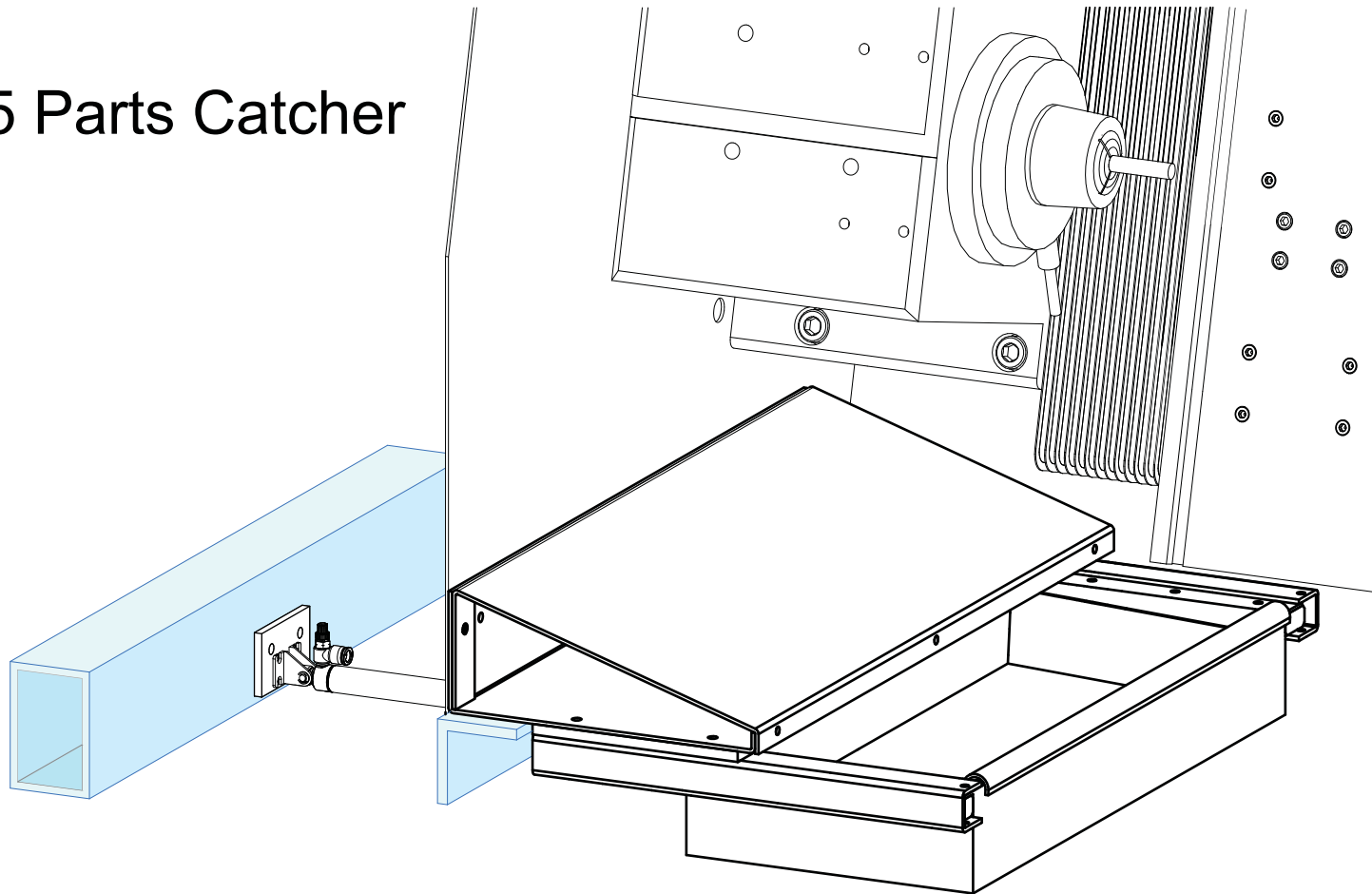
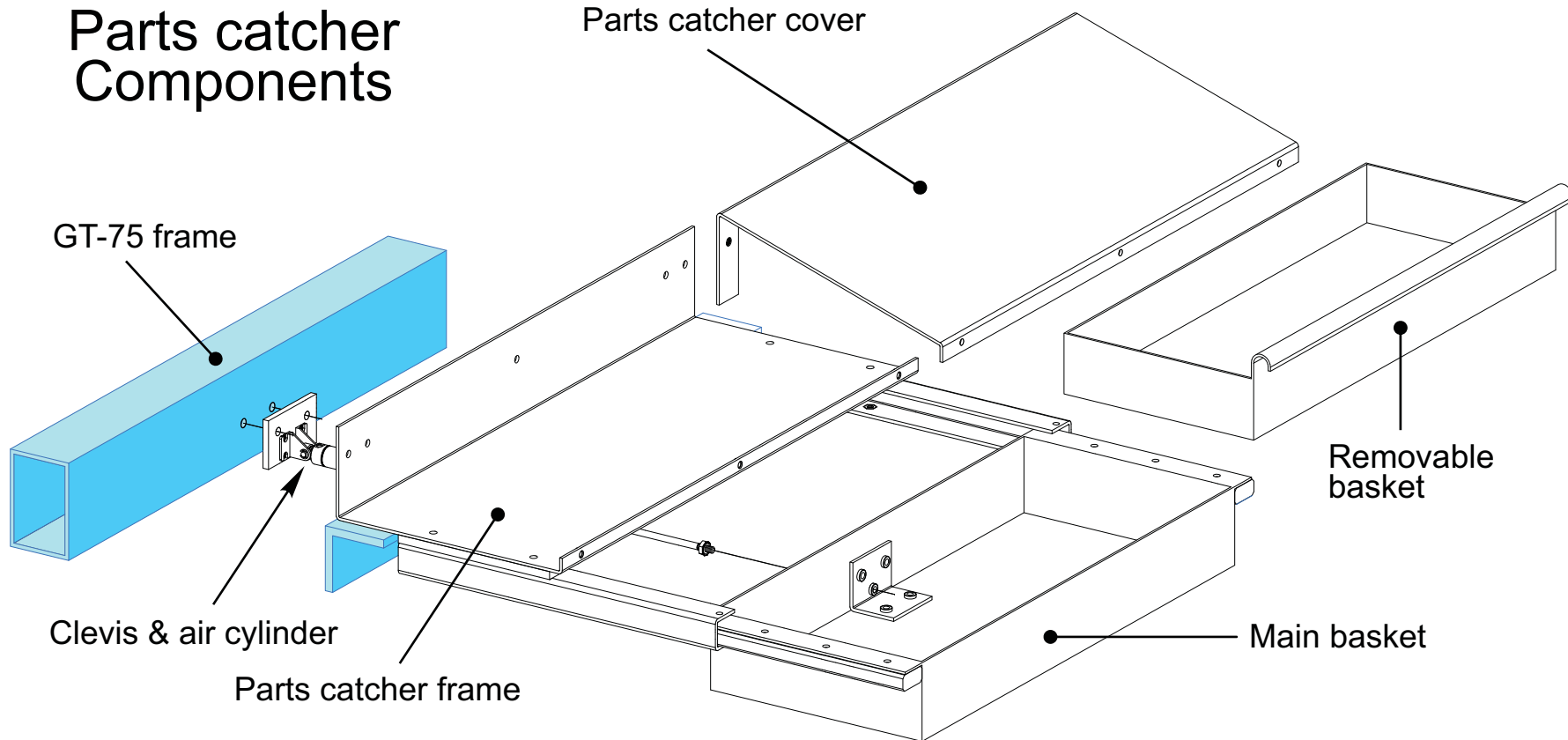


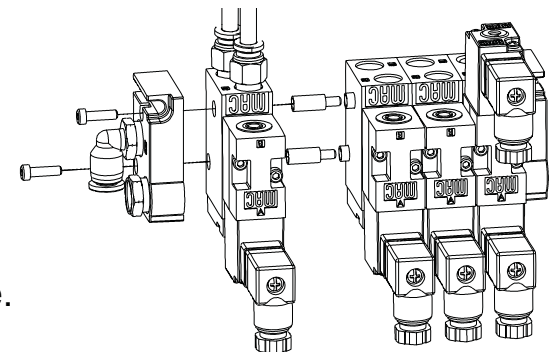
GT-75 Parts Catcher





TO ADD AIR-VALVE TO AIR-PACK:

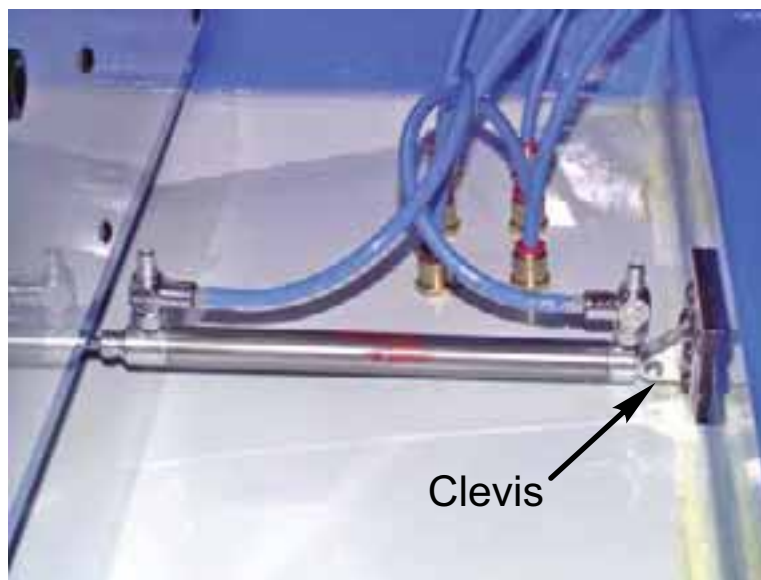
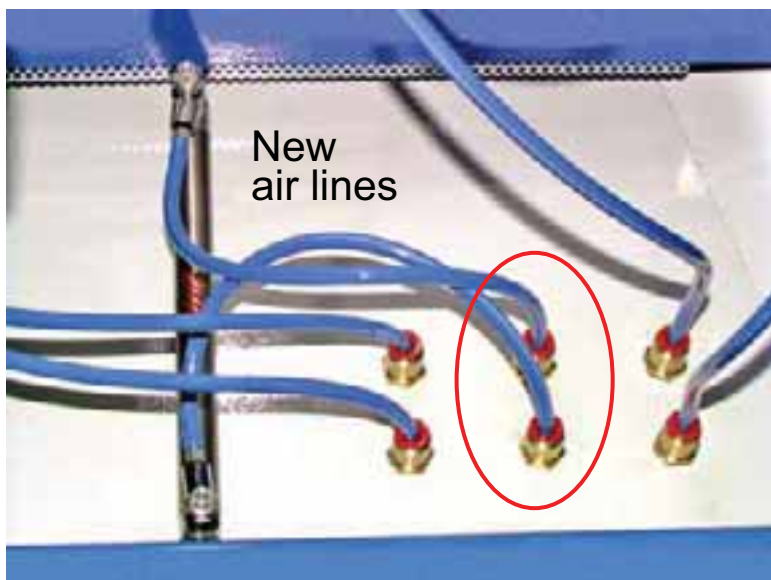
1. Remove two socket-head capscrews and endcap.
2. Add tie-rods (supplied with air-valve).
3. Install new air-valve and gaskets: observe gasket polarity and reassemble. Don't pinch gaskets.



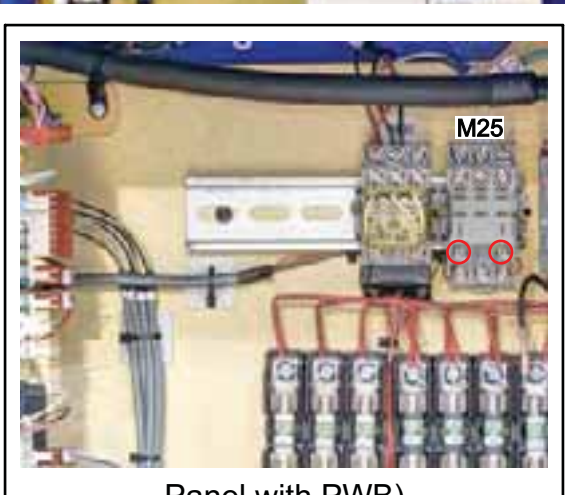
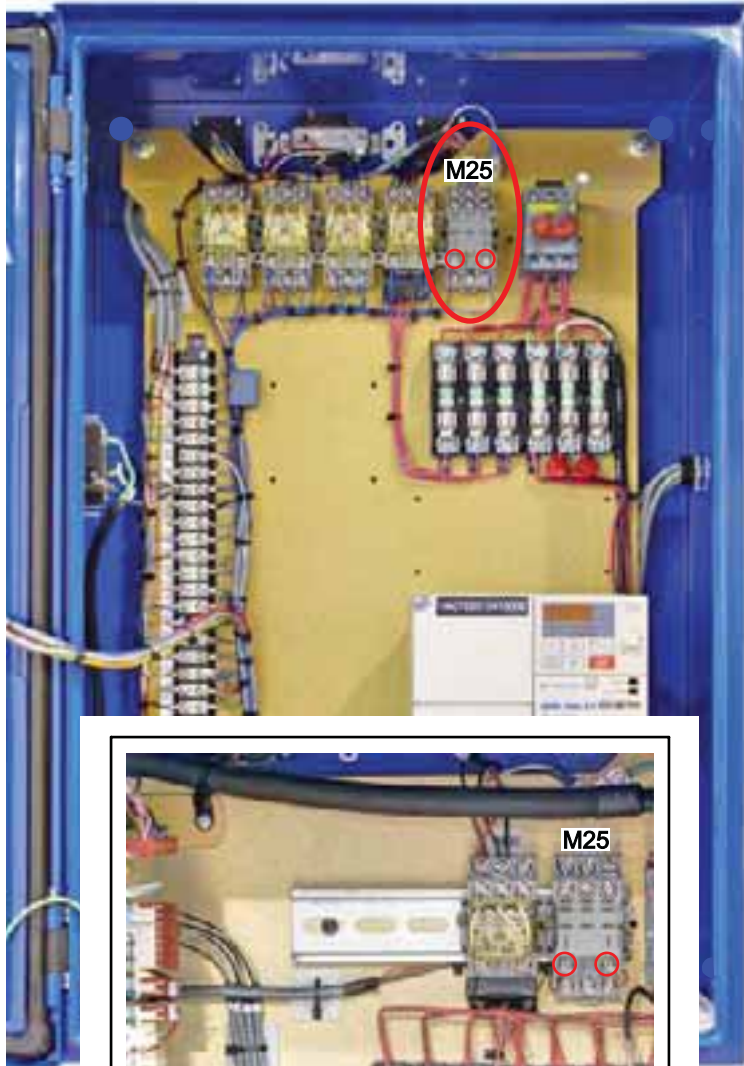
GT-75 Parts Catcher Installation: *above the hopper*



1. Slide baskets out of parts catcher frame. Remove three 8-32 Button Head Cap Screws at front and two sheet-metal screws at back; remove cover from frame.
2. Remove mounting screws from back of frame (three 10-32 x 3/4) and lock nuts.
3. Make sure both machine axes are in Home position and machine is turned off.
4. Place parts catcher frame through front window and place it so that the sheet metal rests on the blue cross-member under the spindle with its back against the white bulkhead panel.
5. Make sure that the part catcher frame sets flat and level with back flush against white bulkhead panel. Mark the bulkhead panel using the five holes as a guide.
6. Drill the five marked holes with a #7 drill and mount the frame using the three screws and nuts provided.
8. Mount the cover with two sheet-metal screws at rear; three 8-32 bhcs at front.
7. Unpack the air cylinder and thread piston shaft into the angle piece on the back of the main basket.
8. Carefully slide the basket onto the frame and guide air cylinder under the blue cross-member.
9. Mount clevis to frame. NOTE: Air connections should be up; flat side of clevis should be down.
10. Insure that basket slides easily in track of parts catcher frame.
11. Remove plastic plugs from hopper; replace with bulkhead fittings for air lines.
12. Preset flow controls full CW, then back three turns; adjust under pressure as required for reliable operation.

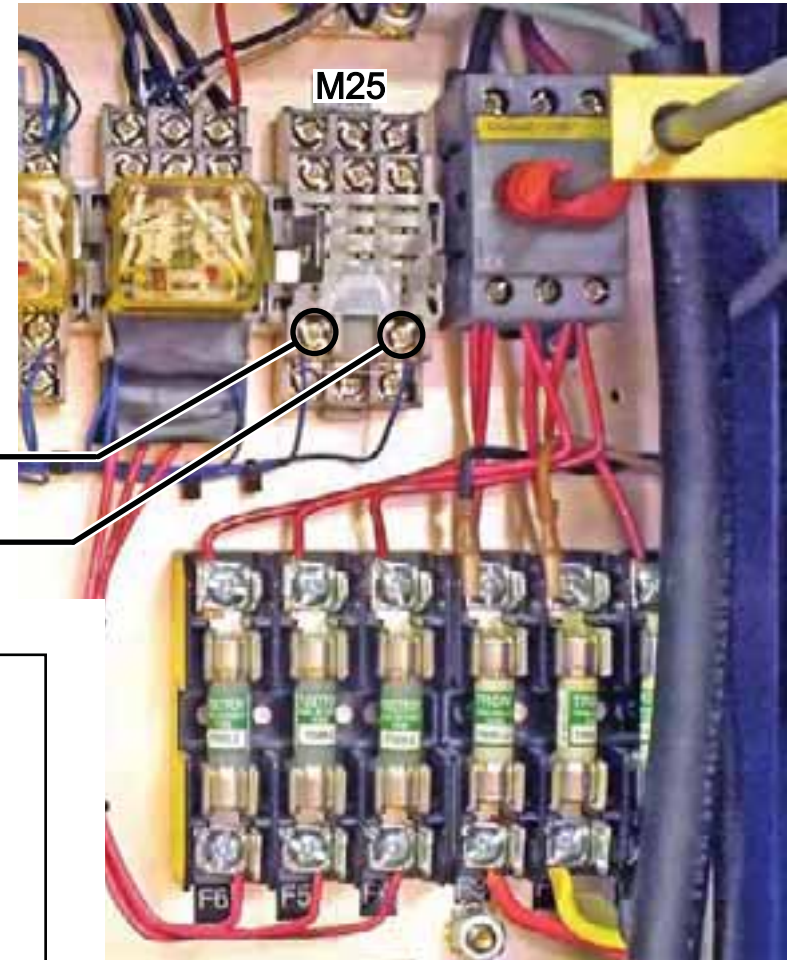


Spindle Drive Panel with TB1
(See inset for panel with PWB)



Panel with PWB)

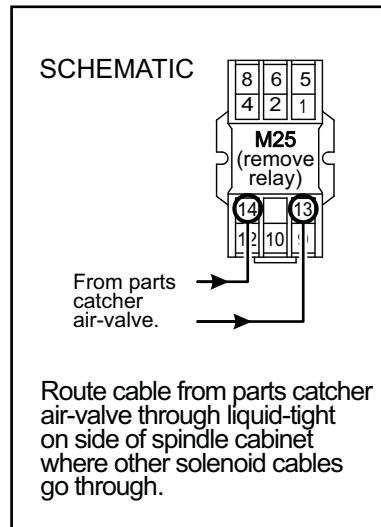
GT-75 Parts Catcher Installation:
below the hopper



Remove the relay from M25 socket to reduce load on driver.

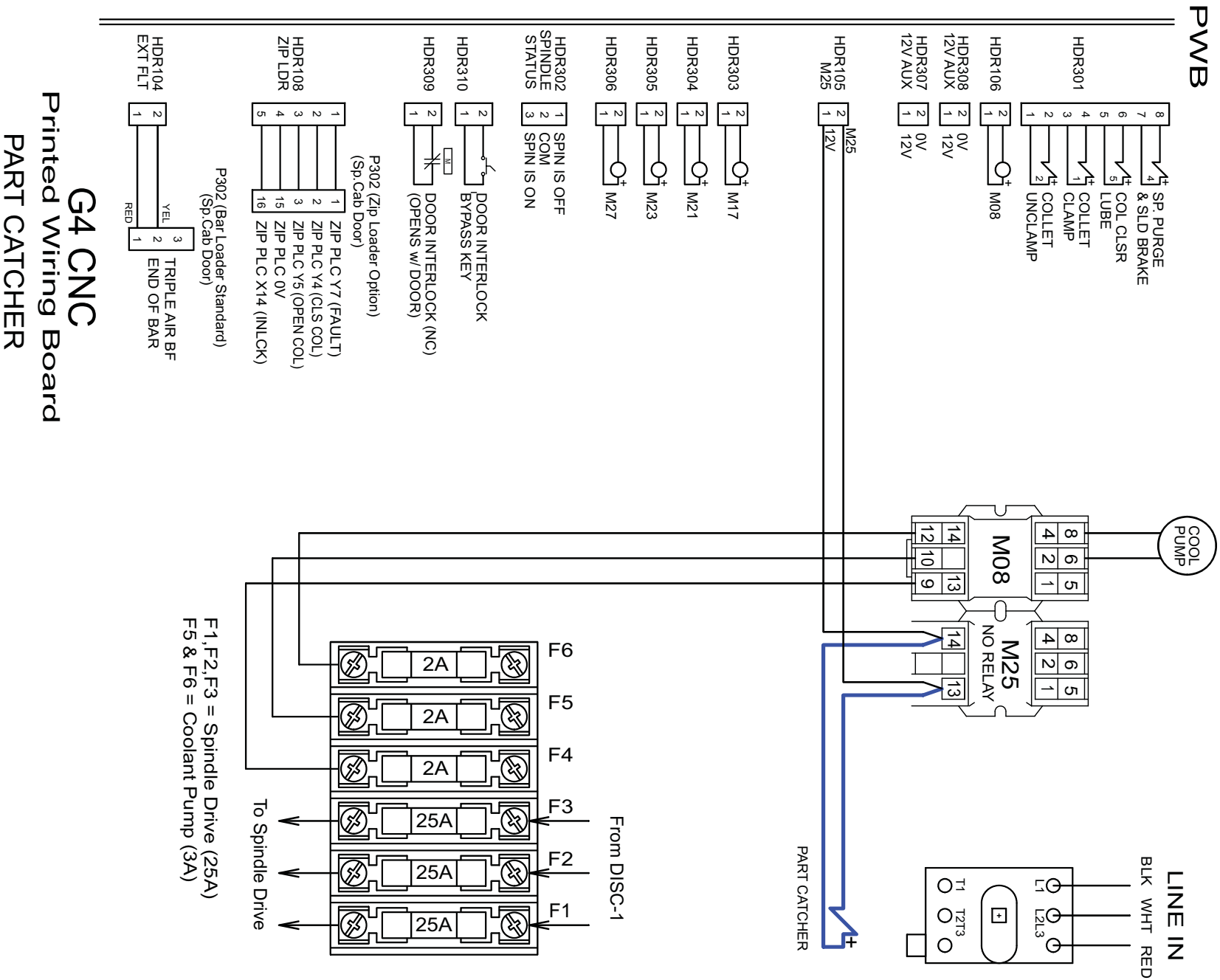
Route cable from new air-valve to M25-14 (clear) and M25-13 (black)

From Parts Catcher Air-valve



Route cable from parts catcher air-valve through liquid-tight on side of spindle cabinet where other solenoid cables go through.

NOTE: If you find any wires on M25 relay except at 13 & 14, **DO NOT continue installation!** Call (541) 332-7004 for assistance.



spindle_cab_pwb_part-catcher.dcd oct 2017

