

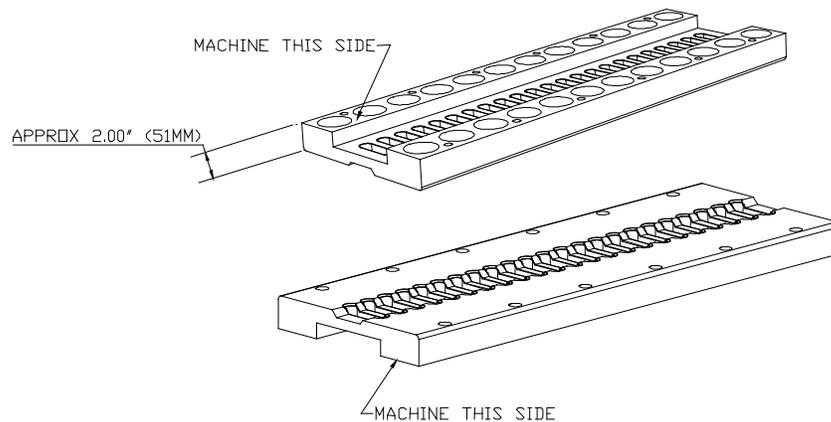
Behlen Mfg. Co.

Stitch Height Control



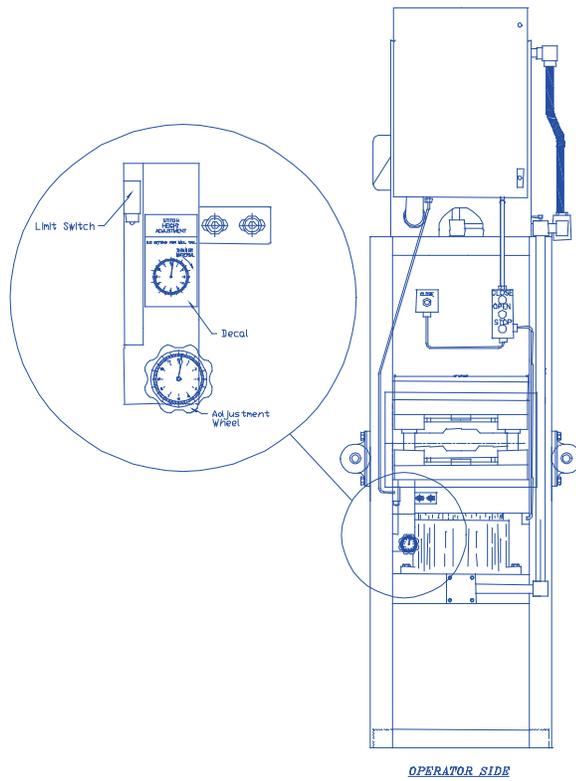
INSTRUCTIONS FOR MOUNTING AND OPERATING STITCH DEPTH GAUGE UNIT

1. Remove die from joiner press and separate into two halves. Remove both stripper plates, loosen urethane stripper plugs and remove them from stripper plates. Machine underside of both plates to a thickness of approximately 2.000" (51mm) as shown below. Re-glue urethane plugs in original holes (this is for ease of assembly of stripper plates to die) and assemble two halves of die. This procedure is required for all dies that have stripper plates greater than 2" (51mm) when used in a joiner with stitch depth gauge.

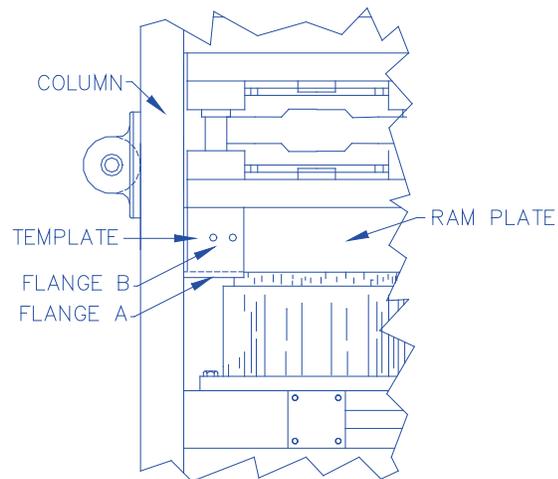


2. Die should now be installed back into joiner.

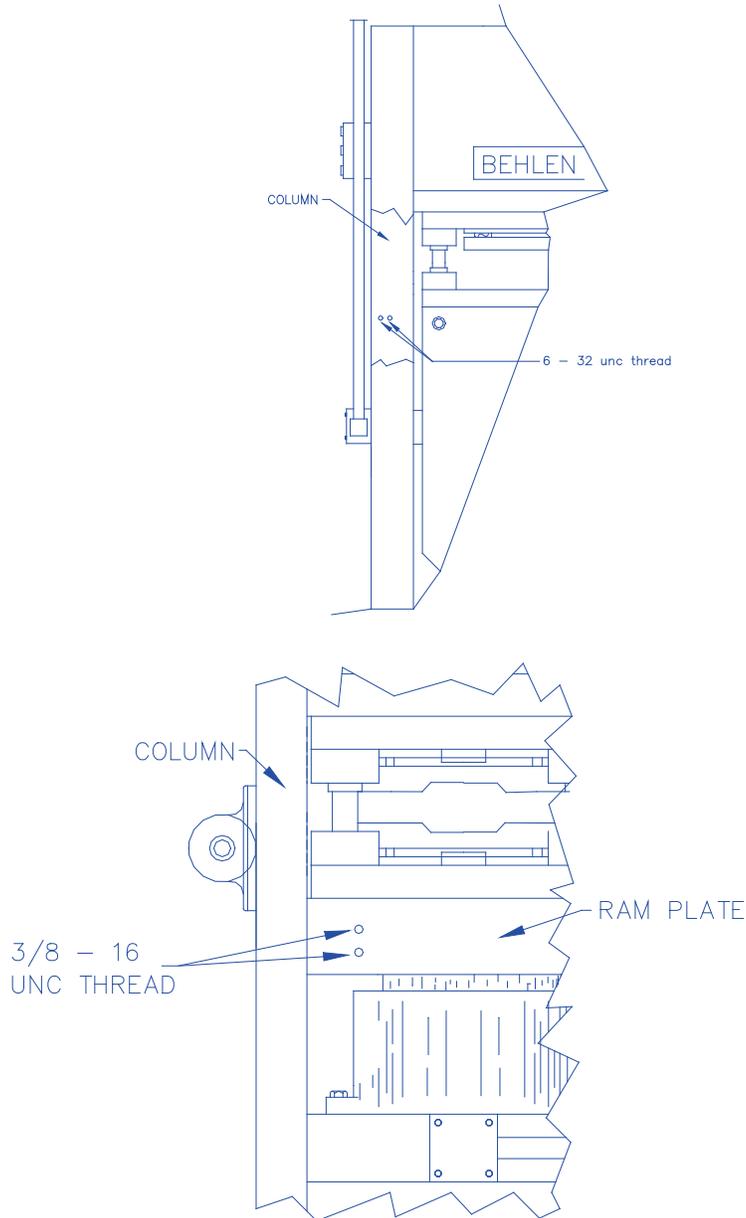
3. The depth gauge unit will be mounted on the Operator end of the joiner and on the left side as viewed from Operator end.



4. Using the jig furnished with the stitch depth gauge unit, position flange "A" up against under side of the ram plate and flange "B" against the left corner post. The marks "A" and "B" are stamped on the metal jig. After the four mounting hole locations are transferred, the jig is no longer needed.

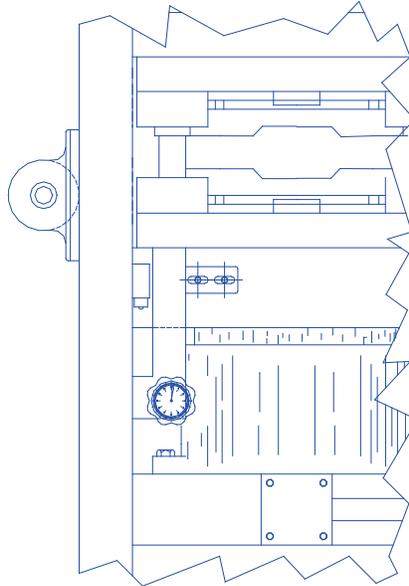


5. Drill two holes on the column 1”(25.4mm) deep using a #36(2.7mm) drill. Tap these holes 6-32 UNC thread. Drill 2 holes on the ram plate 1”(25.4mm) deep using a 5/16”(8mm) drill. Tap these holes 3/8-16 UNC thread.

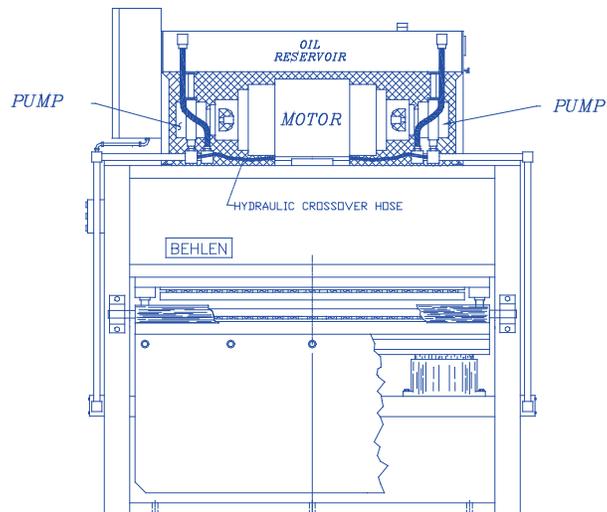


6. Using tapped holes from step 5, attach limit switch to the column using (2) 6-32 screws provided. Mount limit switch with open end facing toward outside of machine and the actuation plunger pointing down. Wiring from the pressure switch must now be removed and routed to the depth limit switch. Connect the limit switch as shown in the wiring schematic (page 8). Remove and discard the old pressure switch.

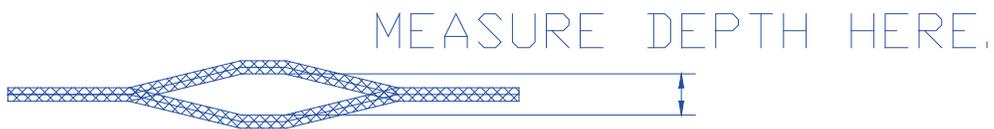
7. The depth gauge unit may now be fastened to the vertical face of the ram plate. Using holes tapped in step 5, attach gauge box to the ram plate using 3/8-16 bolts provided. Do not fully tighten. Adjust box so that the edge of box is 1/16”(2mm) away from column and parallel to column. If jack plate rubs against column, move box farther away from column. Two longer 3/8-16 bolts and a spacer are included and should be used to make the gauge box clear the hydraulic cylinder body if necessary. When the gauge box is positioned correctly, fully tighten bolts.



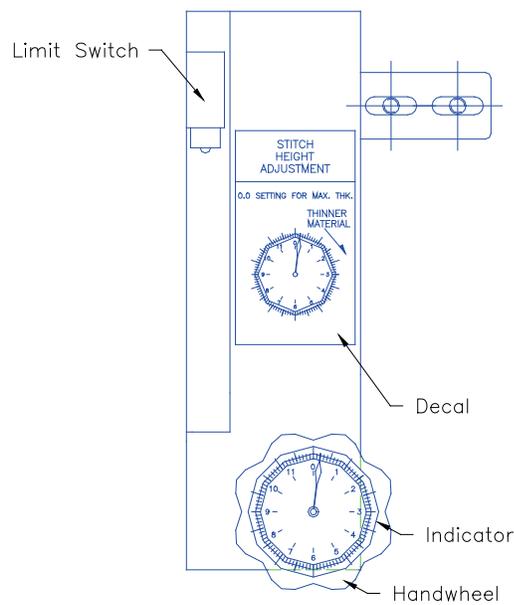
8. The hydraulic crossover hose and two T's should be installed between the relief valves and the elbow behind the valves as shown.

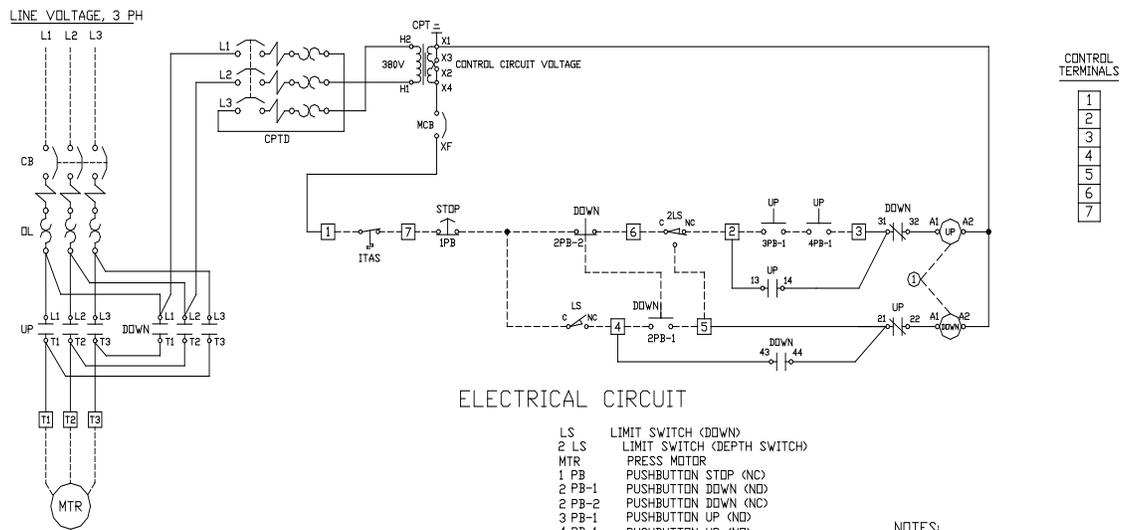


9. The depth gauge unit may now be adjusted. Start by turning the adjusting wheel counter-clockwise to the lowest position, and then turn the wheel clockwise approximately 20 turns. Now cycle the joiner and stitch actual material. Final adjustment of your stitch depth can be made by turning the wheel either clockwise (decrease opening) or counter-clockwise (increase opening) until a vertical stitch opening of approximately 0.080" (2mm) is reached. Each revolution of the wheel changes the stitch opening by 0.025" (0.64mm). If you intend to insert a needle (steel strap) into the stitch opening you will need to adjust your stitch depth to suit your needle size.



10. When a proper stitch is accomplished, loosen (do not remove) the four setscrews on the indicator. Remove indicator from handwheel. Turn indicator until it reads, “shut”. Both the black and red pointers should be indicating 0.0. Place the indicator in the handwheel with 0.0 in the 12 o’clock position. Tighten setscrews. Once the depth switch is set, it should not normally need to be changed for different material thickness being joined.





ELECTRICAL CIRCUIT

- LS LIMIT SWITCH (DOWN)
- 2 LS LIMIT SWITCH (DEPTH SWITCH)
- MTR PRESS MOTOR
- 1 PB PUSHBUTTON STOP (NC)
- 2 PB-1 PUSHBUTTON DOWN (ND)
- 2 PB-2 PUSHBUTTON DOWN (NC)
- 3 PB-1 PUSHBUTTON UP (ND)
- 4 PB-1 PUSHBUTTON UP (ND)
- 1 TAS OVERLOAD SWITCH WOUND IN 1 MTR

- NOTES:
1. MECHANICAL INTERLOCK PROVIDED.
 2. MUST STOP BEFORE CHANGING DIRECTION.
 3. LS HAS ADDITIONAL CONTACTS (2 NO & 1 NC) THAT MAY BE USED FOR INTERLOCKING.