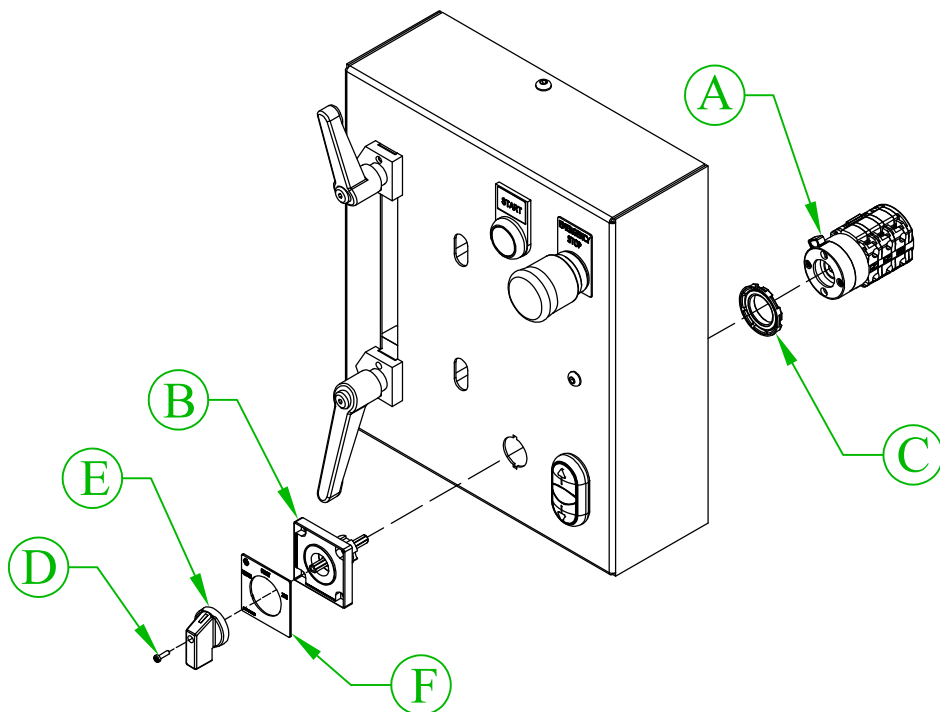


Applies to Serial Numbers:
DO8514: 1259M & After

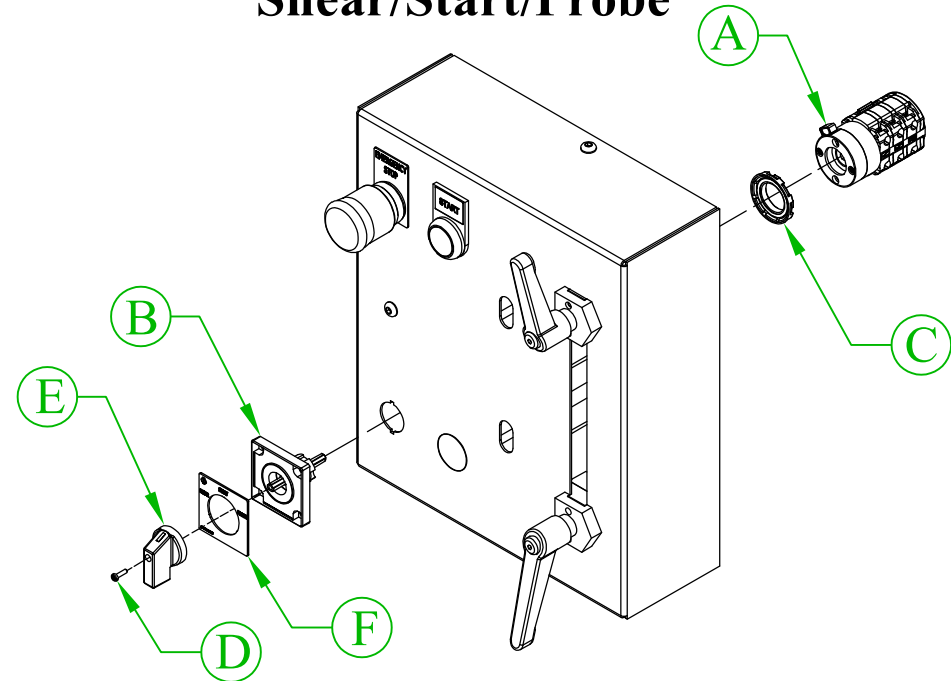
Switch Removal

1. Press the red release handle (A) of the switch to be replaced and disconnect the switch from the legend holder assembly (B).
2. Carefully pull the switch back to allow access to the legend holder assembly from the rear.
3. Remove the old legend holder assembly from the panel by unscrewing the nut (C) from the backside.
4. Install new legend holder assembly by reversing previous instructions.
5. Remove the screw (D) retaining the knob. Remove knob (E).
6. Install the legend plate (F) sold separately (P/N 011214 or 011215). Re-install knob.
7. The switch will contain a variety of 18ga black wires that have printed number labels, and some that do not. The locations of each wire are shown on the following page.
8. Note the location of each wire and remove.

Punch/Start/Jog



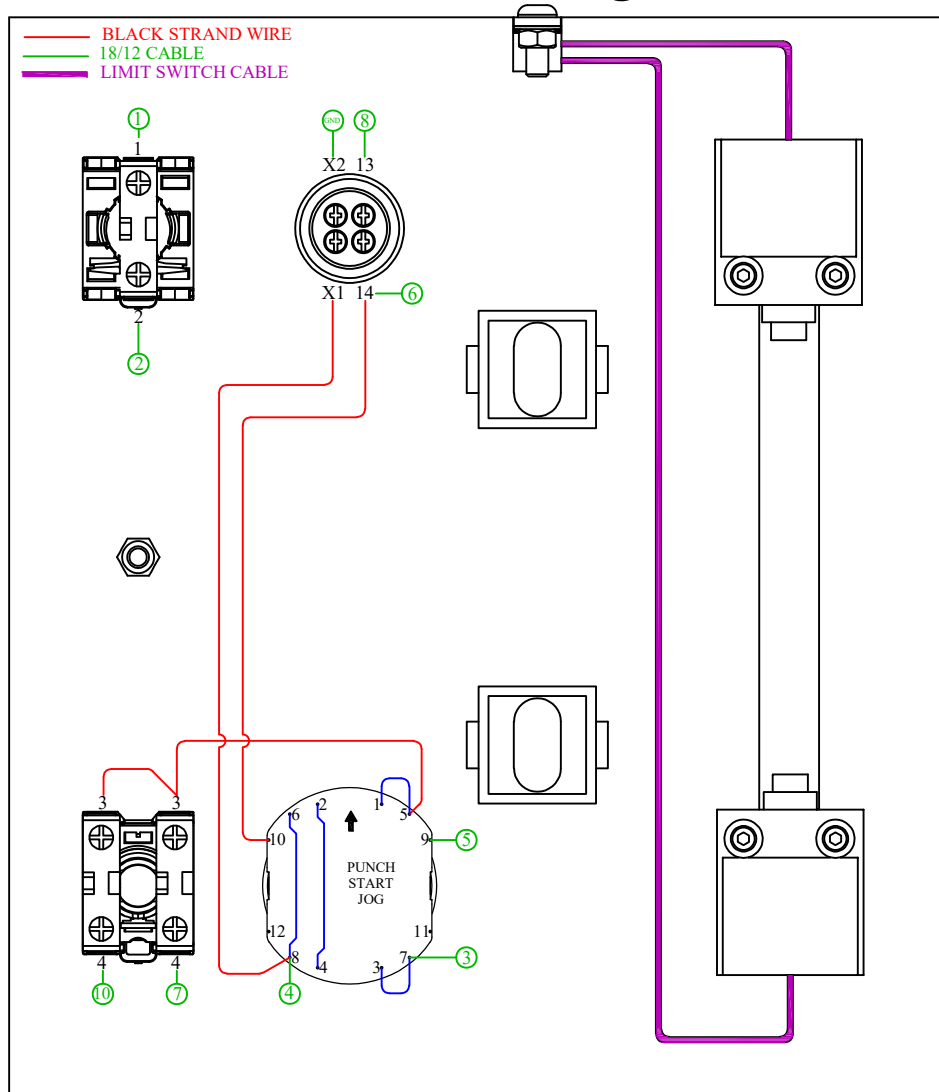
Shear/Start/Probe



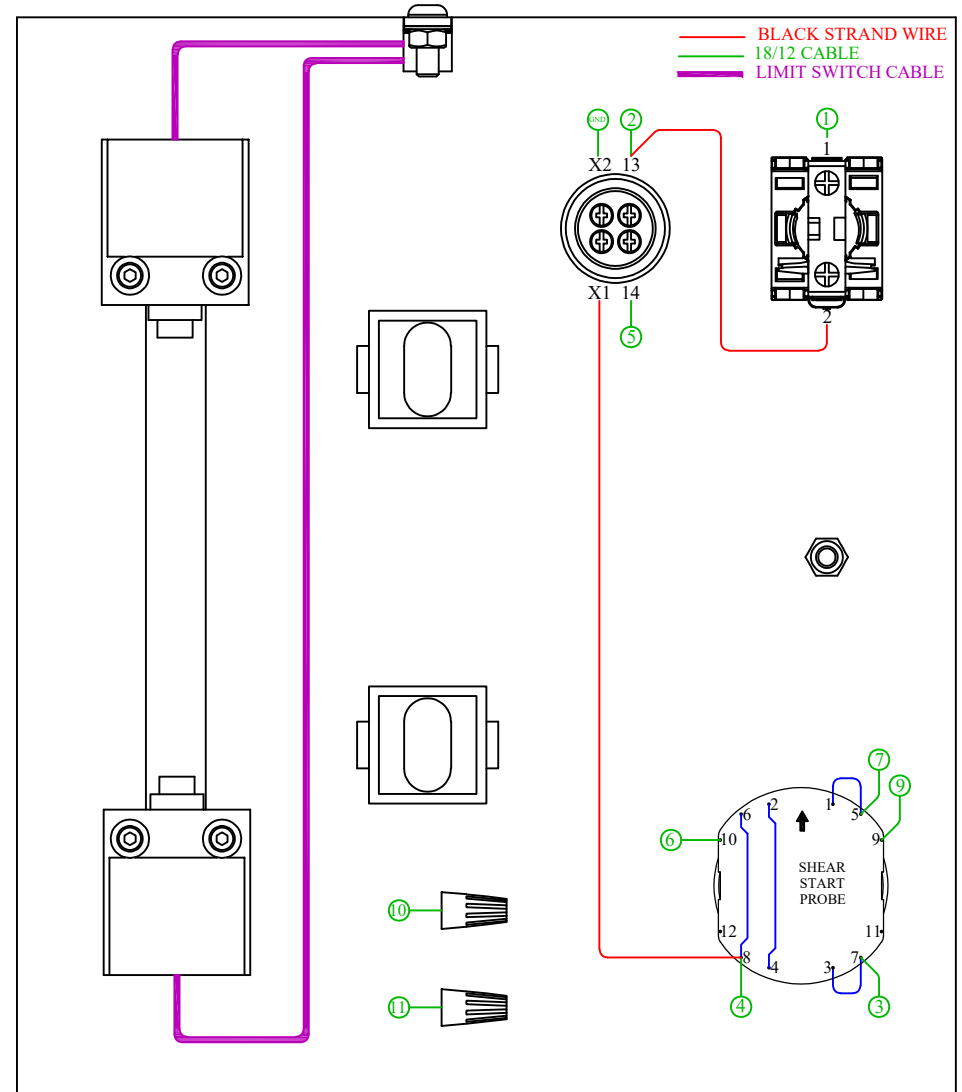
Switch Replacement

1. Wire the new switch(s) as shown below.
2. **Red** indicates jumper wires that do not have labels. Circled **Green** numbers indicate a labeled wire that goes to the lower control panel.
3. Once finished wiring, 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.

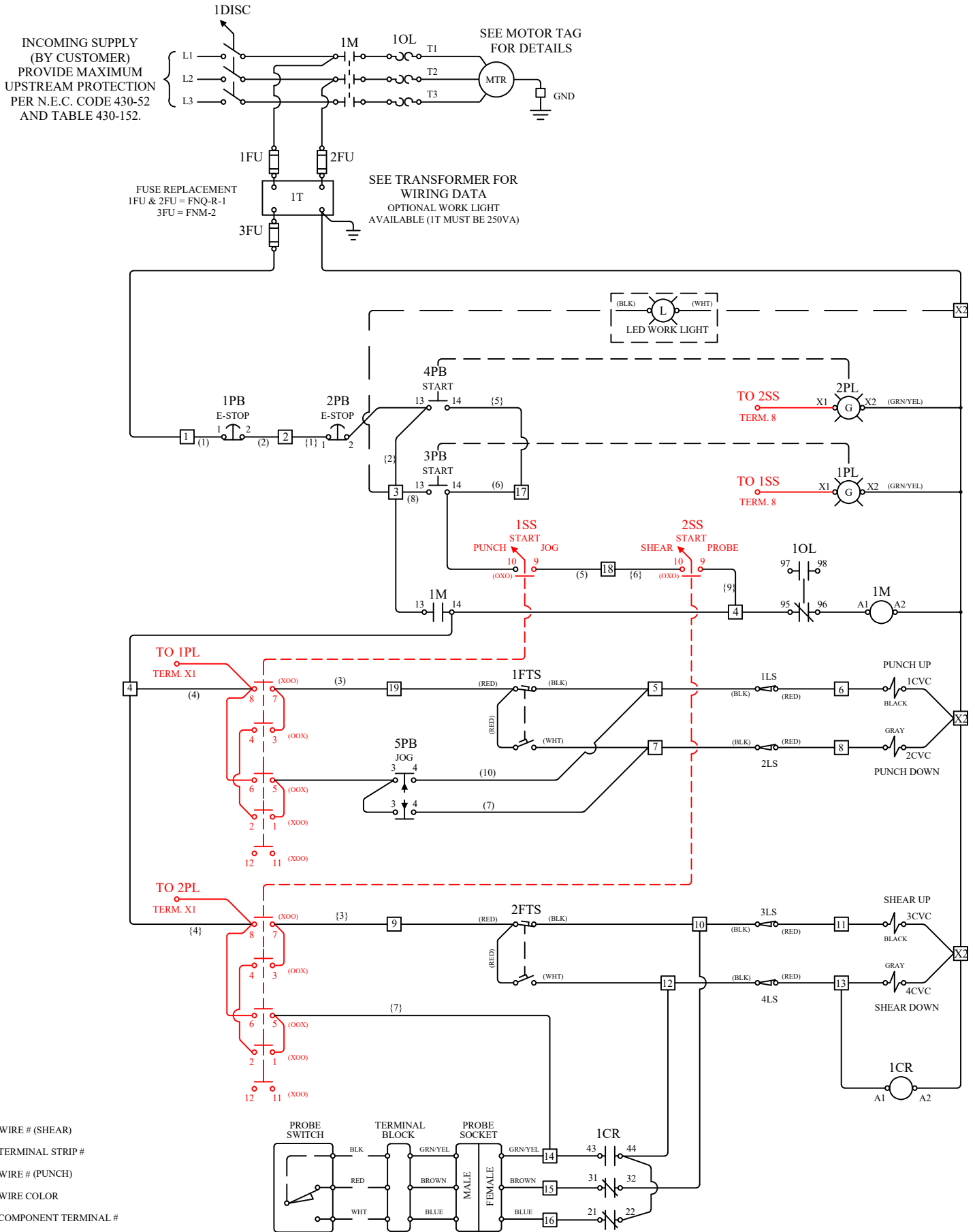
Punch/Start/Jog



Shear/Start/Probe



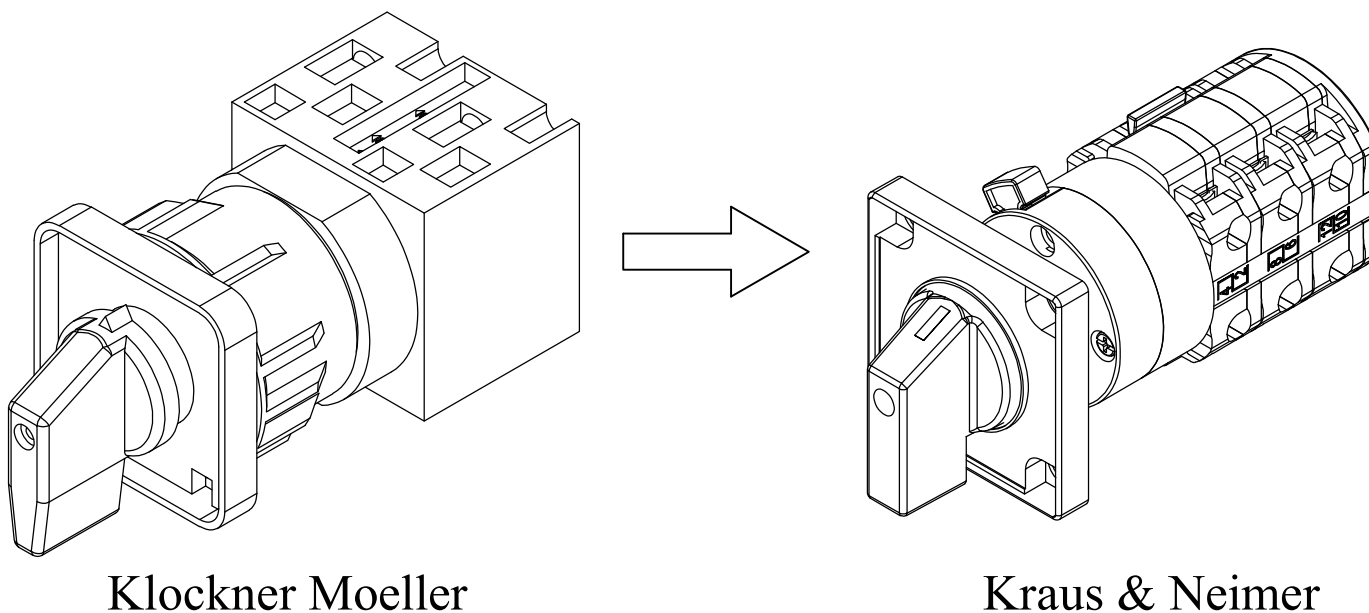
Wiring Diagram



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. Please follow the instructions specific to the switch being replaced.

DISCONNECT POWER TO THE MACHINE BEFORE MODIFICATION.



Applies to Serial Numbers:
DO8514: 1258M1021 & Prior

Switch Differences

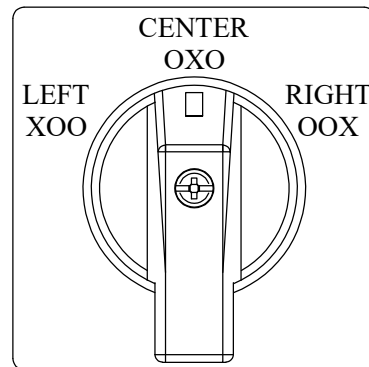
The key difference between the Klockner Moeller switches (011868) and the Kraus & Neimer switches (011200) are the contact numbers and internal jumpers.

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

KLOCKNER MOELLER

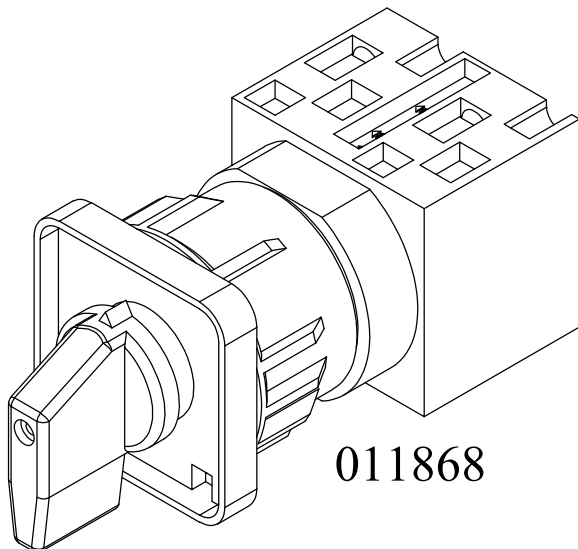
CONTACT	CLOSURE
1 - 2	XOO
3 - 4	XOO
5 - 6	OXO
7 - 8	OOX
9 - 10	OOX
11 - 12	N/A
REMOVABLE JUMPERS	1 - 7
	2 - 10
	3 - 9
	4 - 8

CLOSURES

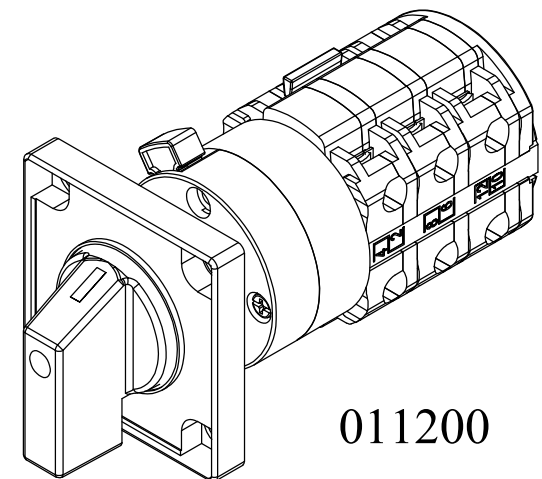


KRAUS & NEIMER

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



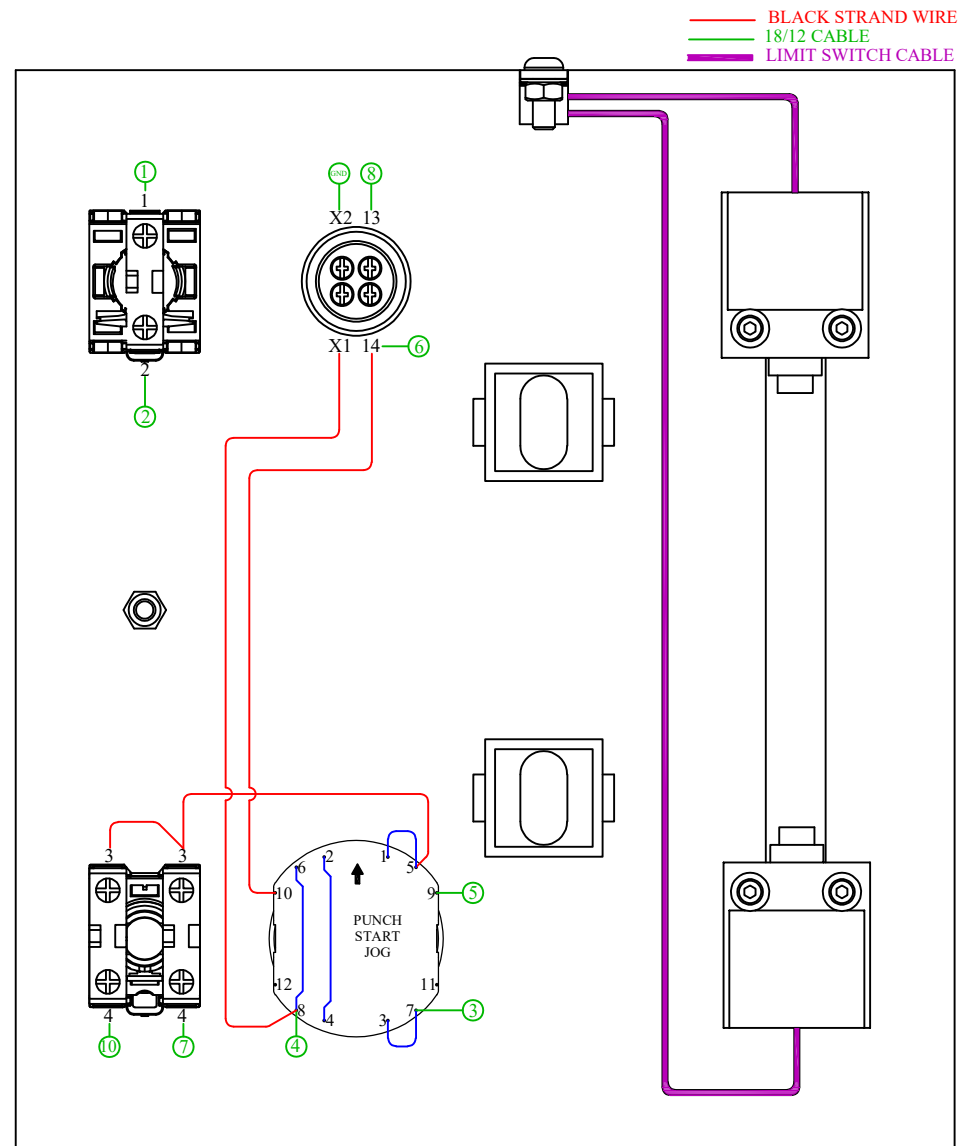
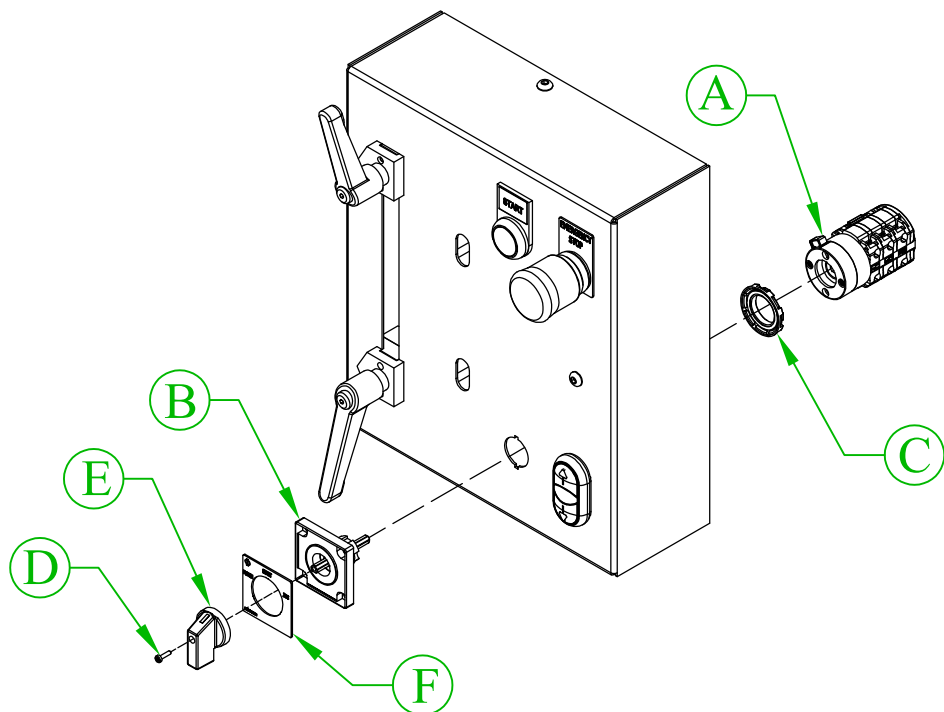
011868



011200

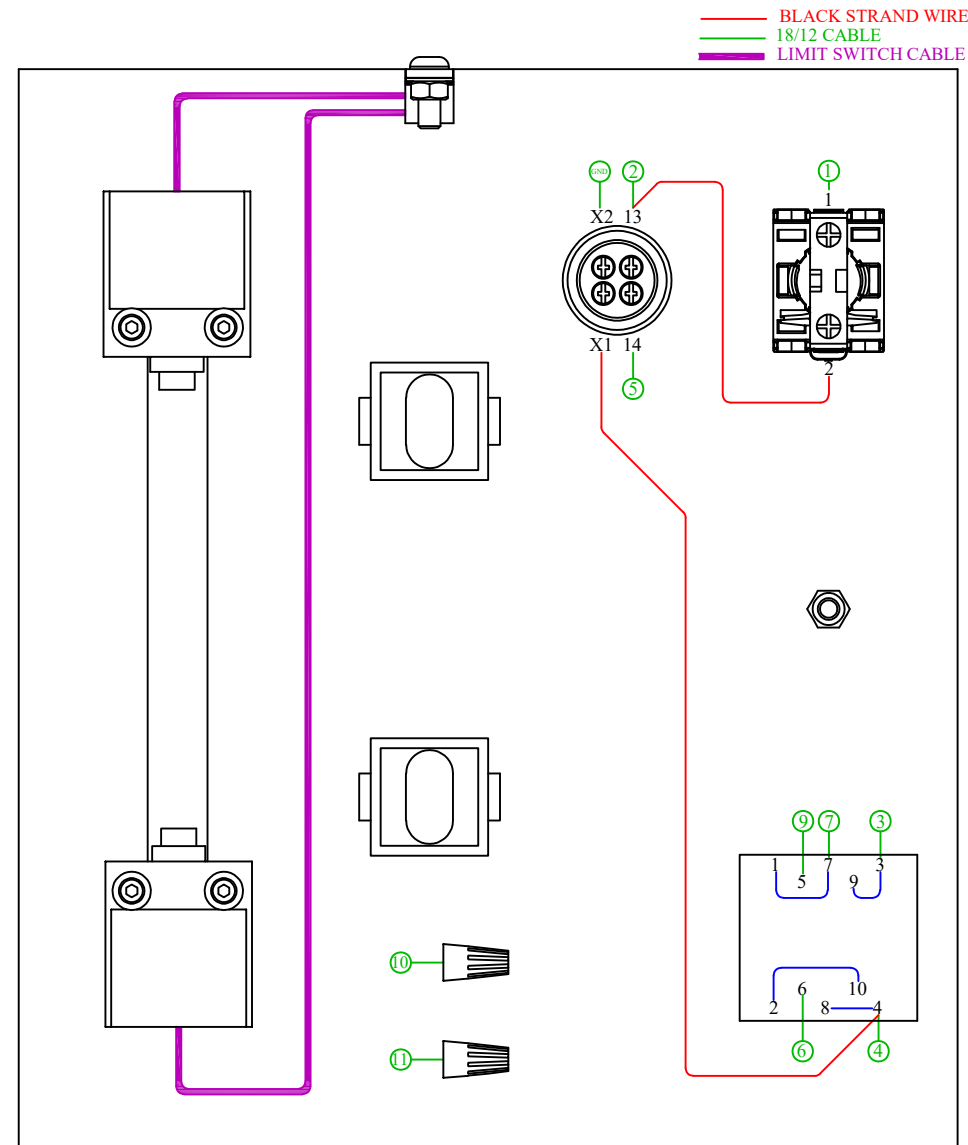
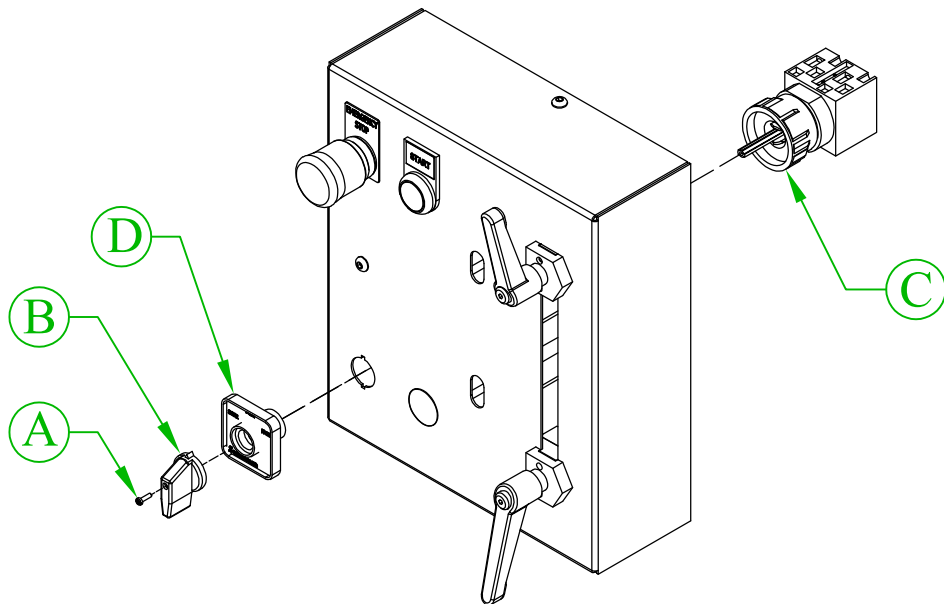
Punch/Start/Jog Switch Retrofit

1. Press the red release handle (A) on the new switch to separate the knob/legend holder from the switch.
2. Install the legend holder (B) into stroke control and fasten with nut (C) from backside.
3. Remove the screw (D) retaining the knob. Remove knob (E).
4. Install the legend plate (F) sold separately (P/N 011214). Re-install knob.
5. Wire the new switch as shown to the right. NOTE: THE NUMBERS ON THE NEW SWITCH DO NOT CORRESPOND WITH THE OLD SWITCH.
6. 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.



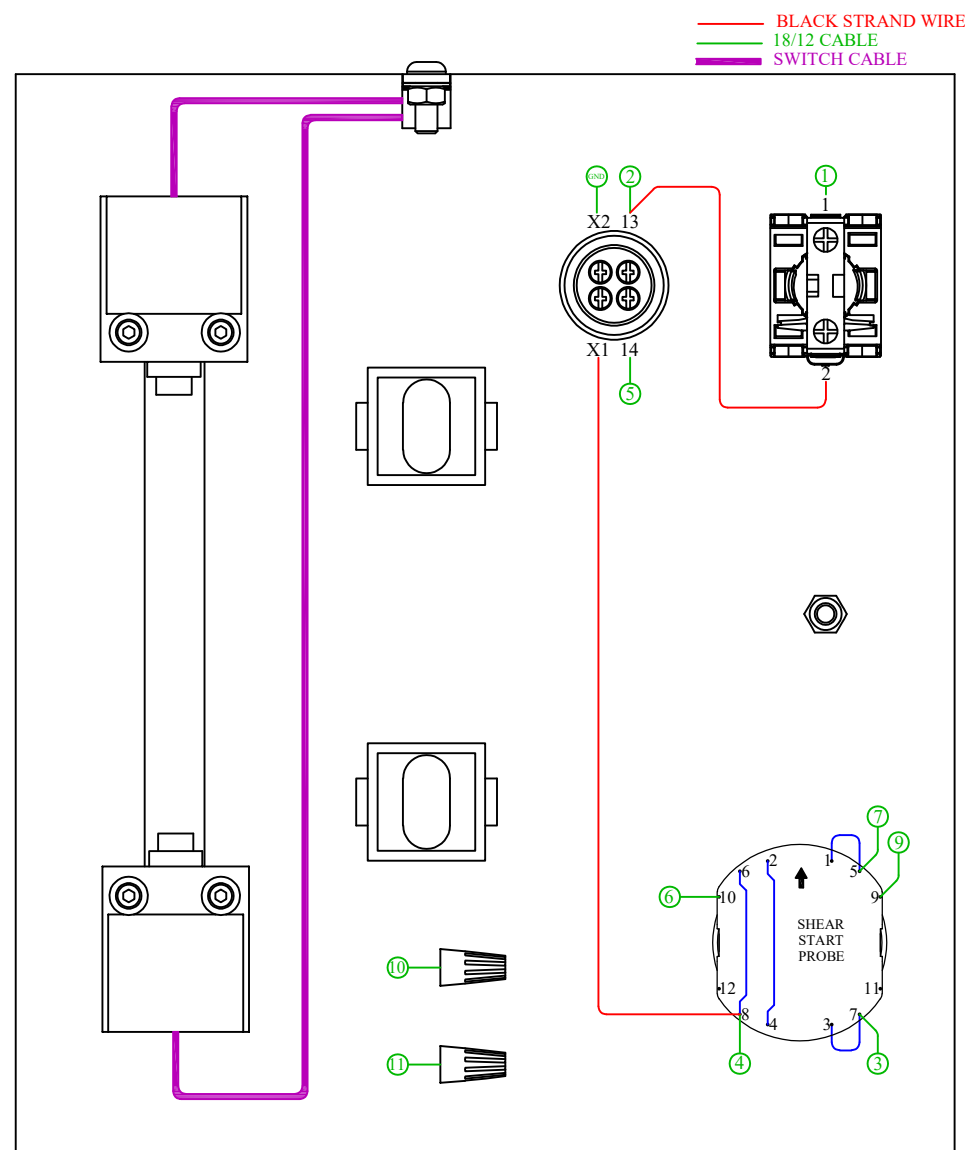
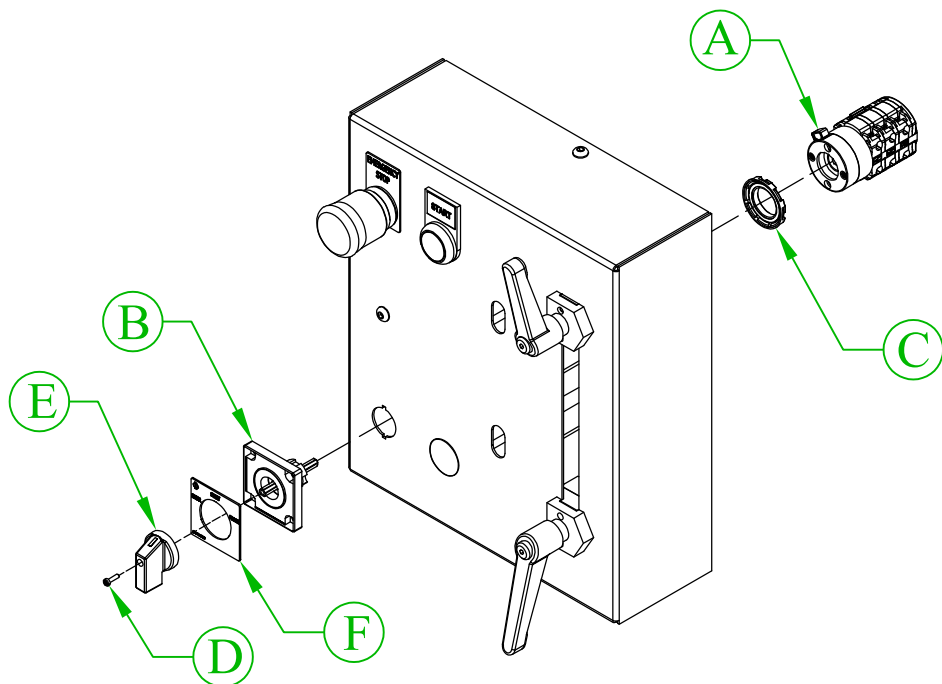
Shear/Start/Probe Switch Removal

1. Loosen the screw (A) retaining the knob. Remove knob (B).
2. Unscrew the large nut (C) of the cam switch from the back side of the panel.
3. Remove the legend plate holder (D) from the panel.
4. Carefully pull the switch back to allow access to the wires.
5. The switch will contain a variety of 18ga black wires that have printed number labels, and some that do not. The locations of each wire are shown to the right. **Red** indicates jumper wires that do not have labels. Circled **Green** numbers indicate a labeled wire that goes to the lower control panel.
6. Note the location of each wire and remove.

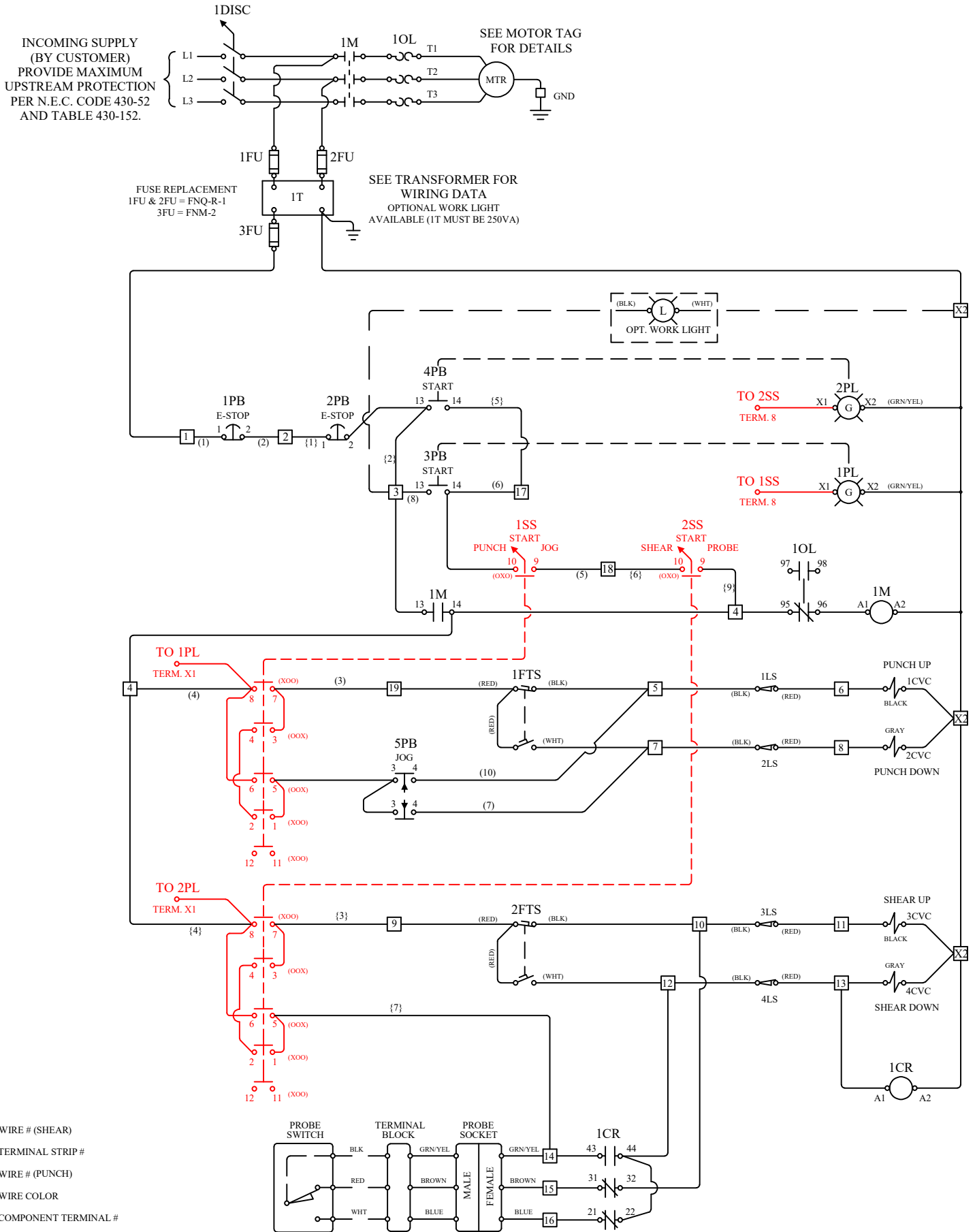


Shear/Start/Probe Switch Retrofit

1. Press the red release handle (A) on the new switch to separate the knob/legend holder from the switch.
2. Install the legend holder (B) into stroke control and fasten with nut (C) from backside.
3. Remove the screw (D) retaining the knob. Remove knob (E).
4. Install the legend plate (F) sold separately (P/N 011215). Re-install knob.
5. Wire the new switch as shown to the right. NOTE: THE NUMBERS ON THE NEW SWITCH DO NOT CORRESPOND WITH THE OLD SWITCH.
6. 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.

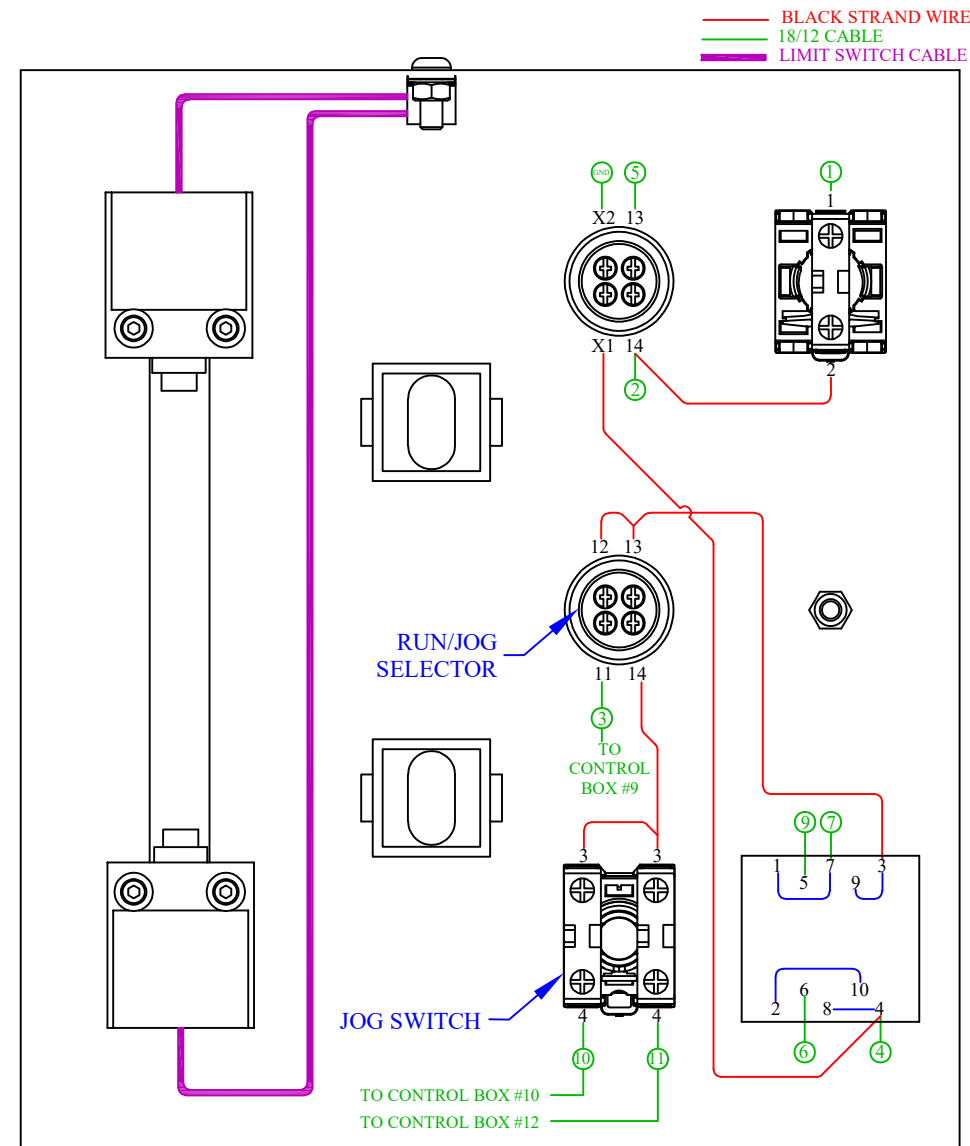
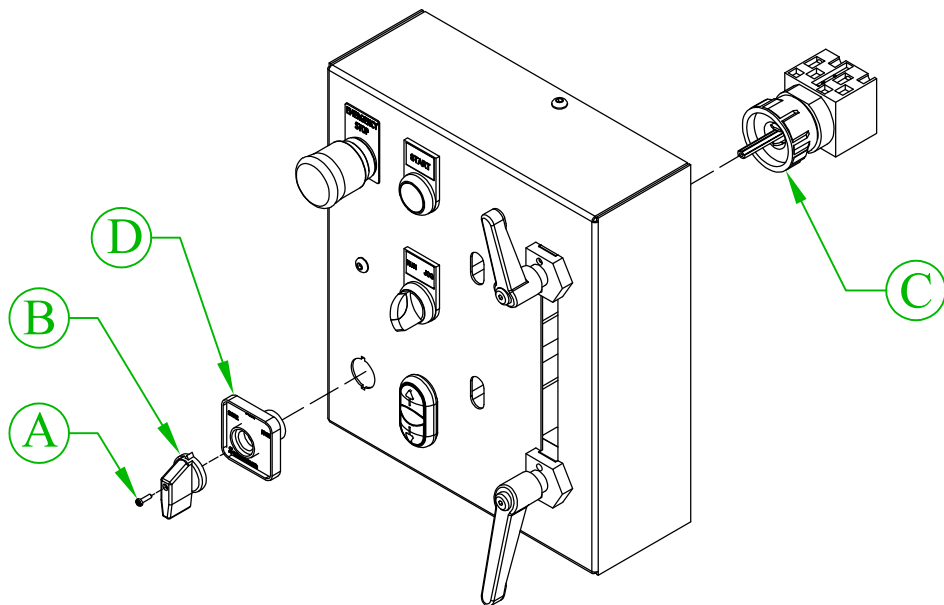


Retrofit Both Switches Diagram



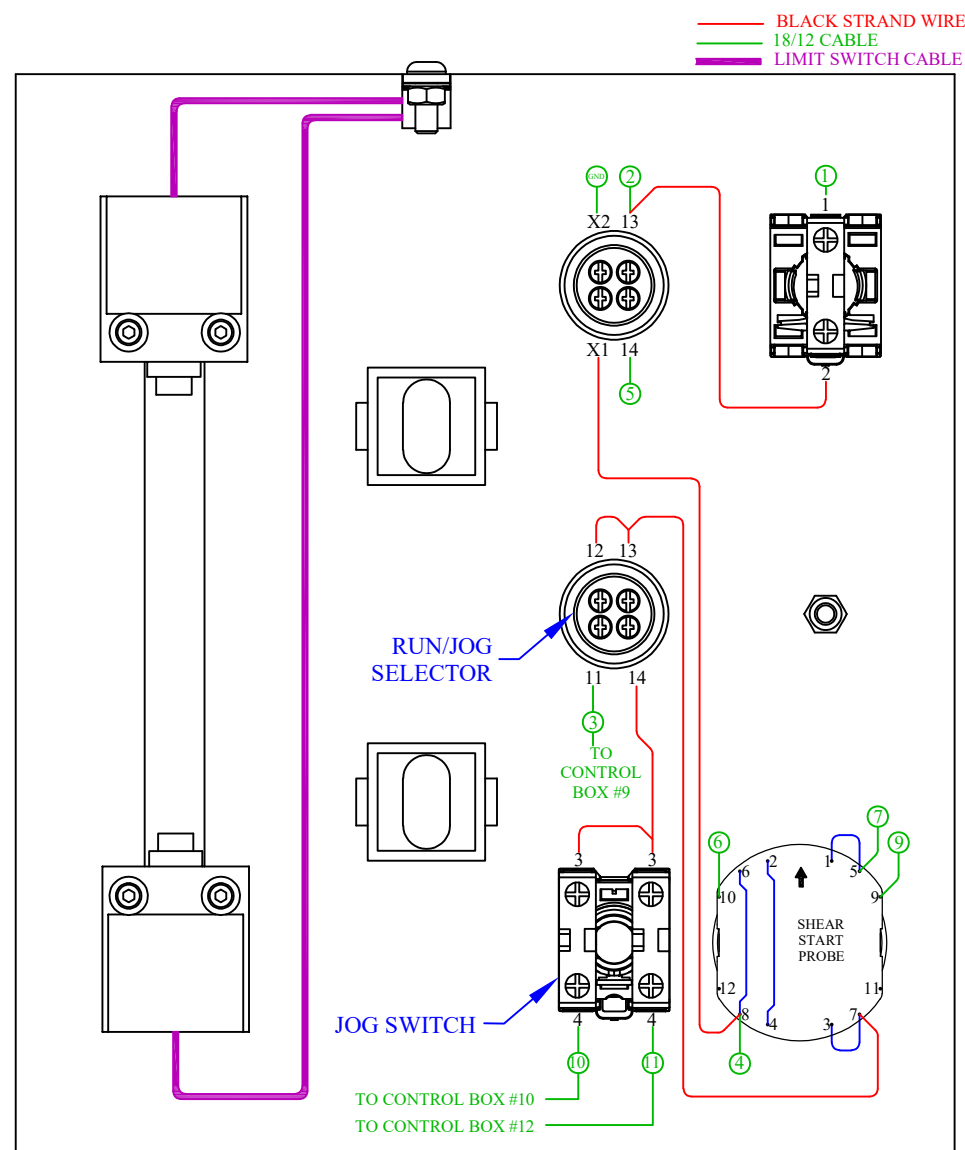
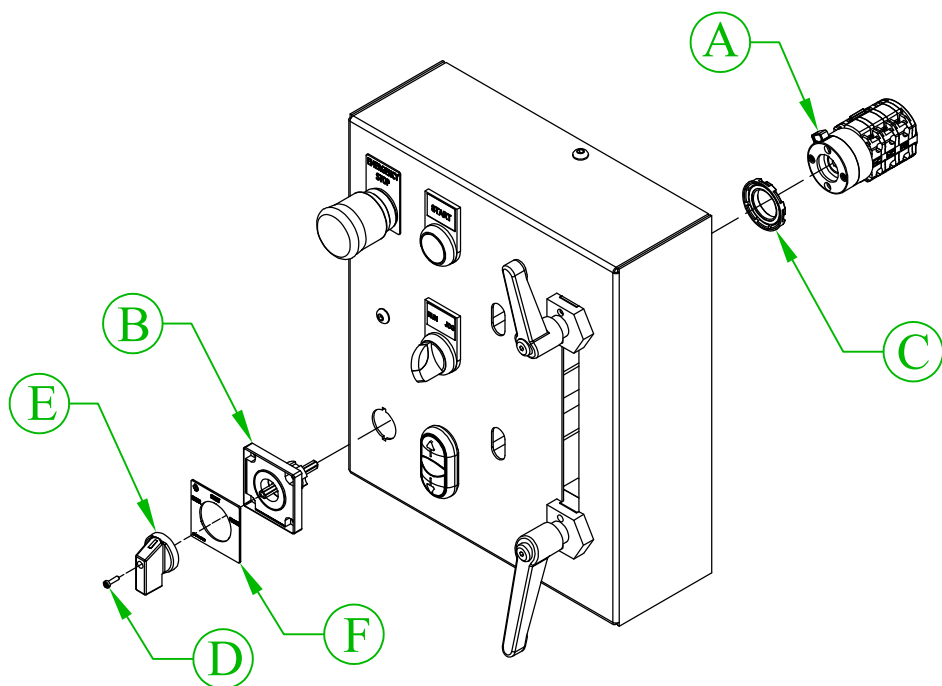
Shear/Start/Probe Switch w/ Jog Removal

1. If the machine is fitted with an optional jog control for the notch station, see the following instructions.
2. Loosen the screw (A) retaining the knob. Remove knob (B).
3. Unscrew the large nut (C) of the cam switch from the back side of the panel.
4. Remove the legend plate holder (D) from the panel.
5. Carefully pull the switch back to allow access to the wires.
6. The switch will contain a variety of 18ga black wires that have printed number labels, and some that do not. The locations of each wire are shown to the right. **Red** indicates jumper wires that do not have labels. **Circled Green** numbers indicate a labeled wire that goes to the lower control panel.
7. Note the location of each wire and remove.



Shear/Start/Probe Switch w/ Jog Retrofit

1. Press the red release handle (A) on the new switch to separate the knob/legend holder from the switch.
2. Install the legend holder (B) into stroke control and fasten with nut (C) from backside.
3. Remove the screw (D) retaining the knob. Remove knob (E).
4. Install the legend plate (F) sold separately (P/N 011215). Re-install knob.
5. Wire the new switch as shown to the right. NOTE: THE NUMBERS ON THE NEW SWITCH DO NOT CORRESPOND WITH THE OLD SWITCH.
6. 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.



Retrofit Both Switches Diagram w/ Shear Jog

