

# **DIGITAL 42/60 LAMINATOR**

## **ASSEMBLY PROCEDURES**

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**UPDATED MARCH 2019**

2204

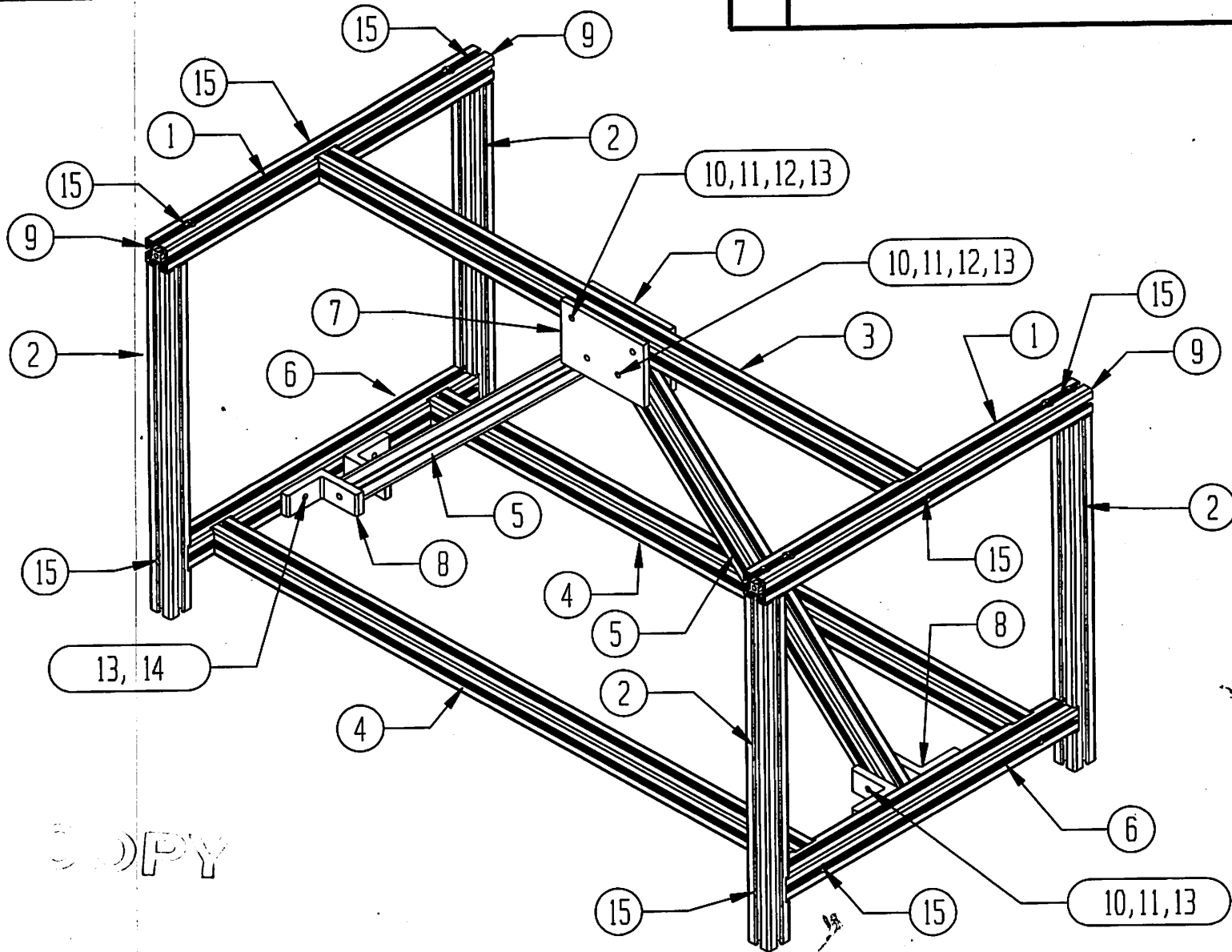
# DIGITAL 42/60 LAMINATOR

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APRIL 2017

Rev.	Description	Date	App. By



COPY

Tolerances Unless Otherwise Specified				
Basic Dimension	UP TO 6.000	6.001 TO 24.000	ABOVE 24.000	$\angle \pm 0^\circ \pm 30'$
2 Place Din.	$\pm .005$	$\pm .010$	$\pm .031$	✓
3 Place Din.	$\pm .002$	$\pm .005$	$\pm .010$	

Finish Specs: CLEAN PARTS

**LED**CO INC.

4265 N. Main St., Henlock N.Y. 14466  
Ph # 585-367-2392 Fax # 585-367-2978

Material Specs: SEE B.D.M. ON SHEET 2

U/M	QTY.	WGT.	Drawn By: RON	App. By: Ron	Date: 02/12/10
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Part # D105 135.5

Title: DIGITAL 42 EXTRUDED STAND WITH CENTER SUPPORTS COMPLETE

Date: 02/12/10

Rev. Level:

Sheet 2 Of 2

Rev. Description

Date

App. By

#	PART #	DESCRIPTION	PCS	#	PART #	DESCRIPTION	PCS
1	EHR44 135.4C	TOP LEFT/RIGHT WIDTH SPANNER	2	9	PRC250	EXTRUDED STAND END CAP 36414	4
2	EP30 135.4D	FRONT/BACK LEGS	4	10	.312PAA48	5/16-18 x 3" SHCS	6
3	D105 135.4B	TOP LENGTH SPANNER	1	11	.312KKC01	5/16-18 FLAT WASHER, SAE	16
4	D105 135.4C	BOTTOM LENGTH SPANNER	2	12	.312LDF00	5/16-18 HEX NUT	4
5	D105 135.4D	DIAGONAL CENTER SUPPORTS	2	13	.312LDE00	5/16-18 ACORN NUT	12
6	EHR44 135.4D	BOTTOM LEFT/RIGHT WIDTH SPANNER	2	14	.312GDA16	5/16-18 x 1" CARRAGE BOLT	4
7	I30 135.4I	MIDDLE BRACE MTG PLATE	2	15	.312PAA24	5/16-18 x 1-1/2" SHCS	14
8	LC38 135.4G	STAND GUSSETS	4				

## Tolerances Unless Otherwise Specified

Basic Dimension	UP TO 6.000	6.001 TO 24.000	ABOVE 24.000	$\angle \pm 0^\circ \pm 30'$
2 Place Din.	±.005	±.010	±.031	✓
3 Place Din.	±.002	±.005	±.010	

Finish Specs: CLEAN PARTS

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Drawn By: RON

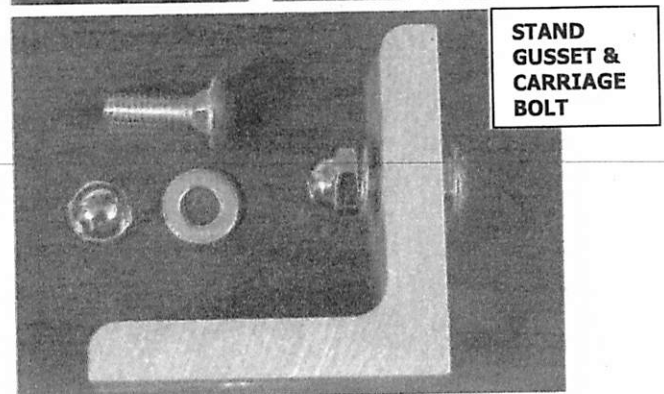
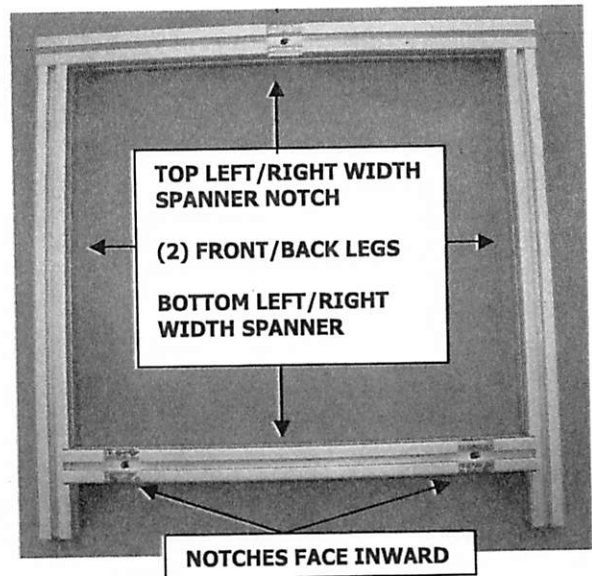
App. By: Ron

Date: 02/12/10

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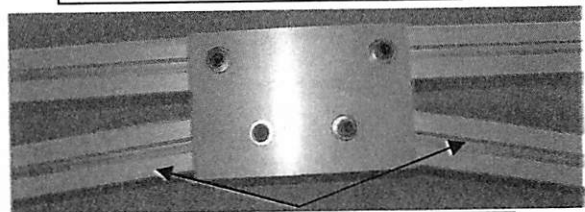
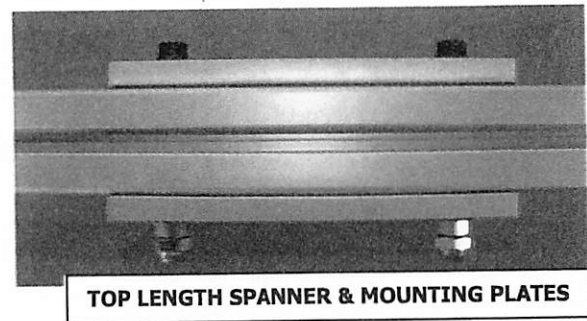
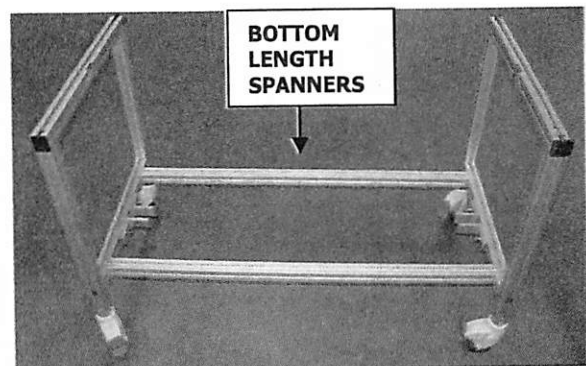
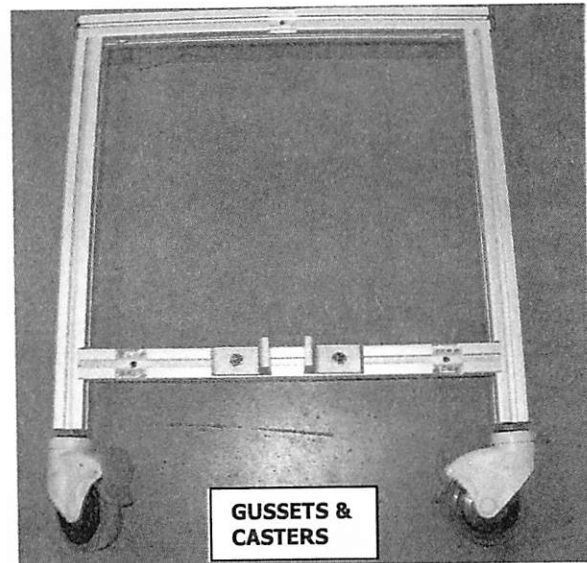
# DIGITAL 42 STAND WITH DIAGONALS

- 1) THE DIGITAL 42 IS SHIPPED ON AN EXTUDED STAND. THE SIDE PANELS AND BOTTOM MOTOR COVER ARE SECURED TO THE STAND WITH (4)  $\frac{1}{2}$ -13 X 2  $\frac{1}{2}$  HEX HEAD BOLTS EACH WITH A  $\frac{1}{2}$  FLAT WASHER. THREAD UPWARD THROUGH THE STAND INTO THE SIDE PANEL FEET.
- 2) ALL EXTRUDED PARTS, MIDDLE BRACE MOUNTING BRACKETS AND END CAPS ARE LOCATED IN LOFT 1.
- 3) WIPE OIL AND MARKS OFF ALL STAND PIECES WITH DAMP RAG.
- 4) ARRANGE ON A WORKTABLE THE (2) TOP LEFT/RIGHT WIDTH SPANNERS (EHR 135.4C) ORIENTED WITH THE COUNTERBORE UPWARD AND THE CENTER NOTCH INWARD. SECURE (2) FRONT BACK LEGS (EP30 135.4D) TO EACH TOP WIDTH SPANNER ORIENTED WITH THE NOTCH DOWNWARD AND INWARD, FACING EACH OTHER. USE 5/16-18 X 1  $\frac{1}{2}$  SHCS THROUGH THE TOP WIDTH SPANNER INTO THE LEGS.
- 5) SECURE A BOTTOM LEFT/RIGHT WIDTH SPANNER (EHR44 135.4D) FITTING INTO THE LEG NOTCHES OF LEFT AND RIGHT SIDE, ORIENTED WITH THE BOTTOM WIDTH SPANNER NOTCHES FACING INWARD, TOWARD EACH OTHER. THE TOP AND BOTTOM WIDTH SPANNER NOTCHES ALL FACE INWARD. USE 5/16-18 X 1  $\frac{1}{2}$  SHCS TO SECURE.
- 6) PLACE A DROP OF LOCTITE BLACK 380 INSTANT ADHESIVE ON THE CENTER INSERT SECTION OF (4) END CAPS (PRC250). SQUARLY TAP THE INSERT SECTION INTO THE CENTER OF THE EXTRUSION END OF THE TOP LEFT/RIGHT WIDTH SPANNERS USING A RUBBER MALLOT.
- 7) PREPARE (4) STAND GUSSETS (LC38 135.4G) WITH HARDWARE. SNUGLY SECURE (2) GUSSETS TO BOTH BOTTOM WIDTH SPANNERS, BY INSERTING THE



5/16-18 X 1 CARRIAGE BOLTS (.312GOA16) INTO THE STRAIGHT SIDES OF THE GUSSET. SLIDE THE SQUARE BOSS OF THE CARRIAGE BOLT INTO THE NOTCH CHANNELS. ALIGN UNDER TOP WIDTH SPANNER NOTCH AND ADD A 5/16 FLAT WASHER SAE (.312KKCO1) AND THREAD ON A 5/16-18 ACORN NUT (.312LDE00).

- 8) THREAD AN "IN HOUSE" CASTER EACH WITH A FIN HEX NUT INTO THE LEGS FOR ASSEMBLY PURPOSES. NEW CASTORS WILL BE SHIPPED WITH THE LAMINATOR FOR THE CUSTOMER.
- 9) USE TWO PEOPLE FOR CONVENIENCE IN ASSEMBLY AND ALIGN THE RIGHT AND LEFT SPANNER END ON THE FLOOR WITH THE NOTCHES AND GUSSETS FACING EACH OTHER. SLIDE THE (2) BOTTOM LENGTH SPANNERS (D105 135.4C) INTO THE MATCHING NOTCHES ON THE BOTTOM WIDTH SPANNERS. INSERT A 5/16-18 X 1 1/2 SHCS INTO EACH AND SECURE SPANNERS.
- 10) PLACE THE TOP LENGTH SPANNER (D105 135.4B) WHICH HAS TWO CENTER HOLES TO ACCOMMODATE THE (2) MIDDLE BRACE MOUNTING PLATES (I30 135.4I) ON A WORKTABLE.
- 11) *LOOSELY* ATTACH THE MIDDLE BRACE MOUNTING PLATES THROUGH THE FRONT AND REAR CENTER HOLES OF THE TOP LENGTH SPANNER. INSERT (2) 5/16-18 X 3 SHCS, EACH WITH A 5/16 FLAT WASHER, *THROUGH THE REAR* MIDDLE BRACE MOUNTING PLATE, THE LENGTH SPANNER AND THE *FRONT MOUNTING PLATE*. PLACE A 5/16 FLAT WASHER ON THE END THREADS AND ADD A 5/16 HEX NUT, THEN ADD A 5/16 ACORN NUT. DO NOT TIGHTEN. *THE ACORN NUTS INDICATE THE FRONT OF THE LAMINATOR.*

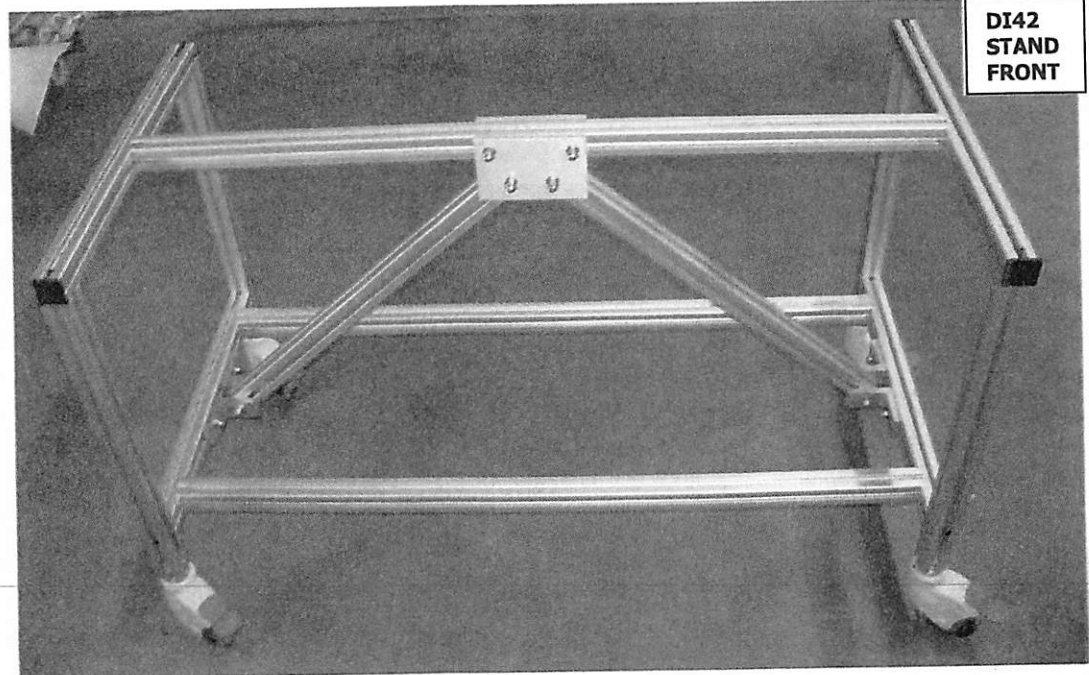
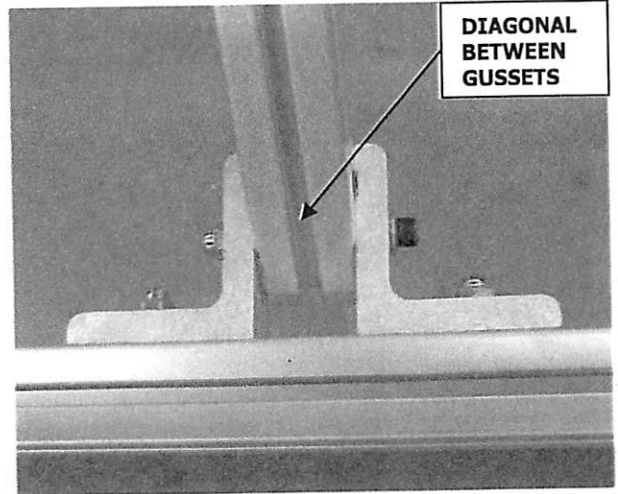
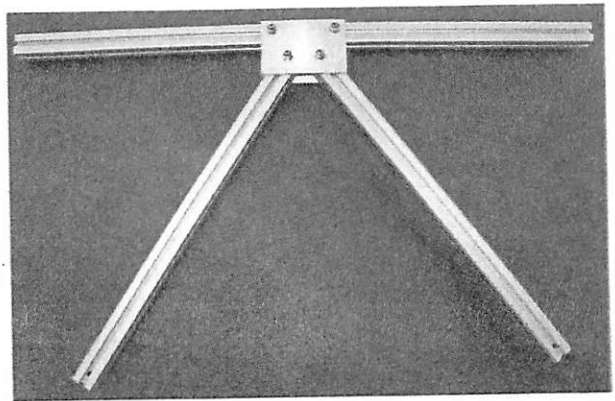


- 12) ALIGN THE (2) DIAGONAL CENTER SUPPORTS (D105 135.4D) BETWEEN THE LOWER SECTIONS OF THE MIDDLE BRACE MOUNTING PLATES. FROM THE REAR INSERT A 5/16-18 X 3 SHCS EACH WITH A 5/16 FLAT WASHER. SNUG A 5/16 FLAT WASHER, 5/16-18 HEX NUT



AND A 5/16-18 ACORN TO THE FRONT OF THE MOUNTING PLATES.

- 13) WITH TWO PEOPLE ALIGN THE TOP LENGTH SPANNER ASSEMBLY BETWEEN THE INNER NOTCHES ON THE TOP WIDTH SPANNERS, WITH THE ACORN NUTS FACING THE FRONT OF THE STAND. SECURE LOOSELY WITH 5/16-18 X 1 1/2 SHCS.
- 14) CENTER THE DIAGONAL SUPPORTS BETWEEN THE GUSSETS, MEASURE FOR EVENNESS ON BOTH SIDES. SECURE THE GUSSETS.
- 15) TIGHTEN ALL SCREWS AT THIS TIME.



Part # EP60 135.5

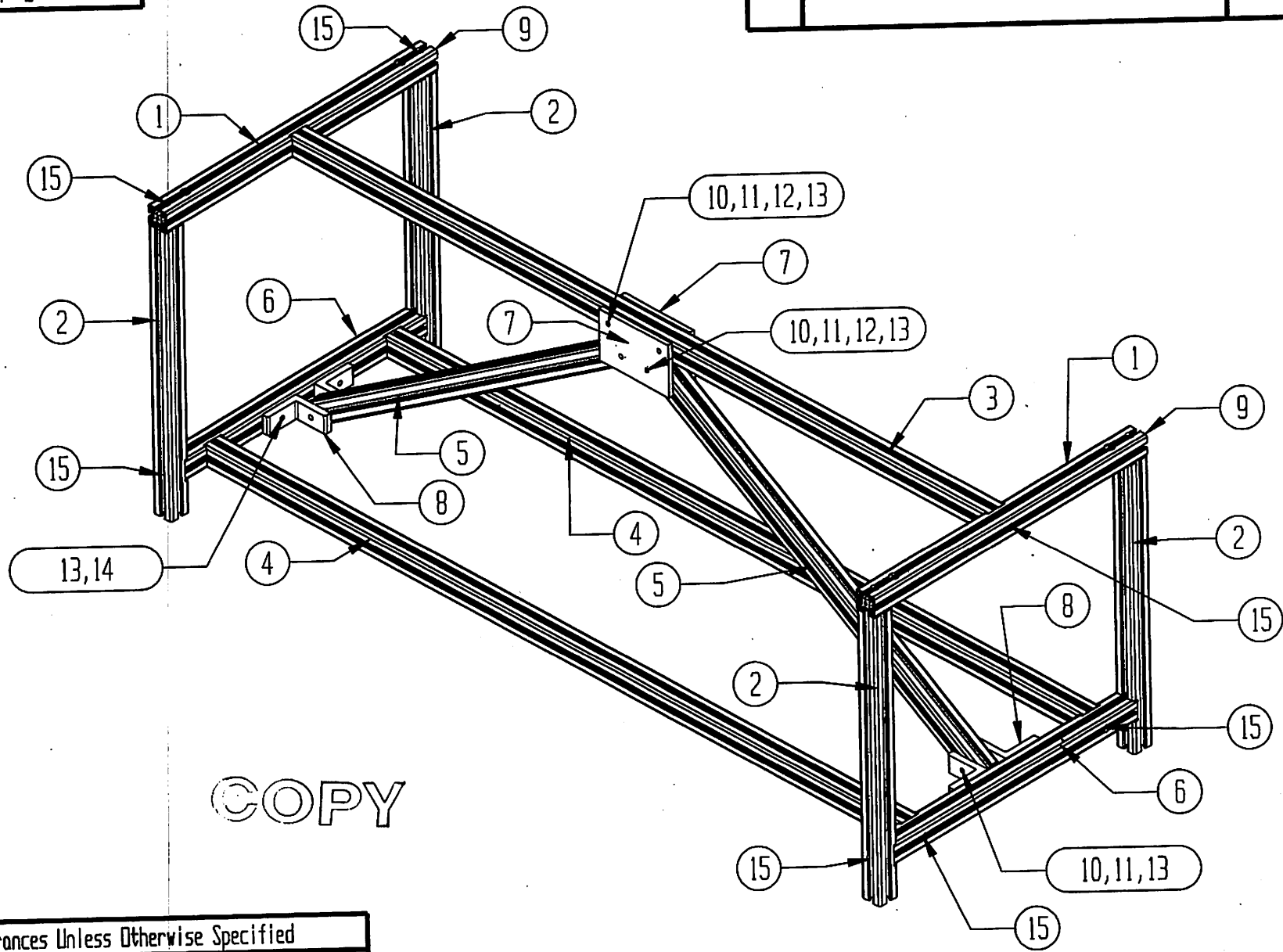
Title: EP60 / 1060 EXTRUDED STAND COMPLETE

Date: 04/08/09

Rev. Level:

Sheet 1 of 2

Rev.	Description	Date	App. By



COPY

Tolerances Unless Otherwise Specified

Basic Dimension	UP TO 6.000	6.001 TO 24.000	ASME 24.000	$\angle \pm 0^\circ \pm 30'$
2 Place Din.	$\pm .005$	$\pm .010$	$\pm .031$	✓
3 Place Din.	$\pm .002$	$\pm .005$	$\pm .010$	

Finish Specs: CLEAN PARTS

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Ph # 585-367-2392 Fax # 585-367-2978

Material Specs: SEE B.D.M.

L/M

QTY.

WGT.

Drawn By: RON

App. By: Ron

Date: 04/08/09



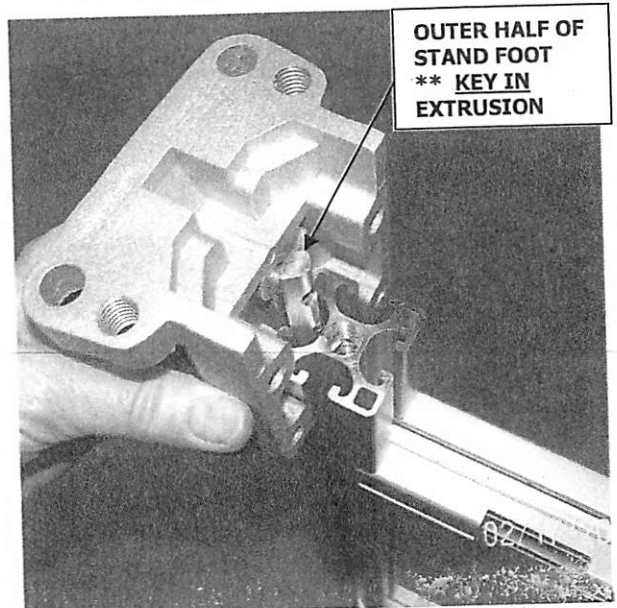
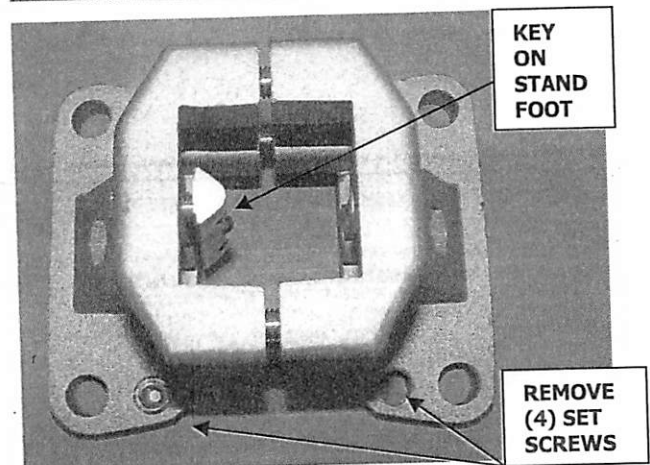
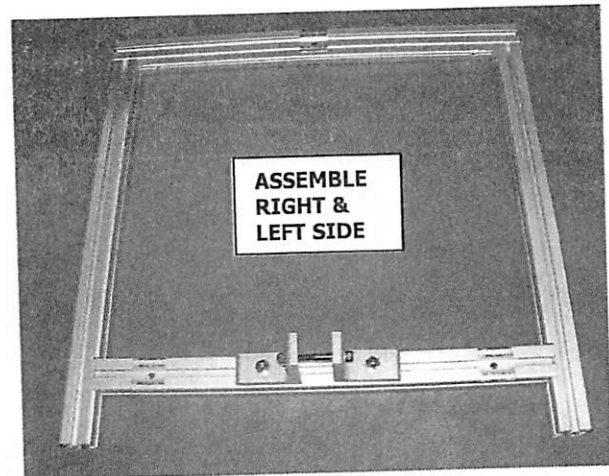
#	PART #	DESCRIPTION	PCS	#	PART #	DESCRIPTION	PCS
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2	EP30 135.4D	FRONT/BACK LEGS	4	10	.312PAA48	5/16-18 x 3" SHCS	6
3	<del>D105 135.4B</del> EP60 135.4AA	TOP LENGTH SPANNER	1	11	.312KKC01	5/16-18 FLAT WASHER, SAE	16
4	<del>D105 135.4C</del> EP60 135.4A	BOTTOM LENGTH SPANNER	2	12	.312LDF00	5/16-18 HEX NUT	4
5	<del>D105 135.4J</del> EP60 135.4J	DIAGONAL CENTER SUPPORTS	2	13	.312LDE00	5/16-18 ACORN NUT	12
6	EHR44 135.4D	BOTTOM LEFT/RIGHT WIDTH SPANNER	2	14	.312GDA16	5/16-18 x 1" CARRAGE BOLT	4
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Tolerances Unless Otherwise Specified					Finish Specs: CLEAN PARTS		4265 N. Main St., Henlock N.Y. 14466 Ph # 585-367-2392 Fax # 585-367-2978	
Basic Dimension	UP TO 6.000	6.001 TO 24.000	ABOVE 24.000					
2 Place Din.	±.005	±.010	±.031					
3 Place Din.	±.002	±.005	±.010		U/M    QTY.    WGT.	Drawn By: RON	App. By: Ron	Date: 04/08/09
Material Specs: SEE B.D.M.								

# DIGITAL 60 STAND WITH HEAVY DUTY CASTERS

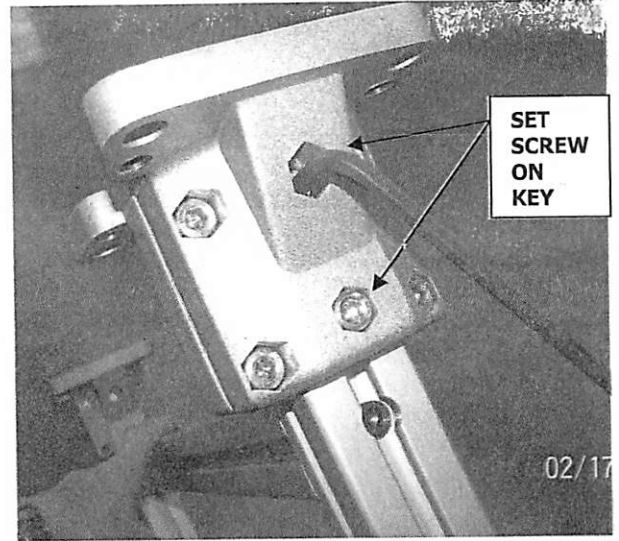
- 1) FOLLOW EP60/D60 STAND DIAGRAM AND ASSEMBLE THE RIGHT AND LEFT SIDES, INCLUDING GUSSETS.
- 2) PREPARE (4) STAND FOOT (PRF010) LOFT 1 FOR ASSEMBLY OF THE DIGITAL 60 STAND WITH HEAVY DUTY CASTERS, BY FIRST REMOVING THE (4) METRIC SET SCREWS ON THE BRACKET SECTION OF THE STAND FOOT. USE THE ALLEN HEX KEY (PRHK01) LOFT 1. THESE SET SCREWS WILL NOT BE USED.
- 3) *LOOSEN* THE (2) SET SCREWS ON THE STAND FOOT KEY. LOOSEN OR REMOVE THE (4) BOLTS AND CAPATIVE HEX NUTS ON STAND FOOT.
- 4) ALIGN A STAND FOOT OR THE OUTER HALF OF THE STAND FOOT OVER THE END OF A STAND LEG, ORIENTED WITH THE CLAMP KEY OUTWARD ON SIDE OF EXTRUSION. BOLTS OUTWARD, NUTS INWARD. SLIDE STAND FOOT INTO THE OUTER SIDE EXTRUSION (SIMILAR TO A CARRIAGE BOLT). PUSH STAND FOOT FLUSH TO WIDTH SPANNER.
- 5) ALIGN BOTH SIDES OF THE STAND FOOT AND SNUG THE (2) SET SCREWS ON THE STAND FOOT KEY TO THE LEG. THEN SNUG THE (4) OUTER SCREWS INTO THE CAPTIVE NUT FACING INWARD. USE AN ALLEN HEX KEY (PRHK01) AND TIGHTEN.
- 6) REPEAT THIS PROCEDURE ON ALL FOUR STAND FEET AND LEGS.
- 7) PLACE THE HEAVY DUTY 4 INCH CASTER (PRC221) LOFT 2 ONTO THE STAND FOOT BRACKETS. ALIGN WITH THE (4) *INNER*, THREADED HOLES THAT THE SET SCREWS WERE REMOVED FROM.
- 8) PLACE A 3/8 FLAT WASHER ONTO A 3/8 X 1 1/4 BH SHCS (.375AA020) AS13 AND INSERT THE BUTTONHEAD FROM THE



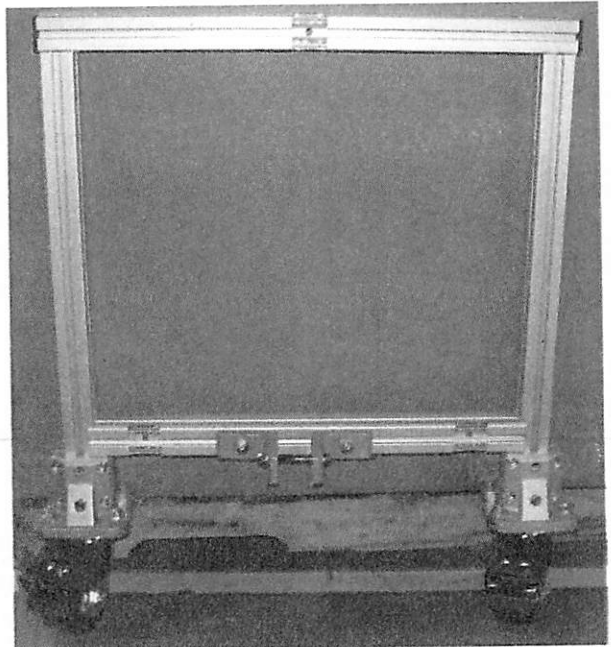
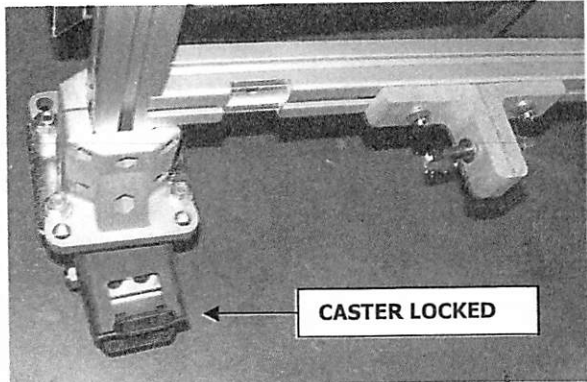
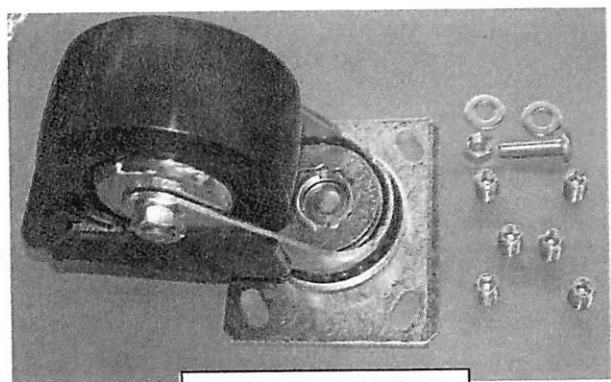
USE LOCK WASHER TO NUT  
NEXT

BOTTOM UPWARD THROUGH THE HEAVY DUTY 4" CASTER AND THE INNER THREADED HOLES OF THE STAND FOOT. PLACE ANOTHER 3/8 FLAT WASHER ON THE THREADS OF THE BUTTONHEAD AND SECURE WITH A 3/8-16 HEX NUT WITH LOCTITE ON HEX NUT THREADS. USE THE WRENCH (MRO544) LOFT 1 TO TIGHTEN NUTS.

- 9) REPEAT THIS PROCEDURE ON ALL FOUR STAND FOOT/CASTER ASSEMBLIES.
- 10) SHIPPING WILL PACK THE DIGITAL 60 STAND WHICH WILL BE PARTIALLY ASSEMBLED.

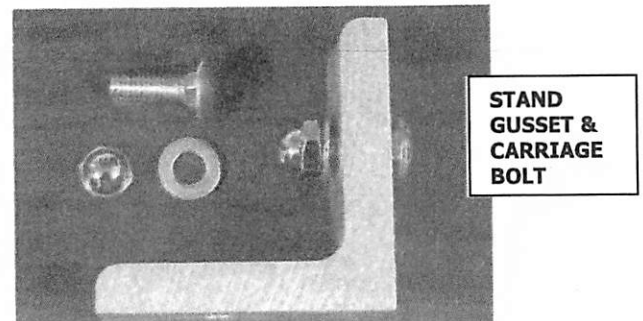
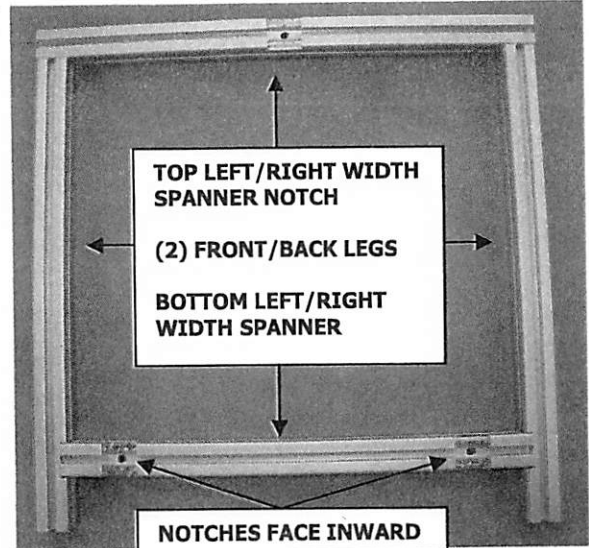


ALIGN CASTER ON STAND FOOT



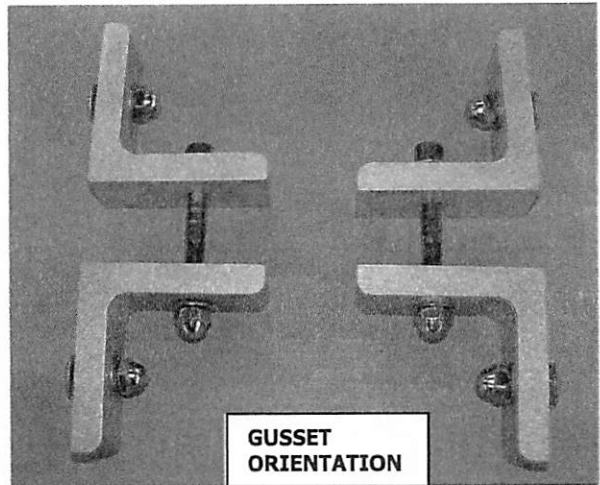
# DIGITAL 60 STAND WITH DIAGONAL SUPPORT ASSEMBLY

- 1) PARTIAL ASSEMBLY OF THE DIGITAL 60 STAND IS COMPLETED BEFORE SHIPPING DEPARTMENT CRATES STAND WITH THE DIGITAL LAMINATOR.
- 2) ALL EXTRUDED PARTS, END CAPS, HEX HEAD KEY AND 9/16 & 1/2 WRENCH ARE LOCATED IN LOFT 1.
- 3) WIPE OIL AND MARKS OFF ALL STAND PIECES WITH DAMP RAG.
- 4) ARRANGE THE (2) TOP LEFT/RIGHT WIDTH SPANNERS (EHR 135.4C) ORIENTED WITH THE COUNTERBORE UPWARD AND THE CENTER NOTCH INWARD. SECURE (2) FRONT BACK LEGS (EP30 135.4D) TO EACH TOP WIDTH SPANNER ORIENTED WITH THE NOTCH DOWNWARD AND INWARD, FACING EACH OTHER. USE (2) 5/16-18 X 1 1/2 SHCS THROUGH THE TOP WIDTH SPANNER INTO THE LEGS.
- 5) SECURE A BOTTOM LEFT/RIGHT WIDTH SPANNER (EHR44 135.4D) FITTING INTO THE LEG NOTCHES OF LEFT AND RIGHT SIDE, ORIENTED WITH THE BOTTOM WIDTH SPANNER NOTCHES FACING INWARD, TOWARD EACH OTHER. THE TOP AND BOTTOM WIDTH SPANNER NOTCHES ALL FACE INWARD. USE 5/16-18 X 1 1/2 SHCS TO SECURE.
- 6) PLACE A DROP OF LOCTITE BLACK 380 INSTANT ADHESIVE ON THE CENTER INSERT SECTION OF (4) END CAPS (PRC250). SQUARLY TAP THE INSERT SECTION INTO THE CENTER OF THE EXTRUSION END OF THE TOP LEFT/RIGHT WIDTH SPANNERS USING A RUBBER MALLOT.
- 7) PREPARE (4) STAND GUSSETS (LC38 135.4G) WITH PROPER HARDWARE. THE CUSTOMER WILL SECURE THE GUSSETS TO THE BOTTOM WIDTH SPANNERS. INSERT (2) 5/16-18 X 1 CARRIAGE

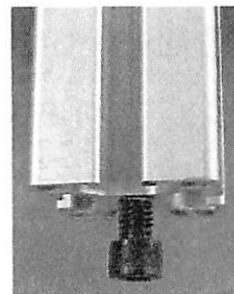


BOLTS (.312GOA16) INTO THE STRAIGHT SIDES OF EACH GUSSET. ADD A 5/16 FLAT WASHER SAE (.312KKCO1) AND THREAD ON A 5/16-18 ACORN NUT (.312LDE00).

- 8) FOR THE CUSTOMER'S CONVENIENCE, SECURE THE RIGHT AND LEFT SIDE GUSSET PAIRS TOGETHER, CORRECTLY ORIENTED. PLACE A 5/16 FLAT WASHER ON EACH OF (2) 5/16-18 X 3 SHCS. INSERT THE SHCS THROUGH TWO OF THE GUSSETS AND SNUG A 5/16 FLAT WASHER AND AN ACORN NUT ON THE SHCS THREADS. SEE PICTURES FOR GUSSET ORIENTATION.

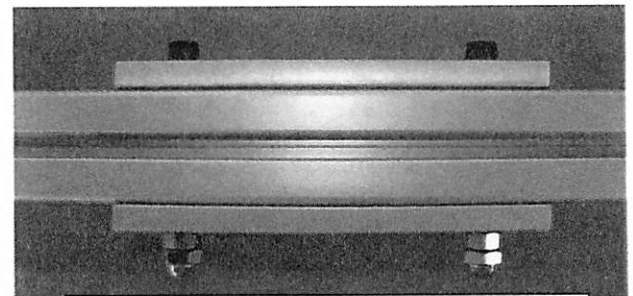


- 9) INSERT A 5/16-18 X 1 1/2 SHCS INTO EACH END OF THE (2) BOTTOM LENGTH SPANNERS (EP60 135.4A). THE BOTTOM LENGTH SPANNERS ARE SHIPPED WITH NO FURTHER ASSEMBLY.



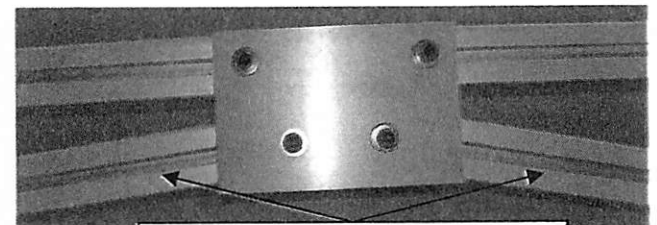
(2) BOTTOM LENGTH SPANNERS WITH 5/16-18 X 1 1/2 SHCS

- 10) THE TOP LENGTH SPANNER (EP60 135.4AA) HAS TWO CENTER HOLES TO ACCOMMODATE THE (2) MIDDLE BRACE MOUNTING PLATES (I30 135.4I).



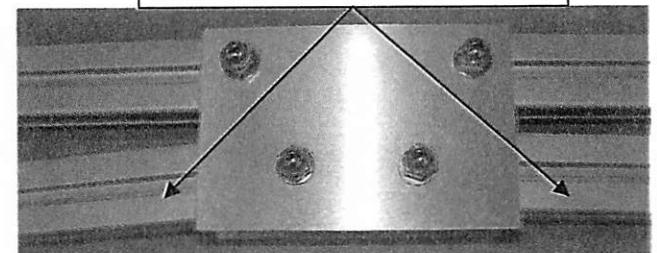
TOP LENGTH SPANNER & MOUNTING PLATES

- 11) *LOOSELY* ATTACH THE MIDDLE BRACE MOUNTING PLATES TO THE FRONT AND REAR CENTER OF THE TOP LENGTH SPANNER. INSERT (2) 5/16-18 X 3 SHCS, EACH WITH A 5/16 FLAT WASHER, *THROUGH THE REAR* MIDDLE BRACE MOUNTING PLATE, THE LENGTH SPANNER AND THE *FRONT MOUNTING PLATE*. PLACE A 5/16 FLAT WASHER ON THE END THREADS AND ADD A 5/16 HEX NUT, AND A 5/16 ACORN NUT. DO NOT TIGHTEN. *THE ACORN NUTS INDICATE THE FRONT OF THE LAMINATOR.*

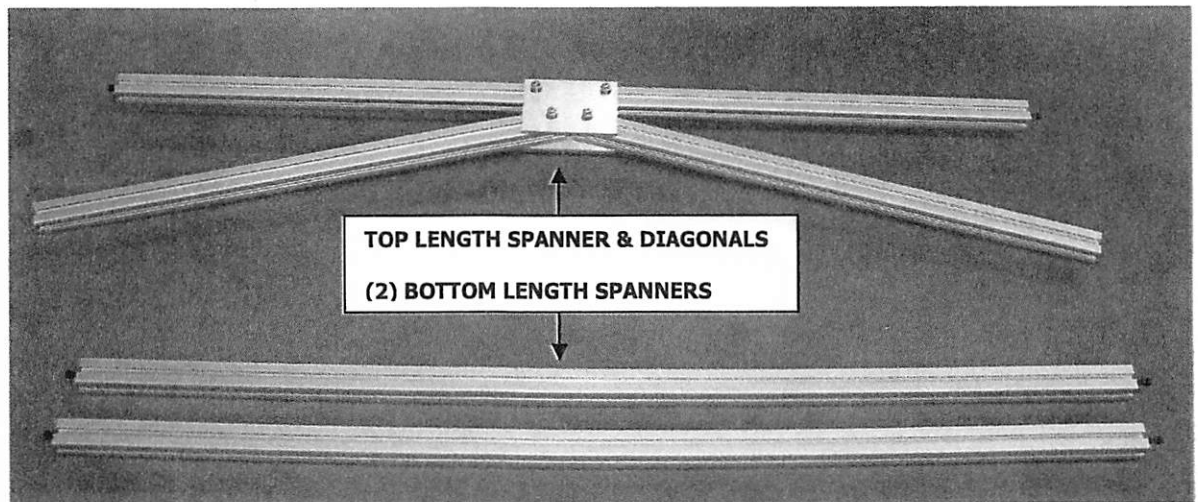


(2) DIAGONAL CENTER SUPPORTS

- 12) SLIDE (2) DIAGONAL CENTER SUPPORTS (EP60 135.4J) BETWEEN THE MIDDLE BRACE MOUNTING PLATES AND SECURE TO THE LOWER HOLES WITH (2) 5/16-18 X 3 SHCS EACH WITH A 5/16 FLAT WASHER FROM THE REAR AND ON THE FRONT ADD A 5/16 FLAT WASHER, 5/16 HEX NUT AND 5/16 -18 ACORN NUT. *SNUG ONLY* AS THE DIAGONALS MUST MOVE TO BE PARALLEL WITH THE TOP LENGTH SPANNER FOR SHIPPING.



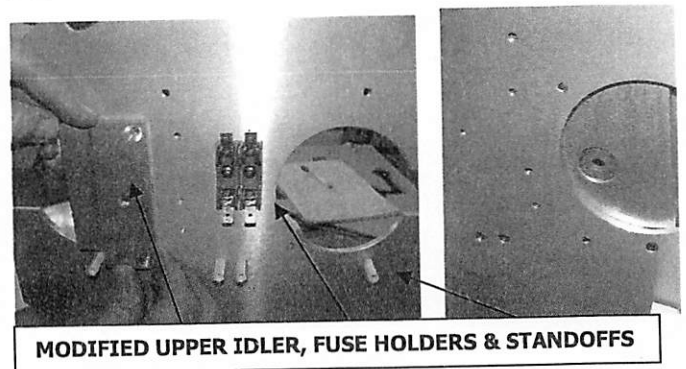
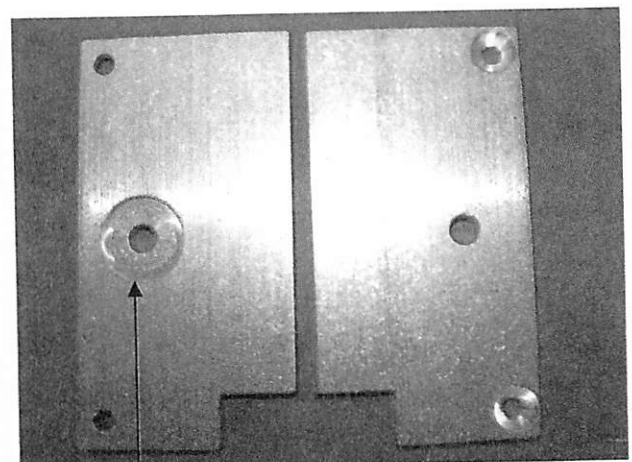
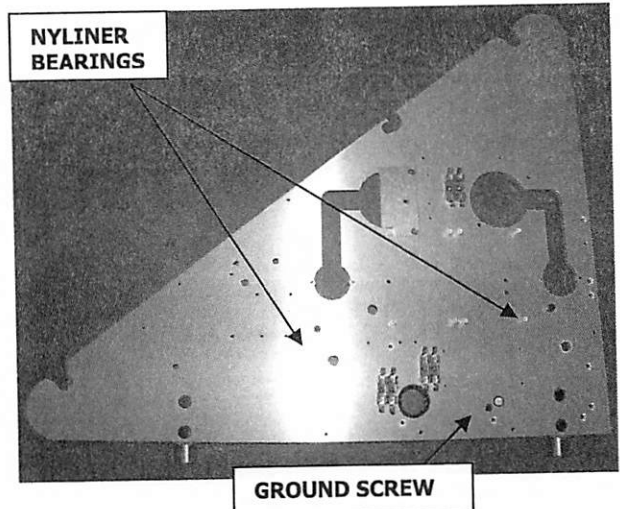
- 13) **THREAD A 5/16-18 X 1/1/2 SHCS INTO BOTH ENDS OF THE TOP LENGTH SPANNER.**
- 14) **ASSEMBLE THE FOLLOWING AND PLACE IN PLASTIC BAG: (4) 1/2-13 X 2 1/2 HEX BOLT (.500HDA40), (4) 1/2 FLAT WASHER SAE (.500KKC01), (1) 1/4 SHORT ARM HEX KEY (MRO543) AND WRENCH (MRO544). LABEL CONTENTS.**
- 15) **IN AN ENVELOPE PLACE THE DIGITAL 60 STAND DIRECTIONS FOR CUSTOMER ASSEMBLY.**
- 16) **ASSEMBLY PACKS THE (2) END SECTIONS. PLACE CUSHION BETWEEN LEFT AND RIGHT LEG SECTIONS. WRAP SECTIONS AND FILL EXCESS SPACE IN CARTON D105 STAND (XS002) SHIPPING DEPARTMENT.**



# DIGITAL NRTL 42/60

## RIGHT SIDE PANEL

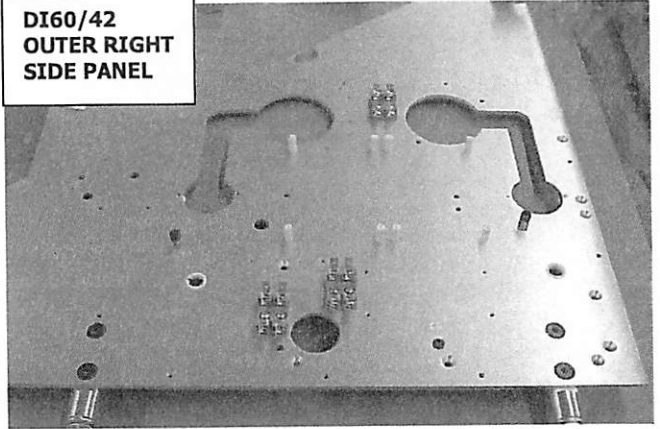
- 1) BEGIN TO ASSEMBLE THE RIGHT SIDE PANEL (D60 090.4R) D-01 BY INSERTING (2) BEARING NYLINERS (PRB059) RACK 21 WITH THE FLANGE ON *OUTER* SIDE PANEL AND RECESSED HOLE ON *INSIDE*. THESE BEARINGS ARE FOR THE CAM SHAFTS.
- 2) ATTACH (2) FEET MOUNTING SHAFT EXTENSIONS (LC38 048.4) AS13 TO BOTTOM OF SIDE PANEL USING (4) 5/16-18 X 3/4 FHSH INSERTED THROUGH THE COUNTERSUNK HOLES ON OUTER SIDE PANEL.
- 3) PLACE A 7/16 STEEL SPACER (PRS232) AS08 ON EACH OF (2) 1/4-20 X 5/8 SHCS. THREAD INTO OUTER RIGHT SIDE PANEL. THE SPACERS STABILIZE CONNECTING PLATES. LOCATE SPACER CLOSER TO THE BACK DRIVE ROLL HOLE THAN TO THE FRONT DRIVE ROLL HOLE.
- 4) THREAD (4) 10-32 X 1/4 TH MS FROM INNER SIDE PANEL INTO THREADED HOLES BY LOWER FRONT AND BACK DRIVE ROLL APERTURES. THE TRUSSHEADS WILL SECURE THE ROLLER BEARINGS.
- 5) ATTACH THE MODIFIED UPPER IDLER BRACKET (D105 053.4) RACK 1 TO THE OUTER RIGHT SIDE PANEL, WITH THE RECESS OF CENTER HOLE FACING INWARD AND THE COUNTERSINKS TOWARD THE REAR. THE LOWER FRONT NOTCH ACCOMMODATES A STANDOFF. USE (2) 10-32 X 7/16 FH MS.
- 6) SECURE (8) STANDOFF-NYLON (LC25 010.4) LD01 TO OUTER PANEL. USE (8) 4-40 X 3/8 FH MS THRU COUNTERSINKS.
- 7) ATTACH (6) FUSE HOLDERS (PRF126)



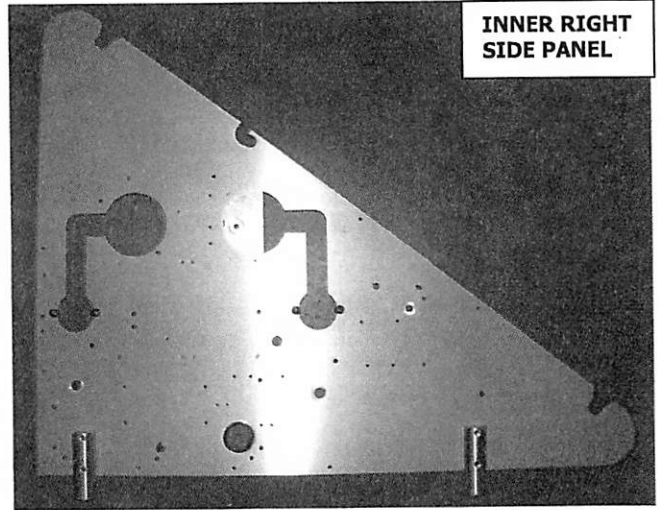
AS07 VERTICALLY TO OUTER RIGHT SIDE PANEL. USE (6) 6-32 X 1/4 PH. ADD FUSES LATER.

- 8) PLACE A #10 STAR WASHER ONTO A 10-32 X 1 BHSH, INSERT FROM LOWER, OUTER PANEL ABOVE COUNTERSINK. BREAKER, MOTOR AND FAN GROUND WIRES ATTACH LATER ON INSIDE.
- 9) ADD GROUND LABEL (LAB06) WB09 ABOVE GROUND SCREW.
- 10) INSERT SNAP BUSHING (PRB088) AS07 INTO LOWER WIRING OPENING, FLANGE OUTWARD, BETWEEN LOWER FUSES.
- 11) THE DIGITAL 42/60 SHOULD BE BUILT ON AN EXTRUDED STAND ASSEMBLY. PLACE A 1/2 FLAT WASHER SAE ON EACH OF (4) 1/2-13 X 2 1/2 HEX HEAD (.500KKCO1) AS13. ALIGN MOUNTING FEET & SHAFT EXTENSIONS OVER STANDTHREADS AND RATCHET TIGHT.

DI60/42  
OUTER RIGHT  
SIDE PANEL



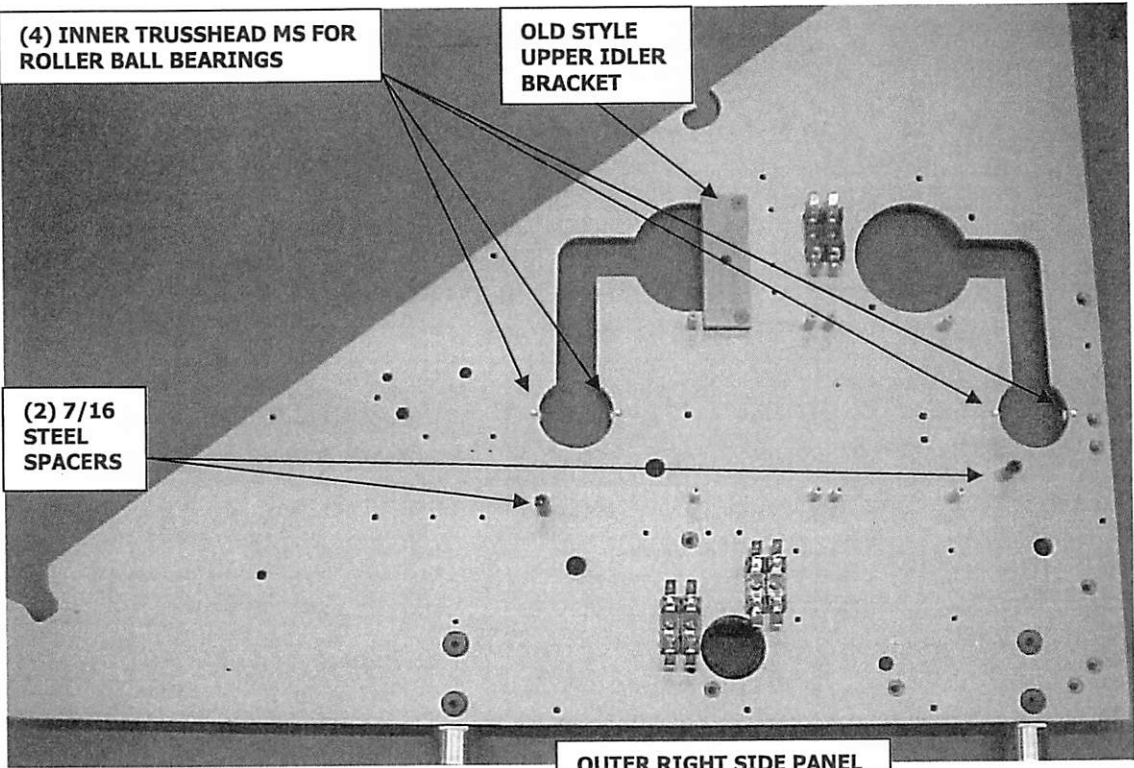
INNER RIGHT  
SIDE PANEL



(4) INNER TRUSSHEAD MS FOR  
ROLLER BALL BEARINGS

OLD STYLE  
UPPER IDLER  
BRACKET

(2) 7/16  
STEEL  
SPACERS



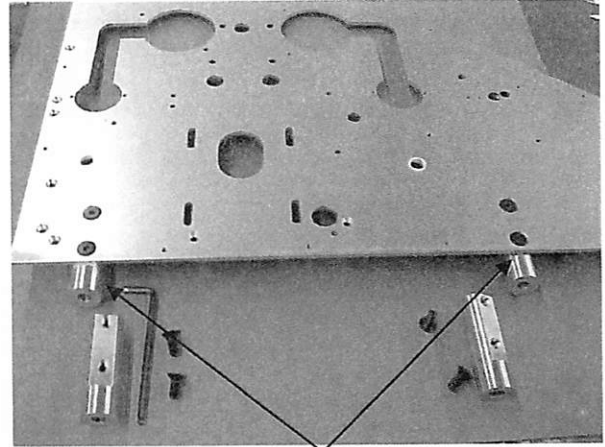
OUTER RIGHT SIDE PANEL



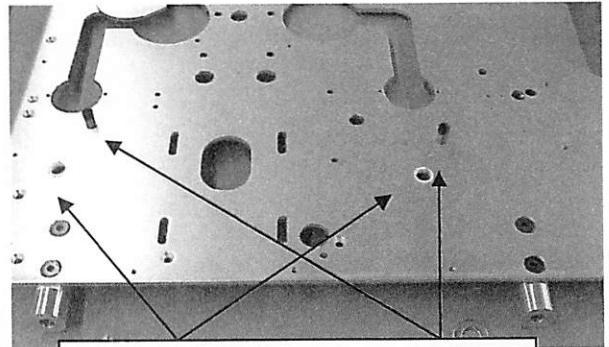
# DIGITAL NRTL 42/60 LEFT SIDE PANEL

- 1) **ASSEMBLE LEFT SIDE PANEL (D60 090.4L) DI-01 BY INSERTING (2) BRG NYLINERS (PRB059) AS01, FLANGE ON OUTER SIDE PANEL AND RECESSED OPENING ON INNER PANEL. THE NYLINER BEARINGS ARE FOR CAM SHAFTS.**
- 2) **ATTACH (2) FEET MOUNTING SHAFT EXTENSIONS (LC38 048.4) AS13 TO BOTTOM OF SIDE PANEL USING (4) 5/16-18 X 3/4 FHSH INSERTED FROM COUNTERSUNK HOLES ON OUTSIDE.**
- 3) **THE DIGITAL 42 AND THE DIGITAL 60 ARE BUILT ON THE EXTRUDED STAND BY FIRST PLACING A 1/2-13 X 2 1/2 HEX HEAD WITH A 1/2 FLAT WASHER SAE AS13. THREAD THIS INTO FEET MOUNTING SHAFT EXTENSION. TIGHTEN WITH WRENCH.**
- 4) **PLACE A 7/16 STEEL SPACER (PRS232) AS08 ON EACH OF (2) 1/4-20 X 5/8 SHCS. THREAD INTO OUTER SIDE PANEL, TO LATER STABILIZING CONNECTING PLATES. THE SPACER WILL BE CLOSER TO THE BACK DRIVE ROLL HOLE THAN IT IS TO THE FRONT DRIVE ROLL HOLE.**
- 5) **THREAD (4) 10-32 X 1/4 TH FROM INSIDE INTO TAPPED HOLES FOR FRONT AND REAR RUBBER ROLL ROLLER BEARINGS.**
- 6) **FROM RACK 2 TAKE (3) 35B12 IDLER SPROCKETS 5/8 BORE (PRS320) AND ARBOR PRESS AN OILITE FLANGE BEARINGS (PRB094) INTO EACH SPROCKET, FLANGE ON TOOTH SIDE.**
- 7) **INSERT (3) 1/2 X 1 SHOULDER BOLTS (.500IAC16) AS13 INTO SPROCKET OILITE BEARINGS WITH BOLT HEAD NEXT TO TEETH. THREAD BOLTS HOLDING SPROCKETS INTO TOP RUBBER ROLL IDLER SPROCKET BRACKET (LC38 054.4) RACK 2 AND SECURE WITH (3)**

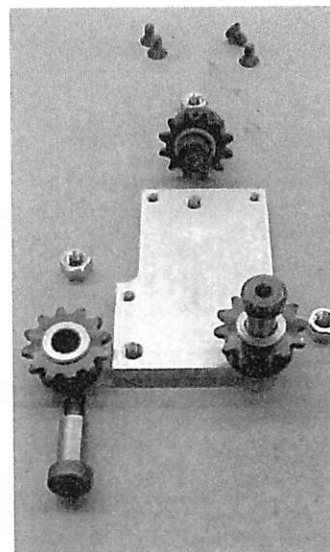
*Rack 2*



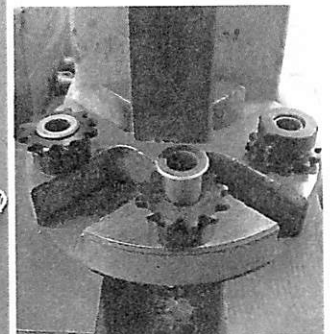
OUTER LEFT: FEET MOUNTING SHAFT EXTENTIONS



NYLINER BRGS & 7/16 STEEL SPACERS

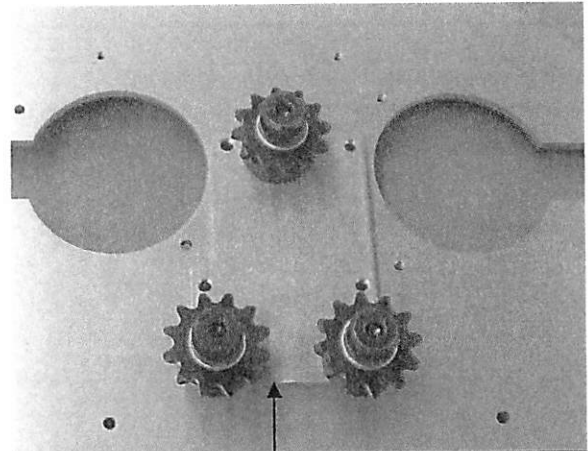


IDLER SPROCKET BRACKET ASSEMBLY

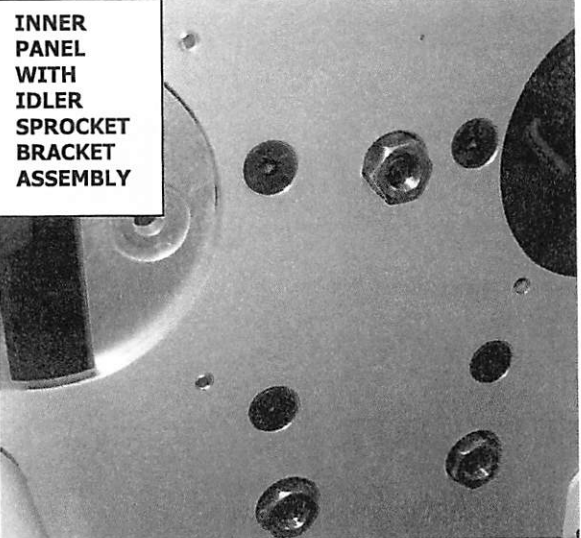
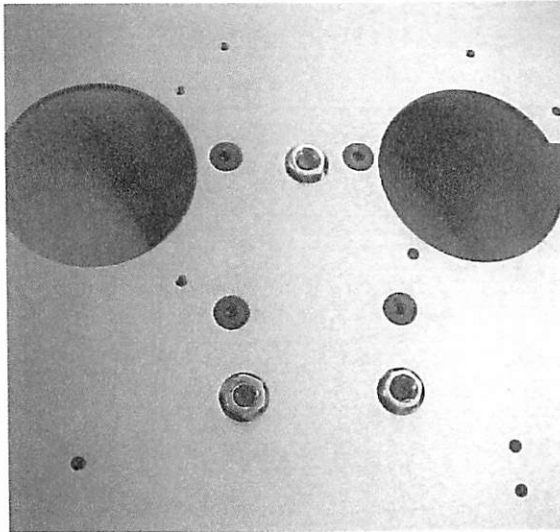


**3/8-16 HEX NUTS (.375LDFOO) ON OTHER SIDE OF BRACKET.**

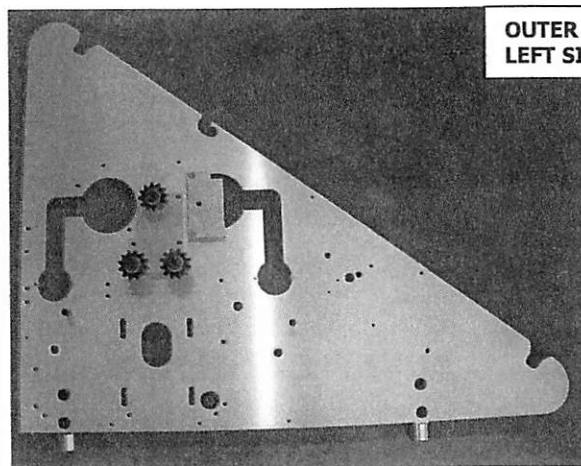
- 8) **ATTACH IDLER SPROCKET BRACKET ASSEMBLY TO OUTER LEFT SIDE PANEL WITH OFFSET BRACKET DOWNWARD, TO THE REAR. USE (4) 1/4-20 X 1/2 FHS FROM INSIDE.**
- 9) **DO NOT ATTACH MODIFIED UPPER IDLER BRACKET (D105 053.4) RACK 1 TO OUTER LEFT PANEL AT THIS TIME.**
- 10) **INSERT SNAP BUSHING (PRB064) AS07 INTO LOWER OPENING, FLANGE OUTWARD.**



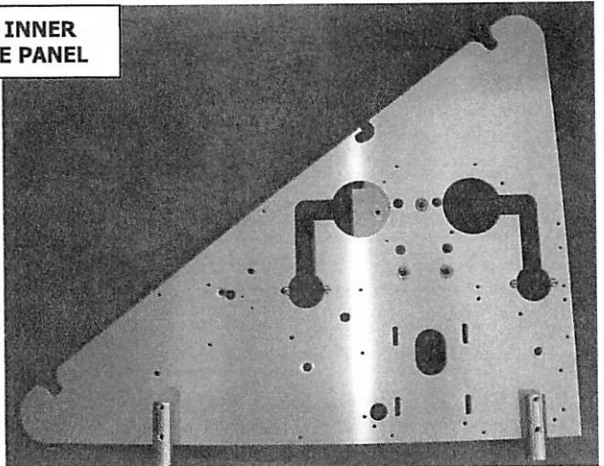
**IDLER SPROCKET BRACKET ON OUTER LEFT PANEL**



**INNER PANEL WITH IDLER SPROCKET BRACKET ASSEMBLY**

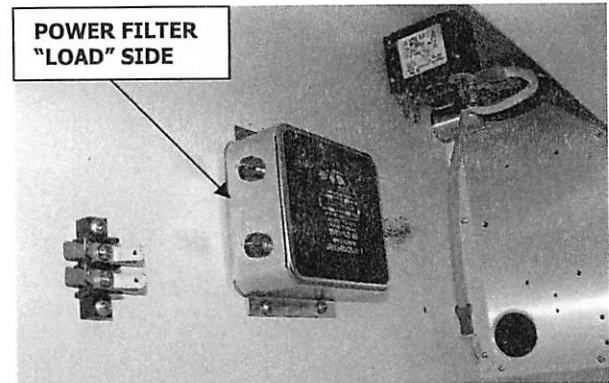


**OUTER & INNER LEFT SIDE PANEL**



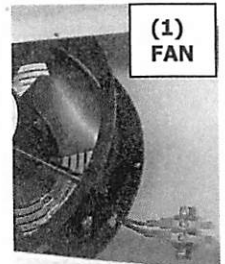
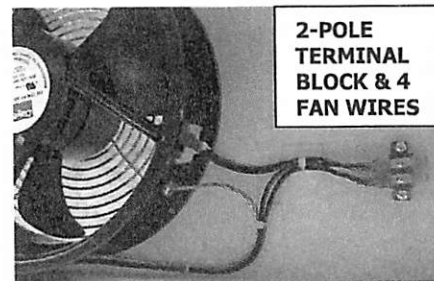
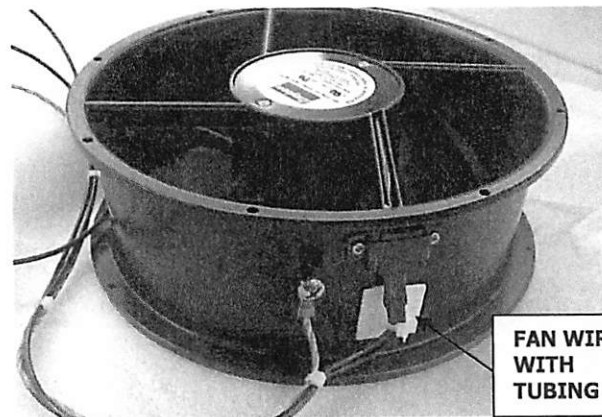
# DIGITAL 42/60 NRTL BOTTOM MOTOR COVER

- 1) PREPARE THE NRTL DIGITAL 42 OR 60 BOTTOM MOTOR COVER (D105 093.4) OR (D60 093.4) LOFT 3 BY PLACING THE BOTTOM MOTOR COVER ON A WORK TABLE, ORIENTED RIGHT SIDE UP, SO PARTS CAN BE ADDED TO THE INSIDE.

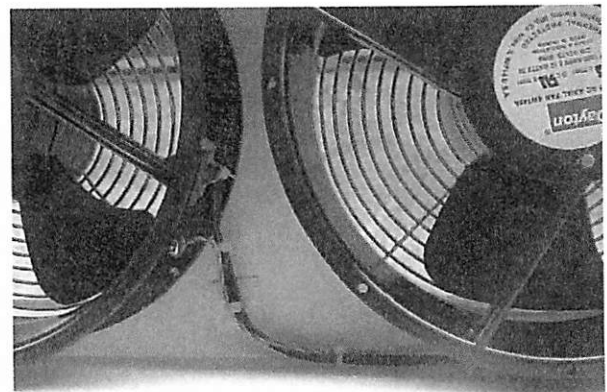


- 2) SECURE POWER FILTER (PRF142) AS08 TO THE BOTTOM COVER WITH "LINE" TERMINALS FACING OUTWARD, TOWARD THE RIGHT SIDE PANEL END AND "LOAD" TERMINALS FACING THE FAN. USE (4) 8-32 X 1/4 RH AND (4) #8 STAR WASHERS.

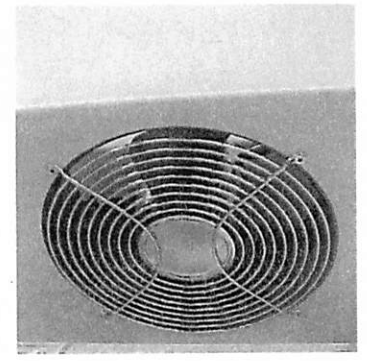
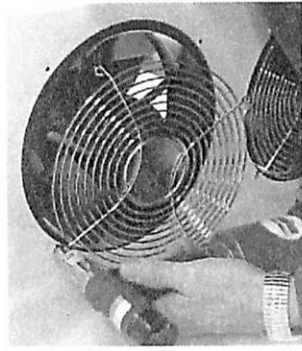
- 3) FOR DI60 WIRE (2) 10" AXIAL FANS (PRF130) AS09 BY CRIMPING A FIF (PRT310) ONTO *ONE END* OF BOTH A 24" GRAY AND 24" BROWN 18 GAUGE WIRE AND BOTH 7" GRAY AND BROWN 18 GAUGE WIRE. PLACE 1" OF 3/8 BLACK INSULATING TUBING (PRI164) AS09 OVER EACH PAIR OF CONNECTIONS. THE FAN WITH THE 24" WIRES LOCATES NEAR THE LEFT SIDE PANEL, FURTHER FROM TERMINAL BLOCK, AND THE FAN WITH 7" WIRES IS CLOSER TO THE TERMINAL BLOCK. CONNECT WIRES TO FAN POSTS. HEAT SHRINK THE TUBING, CABLE TIE TO PRESS CLIP ON FAN. CREATE A "DAISY CHAIN" FAN-TO-FAN FOR GROUND WIRES, DOUBLED BY TERMINAL BLOCK. USE FAN SCREW PROVIDED AND #10 STAR WASHER FOR GROUND WIRE. FOR DI42 USE ONE FAN WITH 7" WIRES AND HARNESS GROUND.



- 4) MOVE MOTOR COVER ONTO ITS FRONT. USING (4) 5/32 X 3/8 BH POP RIVETS (.15600Q06) INSERTED THROUGH LARGE 10" FAN GUARD (PRF121) AS07 FROM OUTER MOTOR COVER ALIGN AND CONNECT 10" AXIAL FAN INSIDE. BEFORE CONNECTING FAN, BE CERTAIN THE PRINTING ON FAN FACES UPWARD AND THE WIRE CONNECTIONS ARE FACING THE TERMINAL BLOCK "AIRFLOW INWARD." BE CONSISTENT WITH FAN GUARD ORIENTATION.



5) FROM AS09 FOR DI42 ATTACH (2) KULKA 180 DEGREE TERMINAL POSTS (PRT306) ONTO A KULKA 2 COND. TERMINAL BLOCK (PRT304) AND SECURE TO INSIDE OF MOTOR COVER USING (2) 8-32 X 1/2 RH. FOR THE DI60 CONNECT (2) KULKA 180 DEGREE TERMINALS AND (2) KULKA 45 DEGREE TERMINALS (PRT307) AND SECURE TO MOTOR COVER WITH SAME HARDWARE. CONNECT FAN WIRES TO TERMINAL BLOCK WITH FULLY INSULATED FEMALE FASTONS (PRT331).



6) FROM AS09 UNTHREAD STRAIN RELIEF (PRB095) AND SLIDE ONTO DI60 POWER CORD (PRC219) OR DI42 POWER CORD (PRC218) AS14. UNTHREAD RELIEF AND SLIDE UP WIRES, TIGHTEN. INSERT POWER CORD THROUGH COVER AND TIGHTEN WITH TOOTHED WASHER.



PRC218 WITH PRB095

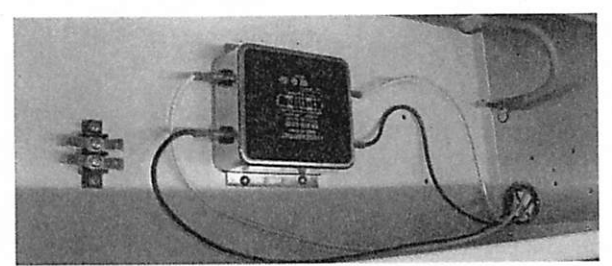


PRC219 & PRB095

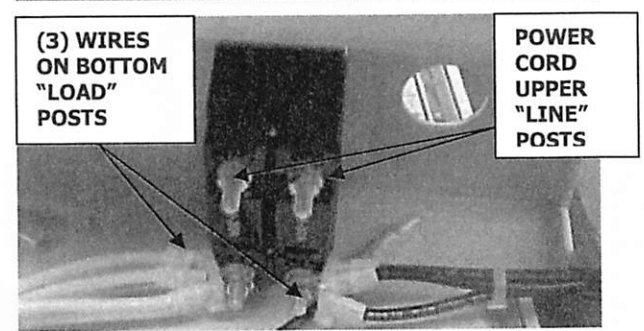
7) BEFORE INSERTING DI60 BREAKER 40 AMP (PRS350) RACK 1 OR DI42 BREAKER 30 AMP (PRS057) RACK 1 ATTACH BLACK AND WHITE RING WIRES FROM DIGITAL 42/60 WIRING PACK (PRW346C) RACK 2 TO BOTTOM "LOAD" POSTS: TOOTHED WASHER, WIRES, WASHER AND NUT. THE (3) BLACK WIRES GO BY SIDE PANEL AND (3) WHITE WIRES ARE INWARD. CABEL TIE EACH SET OF (3) WIRES. INSERT BREAKER FROM INSIDE MOTOR COVER, "OFF" POSITION IS PRINTED AND VISABLE WHEN SWITCH LEVER IS DOWN. SECURE BREAKER TO BOTTOM COVER WITH (4) 6-32 X 1/4 PH.



STRAIN RELIEF

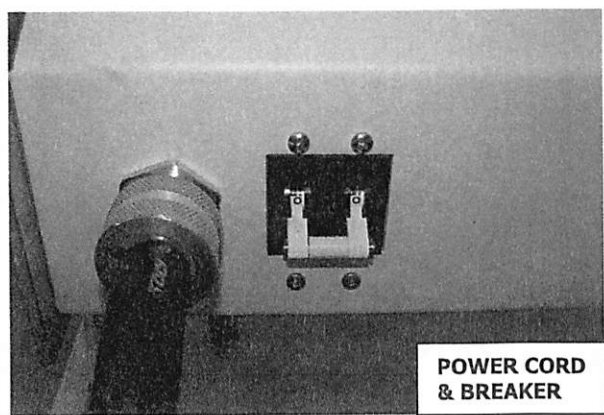


8) CONNECT WHITE POWER CORD WIRE TO INNER TOP "LINE" BREAKER POST AND BLACK POWER CORD TO OUTER TOP "LINE" POST, NEAREST SIDE PANEL.

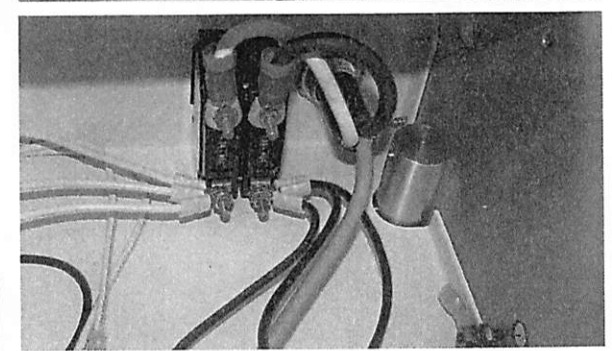


(3) WIRES ON BOTTOM "LOAD" POSTS

POWER CORD UPPER "LINE" POSTS



POWER CORD & BREAKER



# DIGITAL 42/60 POTENTIOMETER

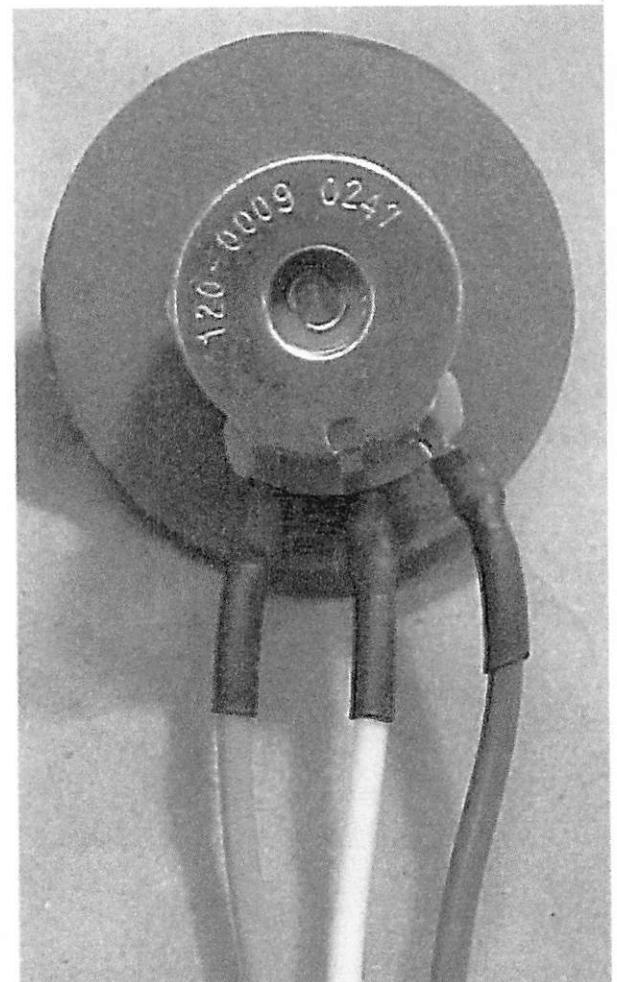
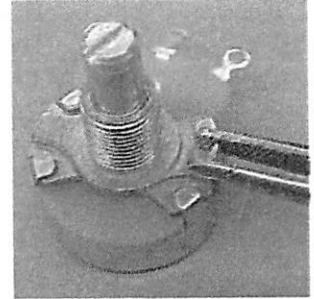
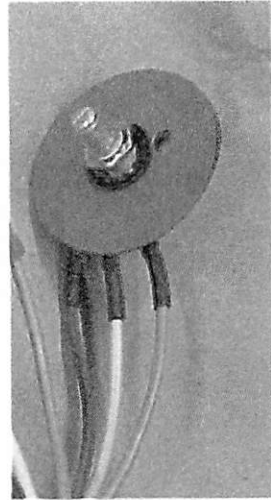
*MM 23061C*

- 1) BREAK OFF TAB FROM STEM SIDE OF POTENTIOMETER IN MINARIK SPEED CONTROL UNIT (PRM218A) AS08.

- 2) CUT (3)  $\frac{3}{4}$  INCH PIECES OF  $\frac{3}{16}$  INCH BLACK SHRINK INSULATION TUBING (PRI165) CAB1 AND SLIDE ONE PIECE OF TUBING OVER EACH INDEPENDENT OPEN ENDED ORANGE, YELLOW AND GRAY WIRES IN THE DIGITAL WIRING HARNESS (PRW346A) A831.

*AS14*

- 3) WITH STEM FROM POTENTIOMETER FACING AWAY FROM YOU AND TERMINAL POSTS FACING DOWNWARD, CAREFULLY SOLDER ORANGE WIRE TO LEFT POST, YELLOW WIRE TO MIDDLE POST AND GRAY WIRE TO RIGHT POST.
- 4) SLIDE THE THREE PIECES OF BLACK INSULATION TUBING UP OVER SOLDERED CONNECTIONS, COVERING AS MUCH TERMINAL POST AS POSSIBLE. HOLD TUBING IN THAT POSITION WITH NEEDLE NOSE PLIERS; HEAT SHRINK TUBING.
- 5) ADD WIRED POTENTIOMETER TO FACIA ASSEMBLY, WIRES FACING CONTROL BUTTONS (SEE FACIA ASSEMBLY PAGE). PLACE LARGE PAPER WASHER ON INSIDE OF FACIA, AND SECURE OUTSIDE OF FACIA WITH TOOTHED WASHER AND HEX NUT.
- 6) POSITION AND SECURE MINARIK KNOB (PRM221A) AS08 ONTO POTENTIOMETER STEM ON OUTSIDE OF FACIA.



Rev.	Description	Date	App. By

# DIGITAL 42, 60, AND HRD44 FACIA HARNESS CONNECTIONS

## TOP HEAT RED

NC	<b>X</b>		<b>X</b>	NC
		WHT/BLK		
NO	BRN/BLK		GRY/BLK	NO
		RED		
C	YEL/BLK		ORA/BLK	C

## MOMENTARY RED

NC	<b>X</b>		JUMPER	NC
		BLUE		
NO	JUMPER		<b>X</b>	NO
		JUMPER		
C	WHT		BLK	C

## FWD / REV

<b>X</b>	<b>X</b>
JUMPER	GREY
BLK	BROWN

## DRIVE GREEN

NC	<b>X</b>		ORA (BAG)	NC
		BLK		
NO	YEL		<b>X</b>	NO
		YEL		
C	RED (BAG)		ORA	C


## FAN BLUE

NC	<b>X</b>		<b>X</b>	NC
		YEL/BLK		
NO	JUMPER		RED/BLU	NO
		JUMPER		
C	BLK/WHT		BLK/WHT	C

## BOTTOM HEAT RED

NC	<b>X</b>		<b>X</b>	NC
		WHT/GRN		
NO	WHT/BLU		WHT/RED	NO
		GREY		
C	BLU/RED		BRN/WHT	C

### Tolerances Unless Otherwise Specified

Basic Dimension	UP TO 6.000	6.001 TO 24.000	ABOVE 24.000	$\pm 0^\circ \pm 30'$
2 Place Dim.	$\pm .005$	$\pm .010$	$\pm .031$	
3 Place Dim.	$\pm .002$	$\pm .005$	$\pm .010$	

Finish Specs:

**LEDCO** INC.

4265 N. Main St., Henlock N.Y. 14466  
Ph # 585-367-2392 Fax # 585-367-2978

Material Specs: FACIA: D105 220.4, WIRING HARNESS

U/M

QTY.

WGT.

Drawn By: RON

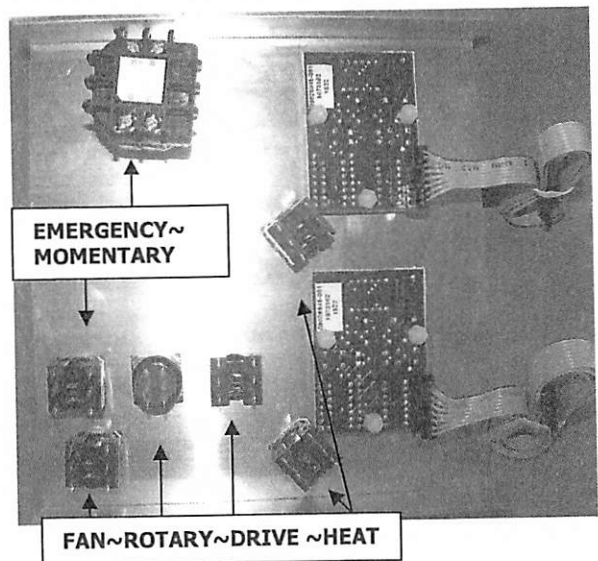
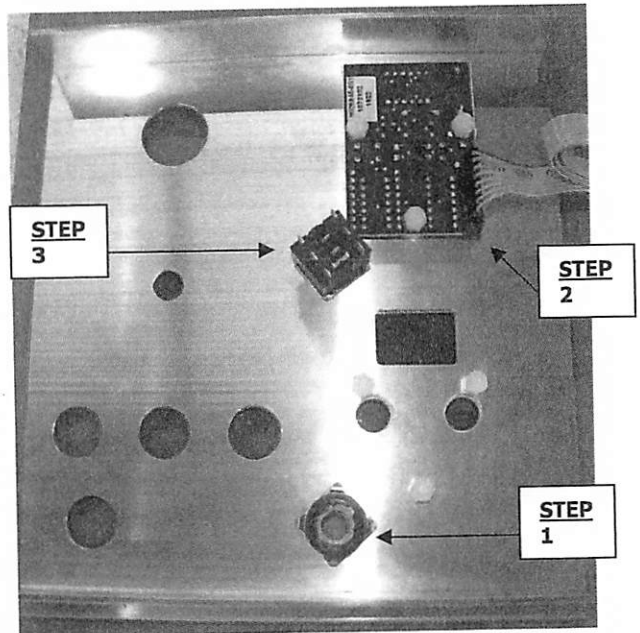
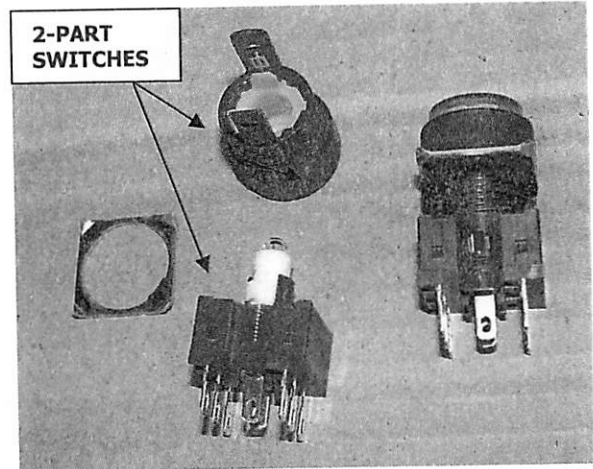
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Date: 06/18/2015

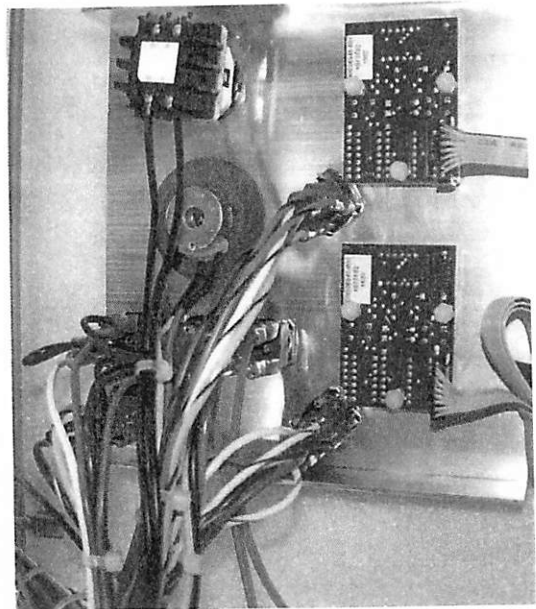
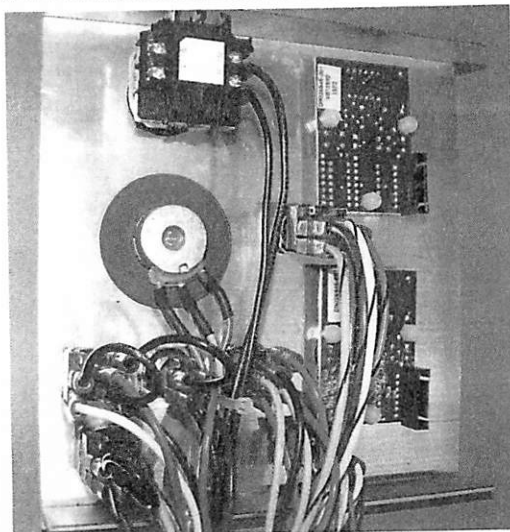
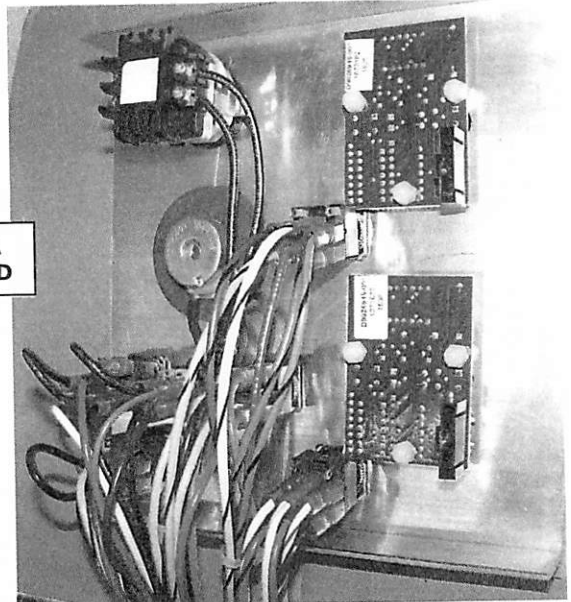
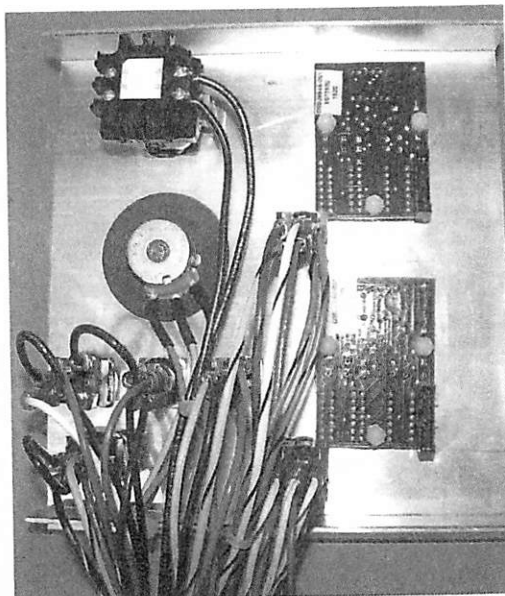
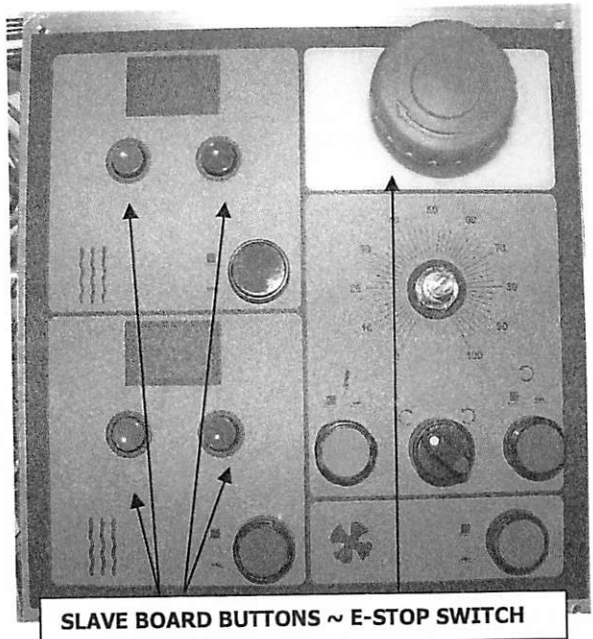
# DIGITAL 42/60 FACIA – 6/2015

A512

- 1) ATTACH (6) STANDOFFS (D25 010.4) RACK 1 TO FACIA CONTROL PANEL (D105 220.4) RACK 2 WITH (6) 4-40 X 1/4 FH.
- 2) ADHERE DIGITAL CONTROL DECAL (LAB98) RACK 2 TO FRONT OF FACIA CONTROL PANEL, CENTERING CAREFULLY OVER HOLES.
- 3) INSERT (2) POS RED LIGHTED ON/OFF HEAT SWITCHES (PRS079) RACK 1 BY SLAVE BOARD AREA. INSERT THE RED SECTION AND ON THE INNER FACIA ORIENT THE LARGER TAB UPWARD, SLIDE ON METAL KEEPER AND ANGLE WITH THE CORNER RIGHT OF LARGER TAB FACING UPWARD. THREAD AND TIGHTEN NUT WITH TOOL.
- 4) PLACE SLAVE BOARDS FROM HEAT CONTROLLER KIT (PRH130) AS08 ON STANDOFFS. COMPONENTS MAY BE SLIGHTLY BENT FOR BETTER SLAVE FIT. SECURE SLAVE BOARD TO STANDOFFS WITH (6) 4-40 NYLON ACORN NUT (.112LDR00) RACK 1.
- 5) SLIDE TERMINAL POST SECTION OF SWITCH ONTO SECURED SECTION. THE 'C' COMMON POST IS DOWNWARD.
- 6) INSERT GREEN LIGHTED DRIVE SWITCH (PRS080) RACK 1 IN HOLE CLOSEST TO ON/OFF HEAT SWITCHES. ORIENT WITH LARGER TAP UPWARD SO 'C' COMMON POST WILL BE DOWNWARD. TIGHTEN WITH CASTLE TOOL.
- 7) NEXT TO THE GREEN LIGHTED DRIVE SWITCH INSERT THE ROTARY FORWARD/REVERSE SWITCH (PRS020) RACK 1. CHECK "UP" POSITION AND TIGHTEN WITH CASTLE LOCK TOOL.
- 8) NEXT TO THE ROTARY SWITCH INSERT THE RED LIGHTED MOMENTARY REVERSE SWITCH (PRS077) RACK 1. LARGER TAP UPWARD 'C' POST WILL BE DOWNWARD AND TIGHTEN WITH CASTLE LOCK TOOL.



- 9) BELOW THE MOMENTARY SWITCH INSERT THE BLUE LIGHTED FAN SWITCH (PRS081) RACK 1. ALIGN LARGER TAB UPWARD SO 'C' POST IS DOWNWARD AND TIGHTEN WITH CASTLE TOOL.
- 10) IN LARGER HOLE INSERT EMERGENCY STOP (PRS374) AS08. ALIGN "TOP" AT 10 O'CLOCK, SO WIRES WILL CONNECT DOWNWARD. TIGHTEN WITH.
- 11) SNAP RED PUSH BUTTON CAP (PRK185) AS08 ONTO LEFT SLAVE BOARD STEM AND BLUE PUSH BUTTON CAP (PRK186) AS08 ONTO RIGHT SLAVE BOARD STEM.
- 12) INSERT PRE-WIRED POTENTIOMETER, WIRES DOWNWARD. USE HEX NUT AND WASHERS PROVIDED. SECURE MINARIK KNOB (PRM221A) AS08 ONTO STEM.
- 13) FROM RACK 2 WIRE FACIA. USE D60 HARNESS (PRW346) AND (3) JUMPERS.





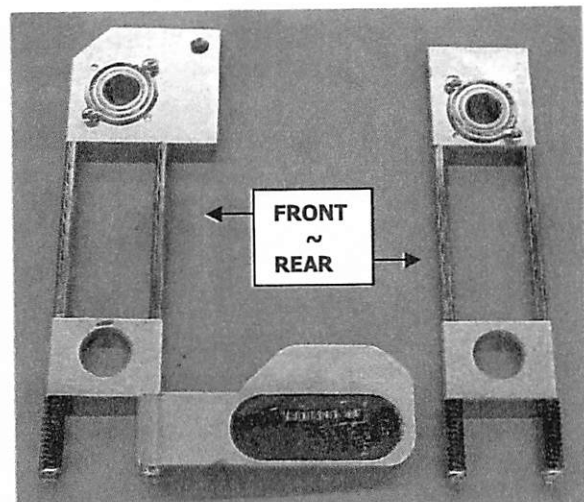
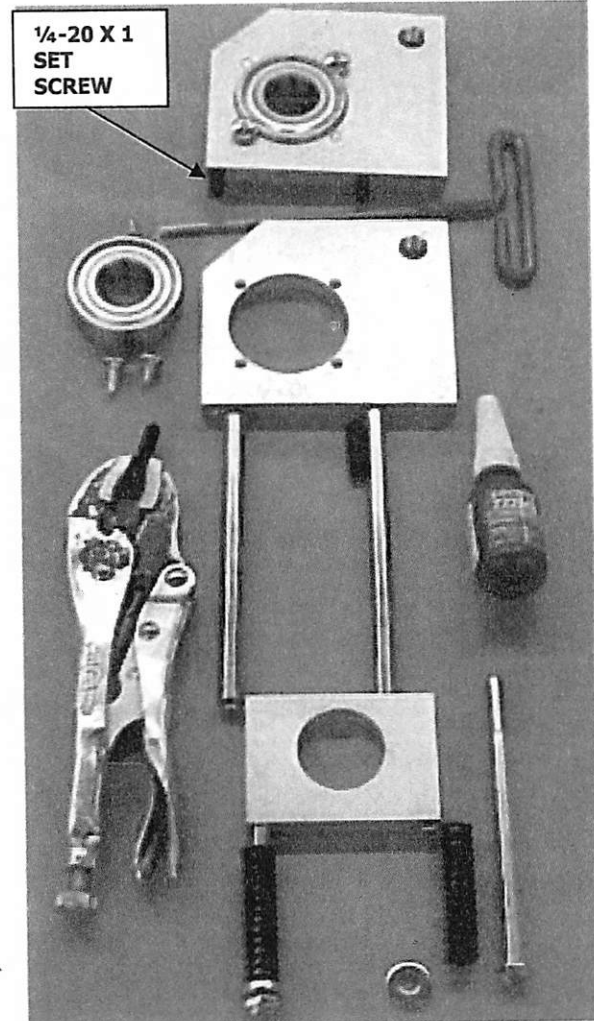
# DIGITAL 42/60 FRONT & BACK PRESSURE PLATE

- 1) ARBOR PRESS R14ZZ ROLLER BALL BEARING (PRB087) AS07 INTO TOP FRONT RUBBER ROLL PRESSURE PLATE (LC38 056.4) RACK 2. GAUGE THIS SO THE ROLLER BALL BEARING IS FLUSH WITH THE OUTSIDE WHEN PRESSURE PLATE IS PLACED ON SIDE PANEL. THERE IS A RIGHT AND LEFT TOP FRONT RUBBER ROLL PRESSURE PLATE. THE DROPPED TOP CORNER OF THE PRESSURE PLATE FACES THE FRONT OF THE MACHINE. THE EXCESS ROLLER BALL BEARING WILL BE ON THE INSIDE OF BOTH PLATES. SECURE ROLLER BALL BEARING WITH (2) 10-32 X 3/8 TRUSSHEAD SCREWS PLACED DIAGONALLY ON THE OUTSIDE AND (2) 10-32 X 1/2 TRUSSHEADS ON THE REMAINING INNER DIAGONAL THREADS.

- 2) PLACE LOCTITE ON HALF OF (2) 1/4-20 X 1 SHSS AND INSERT THAT HALF INTO TOP FRONT RUBBER ROLL PRESSURE PLATE. THEN LOCTITE EXPOSED REMAINING HALF OF SHSS AND THREAD UP (2) PRESSURE PLATE SHAFTS (LC38 059.4) RACK 2.

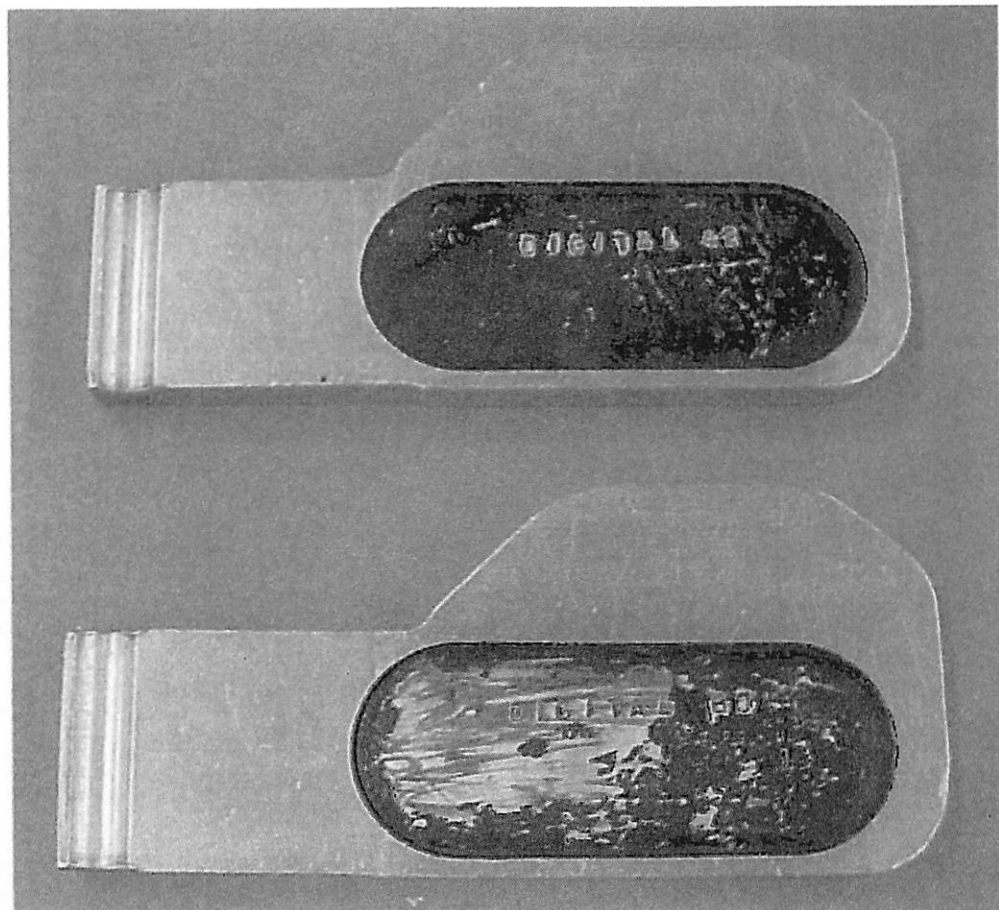
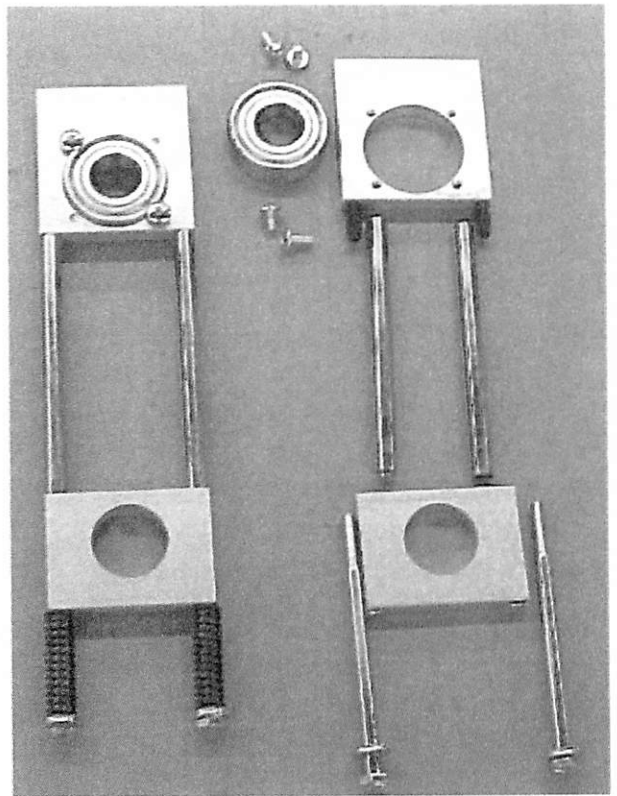
- 3) PLACE (1) 1/4 X 5/8 X 1/8 FLAT WASHER ON EACH OF (2) 1/4-20 X 4 1/2 HEX BOLTS. ADD A BLACK PAINTED PRESSURE SPRING (PRS243) RACK 2 TO EACH HEX BOLT.

- 4) SLIDE THIS ASSEMBLY THROUGH THE BOTTOM RUBBER ROLL PRESSURE PLATE (LC38 057.4) RACK 2 WITH THE CAM SHAFT HOLE TO THE TOP AS PICTURED. THIS IS CRITICAL FOR FIT. THREAD INTO THE PRESSURE PLATE SHAFTS. USE RED GAUGE TO SET SPRING PRESSURE ON DIGITAL 60 MACHINES. USE BLUE GAUGE TO SET SPRING PRESSURE ON DIGITAL 42 MACHINES. THESE GAUGES ARE STORED ON WB09.



*190 EBB06  
190 EBB08  
250 mprack  
5062002  
12-20 Nov 70*

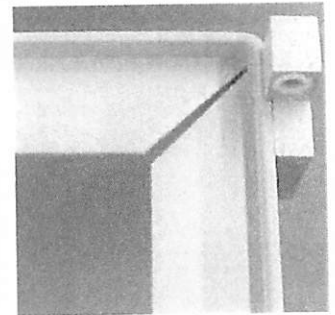
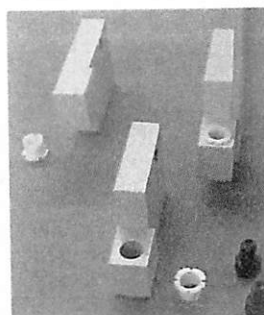
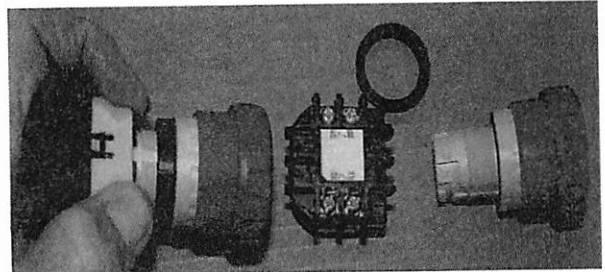
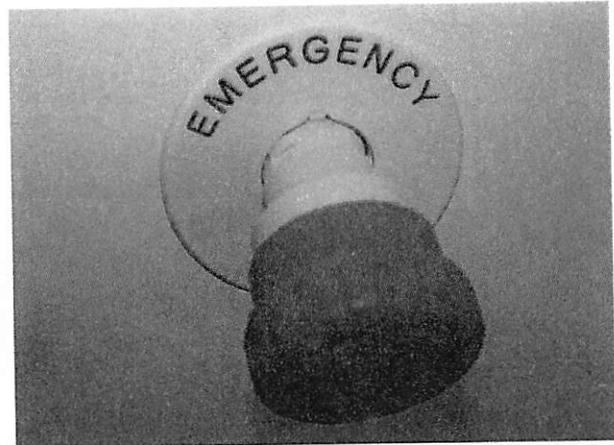
- 5) **PLACE A BLUE MARK ON THE INSIDE OF THE BOTTOM RUBBER ROLL PRESSURE PLATE TO IDENTIFY DIGITAL 42 AND PLACE A RED MARK ON THE INSIDE OF THE BOTTOM RUBBER ROLL PRESSURE PLATE TO IDENTIFY DIGITAL 60 PLATES.**
- 6) **THE RIGHT AND LEFT TOP REAR PRESSURE PLATES (LC38 058.4) RACK 2 ARE ASSEMBLED EXACTLY LIKE THE FRONT PRESSURE PLATES EXCEPT THE PRESSURE PLATE ITSELF IS DIFFERENT. THE SAME HARDWARE AND PROCEDURE IS USED OTHERWISE. SEE PHOTO.**
- 7) **STORE ASSEMBLED PRESSURE PLATES UNTIL READY FOR MACHINE ASSEMBLY.**
- 8) **PICTURED BELOW IS THE BLUE DIGITAL 42 GAUGE AND THE RED DIGITAL 60 GAUGE.**



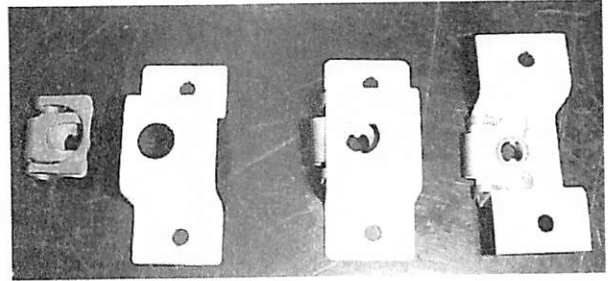
# DIGITAL NRTL 42/60

## RIGHT UPPER HOUSING ASSEMBLY

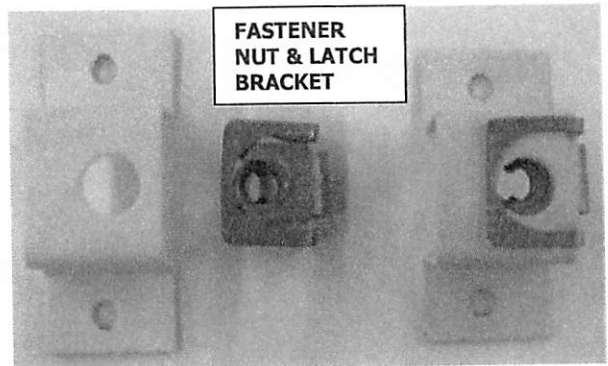
- 1) THE NRTL RIGHT UPPER HOUSING (D105 094.4RT (LOFT 5) HAS (2) EMERGENCY STOP SWITCH. SECURE THE REAR E-STOP SWITCH (PRS374) AS08 AS FOLLOWS. THE FRONT E-STOP SWITCH IS IN THE FACIA ASSEMBLY.
- 2) CENTER THE "EMERGENCY" PRINTING ON THE YELLOW EMERGENCY STOP WASHER (PRS375) AS08 OVER THE REAR OPENING IN THE UPPER HOUSING.
- 3) SEPARATE THE E-STOP SWITCH BY DEPRESSING THE SPRING ON THE YELLOW SCREW SECTION *DOWNWARD AND TWIST*. UNTHREAD PLASTIC NUT AND INSERT THE READ BUTTON SECTION WITH "TOP" INDICATION UPWARD, ALIGNING YELLOW WASHER TOOTH WITH BUTTON CHANNEL. RETHREAD PLASTIC NUT ON INNER HOUSING. TIGHTEN WITH IN-HOUSE "CASTLE" TOOL, KEEPING THE "EMERGENCY" PRINTING CENTERED. DO NOT SECURE THE WIRE CONNECTION SECTION AT THIS TIME. IT IS EASIER TO WIRE E-STOP SWITCH AND TO SECURE HOUSING TO THE SIDE PANEL WITHOUT THE SCREW SECTION ON.
- 4) FROM RACK 1 INSERT A 3/16 NYLINER BEARING (PRB202) INTO BOTH FIXED HINGE BLOCK: LOWER RIGHT/UPPER LEFT (D105 105.4B) AND FIXED HINGE BLOCK: UPPER RIGHT/LOWER LEFT (D105 105.4T).
- 5) ATTACH THE RIGHT UPPER AND LOWER FIXED HINGE BLOCKS TO RIGHT HOUSING, POSITIONING WHITE NYLINER BEARINGS FACING EACH OTHER. USE (4) 8-32 X 1/4 SHCS FROM THE INNER HOUSING INTO HINGE BLOCK THREADS TO SECURE.



6) THE RIGHT HOUSING HAS (2) LATCH KIT ASSEMBLIES ON THE OUTER HOUSING LIP; ONE ON THE FRONT AND ONE ON THE ANGLED FRONT SECTION.



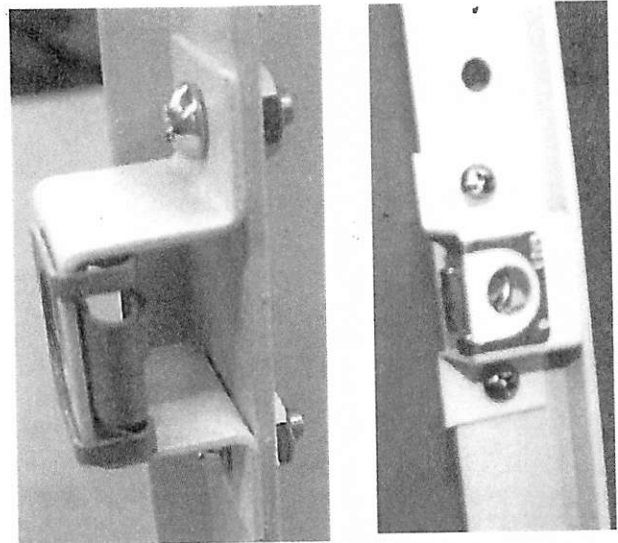
7) FROM AS08 USE 1/4 TURN FASTENER NUT INCLUDED IN THE 1/4 TURN LATCH KIT (PML002). SLIDE (2) QUARTER TURN FASTENER NUTS ONTO (2) HOUSING COVER LATCH BRACKETS (D105 097.4) RACK 1. SLIDE NUTS ON FROM SIDE CLOSER TO HOLE, TEETH INWARD.



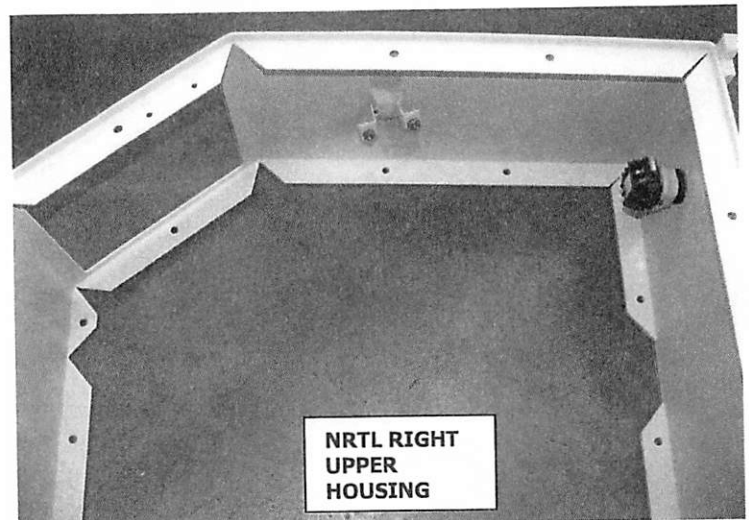
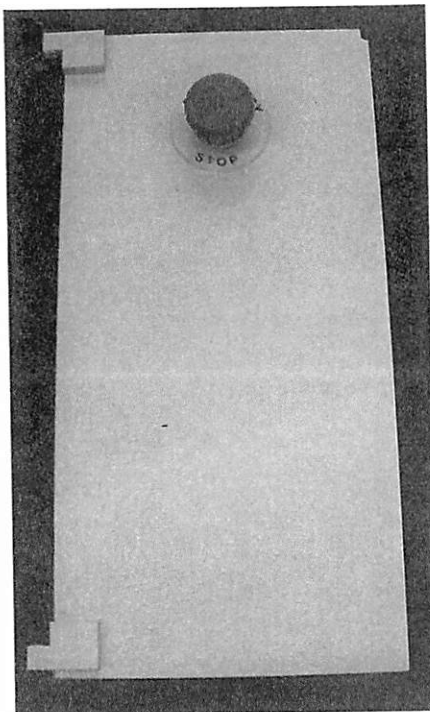
8) USE ADHESIVE TAPE TO TEMPORARILY SECURE THE NUT/BRACKET ASSEMBLY FOR THE ANGLED FRONT SECTION TO THE INNER TOP HOUSING BY. THIS ALLOWS ROOM TO WORK WITH FACIA.

*Right side*

9) SECURE THE LOWER NUT/BRACKET SET TO THE FRONT HOUSING USING (2) 8-32 X 3/8 RH ON THE OUTER LIP AND (2) #8 KEPS HEX NUTS ON THE INNER LIP.

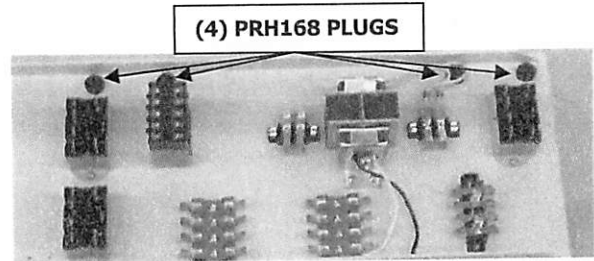


10) STORE ASSEMBLED HOUSING ON SHELF UNTIL NEEDED.

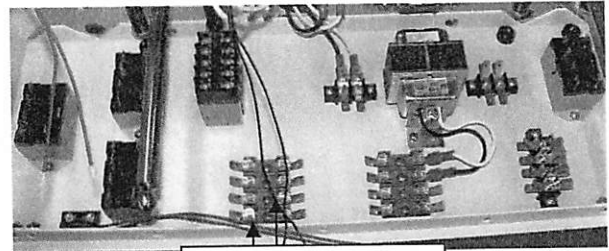


# DIGITAL 42/60 NRTL LOWER RIGHT HOUSING

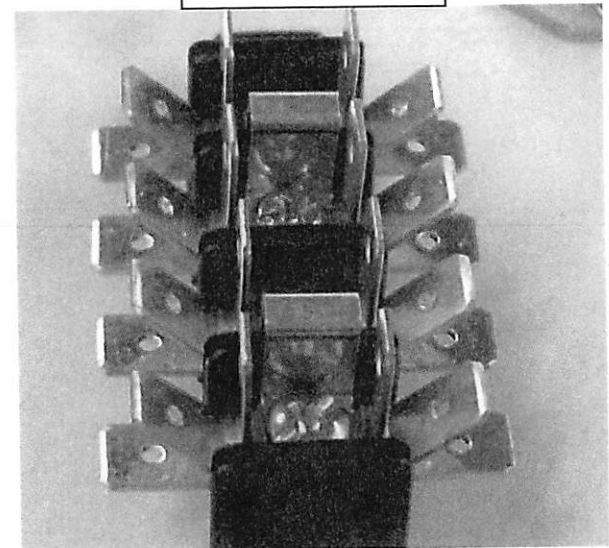
- 1) INSERT (4) BLACK PLASTIC HOLE PLUGS (PRH168) AS07 INTO LOWER RIGHT DIG. HOUSING (D105 094.4RB) LOFT 5.



- 2) ATTACH (4) OMRON RELAYS 24 VAC (PRR251) RACK 1 WITH (8) 8-32 X 1/4 RH. DOUBLE TERMINAL POSTS TO THE RIGHT/REAR ON ALL FOUR RELAYS.

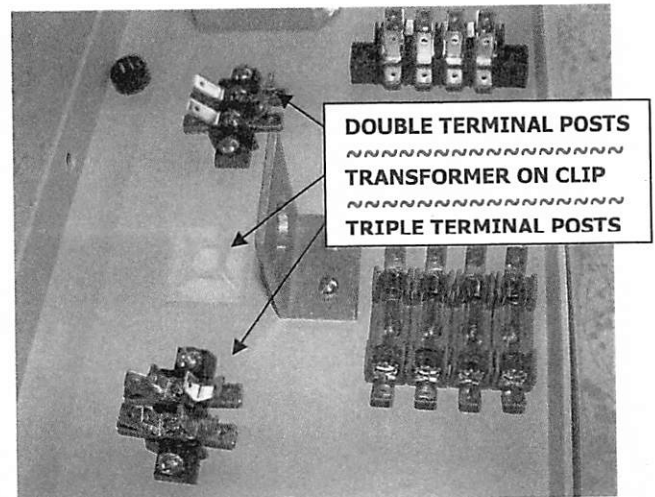


- 3) FROM AS07 ATTACH (8) FUSE HOLDERS (PRF126) USING (8) 6-32 X 1/4 PH. INSERT (6) FAST-ACTING 1/2 AMP FUSES (PRF136) TO THE (4) FUSE HOLDERS ON THE RIGHT NEAREST THE ED TERMINAL BLOCK AND THE INNER TWO NEAREST THE FORWARD/REVERSE RELAY. THE REMAINING (2) FUSE HOLDERS ON THE LEFT OUTSIDE GROUP, INDICATED IN THE PICTURE RECEIVE (2) 1 1/2 AMP FUSES (PRF128).



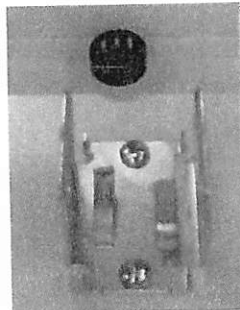
- 4) REMOVE THE JUMPER ON ED TERMINAL BLOCK (PRT301.5) LD01. ADD (4) KULKA 90 DEGREE TERMINAL POSTS (PRT308) AS09 TO POSTS ON TERMINAL BLOCK. PLACE ED TERMINAL BLOCK JUMPER OVER TO CONNECT THE FOUR POSTS FROM ONE SIDE AND ADD ANOTHER KULKA TERMINAL JUMPER (PRT309) AS09 TO CONNECT THE REMAINING FOUR POSTS. ATTACH TERMINAL BLOCK TO HOUSING WITH (2) 8-32 X 1/4 RH.

- 5) FROM AS09: REMOVE SCREWS FROM (2) KULKA TERMINAL BLOCKS (PRT304). ON ONE TERMINAL BLOCK ADD (2) EACH: 180 DEGREE, 45 DEGREE, AND 90 DEGREE TERMINAL POSTS, REPLACE SCREWS. THIS TERMINAL BLOCK CONNECTS LEFT OF THE TRANSFORMER. THE OTHER (PRT304) TERMINAL BLOCK RECEIVES (2) EACH: 180 DEGREE AND 45 DEGREE TERMINAL POSTS, REPLACE SCREWS. ATTACH THIS DOUBLE POSTED TERMINAL BLOCK RIGHT OF TRANSFORMER BY ED TERMINAL BLOCK WITH (4) 8-32 X 1/2 PH.

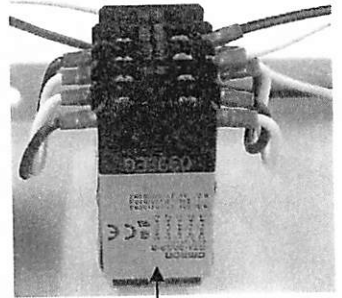


- 6) FROM RACK 1 ATTACH RELAY MOUNTING BRACKET (PRR252) USING (2) 8-32 X 1/4 RH. CLIP IN OMRON RELAY (PRR250) WITH THE PRINTING FACING OUT.
- 7) WITH THE SCREW OPENINGS FACING THE FRONT OF THE BOTTOM HOUSING AND THE LONGER SIDE UPWARD, TO THE REAR, SECURE THE MOUNTING FOOT BRACKET (PRT336.4) RACK 1 THAT HOLDS THE 24 VOLT TRANSFORMER (PRT335) RACK 1. ATTACH MOUNTING THE BRACKET WITH (2) 6-32 X 1/4 PH. TRIM OFF CABLE TIE CATCH FROM PRESS CLIP (PRC081) AS07 AND ATTACH BETWEEN TWO SMALLER TERMINAL BLOCKS POSITIONED SO TRANSFORMER WILL REST ON CLIP INSTEAD OF HOUSING. CONNECT (2) YELLOW WIRES (SEE PHOTO POSITION) TO BACK OF TRANSFORMER WITH FORK CONNECTORS BEFORE ATTACHING TRANSFORMER TO BRACKET.
- 8) ATTACH PROXIMITY SWITCH MAGNET (PRS351) RACK 1 BY LIP WITH (2) 4-40 X 3/8 PH FROM BOTTOM UP AND (2) 4-40 HEX NUTS INSIDE. PRINTING FACES UP.
- 9) ATTACH (2) DIGITAL MACHINE HOUSING CORNER BRACES (D105 098.4) RACK 1 AS PICTURED USING (4) 8-32 X 3/8 FHMS ON OUTER LIP AND (4) 8-32 KEPS NUT ON INNER LIP.
- 10) ATTACH WIRES FROM SEPARATE BAG IN WIRING HARNESS (PRW345A) RACK 2.

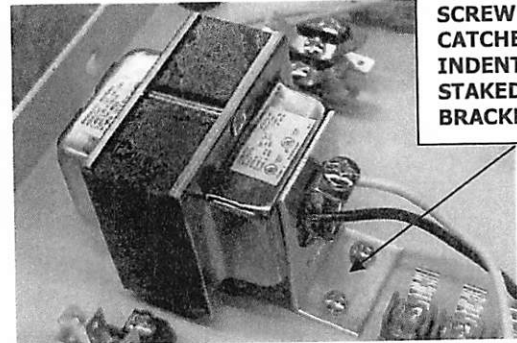
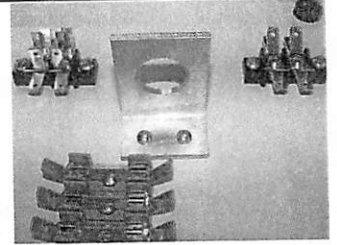
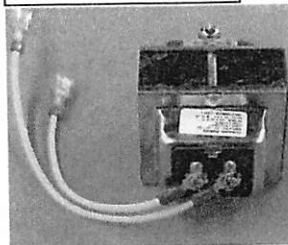
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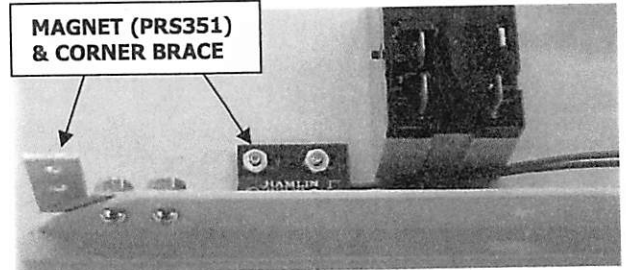
RELAY MTNG BRK



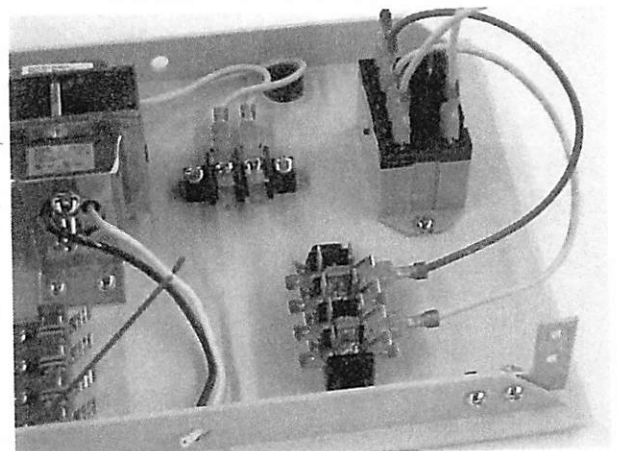
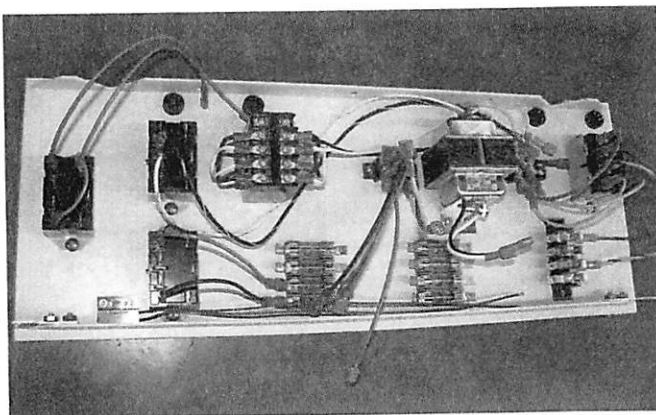
RELAY PRINT OUTWARD



SCREW CATCHES ON INDENTATION STAKED IN BRACKET

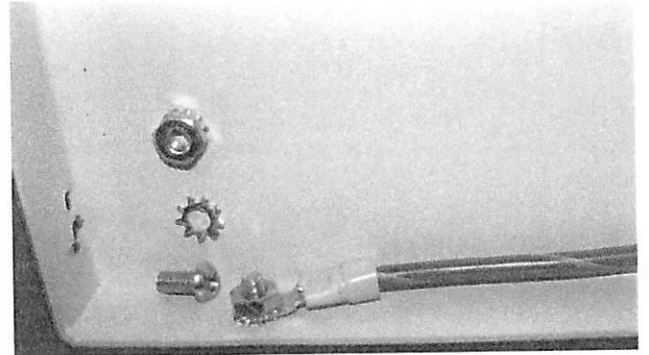


MAGNET (PRS351) & CORNER BRACE



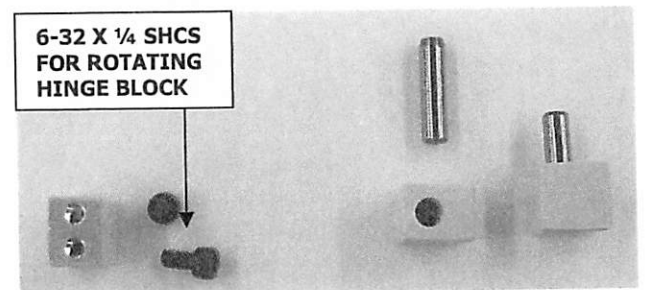
# DIGITAL 42/60 DOOR ASSEMBLY 2015

- 1) BEFORE ASSEMBLY OF THE RIGHT DOOR (D105 095.4R) AS18 USE A #19 DRILL AND OPEN A CLEARANCE HOLE IN THE BACK BOTTOM LIP MEASURING 1 1/4" FROM CORNER AND 12/32" ACROSS LIP.

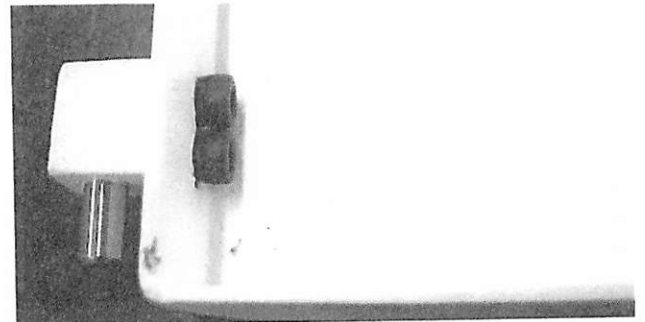


- 2) SECURE AN EARTH GROUND 12 GAUGE, 6" WIRE (PRS004) RACK 1 TO INNER DOOR LIP THROUGH THE CLEARANCE HOLE. USE 8-32 X 3/8 RHMS ON OUTER LIP AND AN #8 STAR WASHER WITH KEPS HEX NUT ON INNER LIP.

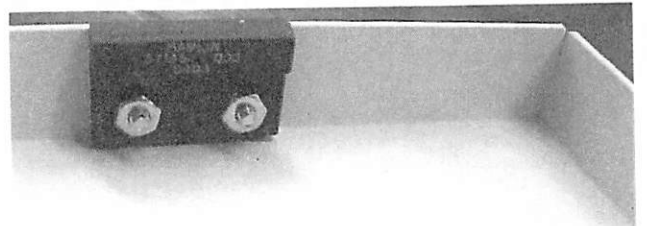
- 3) ARBOR PRESS A 3/16 X 3/4 DOWEL PIN AS12 INTO (4) ROTATING HINGE BLOCKS (D105 106.4) RACK 1. THERE ARE (2) HINGE BLOCKS USED PER DOOR.



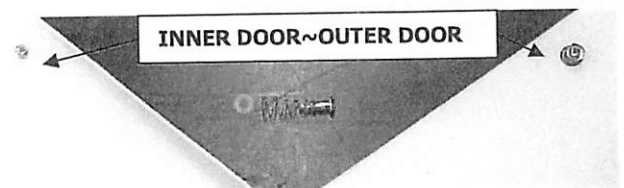
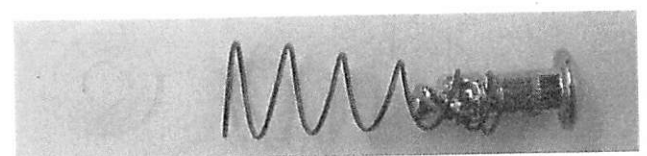
- 4) ATTACH (2) ROTATING HINGE BLOCKS TO BACK LIP OF RIGHT AND LEFT DOORS (D105 095.4L) RACK 1. THE DOWEL PINS FACE UP ON TOP AND DOWN ON THE BOTTOM. USE (4) 6-32 X 1/4 SHCS.



- 5) ON BOTTOM LIP OF RIGHT AND LEFT DOOR ATTACH A MAGNET (PRS352) RACK 1 USING (2) 4-40 X 3/8 PH THROUGH OUTER LIP AND (2) 4-40 HEX NUTS ON INNER LIP, PER MAGNET.



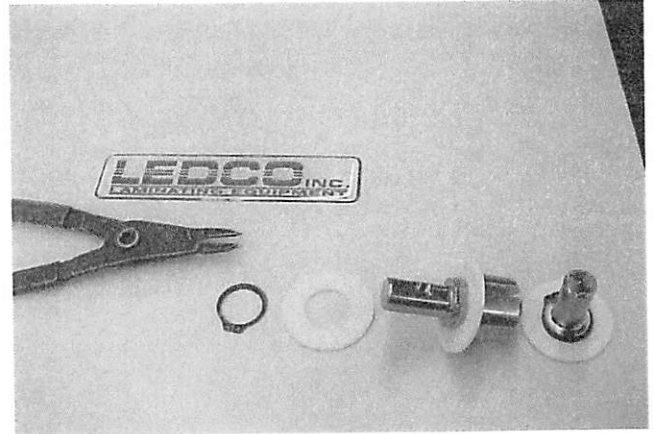
- 6) USING THE 1/4 TURN DOOR LATCH KIT (PML002) AS08 PLACE SMALLER END OF SPRING ON QUARTER TURN FASTENER SCREW. INSERT THE QUARTER TURN FASTENER SCREW INTO DOOR LATCH POSITION ON THE OUTER DOOR, DEPRESSING SPRING. FROM THE INNER DOOR, SLIDE THE PLASTIC WASHER OVER THE THREADS OF THE QUARTER TURN FASTENER SCREW, UNTIL WASHER RESTS ON SHAFT PAST THREADS. THERE ARE (2) OF THE 1/4 TURN DOOR LATCH FASTENER ASSEMBLIES PER DOOR.



7) USE A ROTOBUR TO REMOVE EXCESS PAINT AND OPEN BOTH HOLES FOR HANDLES.

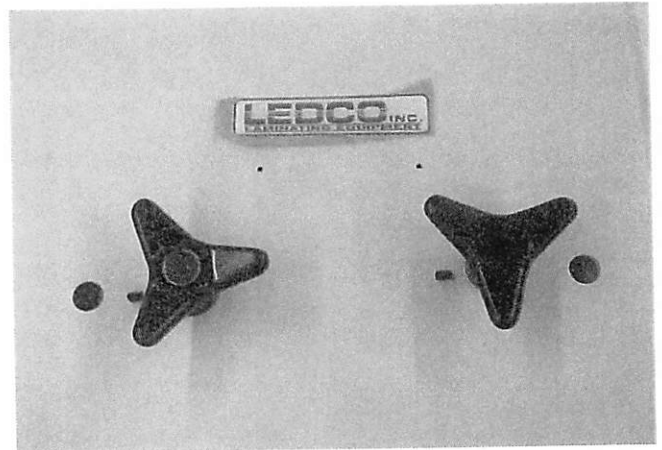
8) HANDLES. PLACE A TEFLON FRICTION WASHER (EP25 004.4) RACK 9 ON (2) CAM SHAFT HANDLE LOCATORS (D105 131.4) RACK 2. FROM INNER DOOR SLIDE SHAFT OF CAM HANDLE LOCATOR THROUGH HOLE. ON OUTER DOOR ADD *ANOTHER* TEFLON FRICTION WASHER. THEN SECURE WASHER WITH  $\frac{3}{4}$ " SNAP RING (PRR192) *AS08* REPEAT THIS ASSEMBLY FOR SECOND CAM SHAFT HANDLE LOCATOR.

*AS07*

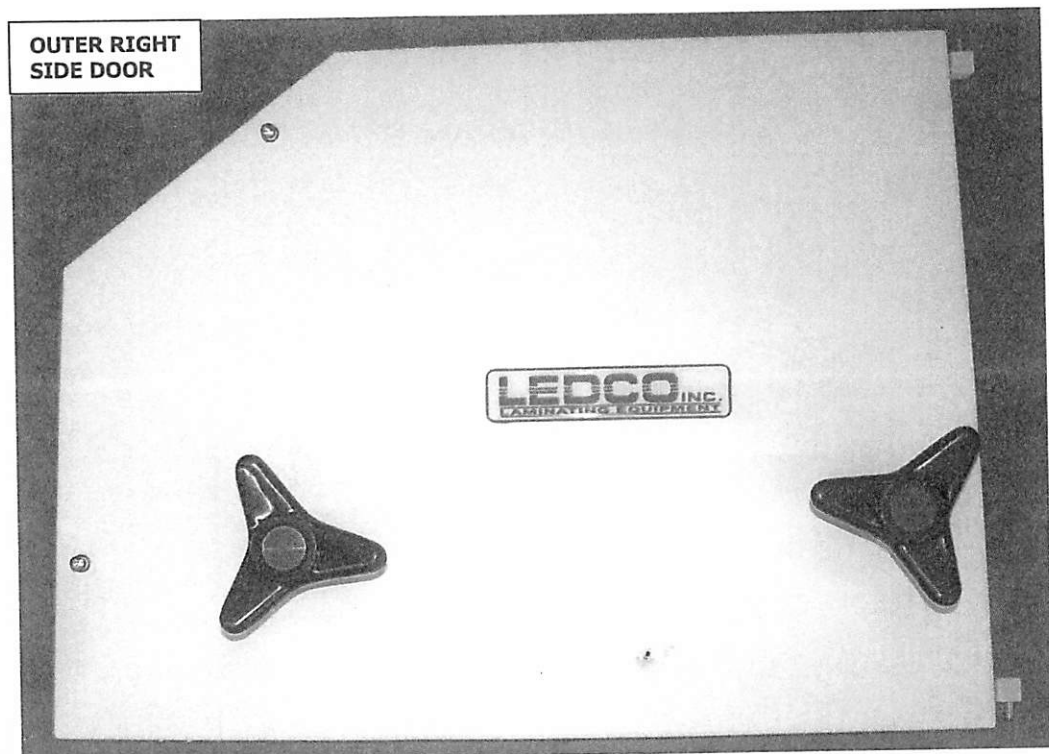


9) SECURE (2) BLACK CAM SHAFT HANDLES (PRH140) *AS07* TO THE CAM SHAFT HANDLE LOCATORS ON OUTER DOOR THREADING A  $\frac{1}{4}$ -20 X  $\frac{3}{8}$  SET SCREW INTO EACH HANDLE. TIGHTEN THE SET SCREW INTO CAM SHAFT HANDLE LOCATOR DEPRESSION.

*AS02*



10) CENTER AND ADHERE LEDCO LABEL (LAB05A) *AS09* OVER TWO HOLES IN CENTER OF RIGHT AND LEFT DOOR.





# DIGITAL NRTL 42/60 LEFT UPPER HOUSING

D105 094.4LT AS22

1) THE NRTL LEFT UPPER HOUSING HAS A FRONT AND REAR EMERGENCY STOP SWITCH. SECURE THE (2) E-STOP SWITCHES (PRS374) AS08 AS FOLLOWS.

2) CENTER THE "EMERGENCY" PRINTING ON THE YELLOW EMERGENCY STOP WASHER (PRS375) AS08 OVER THE OPENING IN THE UPPER HOUSING.

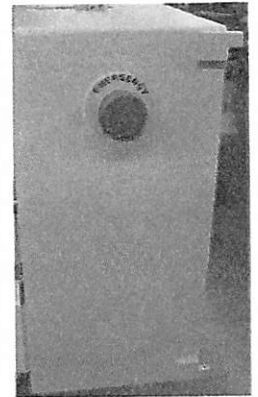
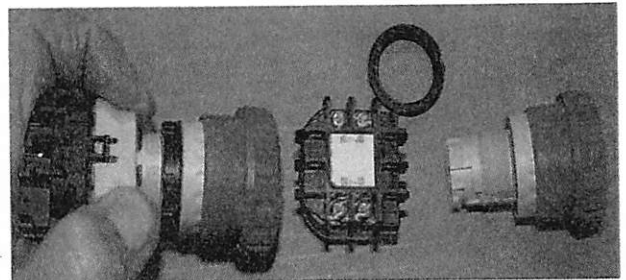
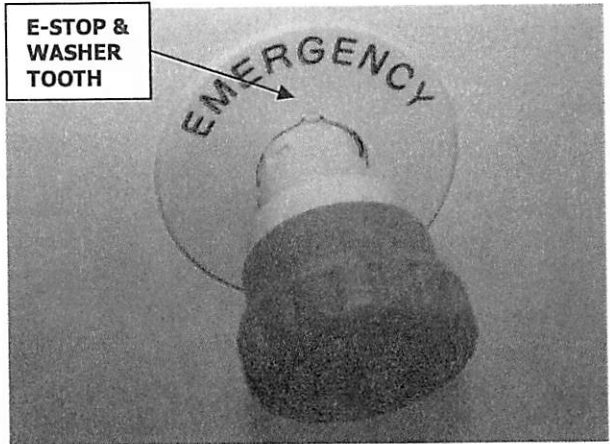
3) SEPARATE THE E-STOP SWITCH BY DEPRESSING THE SPRING ON THE YELLOW SCREW SECTION *DOWNWARD AND TWIST*. UNTHREAD PLASTIC NUT AND INSERT THE RED BUTTON SECTION WITH "TOP" INDICATION UPWARD, ALIGNING YELLOW WASHER TOOTH WITH BUTTON CHANNEL. RETHREAD PLASTIC NUT ON INNER HOUSING. TIGHTEN WITH IN-HOUSE "CASTLE" TOOL, KEEPING THE "EMERGENCY" PRINTING CENTERED. DO NOT SECURE THE WIRE CONNECTION SECTION AT THIS TIME. IT IS EASIER TO WIRE THE E-STOP SWITCHES AND TO SECURE THE HOUSING TO THE SIDE PANEL WITHOUT THE SCREW SECTION ON.

4) FROM RACK 1 INSERT A 3/16 WHITE NYLINER BEARING (PRB202) INTO BOTH FIXED HINGE BLOCKS: LOWER RIGHT/UPPER LEFT (D105 105.4B) AND FIXED HINGE BLOCK: UPPER RIGHT/LOWER LEFT (D105 105.4T).

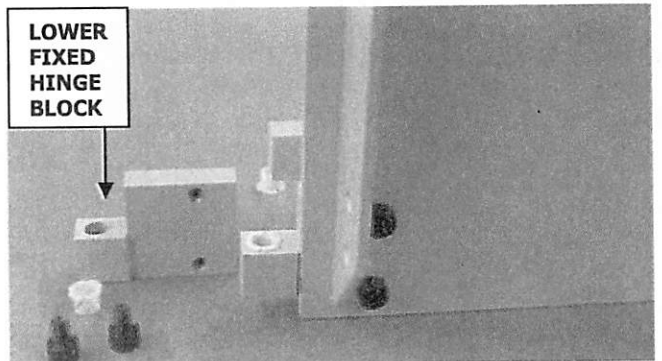
5) ATTACH LEFT UPPER AND LOWER FIXED HINGE BLOCKS TO LEFT HOUSING, POSITIONING THE (2) WHITE NYLINER BEARINGS FACING EACH OTHER. USE (4) 8-32 X 1/4 SHCS TO SECURE.

6) THE LEFT HOUSING HAS (2) LATCH KIT ASSEMBLIES ON THE OUTER HOUSING LIP, ONE ON THE FRONT AND ONE ON THE ANGLED FRONT SECTION. PREPARE THE LATCH KIT ASSEMBLY AS FOLLOWS.

E-STOP &  
WASHER  
TOOTH



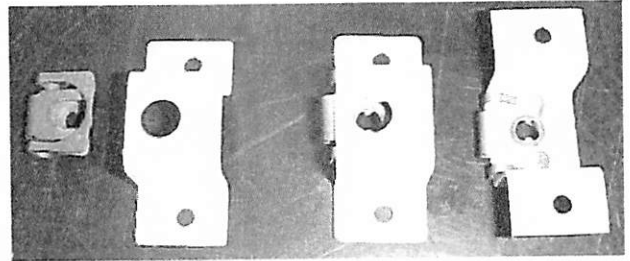
LOWER  
FIXED  
HINGE  
BLOCK



Put DO NOT  
Front in  
with stop  
is attached to  
the side  
panel!

1648AA04

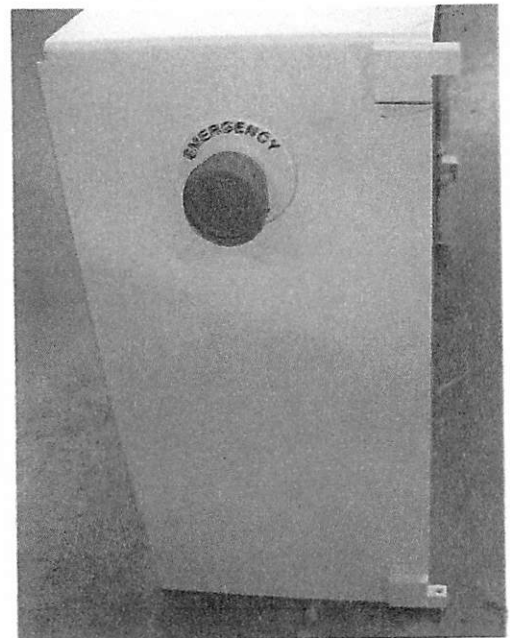
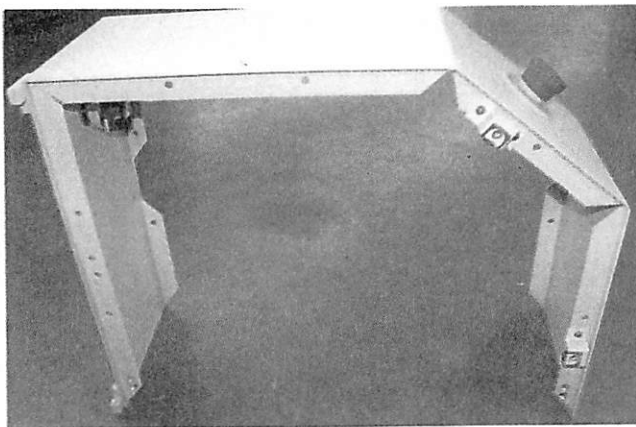
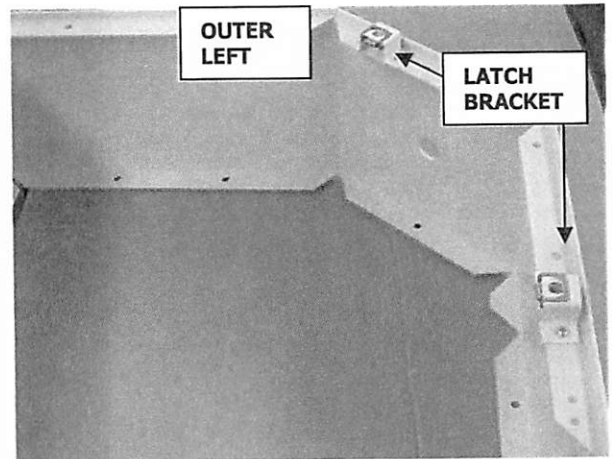
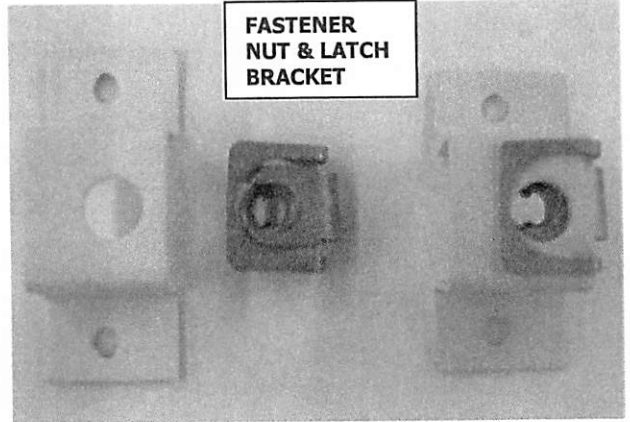
7) USING THE PARTS FROM THE QUARTER TURN LATCH KIT (PML002) RACK 1 SLIDE (2) QUARTER TURN FASTENER NUTS ONTO (2) HOUSING COVER LATCH BRACKETS (D105 097.4) RACK 1. SLIDE NUTS ON FROM SIDE CLOSER TO HOLE.



8) SECURE NUT/BRACKET ASSEMBLY SETS TO THE LEFT UPPER HOUSING USING (4) 8-32 X 3/8 RH ON OUTER LIP AND (4) #8 KEPS HEX NUTS ON INNER LIP.

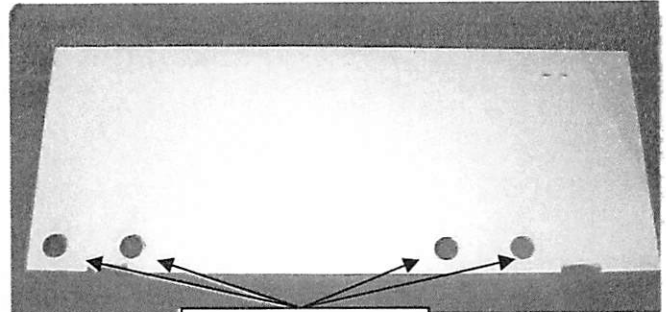
*164 CBA06*  
*164 LCL00*

9) STORE ASSEMBLED LEFT UPPER HOUSING ON SHELF UNTIL NEEDED.



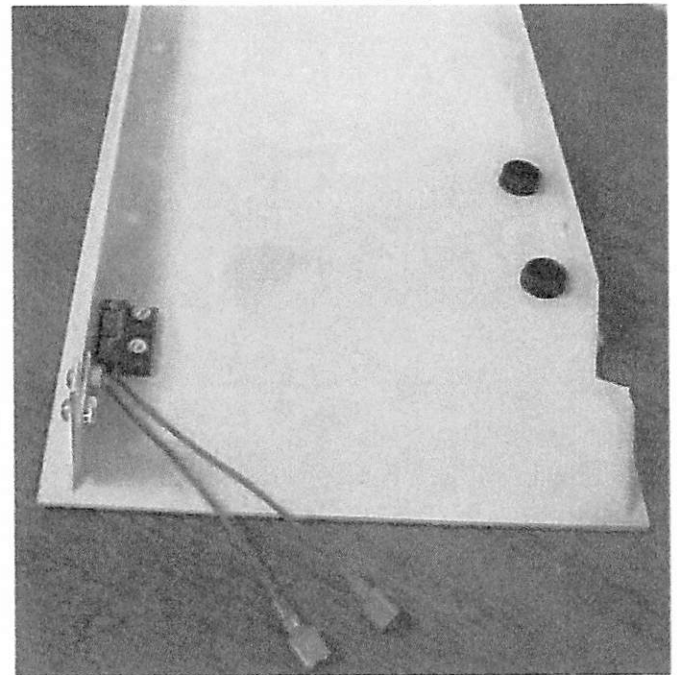
# DIGITAL 42/60 LOWER LEFT HOUSING

1) INSERT (4) 5/8" DIAMETER BLACK PLASTIC HOLE PLUGS (PRH168) AS07 FROM THE OUTSIDE UPWARD INTO LOWER LEFT DIGITAL HOUSING (D105 094.4LB) AS22.



(4) PRH168 PLUGS

2) TRIM THE RED WIRES ON PROXIMITY SWITCH MAGNET (PRS351) RACK 1 SO APPROXIMATELY 4 INCHES REMAIN ON MAGNET. TERMINATE THESE WIRES WITH (2) FULLY INSULATED FEMALE CONNECTORS (PRT331).



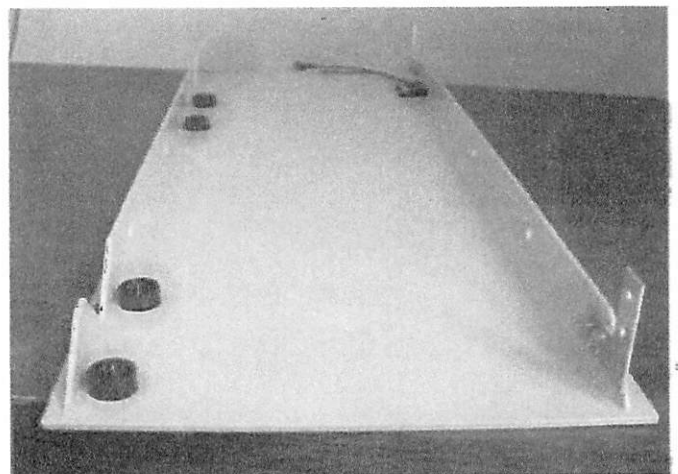
3) SECURE THE TRIMMED PROXIMITY SWITCH MAGNET ALONG THE OUTER LIP OF LOWER LEFT DIGITAL HOUSING, WIRES OUTWARD. USE (2) 4-40 X 3/8 PH FROM BOTTOM UPWARD AND (2) 4-40 HEX NUTS INSIDE. MAGNET PRINTING FACES UPWARD.

112ABA06  
112LDR00

4) ATTACH (2) DIGITAL MACHINE HOUSING CORNER BRACES (D105 098.4) RACK 1 AS PICTURED USING (4) 8-32 X 3/8 FH ON OUTER LIP AND (4) 8-32 KEPS HEX NUT ON INNER LIP.

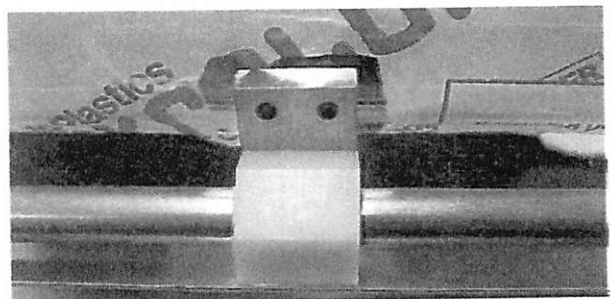
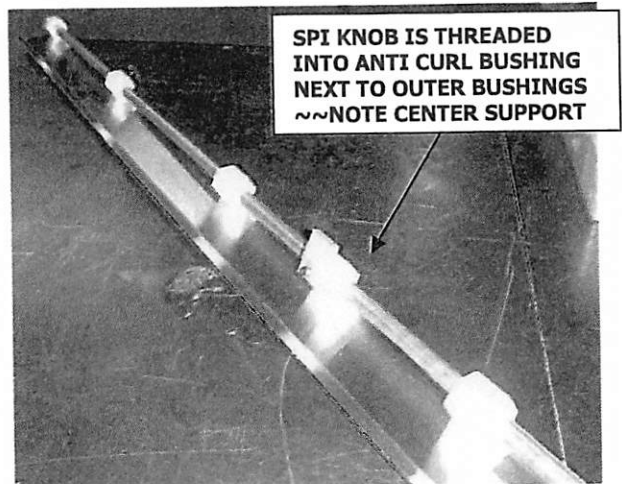
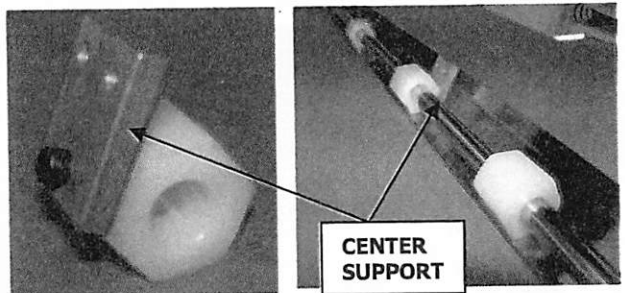
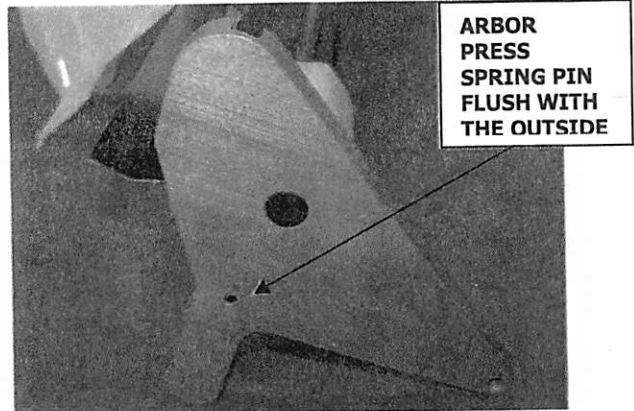
164BB A06  
164 L0200

5) STORE ASSEMBLY UNTIL NEEDED.



# DIGITAL NRTL 42/60 SAFETY SHIELD

- 1) ARBOR PRESS 1/8 X 3/4 SPRING PIN INTO RIGHT AND LEFT SAFETY SHIELD BRACKET (D105 091.4R AND D105 091.4L) AS13 FROM GROOVED SIDE, SO PIN IS FLUSH ON OUTSIDE OF BOTH BRACKETS.
- 2) ***FOR DI60 ONLY:*** FROM AS13 ATTACH SAFETY SHIELD CENTER SUPPORT (D60 112.4) TO ANTI CURL STRIP MOUNTING BUSHING (D105 099.4) USE AN 8-32 X 1/2 SHCS.
- 3) ***FOR DI60:*** SLIDE (3) ANTI CURL STRIP MOUNTING BUSHINGS ONTO A SAFETY SHIELD TIE ROD/SPANNER BAR (D60 103.4) D60-01 WITH LARGER (#10 TAPPED) HOLES TOWARD THE BACK ON THE OUTER BUSHINGS AND THE #10 TAPPED HOLE TOWARD THE FRONT ON THE MIDDLE ONE. SLIDE ON THE ANTI CURL STRIP MOUNTING BUSHING WITH THE CENTER SUPPORT, TWO HOLES FACING UP AND TOWARD THE BACK. ADD ANOTHER (3) ANTI CURL STRIP MOUNTING BUSHINGS WITH #10 HOLES TOWARD THE BACK ON THE OUTER PAIR AND TOWARD THE FRONT ON THE MIDDLE ANTI CURL BUSHING. SECURE THE (6) ANTI CURL BUSHINGS TO THE LAY DOWN SHIELD (D60 075.4) D60-01 WITH (6) 8-32 X 1/4 TH. ANTI CURL BUSHING WITH THE CENTER SUPPORT DOES NOT ATTACH TO THE LAY DOWN SHIELD. DI42 USES (4) ANTI CURL MOUNTING BUSHINGS ON TIE ROD (D105 103.4) AND LAY DOWN SHIELD (D105 075.4) BOTH IN D60-01.
- 4) THREAD (2) SPI KNOBS (PRK177) AS08 INTO #10 HOLES ON 2<sup>ND</sup> AND 6<sup>TH</sup> ANTI CURL BUSHINGS ON DI60. ON DI42 (2) SPI KNOBS ARE ON INNER PAIR.
- 5) CUT PLASTIC AROUND (2) CENTER HOLES ON SAFETY SHIELD "A" REV (D60 102.4) AS22. PEEL OFF INNER COVERING ON SAFETY SHIELD,



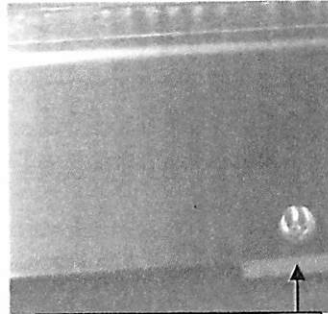
Left 2 shelf

Left 2

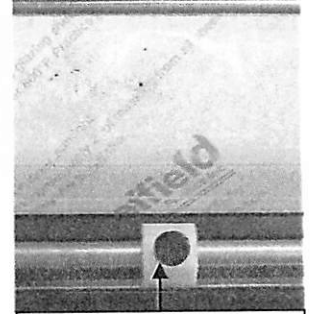
Left 2

DISCARD. DI42 USES SAFETY SHIELD (D105 102.4) AS22.

6) ATTACH RIGHT SAFETY SHIELD BRACKET TO TIE ROD END WITH 10-32 X 3/4 FH SH, USE LOCTITE. SET SAFETY SHIELD INTO BOTH BRACKETS BEFORE SECURING TIE ROD ON LEFT SIDE. THE LAY DOWN SHIELD RESTS ON THE SPRING PINS. SECURE OTHER SIDE WITH 10-32 X 3/4 FH SH WITH LOCTITE.

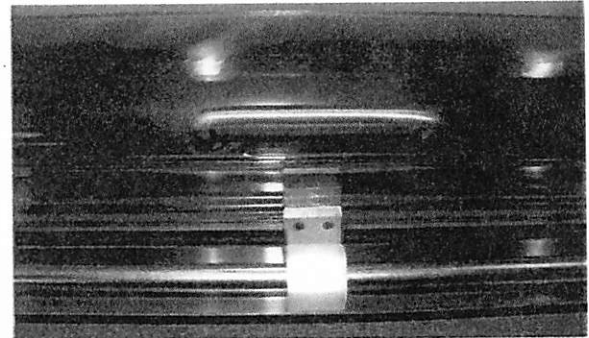


LAY DOWN SHIELD & ANTI CURL BUSHING

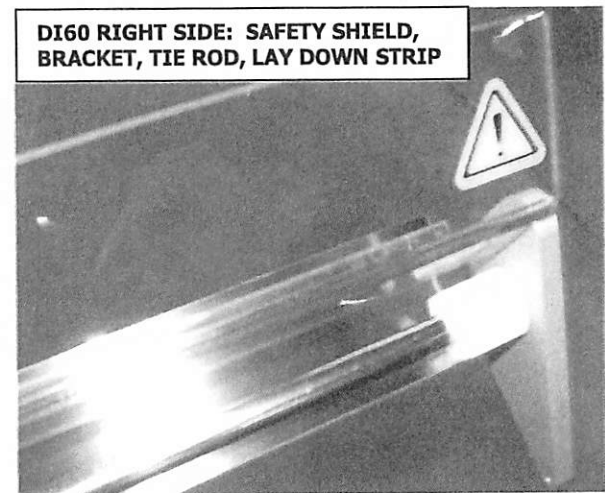


SPI KNOB, ANTI CURL BUSHING & TIE ROD

7) ATTACH SAFETY SHIELD CENTER SUPPORT TO SAFETY SHIELD WITH (2) 8-32 X 1/2 SHCS. THE SCREWS ENTER THROUGH THE SAFETY SHIELD AND THREADS INTO CENTER SUPPORT.

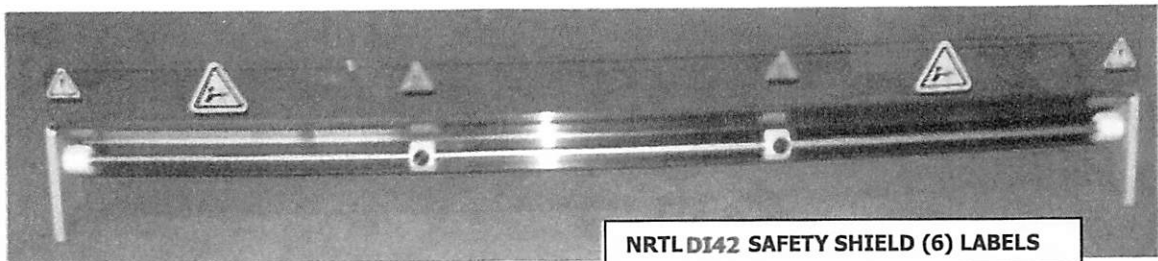


8) FROM AS09 ON DI60 SAFETY SHIELD ADHERE (2) "GENERAL DANGER" LABELS (LAB52) TO OUTER ENDS, (2) "ARM ENTANGLEMENT" LABELS (LAB51) OVER THE SPI KNOBS AND (2) "HOT" LABELS (LAB100) ABOVE ANTI CURL BUSHINGS RIGHT AND LEFT OF CENTER SUPPORT. ON THE DI42 ADHERE (2) YELLOW "GENERAL DANGER" LABELS TO OUTER ENDS, (2) "HOT" LABELS ABOVE ANTI CURL BUSHINGS WITH SPI KNOBS AND (2) "ARM ENTANGLEMENT" LABELS CENTERED BETWEEN "GENERAL DANGER" AND "HOT" LABELS.

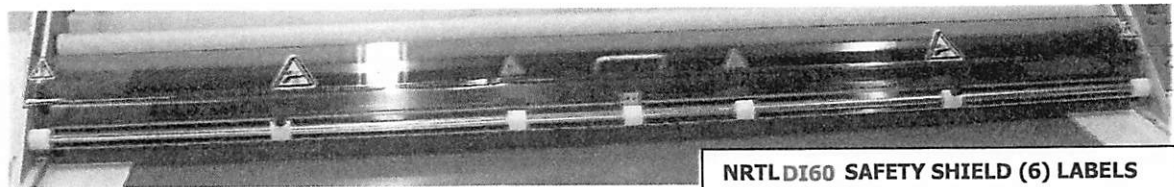


DI60 RIGHT SIDE: SAFETY SHIELD, BRACKET, TIE ROD, LAY DOWN STRIP

9) SECURE HANDLE (PRH141R) AS07 ONTO DI60 SAFETY SHIELD USING (2) 8-32 X 1/2 PH. NO HANDLE ON DI42.



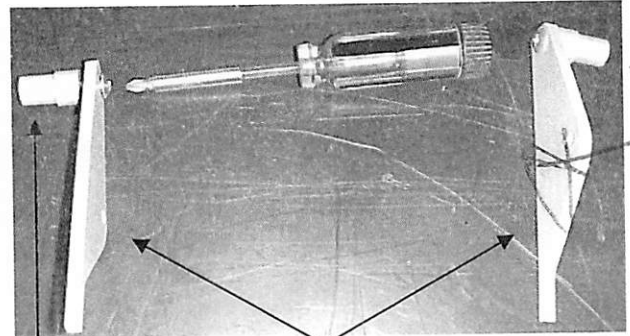
NRTL DI42 SAFETY SHIELD (6) LABELS



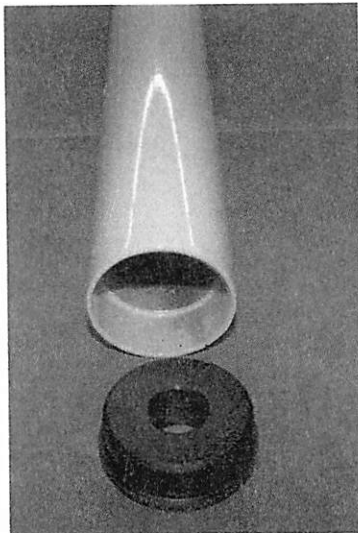
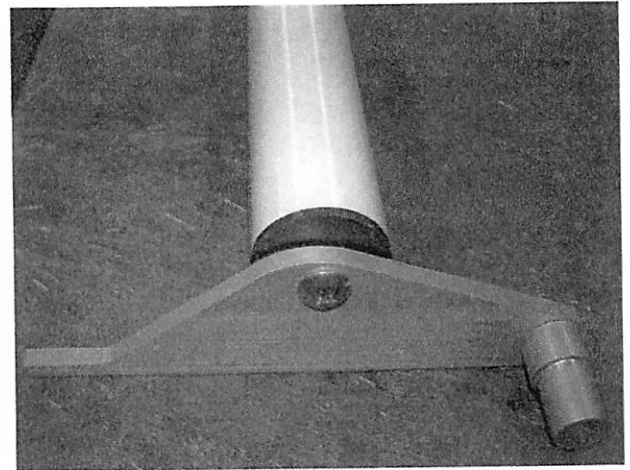
NRTL DI60 SAFETY SHIELD (6) LABELS

# DIGITAL 42/60 S-WRAP

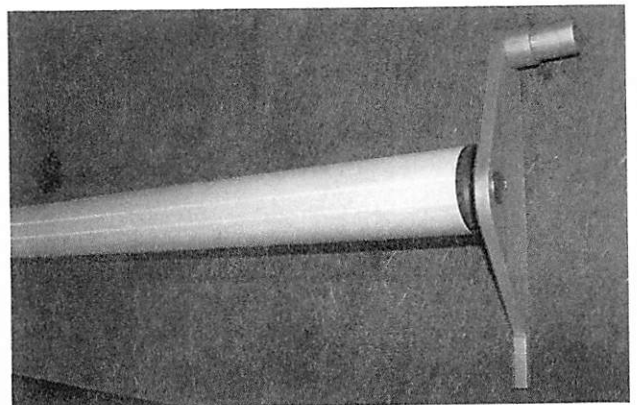
- 1) FROM RACK 2 PLACE (2) S-WRAP IDLER BRACKETS (D105 250.4) ON TABLE. ATTACH A MOUNTING BUSHING (D105 252.4A) FROM THE INSIDE, SO BUSHING IS LOCATED ON OUTSIDE OF BRACKET, USE THE BRACKET END HOLES OF EACH. PLACE LOCTITE ON THREADS OF (2)  $\frac{1}{4}$ -20 X  $\frac{3}{4}$  TH TO SECURE.
- 2) TAP (2) IDLER BEARINGS (PRB086A) AS13 ONTO ENDS OF THERMAL IDLER S-WRAP TUBE (D60/D105 303.4) D-01.
- 3) INSERT S-WRAP IDLER SHAFT (D60 251.4) LOFT 2 THROUGH BOTH IDLER BEARINGS ON IDLER S-WRAP TUBE.
- 4) ATTACH S-WRAP IDLER BRACKET TO IDLER SHAFT ON BOTH ENDS OF TUBE WITH (2)  $\frac{1}{4}$ -20 X  $\frac{3}{4}$  TH, LOCTITE ON THREADS. THE MOUNTING BUSHING WILL BE FACING OUT.
- 5) STORE COMPLETED S-WRAP ASSEMBLY UNTIL NEEDED FOR MACHINE.



MOUNTING BUSHING ~ S-WRAP IDLER BRACKET

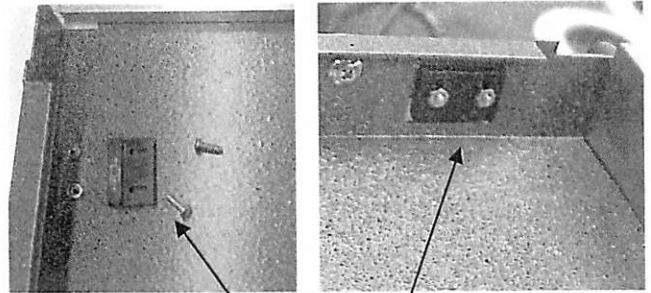


THERMAL  
IDLER S-  
WRAP  
TUBE &  
IDLER  
BEARING



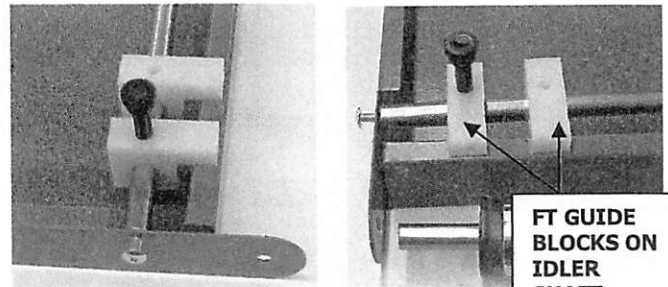
# DIGITAL 42/60 FEED TABLE

- 1) LAY FEED TABLE (D105/60 108.4) D-02 UPSIDE DOWN ON WORK BENCH. SECURE PROXIMITY SWITCH MAGNET (PRS352) RACK 1 INTO SLOT WITH (2) 4-40 X 3/8 PH ON OUTSIDE AND (2) 4-40 NUTS ON INSIDE.



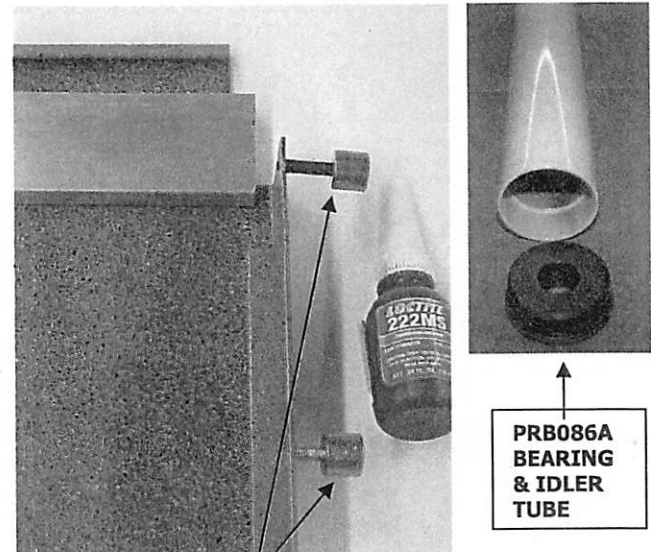
MAGNET BEFORE AND AFTER INSERTION

- 2) SLIDE (4) FEED TABLE GUIDE MOUNTING BRACKETS (D105 104.4) AS13 ONTO FEED TABLE IDLER SHAFT (D60 109.4) LOFT 2. NOTE POSITION IN PHOTO, AND SECURE SHAFT WITH (2) 10-32 X 1/2 TH. USING LOCTITE ON THREADS. INSERT (2) STOP COLLAR THUMB SCREWS (PRK184) AS09 INTO OUTSIDE GUIDE BLOCKS.



FT GUIDE BLOCKS ON IDLER SHAFT

- 3) TAP (2) IDLER BEARINGS (PRB086A) RACK 13 ONTO ENDS OF FEED TABLE IDLER TUBE (D60 054.4) D-01. RUN FEED TABLE IDLER SHAFT THROUGH BEARINGS AND SECURE TO FEED TABLE ARM IN FRONT OF GUIDE BLOCKS USING 10-32 X 1/2 TH.



PRB086A BEARING & IDLER TUBE

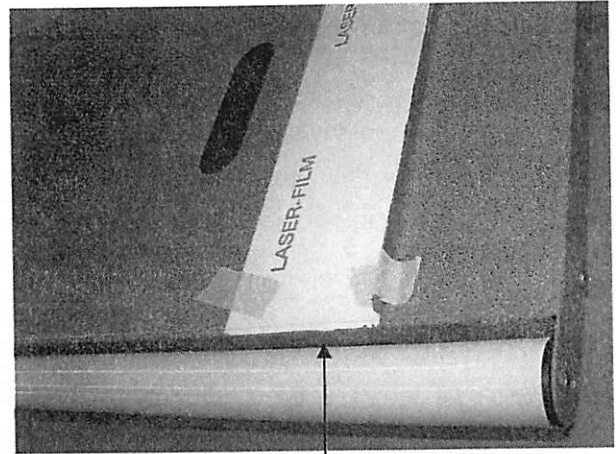
- 4) TO ATTACH FEED TABLE SUPPORT BAR <sup>D42</sup>(D60 111.4) LOFT 2 USE (2) 10-32 X 3/4 SHSS. LOCTITE HALF OF THE THREADS AND INSERT THOSE HALVES INTO SUPPORT BAR. LOCTITE EXPOSED REMAINING HALF OF THREADS AND ATTACH (2) FEED TABLE MOUNTING STUB SHAFTS (D105 101.4) AS13 WITH BEVELED SIDE OF STUB OUT.

FEED TABLE MOUNTING STUB SHAFTS

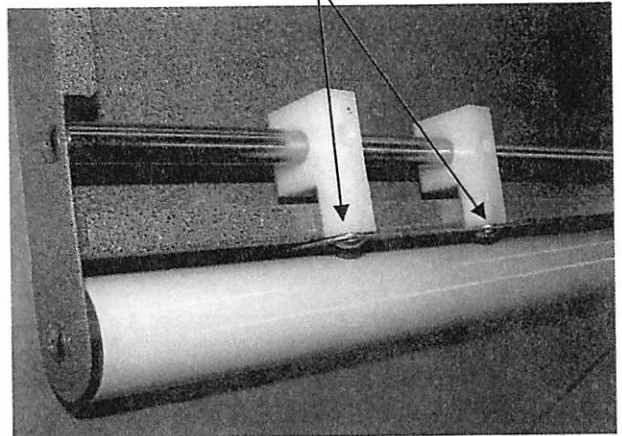
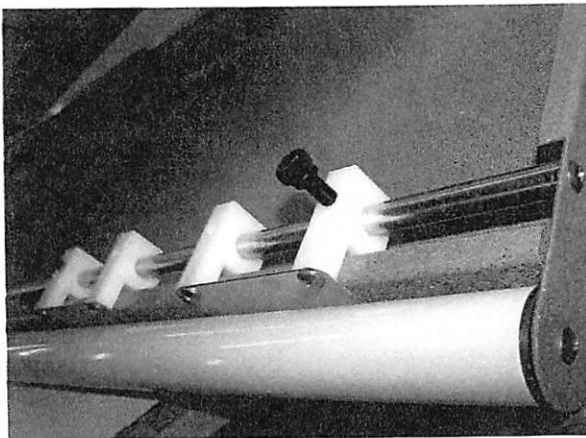
- 5) ADD ANOTHER PAIR OF FEED TABLE MOUNTING STUB SHAFTS ON RIGHT

AND LEFT OUTER FEED TABLE LIP,  
SECURED WITH (2) 10-32 X 1/2 TH FROM  
INSIDE, LOCTITE THREADS.

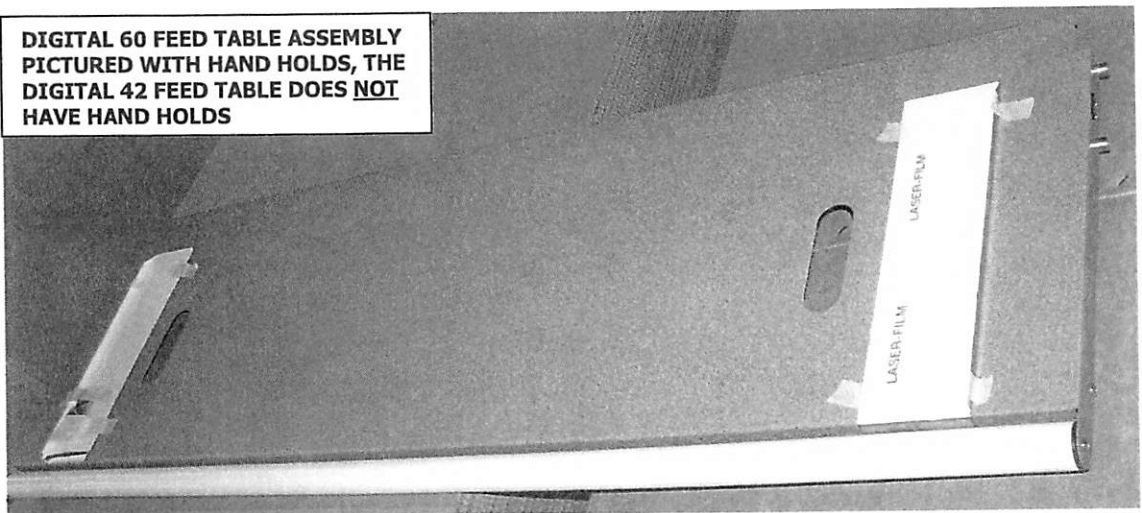
- 6) PEEL BACK PLASTIC COVERING ON  
RIGHT AND LEFT FEED TABLE GUIDES  
(LC38 097.4L AND LC38 097.4R) AS13 TO  
EXPOSE HOLES. SECURE TO FEED TABLE  
GUIDE BLOCKS WITH (4) 10-32 X 1/2 TH.  
LOCK ON IDLER SHAFT WITH STOP  
COLLAR THUMB SCREWS.
- 7) STORE COMPLETED FEED TABLE UNTIL  
READY TO INSTALL ON LAMINATOR.



FEED TABLE GUIDE ATTACHED TO GUIDE BLOCKS



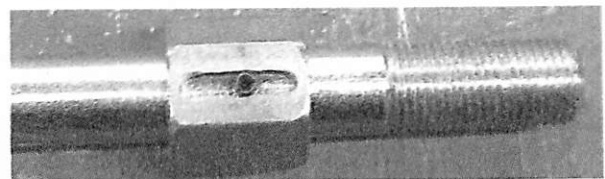
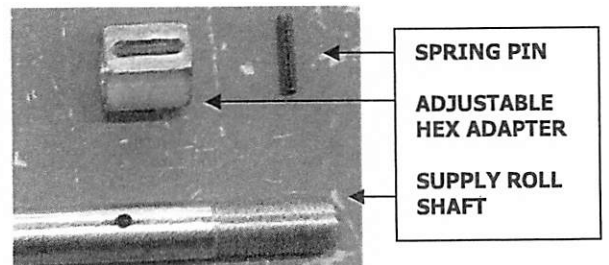
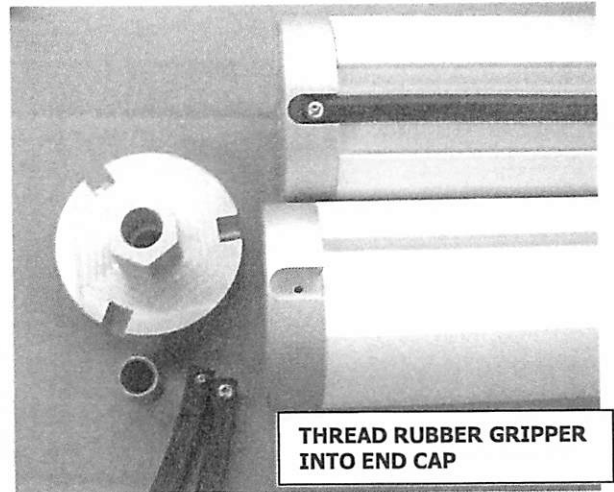
DIGITAL 60 FEED TABLE ASSEMBLY  
PICTURED WITH HAND HOLDS, THE  
DIGITAL 42 FEED TABLE DOES NOT  
HAVE HAND HOLDS



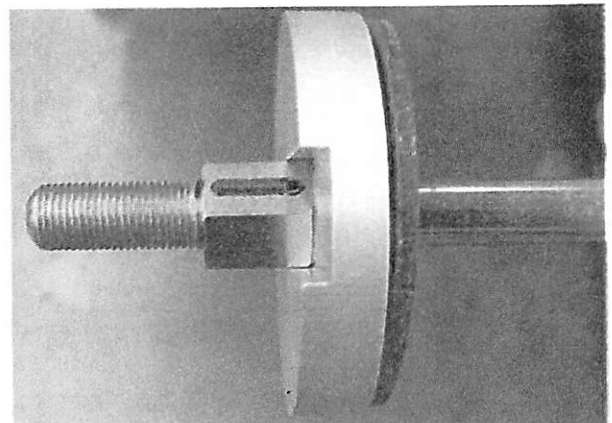


# DIGITAL 42/60 SUPPLY ROLL

- 1) THE DIGITAL 42/60 USES TWO IDENTICAL SUPPLY ROLL ASSEMBLIES. ASSEMBLY IS PREPARED AS FOLLOWS.
- 2) INSERT 6-32 X 1/2 RH SCREWS INTO THE DRILLED ENDS OF (6) RUBBER SUPPLY ROLL GRIPPERS (D105 003.4B) FOR D42 OR (D60 003.4B) FOR D60, BOTH IN LOFT3. SET GRIPPER ASSEMBLY ASIDE.
- 3) ALIGN THE SUPPLY ROLL END CAPS (I30 008.4) AS08 WITH THE THREADED HOLES IN THE RECESSED SECTIONS OF THE SUPPLY ROLL CORES (D105 002.4B) FOR D42 OR (D60 002.4B) FOR D60, BOTH IN LOFT3 AND TAP THE END CAP HEXES INTO SUPPLY ROLL CORES.
- 4) THREAD THE SCREWS IN THE RUBBER GRIPPERS INTO THE SUPPLY ROLL END CAPS. THE GRIPPERS RUN ALONG THE RECESSED SECTIONS OF SUPPLY ROLLS.
- 5) PREPARE (2) SUPPLY ROLL SHAFTS (D105/D60 011.4A) LOFT3 BY SLIDING AN ADJUSTABLE HEX ADAPTER (D105 022.4) AS08, ALIGNED OVER BOTH SHAFT OPENINGS.
- 6) USE THE STARTER TOOL TO INSERT A 1/8 X 3/4 SPRING PIN (.125J0012) THROUGH THE ADJUSTABLE HEX CHANNEL INTO SHAFT APERTURE. REMOVE TOOL, TAP PIN UNTIL IT IS FLUSH WITH HEX ON BOTH SIDES.
- 7) SLIDE A SUPPLY ROLL PRESSURE PLATE (LC38 007.4) AS08 DOWN THE LONG END OF BOTH SUPPLY ROLL SHAFTS. THE SPRING PIN ON ADJUSTABLE HEX ADAPTER SHOULD LOCATE BETWEEN RECESS ON PRESSURE PLATES.
- 8) SLIDE A 1/8 X 1/2 ID X 2-3/4 OD LEATHER DISC (H380 004.4) AS08 ONTO EACH SUPPLY ROLL SHAFT NEXT TO THE

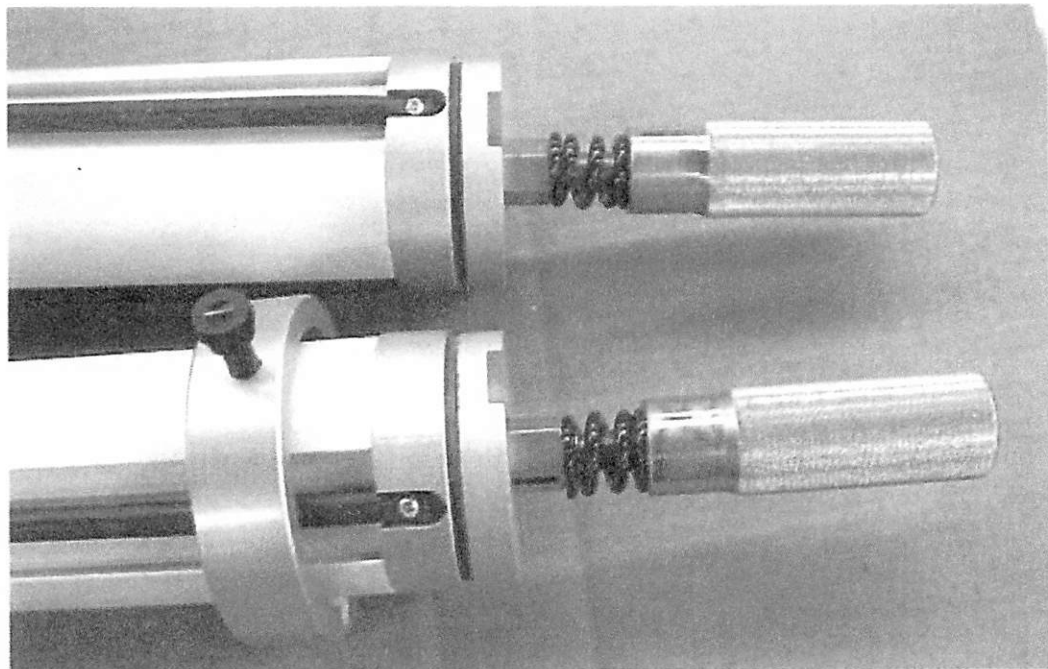
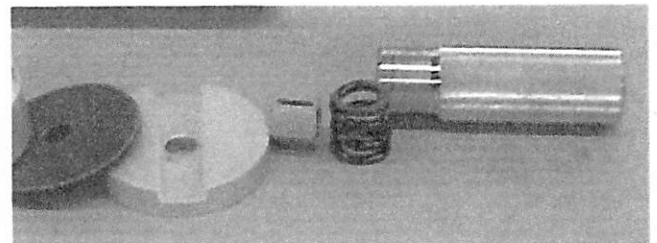
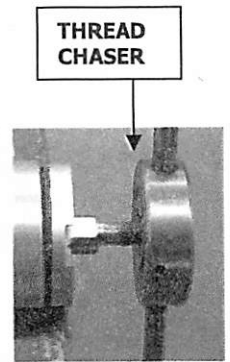


SPRING PIN FLUSH INTO ADJUSTABLE HEX ADAPTER



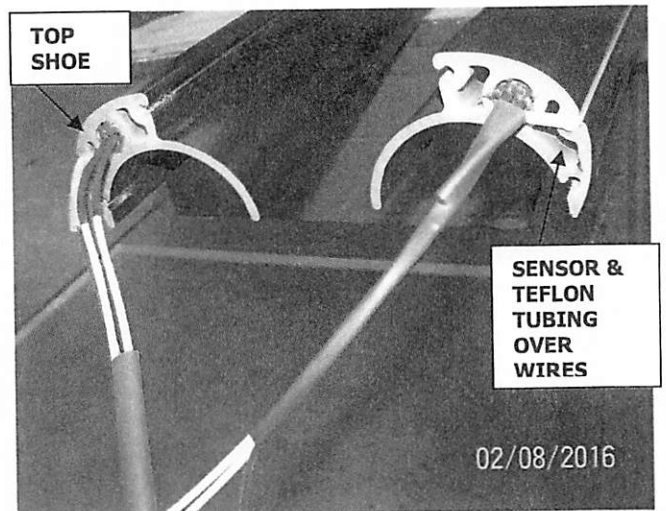
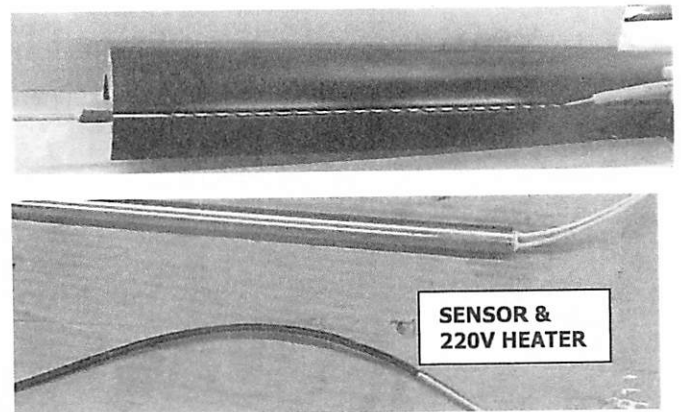
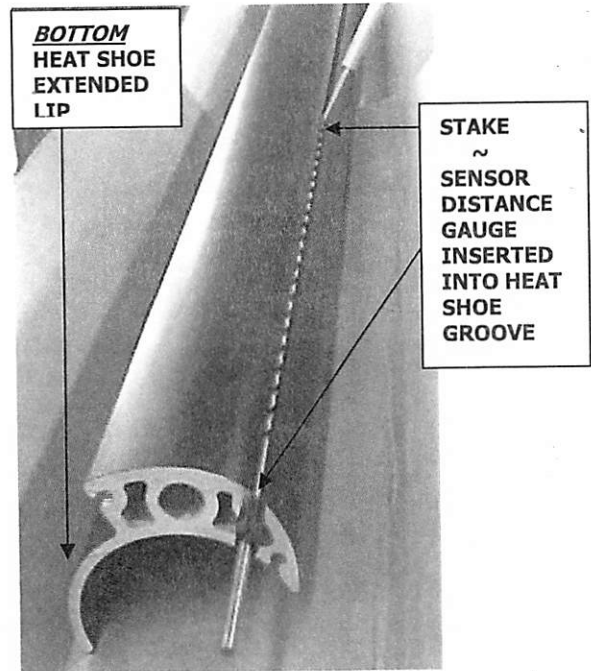
**PRESSURE PLATE. INSERT SUPPLY ROLL SHAFT WITH THIS ASSEMBLY THROUGH THE SLEEVE BEARINGS ON THE SUPPLY ROLL END CAPS.**

- 9) **DUPLICATE THE OTHER END OF THE SUPPLY ROLL SHAFT WITH ANOTHER LEATHER DISC, PRESSURE PLATE AND A SUPPLY ROLL HEX ADAPTER (LC38 023.4) AS08 FITTING INTO PRESSURE PLATE RECESS.**
- 10) **BRUSH LOCTITE ANTI-SEIZE ONTO END THREADS OF BOTH SUPPLY ROLL SHAFTS. SLIDE ON SUPPLY ROLL TENSION SPRING (PRS222) AS01 AND THREAD ON KNURLED SUPPLY ROLL TENSION KNOB (D105 001.4) AS01. IF SUPPLY ROLL SHAFTS' THREADS ARE OVER PLATED, TRIM THEM WITH DIE/THREAD CHASER. TIGHTEN KNOB UNTIL SPRING PIN IS CENTERED IN ADJUSTABLE HEX ADAPTER CHANNEL.**
- 11) **THREAD (2) 5/16-18 X 1 PLASTIC MOLDED THUMBSCREWS (PRK184) AS09 INTO (2) STOP COLLAR-CORE CHUCK STYLE (D105 004.4) AS09. STORE UNTIL NEEDED.**



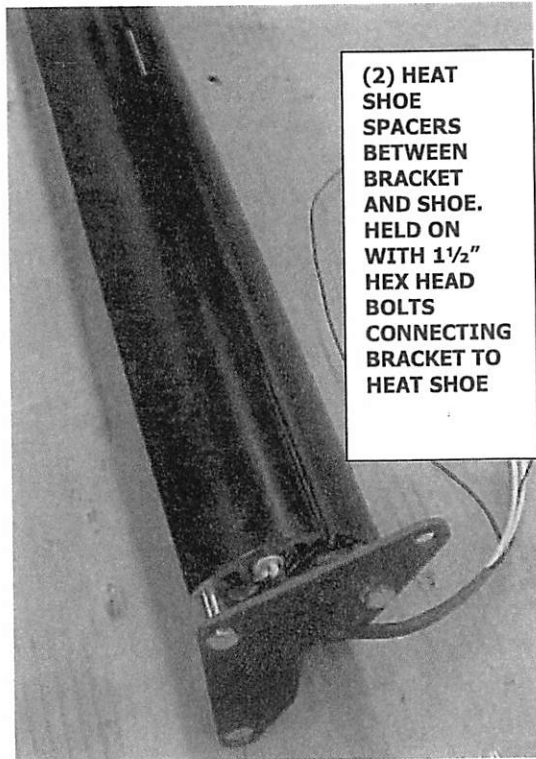
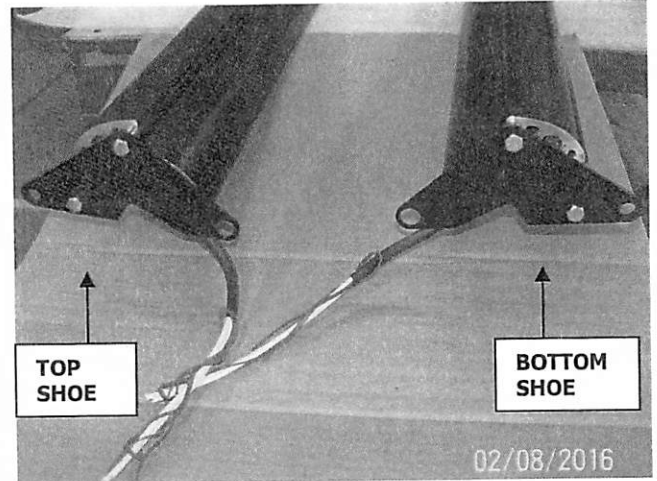
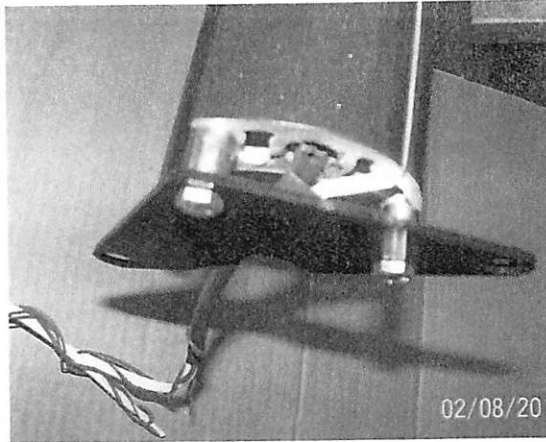
# DIGITAL 42/60 HEAT SHOES-RED SENSOR

- 1) PLACE (2) UNIVERSAL 60" HEAT SHOES (D60 060.4) LOFT 2 ON CUSHIONED WORKTABLE. PLACE HEAT SHOES WITH EXTENDED LIP FACING EACH OTHER AND ASSEMBLE UPPER AND LOWER SHOE.
- 2) PREPARE BOTH HEAT SHOES TO HOLD SENSORS FOR HEATERS (PRC2121) LD00 BY INSERTING 15" MEASURING TOOL INTO SENSOR GROOVE ON SHOE AND STAKING INSIDE GROOVE TO HOLD SENSOR. WHEN SHOES ARE ATTACHED TO MACHINE THE WIRES SHOULD BE ON THE RIGHT FROM MACHINE FRONT.
- 3) INSERT SENSOR INTO STAKED GROOVE ON BOTH UPPER AND LOWER SHOE.
- 4) SLIDE 15" OF TEFLON TUBING FOR HEAT SENSOR (LC38 344.4) AS17 UP WIRES UNTIL IT TOUCHES THE SENSOR.
- 5) INSERT A 42" OR 60" CARTRIDGE HEATER .625 DIAMETER (PRH172) LOFT 2 INTO BOTH HEAT SHOES. ADD LOCTITE RED HIGH TEMPERATURE RTV SILICONE ADHESIVE SEALANT CAB1, COVERING CERAMIC END AND AROUND WIRES. STAKE BOTH ENDS OF HEAT SHOES TO HOLD HEATER CARTRIDGE.
- 6) FROM CAB1 CUT (4) 2" PIECES OF BLACK INSULATION TUBING 3/16" (PRI165) AND SLIDE ONE EACH ONTO INDIVIDUAL HEATER WIRES TIGHT TO CARTRIDGE. HEAT AND SHRINK INSULATION. CUT (2) 6" PIECES OF LARGER BLACK INSULATION TUBING 3/8" (PRI164). BUNDLE AND COVER HEATER WIRES WITH SENSOR WIRES THAT ARE ENCLOSED BY TEFLON TUBING, FLUSH TO CARTRIDGE. DRAPE DOWNWARD TOWARD LIP. HEAT AND SHRINK.
- 7) ATTACH (2) HEAT SHOE BRACKETS FOR DIGITAL 105 (LC38 065.4) RACK 1 TO ENDS OF SHOES WITH LARGER HOLE ON BRACKETS TOWARD EXTENDED LIP. DRAPE WIRES DOWNWARD, BETWEEN SPACERS. SECURE EACH HEAT SHOE

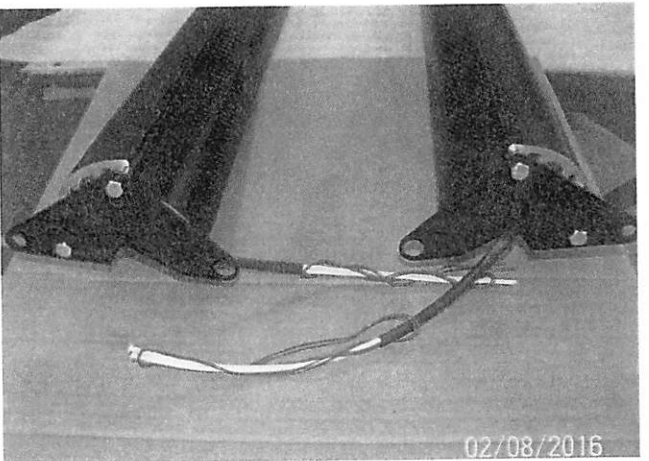
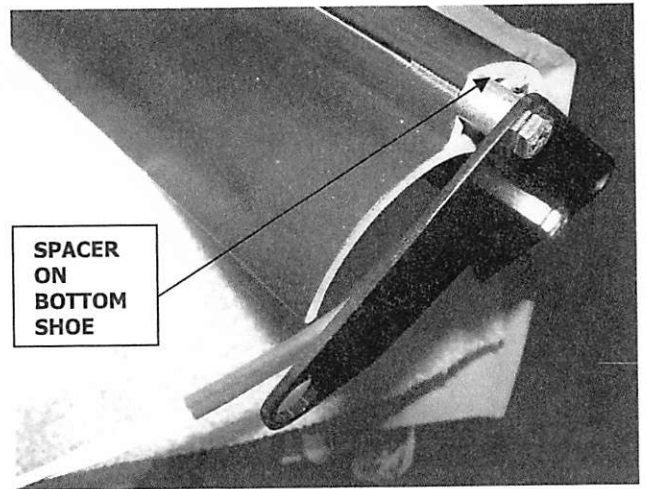


**BRACKET WITH (2) 1/4-20 X 1 1/2 HEX HEAD BOLT AND A HEAT SHOE SPACER (LC38 064.4) RACK 1 BETWEEN INSIDE OF BRACKET AND HEAT SHOE. THREAD INTO ENDS OF SHOES.**

- 8) STORE COMPLETED HEAT SHOES WHERE THEY WILL NOT BE SCRATCHED.**

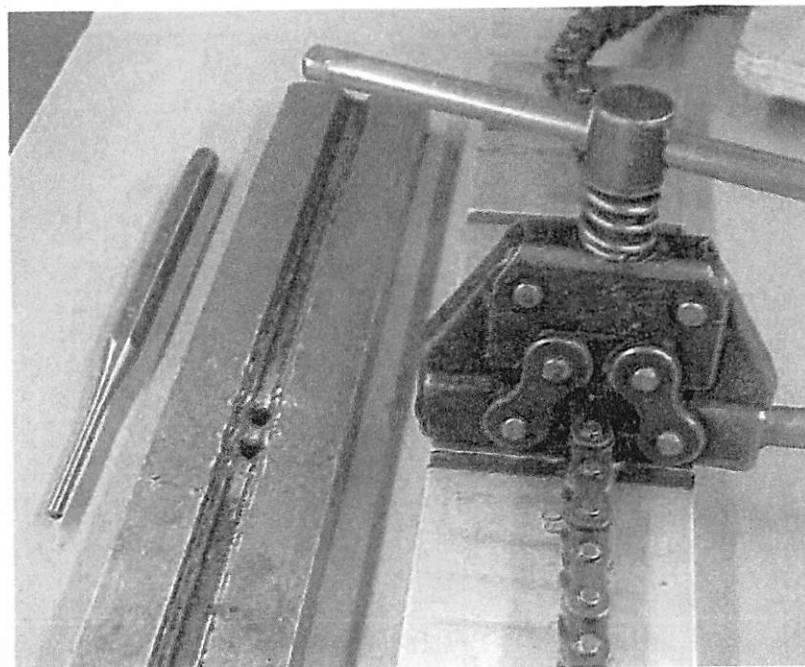
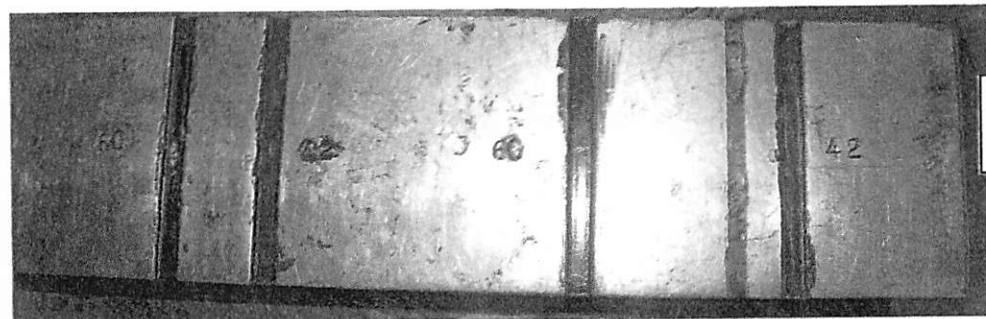
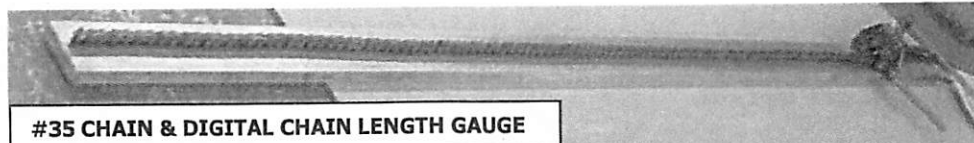
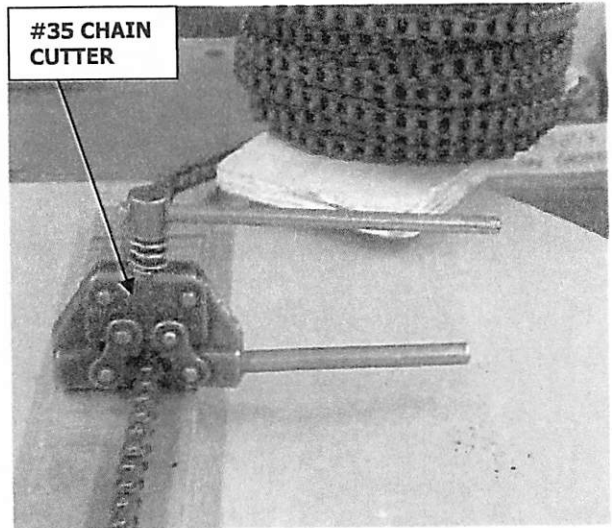


**(2) HEAT SHOE SPACERS BETWEEN BRACKET AND SHOE. HELD ON WITH 1 1/2" HEX HEAD BOLTS CONNECTING BRACKET TO HEAT SHOE**



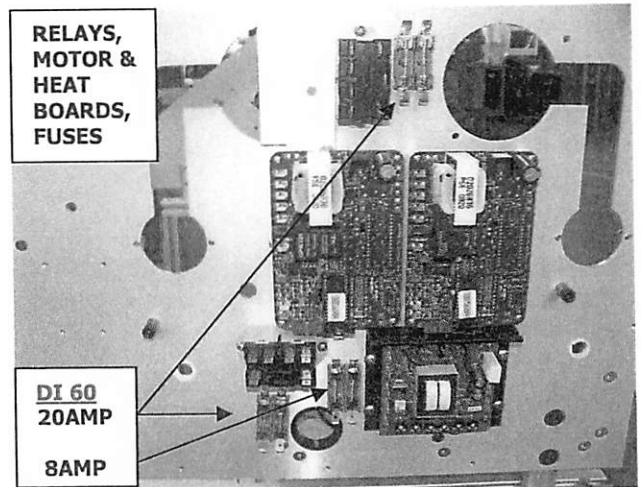
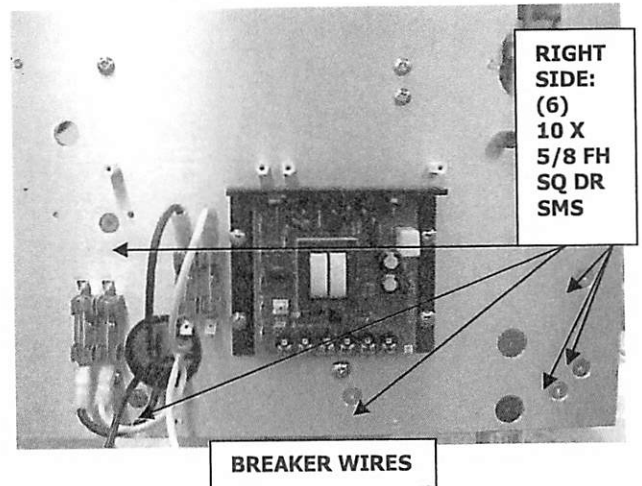
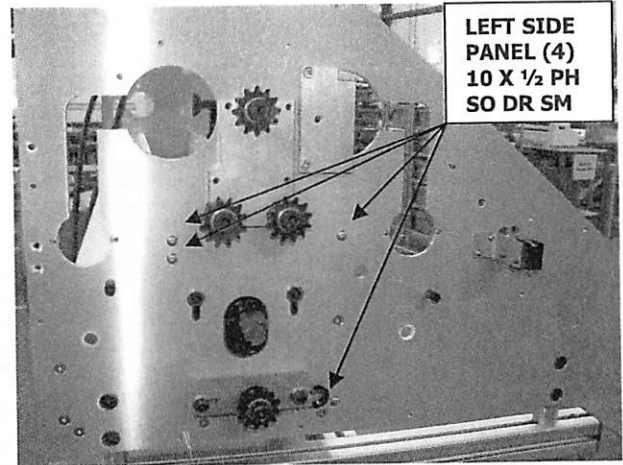
# DIGITAL 42/60 CHAINS

- 1) CUT (2) CHAINS FROM #35 CHAIN ROLL (PRC086) CCT. ONE EACH MEASURED TO LONG/SHORT, BLUE/RED DIGITAL 42 OR 60 INDICATION ON CHAIN GAUGE.
- 2) PROCEDURE FOR CUTTING #35 CHAIN: PLACE END LINK OVER PIN ON CHAIN GAUGE. SET CHAIN BREAKER ON INDICATED LINE AND ROTATE TOP LEVER CLOCKWISE UNTIL YOU FEEL THE GIVE IN THE LINK THAT DISCONNECTS. *NEVER* CUT SHORT OF LINE.
- 3) USE PUNCH & TOOL TO REMOVE LINKS.



# DIGITAL NRTL 42/60 CHASSIS ASSEMBLY

- 1) ATTACH LEFT SIDE PANEL ASSEMBLY TO ASSEMBLED BOTTOM MOTOR COVER USING (4) 10 X 1/2 PH SQ DR SMS AND (6) 10 X 5/8 FH SQ DR SMS.
- 2) ATTACH RIGHT SIDE PANEL ASSEMBLY TO ASSEMBLED BOTTOM MOTOR COVER USING (4) 10 X 1/2 PH SQ DR SMS AND (6) 10 X 5/8 FH SQ DR SMS. ALIGN MOUNTING SHAFT FEET OVER STAND HOLES. SECURE WITH 1/2-13 X 1 1/2 HEX HEAD, EACH WITH A 1/2 FLAT WASHER.
- 2) ON RIGHT SIDE PANEL ATTACH MINARIK SPEED CONTROL 115-220 VAC (PRM218A) AS08 BOARD, POSITIONING THE FIVE TERMINAL POSTS ON LEFT TOWARD THE FRONT OF MACHINE. SWITCH BOTH VOLT INDICATORS TO THE RIGHT, 180 AND 230 SETTING THE BOARD FOR 220V. USE (4) 8-32 X 3/8 THMS AND A #8 STAR WASHER TO SECURE SPEED CONTROL TO SIDE PANEL.
- 3) ATTACH (2) HEAT CONTROLLER KIT BOARDS (PRH130) AS07 WITH TERMINAL POSTS ON LEFT FACING FRONT OF MACHINE. SECURE WITH (8) 4-40 X 3/8 PHMS INTO STANDOFFS ALREADY ON SIDE PANEL.
- 4) ATTACH (2) 24 VAC OMRON RELAYS (PRR251) RACK 1 WITH TOP RELAY DOUBLE TERMINAL POSTS FACING RIGHT/REAR AND LOWER HORIZONTAL RELAY POSITIONED WITH DOUBLE TERMINAL POSTS ON BOTTOM. SECURE BOTH RELAYS TO SIDE PANEL USING (4) 8-32 X 3/8 RHMS.
- 5) INSERT THE FOLLOWING FUSES LOCATED IN AS07 FOR THE DIGITAL 42: (2) 12 AMP (PRF131) INTO TOP FUSE HOLDERS, (2) 12 AMP (PRF131) INTO FUSE HOLDERS BELOW LOWER RELAY, AND (2) 8 AMP LITTLEFUSE SLO BLO

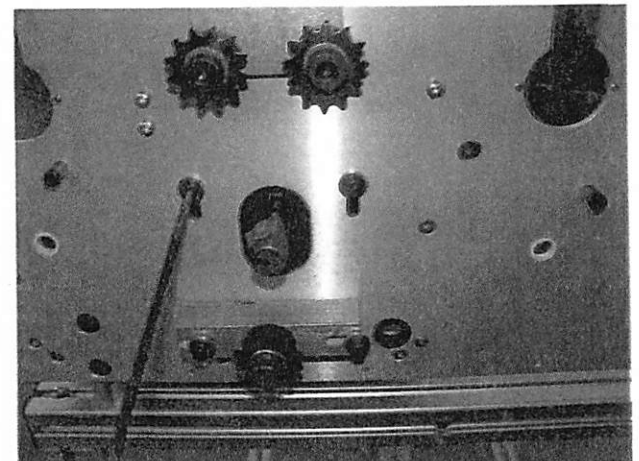
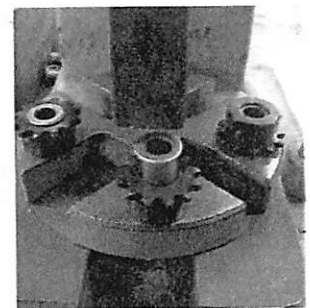
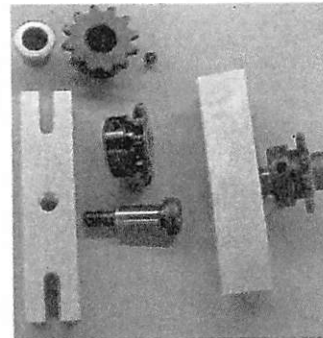
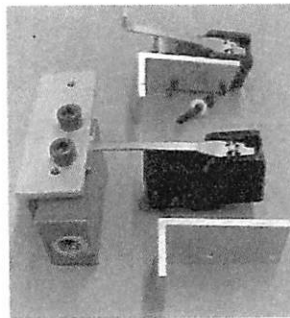
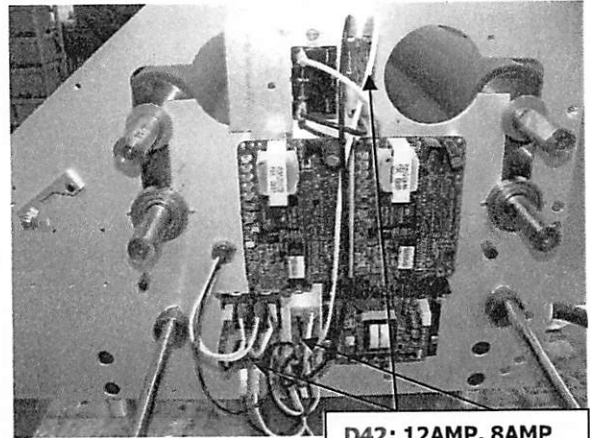


(PRF137) RIGHT OF LOWER RELAY. INSERT THE FOLLOWING FUSES FOR THE DIGITAL 60: (2) 20 AMP LITTLEFUSE FAST ACTING (PRF138) INTO THE TOP FUSE HOLDERS, (2) 20 AMP (PRF138) INTO FUSE HOLDERS BELOW LOWER RELAY, AND (2) 8 AMP LITTLEFUSE SLO BLO (PRF137) RIGHT OF LOWER RELAY.

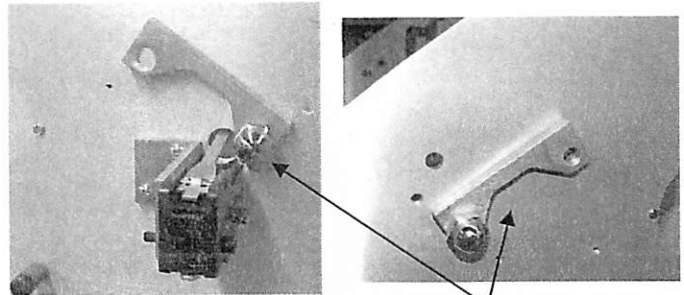
- 6) FROM RACK 1 ASSEMBLE LEVER TYPE MICROSWITCH (PRS313) BY FIRST BENDING UP MICROSWITCH TONGUE WITH GAUGED TOOL. INSERT (2) 6-32 X 1 SHCS WITH A #6 FLAT WASHER ON EACH, THROUGH SIDE OF MICROSWITCH AND INTO SAFETY SWITCH BRACKET (LC38 170.4). ALIGN TONGUE UPWARD THROUGH LEFT SIDE PANEL APERTURE AND SECURE BRACKET TO OUTER SIDE PANEL WITH (2) 6-32 X 1/4 PH.

- 7) TO ASSEMBLE BOTTOM RUBBER ROLL CHAIN ADJUSTER (LC38 055.4) RACK 2 TAKE A 35B12 IDLER SPROCKET 5/8 BORE (PRS320) RACK 2 AND ARBOR PRESS AN OILITE FLANGE BEARING (PRB094) RACK 2 INTO THE SPROCKET FROM THE TOOTH SIDE. INSERT A 1/2 X 1 SHOULDER BOLT (.500IAC16) AS13 INTO FLANGE/TOOTH SIDE OF IDLER SPROCKET AND THREAD SHOULDER BOLT INTO BOTTOM RUBBER ROLL CHAIN ADJUSTER.

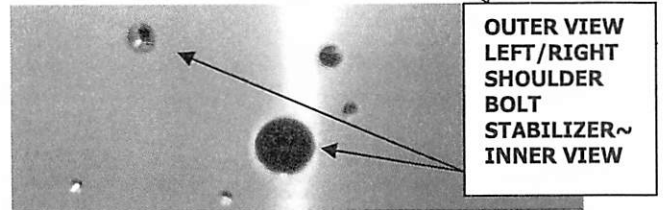
- 8) PLACE LEESON OR BALDOR GEAR MOTOR (PRM2000) AS05 IN MOUNTING POSITION THROUGH LEFT SIDE PANEL, MOTOR WIRES UPWARD. FROM OUTSIDE START (2) 1/4-28 X 3/4 BH WITH A 1/4 X 5/8 X 1/8 WASHER ON EACH INTO TOP MOTOR THREADS. START A 1/4-28 X 1 3/4 SHCS WITH A 1/4 X 5/8 X 1/8 WASHER ON IT INTO ONE BOTTOM MOTOR THREAD, SLIDE ON LOWER CHAIN ADJUSTER ASSEMBLY AND THEN START THE OTHER BOTTOM MOTOR THREAD WITH SAME HARDWARE. RAISE MOTOR UP AS FAR AS POSSIBLE AND TIGHTEN ONE TOP SCREW, ONLY SNUG OTHERS AS MOTOR WILL BE LOWERED WHEN CHAIN IS CONNECTED.



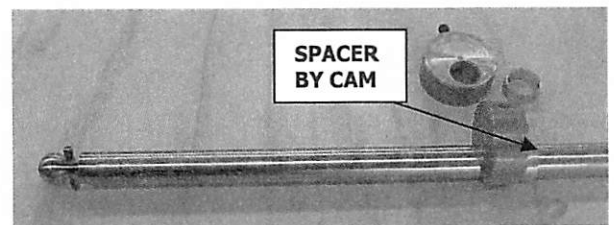
- 9) ALIGN AND ATTACH LEFT AND RIGHT SHOULDER BOLT STABILIZER (D60 080.4) RACK 1 TO OUTER SIDE PANELS. STABILIZER COUNTERSINKS NEXT TO PANEL. USE (2) 5/16 X 18 X 3/4 FHCS ON LOWER THREADS AND TIGHTEN. ON OUTSIDE SECURE THREADS WITH (2) 5/16 X 18 ACORN NUTS. THE UPPER HOLES WILL BE SECURED LATER.



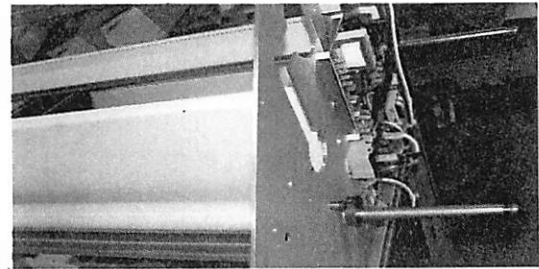
- 10) PREPARE (2) CAM SHAFTS (D60 OR D105 130.4) FROM LEFT 2 BY TAPPING A 1/8 X 1" SPRING PIN (.125J0016) INTO THE BALL END OF EACH SHAFT, EVEN ON BOTH SIDES. SECURE A CAM (H850 133.4) AS08 ON BALL END OF BOTH SHAFTS USING A 10-32 X 3/4 SET SCREW IN HOLE PROVIDED. SLIDE CAM SPACER (LC38 131.4) RACK 2 ONTO EACH SHAFT, NEXT TO SECURED CAM. INSERT LONG END OF CAM SHAFT INTO BACK BEARING NYLINER FROM RIGHT SIDE OF MACHINE. EXIT SHAFT THROUGH LEFT SIDE NYLINER, ADD ANOTHER CAM SPACER AND SECURE CAM SHAFT ON LEFT WITH CAM AND 10-32 X 3/4 SS. INSERT FRONT CAM SHAFT WITH CAM SPACER ON IT FROM RIGHT AND SLIDE ON IDLER TUBE (D60 OR D105 052.4) D60 OR D105-01 WITH AN IDLER BEARING (PRB086A) AS13 ON EACH END. RUN CAM SHAFT THROUGH IDLER TUBE AND LEFT SIDE PANEL, ADD A CAM SPACER AND SECURE WITH CAM AND 10-32 X 3/4 SET SCREW.



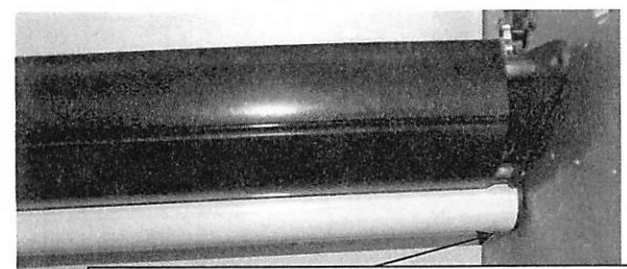
OUTER VIEW  
LEFT/RIGHT  
SHOULDER  
BOLT  
STABILIZER~  
INNER VIEW



SPACER  
BY CAM

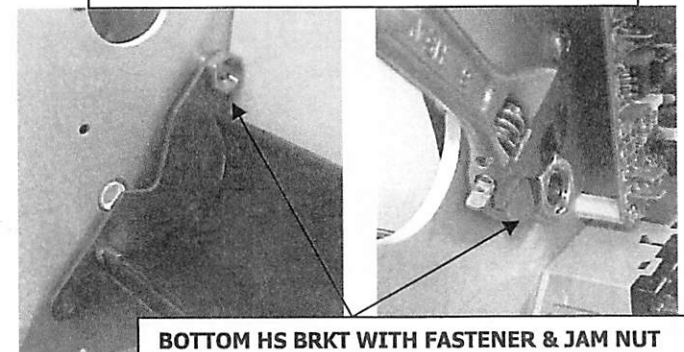


- 11) ADD THE BOTTOM HEAT SHOE ASSEMBLY BEFORE THE BOTTOM RUBBER ROLL. ATTACH HEAT SHOE BRACKET FOR DIGITAL BETWEEN SIDE PANELS BY MOTOR COVER WITH (2) BOTTOM HEAT SHOE FASTENERS (LC38 067.4) RACK 1 FROM INNER SIDE PANEL. RUN HEAT SHOE WIRES THROUGH FASTENER ON RIGHT. SECURE FASTENER WITH (2) 1/2-20 JAM NUTS (.500LDB00) AS13.



CAM SHAFT & IDLER TUBE UNDER HEAT SHOE

- 12) ADD (4) RUBBER ROLLS (D60/D105 040.4) LOFT 5 INTO CHASSIS. JOURNAL KEYWAYS GO ON LEFT/MOTOR SIDE. REMOVE RUBBER ROLL PROTECTIVE COVERING AND CLEAN JOURNALS IF



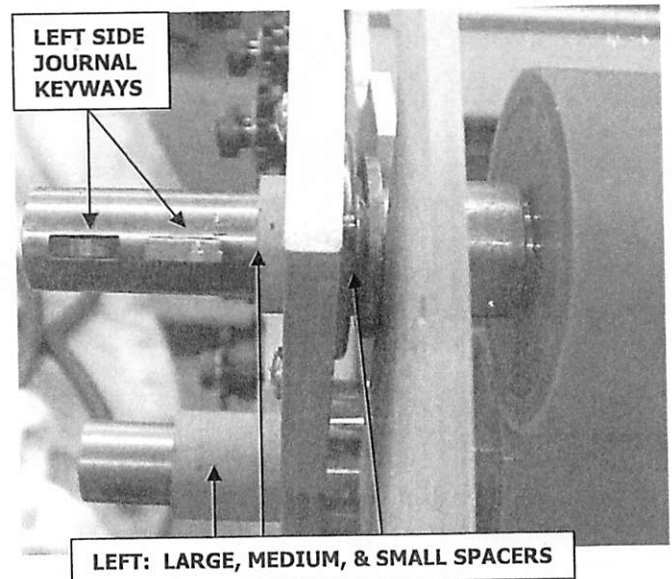
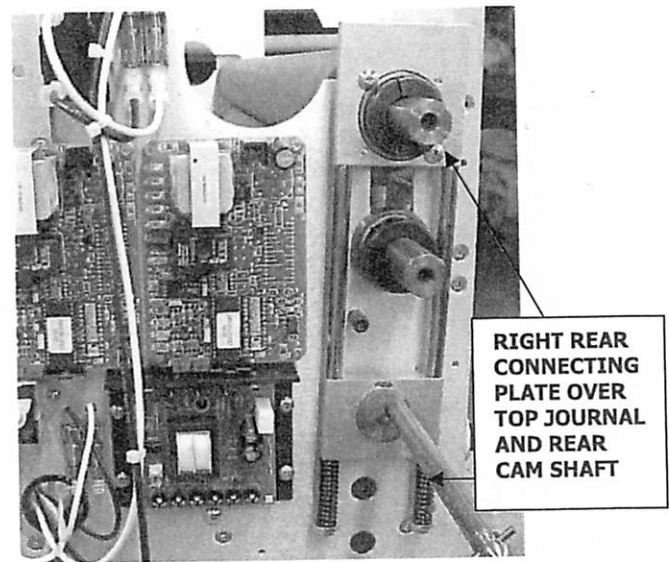
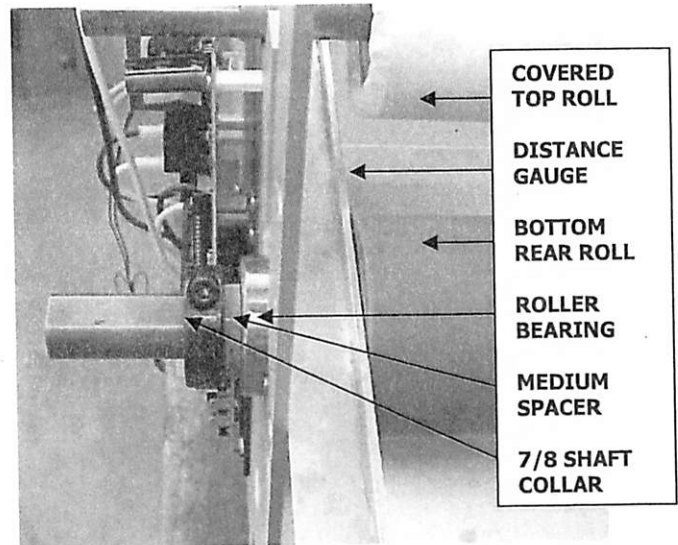
BOTTOM HS BRKT WITH FASTENER & JAM NUT



NECESSARY. TAP A R14Z ROLLER BALL BEARING (PRB087) AS07 ONTO BOTH SIDES OF THE BOTTOM REAR RUBBER ROLL JOURNAL. SNUG BOTH OF THE ROLLER BEARINGS INTO SIDE PANEL. ADD TO RIGHT SIDE OF BOTTOM REAR RUBBER ROLL JOURNAL A "MEDIUM" TOP LEFT OUTER SPACER (LC38 032.4) RACK 2, AND A 7/8 SPLIT SHAFT COLLAR (PRC112) RACK 2. USE GAUGE AND MEASURE ROLL DISTANCE FROM SIDE PANEL. ADD TO LEFT SIDE OF BOTTOM REAR RUBBER ROLL JOURNAL A "LARGE" BOTTOM RUBBER ROLL SPACER (LC38 033.4) RACK 2 A SPROCKET WILL HOLD THE LARGE SPACER IN PLACE WHEN CHAIN IS ADDED. GAUGE DISTANCE AGAIN AND TIGHTEN RIGHT COLLAR.

- 13) PLACE TOP REAR RUBBER ROLL ONTO BOTTOM ROLL, MEASURE DISTANCE WITH GAUGE. SLIDE A WORKED OILITE BEARING (PRB089) RACK 2 ON EACH JOURNAL, FLANGE OUTWARD. SLIDE INTO SIDE PANELS. ADD A "SMALL" TOP INNER RUBBER ROLL SPACER (LC38 031.4) RACK 2 TO EACH JOURNAL. BRUSH ANTI-SEIZE ONTO CIRCUMFERENCE OF BOTH REAR CAMS. TAP RIGHT REAR CONNECTING PLATE OVER TOP JOURNAL AND CAM. ***REMEMBER!*** THE EXCESS ROLLER BEARING GOES TOWARD SIDE PANEL. GAUGE DISTANCE AGAIN AND SECURE CONNECTING PLATE ON JOURNAL WITH A 7/8 SPLIT SHAFT COLLAR ON RIGHT. ON TOP LEFT JOURNAL AFTER "SMALL" SPACER, ADD CONNECTING PLATE AND A "MEDIUM" SPACER.

- 14) TAP A ROLLER BALL BEARING R14Z (PRB087) AS07 ONTO BOTH JOURNALS OF THE BOTTOM FRONT RUBBER ROLL AND SNUG INTO SIDE PANEL. ON THE RIGHT JOURNAL ADD A "MEDIUM" SPACER. ADJUST DISTANCE FROM SIDE PANEL WITH GAUGE. SECURE WITH 7/8 SPLIT SHAFT COLLAR. ON THE LEFT SIDE ADD A "LARGE" SPACER. ADD A WORKED OILITE BEARING TO BOTH JOURNALS OF THE TOP FRONT RUBBER ROLL, SLIDE



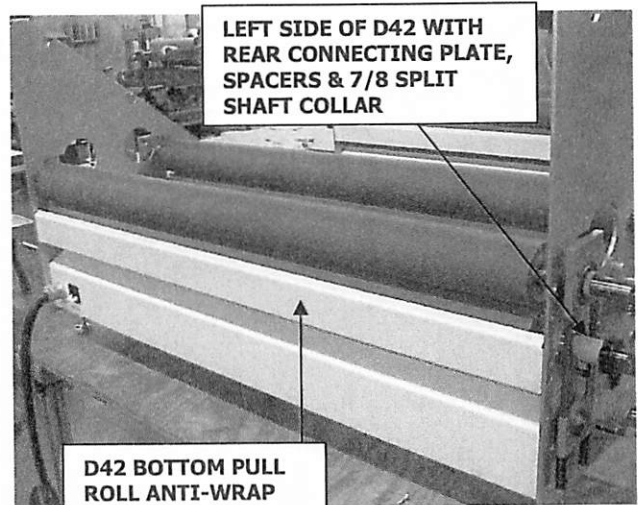
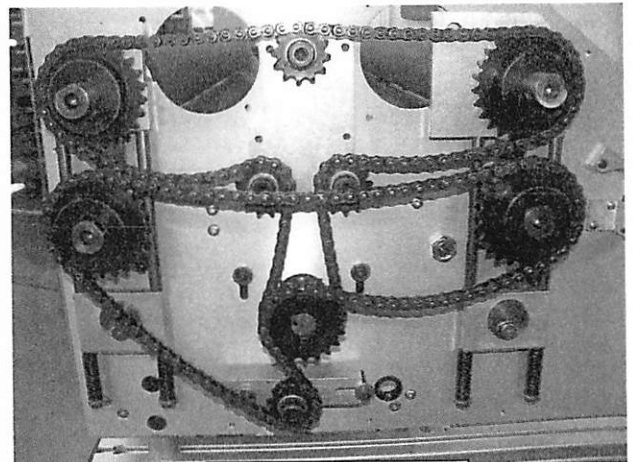
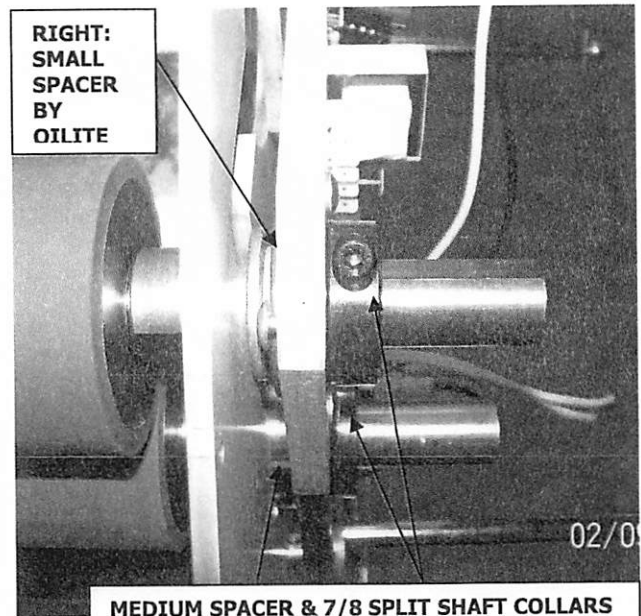
BEARINGS INTO SIDE PANEL AND SET TOP ROLL ONTO BOTTOM ROLL. REMEASURE DISTANCE. SLIDE A "SMALL" SPACER ONTO BOTH TOP FRONT JOURNALS NEXT TO OILITE BUSHING. ANTI-SEIZE CAMS AND ADD FRONT CONNECTING PLATES WITH ANGLED SECTION FACING FRONT AND THREADED HOLE FOR TOP HEAT SHOE FACING REAR. SECURE RIGHT SIDE WITH 7/8 SPLIT SHAFT COLLAR. ON LEFT FRONT ADD MEDIUM SPACER.

- 15) USE (4) KEYS (MI61) AS13 IN KEYWAYS ON RUBBER ROLL JOURNALS: TOP ROLLS INNER KEYWAYS, BOTTOM ROLLS OUTER KEYWAYS. FROM RACK 2 ADD 1/4-28 X 1/2 SET SCREWS ON (2) LAMINATOR ROLL SPROCKETS 35B25 (PRS321) AND (2) PULL ROLL SPROCKETS 35B24 (PRS322). TOP SPROCKETS MUST GO ON FIRSTS. THE 35B24 SPROCKETS GO ONTO BOTH BACK JOURNALS AND THE 35B25 SPROCKETS GO ONTO BOTH FRONT JOURNALS. ALL (4) SPROCKETS ARE HUB OUT/TEETH IN. D60 MOTOR ADD (2) 35-12 DRIVE SPROCKETS (PRS320A) 8-32 X 1/4 SS. D42 MOTOR ADD (2) 35-19 DRIVE SPROCKETS (PRS323) BOTH HUB INWARD/TEETH OUTWARD, 1/4-28 X 3/8 SS ON KEY.

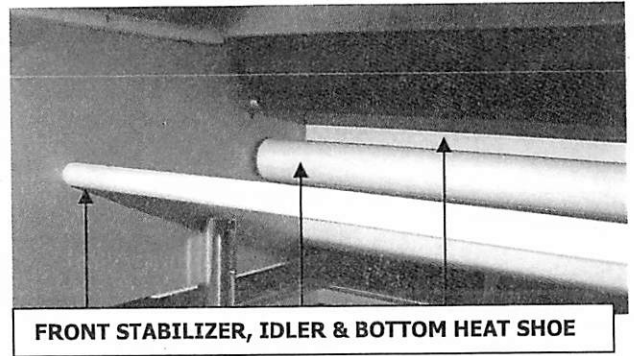
- 16) PLACE ROLLS IN "UP" POSITION. USE (2) #35 CHAIN CONNECTING LINKS (PRC087) AS07. CONNECT THE LONGER #35 CHAIN TO TOP SPROCKETS AND INNER MOTOR SPROCKET AFTER USING A STRAIGHT EDGE TO ALIGN TEETH. CONNECT LOWER SPROCKETS WITH OUTER MOTOR SPROCKET. TIGHTEN CHAIN BY LOWERING MOTOR AND ALIGNING CHAIN ADJUSTOR. FINAL TENSION: INNER CHAIN CAN LIFT TO MIDDLE UPPER SPROCKET TOOTH TIPS, OUTER CHAIN SHOULD BE TIGHT.

- 17) ATTACH THE BOTTOM PULL ROLL ANTI-WRAP SAFETY SHIELD (D60 013.4) ~~D105-01~~ TO THE BACK OF THE DIGITAL LAMINATOR ABOVE THE MOTOR COVER. THE ANGLED LIP FACES UPWARD AND THE STRAIGHT LIP DOWNWARD. USE (4) 10 X 5/8 FH SQ DR SMS TO SECURE.

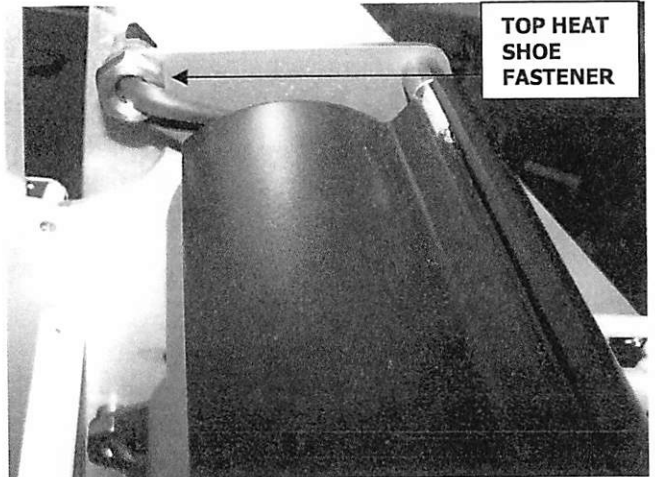
Left 2



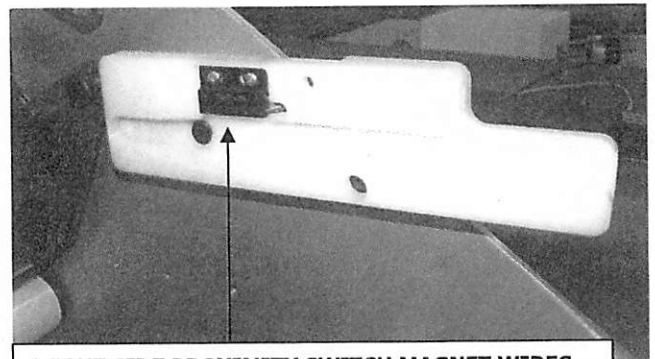
- 18) RAISE AND POSITION BOTTOM HEAT SHOE. FINISH SECURING TO SIDE PANELS BY INSERTING (2) 3/8 X 5/8 SHOULDER BOLTS THROUGH HEAT SHOE BRACKETS INTO THREADS OF SHOULDER BOLT STABILIZERS ON OUTER SIDE PANELS.
- 19) ATTACH PAINTED FRONT SPREADER BAR FOR D42 (D105 216.4) OR D60 (EP60 216.4) LOFT 2 SHELF BETWEEN SIDE PANELS USING (2) 1/4-20 X 3/4 BSHS.
- 20) INSERT TOP HEAT SHOE ASSEMBLY, CAREFULLY RUNNING HEATER AND SENSOR WIRES THROUGH TOP HEAT SHOE FASTENER (LC38 068.4) RACK 1 ON RIGHT. SECURE BOTH TOP HEAT SHOE FASTENERS THREADING INTO RIGHT AND LEFT FRONT CONNECTING PLATES.
- 21) ATTACH PROXIMITY SWITCH MAGNET (PRS351) RACK 1 WITH (2) 4-40 X 1/4 PHMS TO RIGHT FEEDTABLE BRACKET (D60 098.4R) AS13 RED WIRES GOING THROUGH CLOSEST HOLE IN BRACKET. ADD BRACKET TO INSIDE OF RIGHT SIDE PANEL USING (2) 1/4 X 5/8 X 1/8 WILLIAMS FLAT WASHER AND (2) 10-32 X 3/4 FSHS SCREWS, WIRES THROUGH SIDE PANEL. ATTACH LEFT FEEDTABLE BRACKET (D60 098.4L) AS13 TO LEFT SIDE PANEL, SAME HARDWARE.
- 22) ATTACH RIGHT AND LEFT BOTTOM HOUSINGS TO SIDE PANELS USING 10-32 X 1/4 THMS AND LONG SCREWDRIVER.
- 23) ATTACH RIGHT AND LEFT UPPER HOUSING ASSEMBLIES BETWEEN SIDE PANELS WITH 10-32 X 1/4 THMS. \*\*\*PROXIMITY SWITCH WIRES GO THROUGH HOUSING HOLE. USE A LONG SCREWDRIVER.
- 24) ON LEFT SIDE FRONT UPPER HOUSING INSERT RED EMERGENCY PUSHBUTTON ACTUATOR (PRS374) AS08 USING CASTLE LOCK TOOL.
- 25) FASTEN DIGITAL MACHINE HOUSING CORNER BRACES ON BOTH BOTTOM HOUSINGS TO UPPER HOUSINGS USING



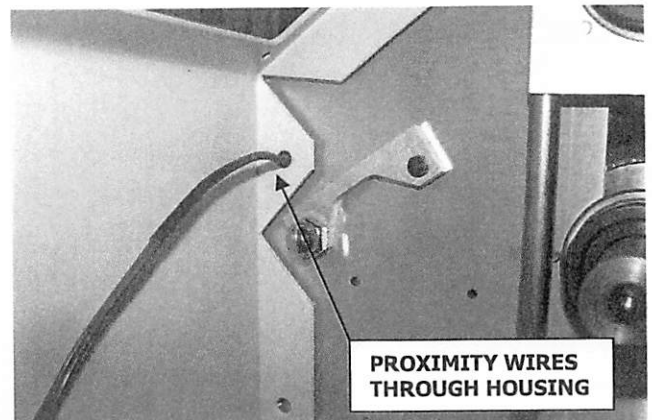
FRONT STABILIZER, IDLER & BOTTOM HEAT SHOE



TOP HEAT SHOE FASTENER



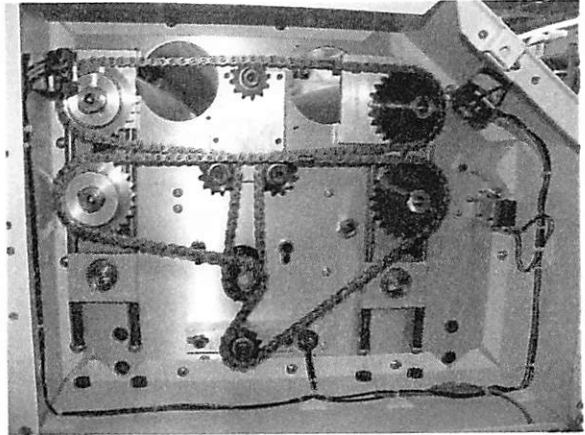
RIGHT SIDE PROXIMITY SWITCH MAGNET WIRES



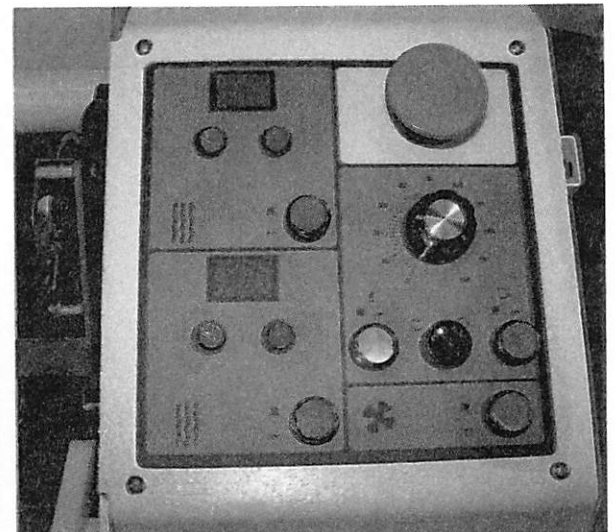
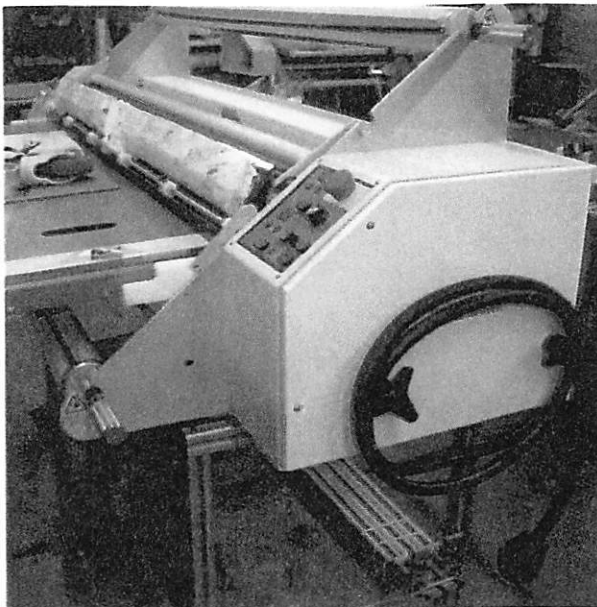
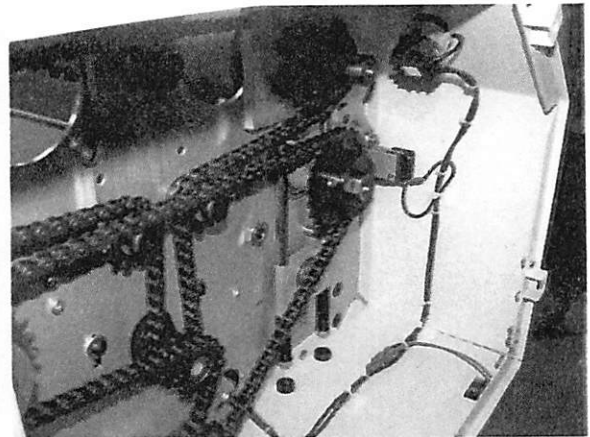
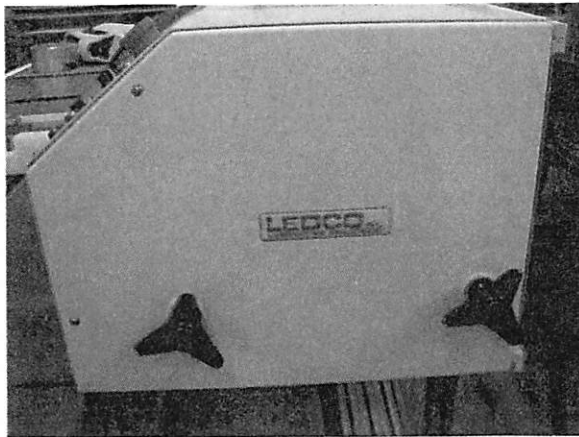
PROXIMITY WIRES THROUGH HOUSING

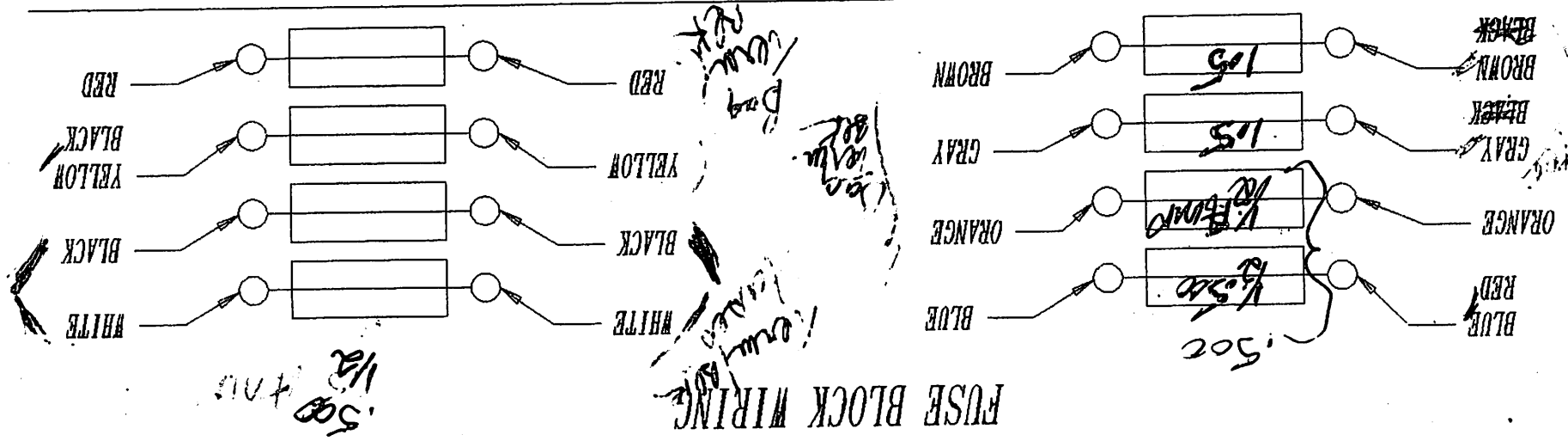
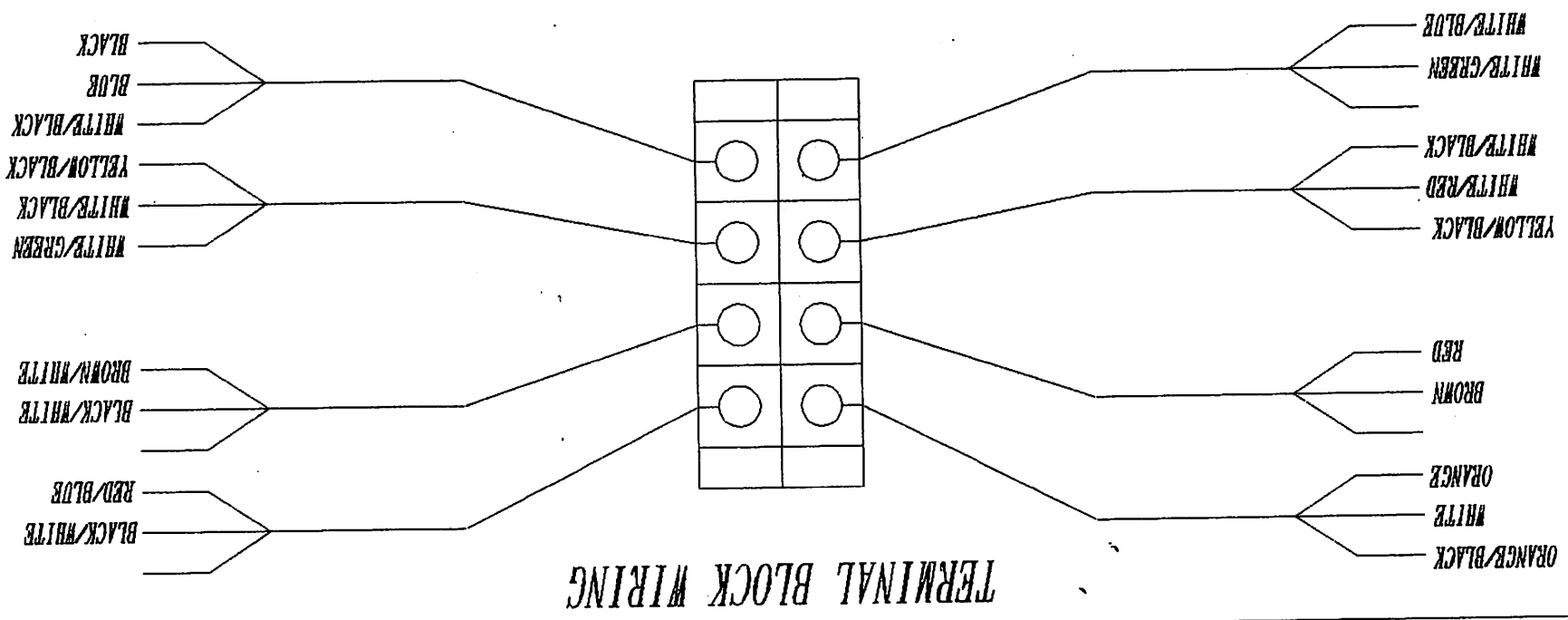
(2) 8-32 X 3/8 FH ON OUTSIDE AND (2)  
# 8 KEPS HEX NUTS ON INSIDE.

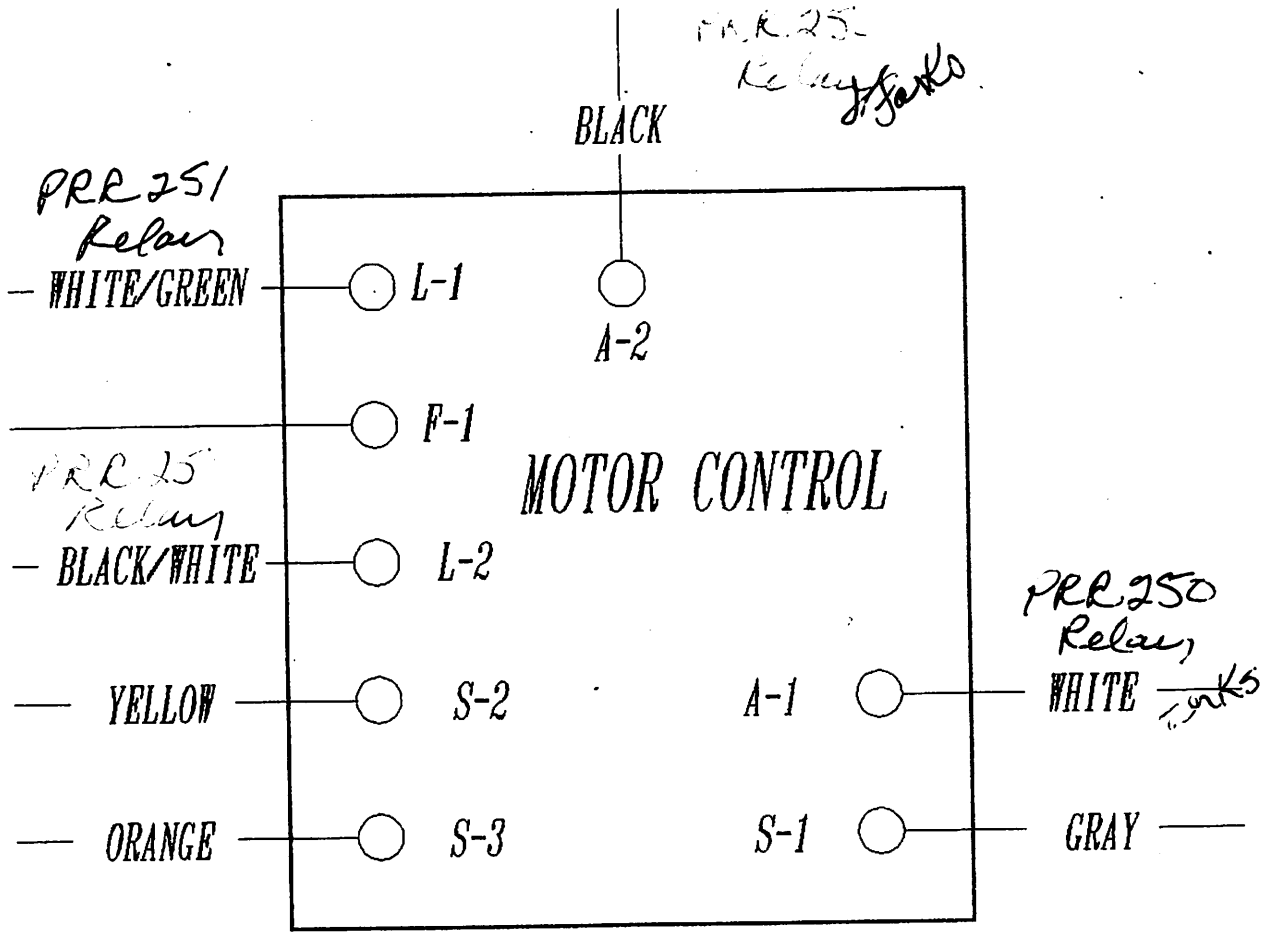
- 26) ADD FACIA ASSEMBLY TO RIGHT UPPER HOUSING SECURED WITH (4) 6-32 X 1/4 PH. ADD RIGHT FRONT EMERGENCY SWITCH BUTTON.
- 27) SECURE TAPED DOOR LATCH TO UPPER RIGHT HOUSING WITH (2) 8-32 X 3/8 RH ON OUTSIDE AND (2) #8 KEPS HEX NUTS INSIDE.
- 28) FOLLOW WIRING DIAGRAMS.



CORNER BRACKETS AND FASTENERS IN PLACE





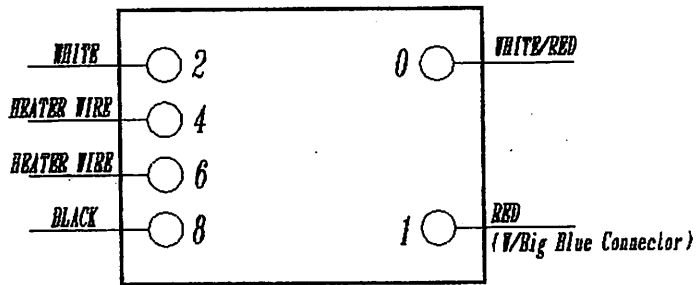


TOP MAGNET: FEMALE CONNECTORS BOTH WIRES

BOTTOM MAGNET: ONE MALE/ONE FEMALE CONNECTOR

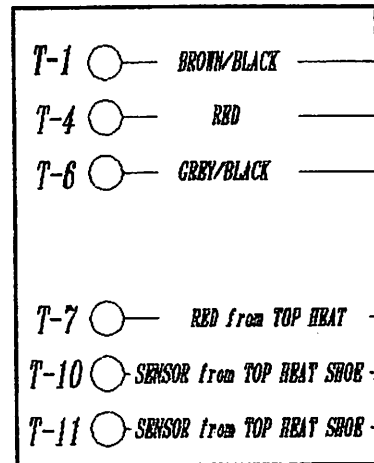
# TOP HEAT CIRCUIT

## TOP RELAY



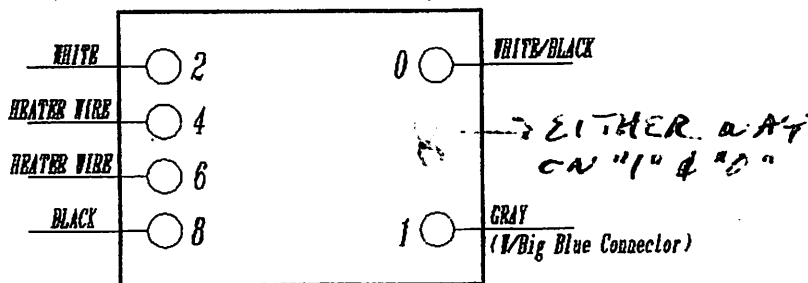
# TOP HEAT CONTROLLER

(Rea)

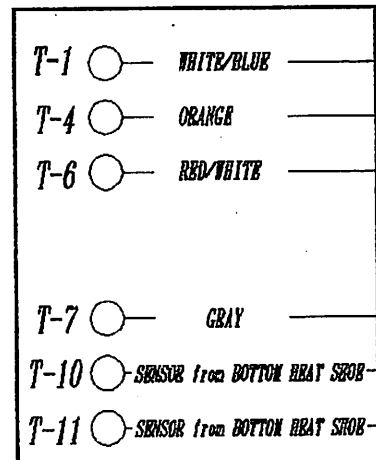


# BOTTOM HEAT CIRCUIT

## BOTTOM RELAY

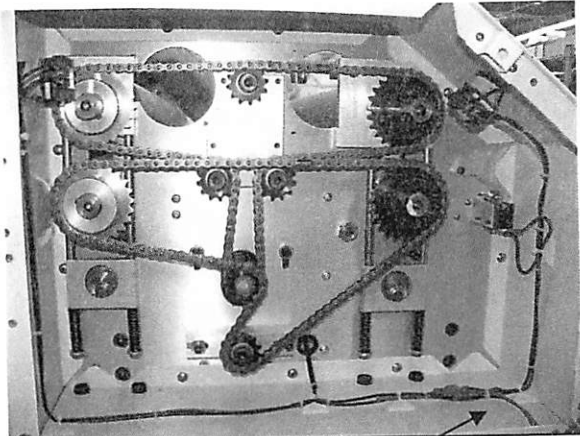


# BOTTOM HEAT CONTROLLER

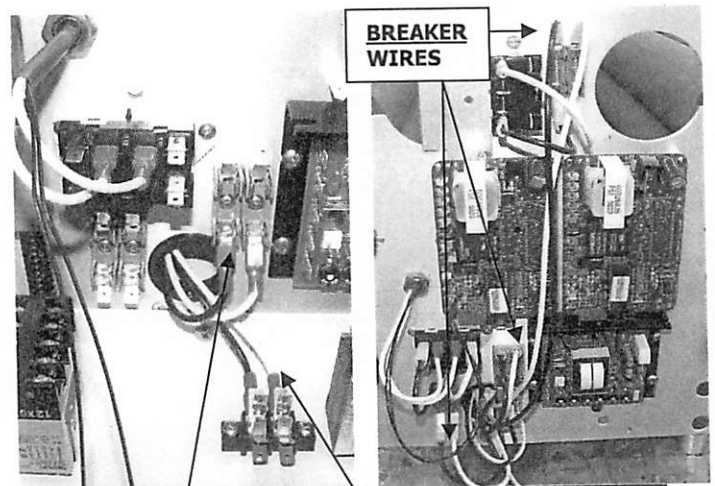


# DIGITAL NRTL 42/60 WIRING & CHASSIS COMPLETION

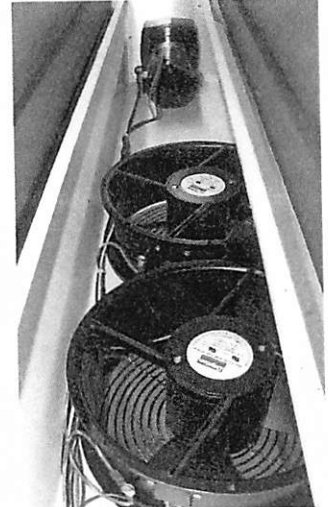
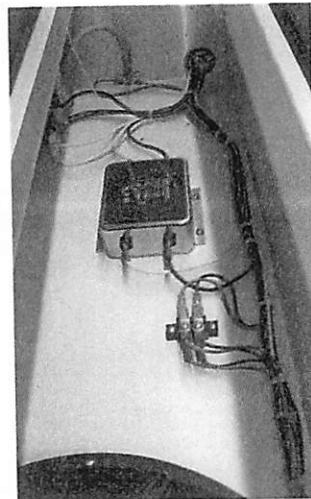
- 1) WITH FACIA INSTALLED, LAY DIGITAL LAMINATOR WIRING HARNESS (PRW346A) RACK 2 IN RIGHT HOUSING. EXIT MOTOR, GROUNDS, FAN WIRES AND LONG BLACK WIRES THROUGH SNAP BUSHINGS. CONNECT (3) MOTOR WIRES, GROUND TO FAN WIRE, AND GROUND WIRES TO SIDE PANEL. EXIT REMAINING BLACK WIRES THROUGH LEFT SIDE PANEL.
- 2) ON LEFT HOUSING CONNECT BLACK OPEN ENDED WIRES TO FRONT AND REAR E-STOP SWITCH OUTER SCREWS. CONNECT MAGNET WIRES TO HARNESS AND LEVER TYPE MICROSWITCH WITH FORKS TO (2) OUTER SCREWS.
- 3) ON RIGHT SIDE, THE BOTTOM HEATER WIRES TERMINATE ON LOWER RELAY #4 AND #6 AS SHOWN IN PICTURES.
- 4) FROM BAG #4 CONNECT BLACK AND WHITE WIRES BETWEEN POWER FILTER "LINE" SIDE AND LOWER 8 AMP FUSE TERMINALS BY SPEED BOARD. CONNECT "LOAD" SIDE BLACK AND WHITE TO INNER 90 DEGREE TERMINAL BLOCK, WHITE TO REAR.
- 5) CONNECT THE 12 GAUGE BLACK AND WHITE WIRES FROM "LOAD" ON BREAKER AND BAG #4 ONTO FUSES AND RELAYS. BLACK ON RELAY #8 WHITE ON #2. THE WHITE WIRES CONNECT TO THE REAR FUSE AND THE BLACK WIRES GO TO THE FRONT.
- 6) ARRANGE THE WIRING BUNDLE ALONG RIGHT HOUSING BOTTOM. CONNECT OPEN ENDED WIRES TO REAR E-STOP. ANCHOR THE WIRING BUNDLE WITH CONNECTIONS TO THE MOTOR SPEED CONTROL BOARD: WHITE/GREEN=L1, BLACK/WHITE=L2, BLACK=A2, WHITE=A1, GRAY=S1, YELLOW=S2, ORANGE=S3 AND CONNECT MOLEX. ARRANGE WIRES SO THEY DO NOT



LEFT SIDE: E-STOPS, LEVER MICROSWITCH & MAGNET



FILTER: "LINE" TO FUSE & "LOAD" TO TERMINAL BLOCK

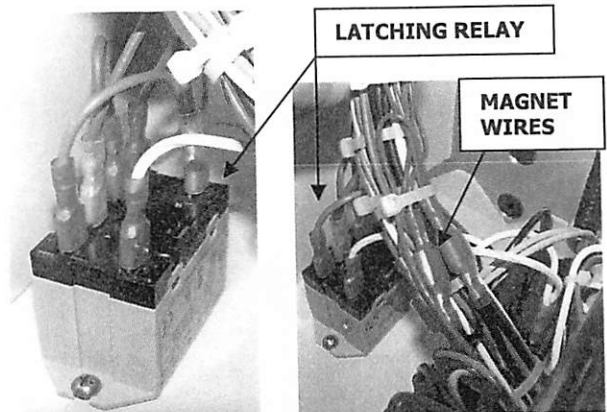
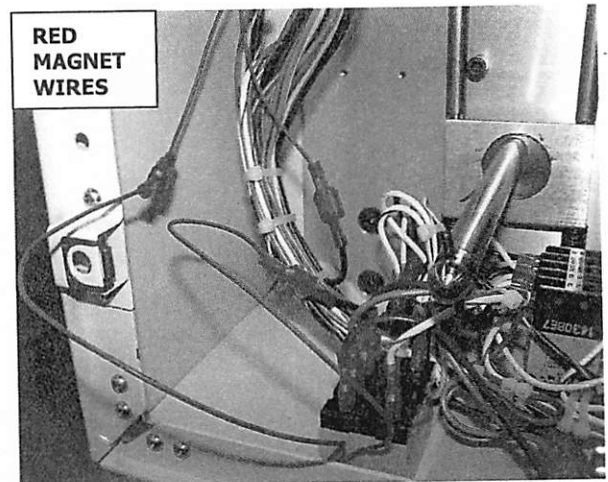
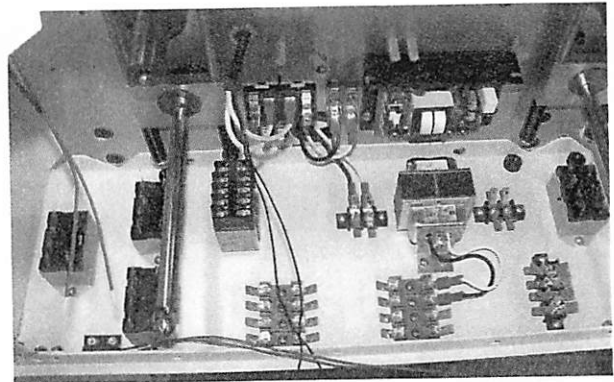


*to top rail*

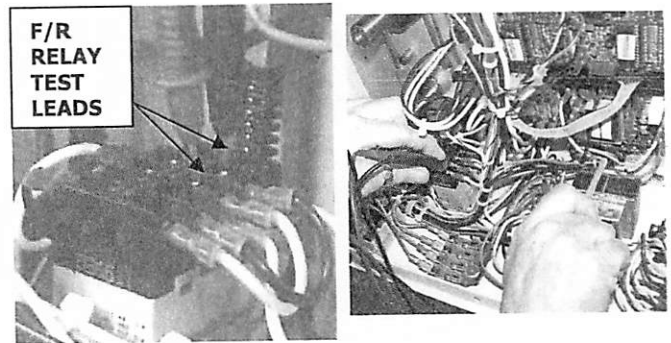


**INTERFER WITH SHAFTS OR RUB ON ANY PARTS. FOLLOW WIRING DIAGRAM.**

- 7) **IN THE FRONT OF THE RIGHT HOUSING, CONNECT ONE RED WIRE FROM THE MAGNET IN THE FEED TABLE BRACKET WITH ONE RED WIRE ON THE DOOR MAGNET. CONNECT THE REMAINING RED MAGNET WIRES WITH THE (2) BLACK WIRES IN THE HARNESS THAT HAVE MALE CONNECTORS.**
- 8) **THE NRTL DIGITAL FACIA HAS (2) ADDITIONAL WIRES ON THE GREEN, DRIVE SWITCH; ONE RED AND ONE ORANGE WITH AN ORANGE JUMPER.**
- 9) **THE FRONT "LATCHING" RELAY IS TERMINATED WITH THE DOUBLED ORANGE ON #0, WHITE/GREEN JUMPER ON #1, ORANGE JUMPER ON #8, DOUBLED RED ON #6, RED JUMPER ON #4 AND RED FROM FACIA ON #2.**
- 10) **TO TURN ON THE DIGITAL LAMINATOR WITHOUT USING THE FEED TABLE, YOU CAN TAPE A MAGNET (PRS352) RACK 1 ONTO THE PROXIMITY SWITCH MAGNET AND HOLD THE MICROSWITCH LEVER DOWN WITH TOOL. RELEASE (2) EMERGENCY ACTUATORS ON LEFT SIDE. CHECK THAT ALL SWITCHES ARE "OFF." PLUG 40 AMP CORD INTO 60 HRZ RECEPTACLE (50HZ IF GOING TO EUROPE). RELEAASE EMERGENCY SWITCHES. CHECK FAN FUNCTION.**
- 11) **SET HEAT ON BOTH SLAVE BOARDS BY PRESSING THE RED PUSHBUTTON CAP AND LETTING IT RUN TO 400 DEGREES, IT SHOULD STOP BY ITSELF THEN. NOW REDUCE HEAT BY PUSHING THE BLUE PUSHBUTTON CAP UNTIL TEMPERATURE REACHES 240 DEGREES. SET BOTH HEATERS TO 240 DEGREES.**
- 12) **SET MAXIMUM MOTOR SPEED WITH DRIVE SWITCH ON. INCREASE SPEED TO FULL EXTENT. USE VOLT METER ON DC. HOLD RED METER TEST LEAD ON THE FORWARD/REVERSE RELAY SCREW FOR DOUBLE WHITE WIRES (34/32) ON RIGHT SIDE OF RELAY AND HOLD BLACK TEST LEAD ON SCREW FOR BLACK WIRE (44/42) BEHIND WHITE DOUBLE WIRES,**

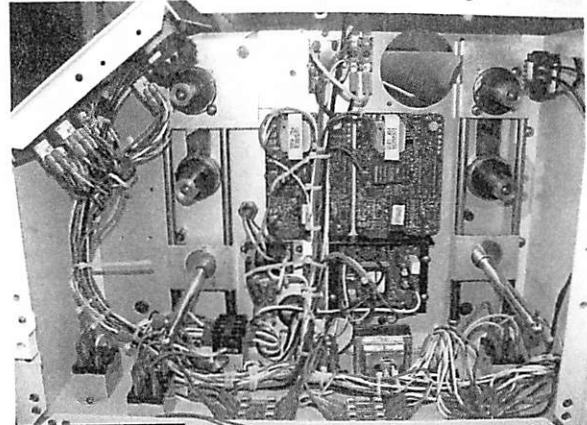


NEXT TO SIDE PANEL. AT THE SAME TIME ADJUST SPEED ON "MAXIMUM" POT (THIRD FROM LEFT) WITH TRIMMING TOOL. THE OPTIMUM READING IS 180, TOUCHY BOARDS CAN RANGE FROM 179.8-180.2. BE VERY CAREFUL OF JEWELRY TOUCHING METAL INSIDE BECAUSE YOU CAN BE SHOCKED.

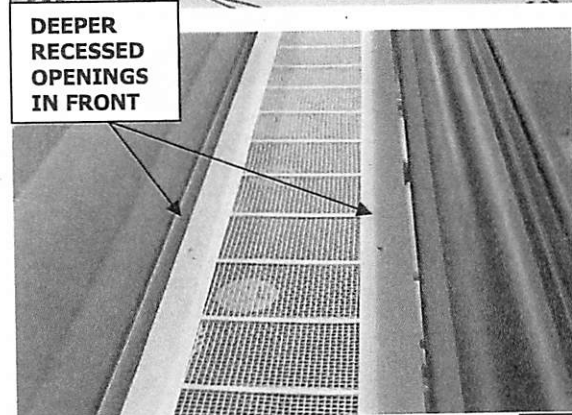


- 13) LIGHTLY APPLY STP LUBRICANT ONTO BOTH LEFT SIDE #35 CHAINS WHILE MOTOR IS RUNNING. DO NOT USE TOO MUCH OIL AS THE EXCESS WILL DRIP AND POOL ON THE BOTTOM HOUSING.

- 14) PLACE THE PERFORATED TOP MOTOR COVER (D60 092.4A) AS22 OVER THE BOTTOM MOTOR COVER HOLES, CHECKING THAT WIRES ARE TIED. THE DEEPER RECESSED SCREW HOLES FACE THE FRONT OF THE MACHINE. CONNECT THE TOP MOTOR COVER TO THE MOTOR COVER USING 10 X 1/2 PH SQ DR SMS.



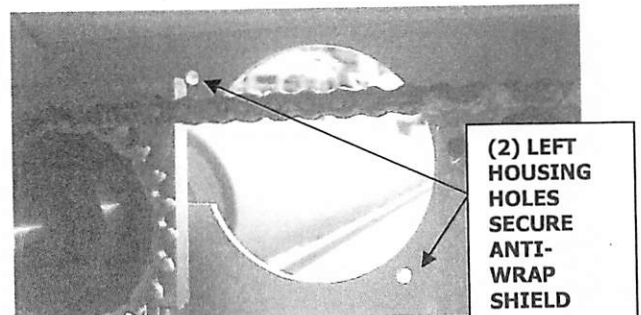
- 15) ADHERE A DOMED LEDCO EMBLEM (LAB05A) AS09 CENTERED OVER D42 TWO HOLES IN REAR OR DI60 HOLES IN FRONT OF ANTI-WRAP SHIELD (D60 012.4) LOFT 3. ALIGN LABEL USING GAUGE MEASURING RUBBER ROLL DISTANCE FROM SIDE PANELS. PLACE THE "L" FROM "LEDCO" OVER THE LEFT HOLE. USE ARROW ON GAUGE TO ALIGN (2) "ARM ENTANGLEMENT LABELS (LAB51) AS09 ON BACK OF SHIELD.



- 16) INSERT *INHOUSE* SPREADER BAR BETWEEN SIDE PANELS. WITH REAR RUBBER ROLLS DOWN, SECURE ANTI-WRAP SHIELD BETWEEN PANELS FROM INSIDE, BENT ANGLE TO REAR. USE (2) SIDE PANEL HOLES BY RUBBER ROLL APERTURES. THE ANTI-WRAP SHIELD FRONT AND TOP HOLES ARE SECURED, THE BACK HOLE IS NOT. USE (4) 10 X 1/2 PH SQ DR SMS.

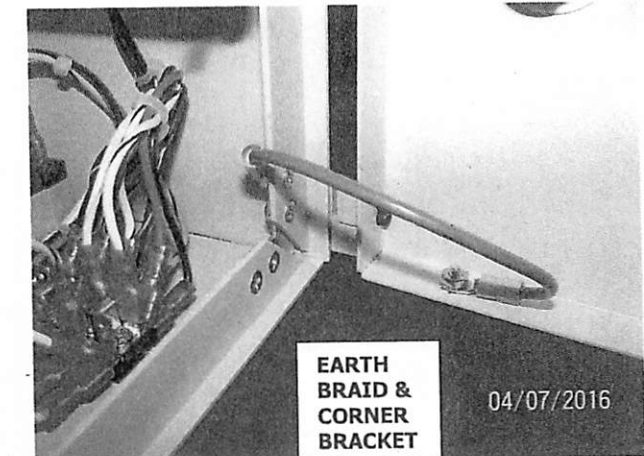
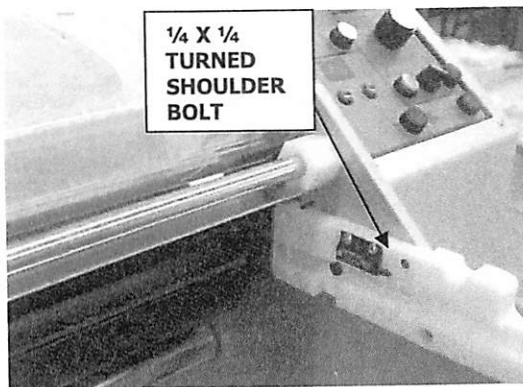
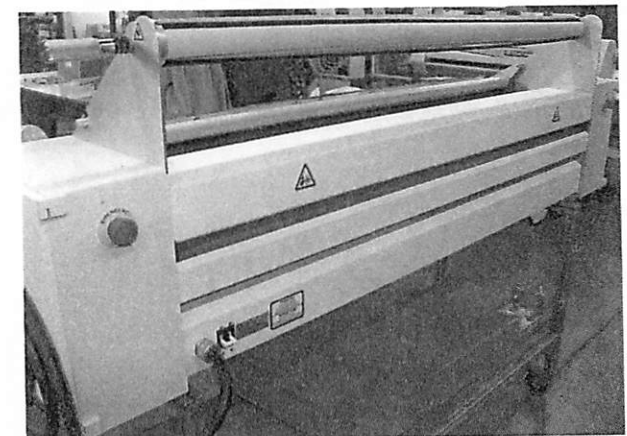
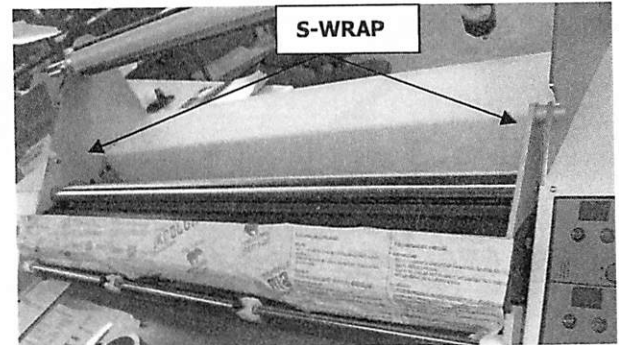
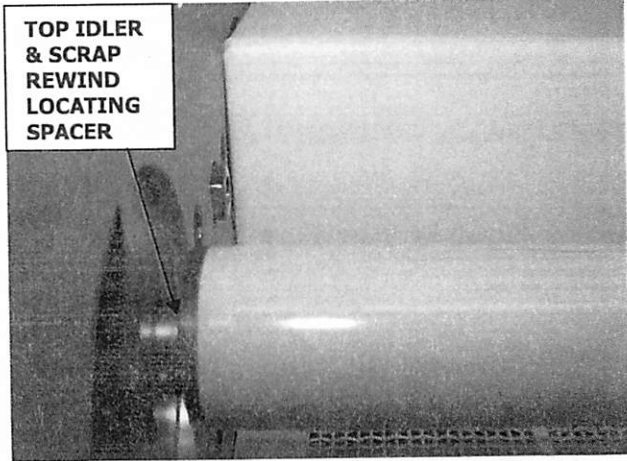


- 17) ATTACH UPPER IDLER BY INSERTING A SPREADER BAR (D42/60 110.4) LOFT 2 THROUGH IDLER TUBE (D60 052.4) D60-01 WITH A PLASTIC BEARING (PRB086A) AS13 ON EACH END. SLIDE



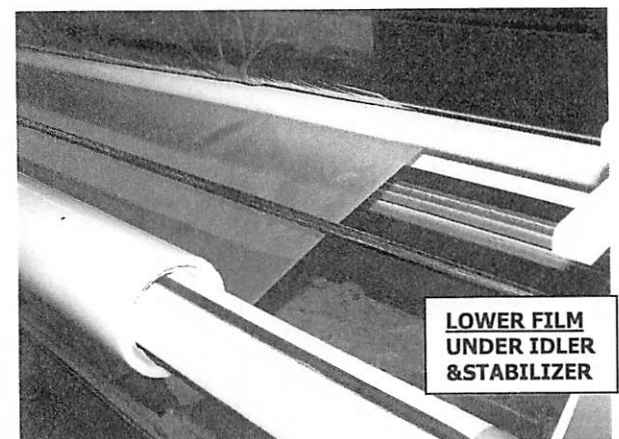
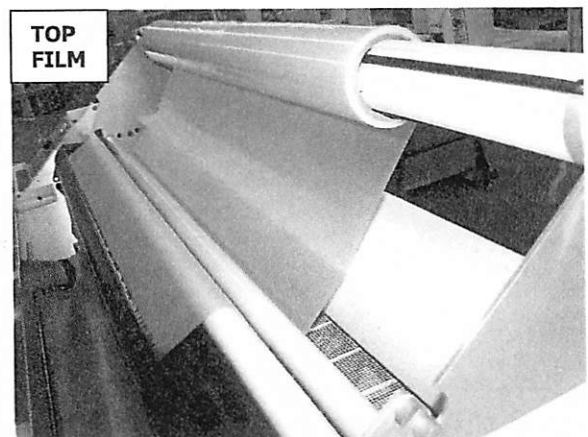
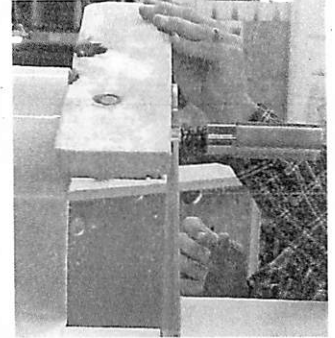
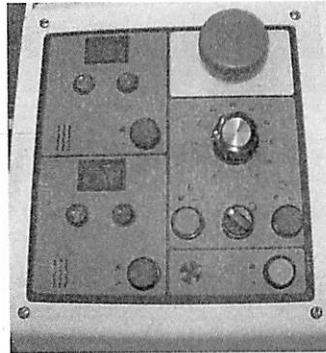
A SCRAP REWIND LOCATING SPACER (D105 202.4) RACK 22 ONTO ONE END OF THE SPREADER BAR. INSERT SPACER INTO ROUND UPPER IDLER BRACKET INDENTATION. SECURE SPREADER BAR WITH 1/4-20 X 3/4 BSHH. ON THE OTHER SIDE ADD A SCRAP REWIND LOCATING SPACER TO THE SPREADER BAR. SECURE TO ROUND INDENTATION ON UPPER IDLER BRACKET WITH 1/4-20 X 3/4 BH. SECURE IDLER BRACKET 10-32 X 7/16 FHMS.

- 18) REST S-WRAP IN UPPER SIDE PANEL NOTCH AND ON HOT ROLL BUSHING.
- 19) PLACE SAFETY SHIELD ASSEMBLY INTO FEED TABLE BRACKETS. SECURE WITH (2) 1/4 X 1/4 TURNED SHOULDER BOLT (.250IAC04A) COMMON.
- 20) INSERT FEED TABLE ASSEMBLY.
- 21) PLACE SUPPLY ROLLS IN NOTCHES.
- 22) SECURE RIGHT DOOR TO HOUSING. CONNECT EARTH BRAID STRAP TO REAR CORNER BRACKET ON HOUSING WITH 8-32 X 3/8 FH AND #8 KEPS HEX



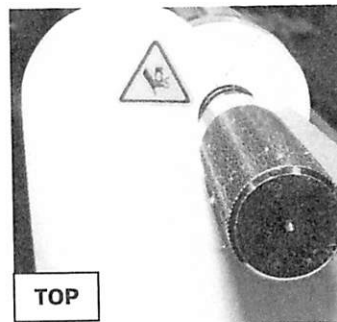
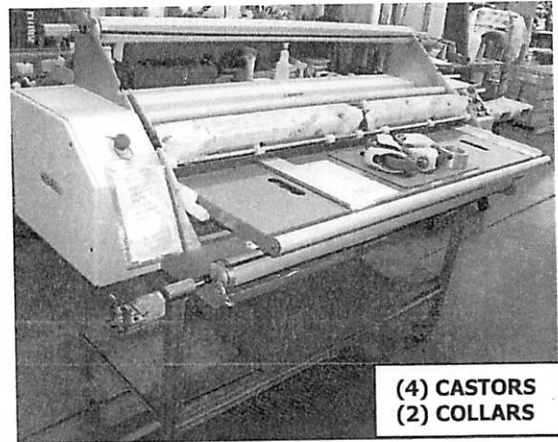
# DIGITAL NRTL 42/60 TESTING

- 1) **PLUG INTO 60 HRZ SOURCE. THE D42 USES AN ADAPTER. TURN ON. SET HEAT CONTROLS TO 240 FAHRENHEIT. THE 220 VOLT DIGITALS HEAT QUICKLY.**
- 2) **LOAD FILM ONTO TOP AND BOTTOM SUPPLY ROLLS. PLACE ROLLS ON MACHINE. REMEMBER FILM DIRECTION RULE: "SHINY SIDE TO SHOE."**
- 3) **USING WOODEN BLOCK GAUGE, CHECK WIDTH OF FILM ON BOTH ENDS OF SUPPLY ROLL FROM SUPPORT NOTCH ON RIGHT AND LEFT SIDE PANELS. CENTER AS EVEN AS POSSIBLE.**
- 4) **WITH *DRIVE AND PULL ROLLS UP*, THREAD TOP FILM UNDER BACK IDLER AND OVER FRONT S-WRAP IDLER. SHINY SIDE OF FILM ONTO HEAT SHOE.**
- 5) **THREAD LOWER FRONT FILM UNDER STABILIZER BAR AND UNDER IDLER TUBE. ALIGN BOTTOM FILM WITH TOP FILM AND LAY OVER TOP FILM ALREADY ON HEAT SHOE. THEY WILL STICK TOGETHER.**
- 6) **INSERT FEED TABLE, ACTIVATING PROXIMITY MAGNETS.**
- 7) ***PUT ROLLS DOWN*, DEPRESS GREEN DRIVE BUTTON, SLOWLY INSERT THREADBOARD INTO NIP AND RUN FILM BETWEEN HEAT SHOES.**
- 8) **STOP MACHINE, THEN RESTART AND CHECK DWELL LINE. RUN TEST PAPER THROUGH MACHINE. CHECK FOR CURL AND WRINKLES. ADJUST WITH SUPPLY ROLL TENSION.**
- 9) **ADHERE SILVER/BLACK SERIAL LABEL (LAB01) WITH JOB RIGHT OF BREAKER ON BOTTOM MOTOR COVER.**
- 10) **FILL OUT ALL PAPERWORK; "TEST LAMINATE SHEET – DIGITAL LAMINATOR," WHICH WILL SHIP TO THE CUSTOMER, THE JOB SHEET FOR THE OFFICE, AND "DIGITAL LAMINATE TEST"**

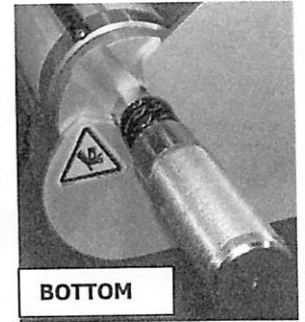


SHEET FOR THE OFFICE, WITH DATE OF COMPLETION INDICATED.

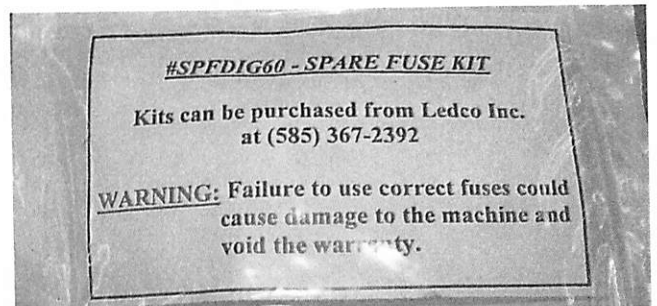
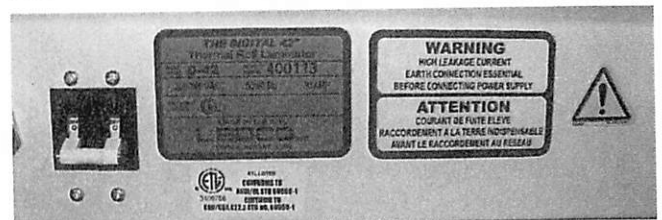
- 11) LAMINATE THE COMPLETED PAPER WORK AT 35 TO 40 SPEED AND TRIM FINISHED LAMINATES. PLACE PAPERWORK ON FEED TABLE.
- 12) FOR DIGITALS SOLD SHOWING CENTIGRADE TEMPERATURE READING, CHANGE BOTH HEAT REGISTERS FROM FAHRENHEIT TO 126 C.
- 13) PLACE (4) CASTORS (PRC210) AS14 WITH A 1/2-13 HEX NUT AS13 THREADED ON EACH ONTO FEED TABLE.
- 14) PLACE (2) STOP COLLARS WITH PLASTIC MOLDED THUMBSCREWS (PRK184) AS09 FEED TABLE.
- 15) CHECK MACHINE FOR LABELS. ON THE BACK BOTTOM MOTOR COVER, JUST RIGHT OF THE BREAKER IS THE SERIAL LABEL, RIGHT OF SERIAL LABEL ADHERE YELLOW WARNING/ATTENTION "HIGH LEAKAGE" LABEL (LAB101A) AS09.
- 16) ADHERE (4) HAND CRUSH FORCE FROM ABOVE LABELS (LAB35) AS09 TO THE OUTER SUPPLY BRACKETS, FITTING BY NOTCH AS PICTURED.
- 17) FROM AS09 CENTERED BETWEEN THE DOOR HANDLES BY THE LOWER DOOR LIP ADHERE THE YELLOW FUSE CHART LABEL (LAB44) FOR THE DI42 OR THE ORANGE FUSE CHART LABEL (LAB45) FOR THE DI60.
- 18) SECURE A SPARE FUSE KIT (SPFDI42) AS07 FOR THE DI42 CONSISTING OF THE FOLLOWING FUSES: (1) 1.5 AMP (PRF128), (2) .5 AMP (PRF136), (2) 12 AMP (PRF131) AND (1) 8 AMP (PRF137) PLUS THE SPARE FUSE LABEL (LAB126) OR THE SPARE FUSE KIT (SPFDI60) AS09 FOR THE DI60 CONSISTING OF (1) 8 AMP (PRF137), (2) .5 AMP (PRF136), (2) 20 AMP (PRF138) AND (1) 1.5 AMP (PRF128) PLUS A SPARE FUSE LABEL. ALL OF THESE FUSES ARE LOCATED IN AS07. ADHERE THE EMPTY POUCH ON THE INNER RIGHT DOOR, CENTERED



TOP



BOTTOM



**#SPFDIG60 - SPARE FUSE KIT**

Kits can be purchased from Ledco Inc.  
at (585) 367-2392

**WARNING:** Failure to use correct fuses could cause damage to the machine and void the warranty.

**POUCH FOR EXTRA HOLD ON THE DOOR. CENTER POUCH ABOVE THE FUSE CHART DIAGRAM LABEL.**

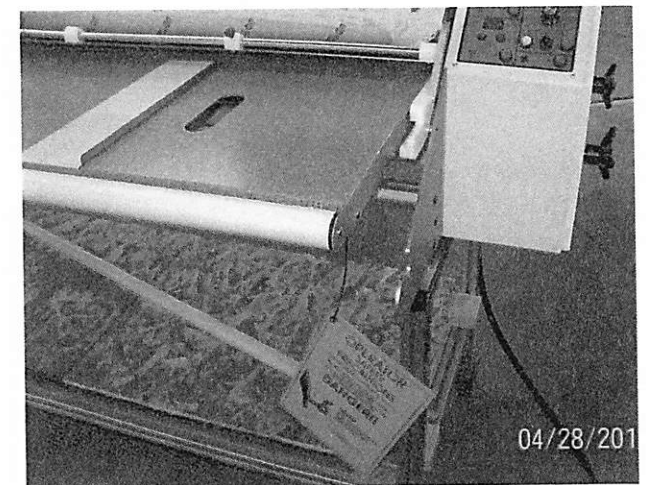
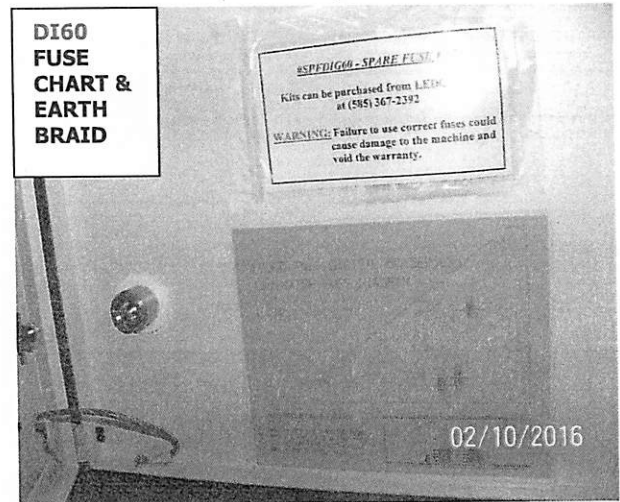
19) **SPRAY MULTIPURPOSE ADHESIVE ON THE FUSE CHART DIAGRAM LABEL BACK AFTER THE BACK PORTION IS REMOVED. USE (LAB44 DIAGRAM FOR THE DI42 OR THE LAB45 DIAGRAM FOR THE DI60).**

20) **SNAP A LAMINATED, ORANGE "OPERATOR SAFETY PRECAUTIONS" SHEET (LIT011) AS13 ONTO THE PAINTED SPREADER BAR.**

21) **THE DIGITAL 42" AND DIGITAL 60" BASE LAMINATOR WITH HEAT SHOES, THE DIGITAL THREE-PHASE LAMINATOR, AND THE DIGITAL THERMOGLIDE LAMINATOR, WHETHER IN CENTIGRADE OR FAHRENHEIT HAVE BEEN CERTIFIED FOR U.S. ETL SHIPMENT AS OF 2/2009. THESE LAMINATORS MUST ALL PASS A HIGH POT TEST TO CHECK ELECTRICAL LEAKAGE AND GROUND CONNECTION.**

22) **TO HIGH POT TEST ALL THE DIGITAL MACHINES, THE MACHINE GROUND CONNECTION LOCATION WILL BE THE SAME ON EVERY ONE OF THE DIGITAL MACHINES. THAT IS: THE OUTER SHOULDER BOLT HOLDING THE BOTTOM HEAT SHOE BRACKET ON THE RIGHT SIDE PANEL. TO HIGH POT TEST THE DIGITAL LAMINATORS FOLLOW THESE STEPS.**

23) **A) WITH THE HIGH POT POWER SWITCH IN THE "OFF" POSITION, CONNECT THE BLACK TESTER POWER CORD PLUG TO THE TESTER "INPUT" INLET.**

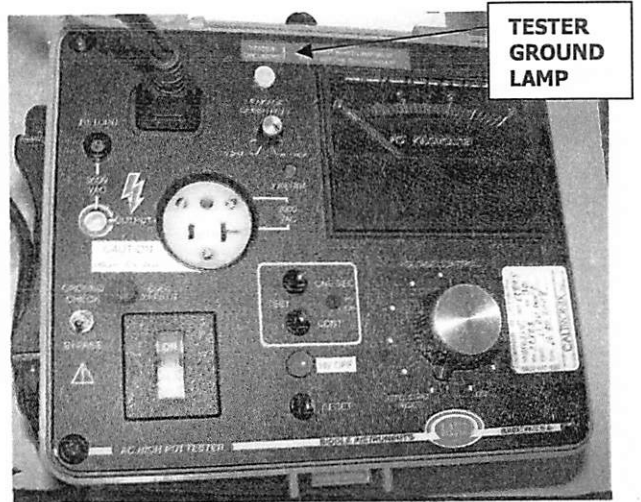


**OPERATOR SAFETY PRECAUTIONS**

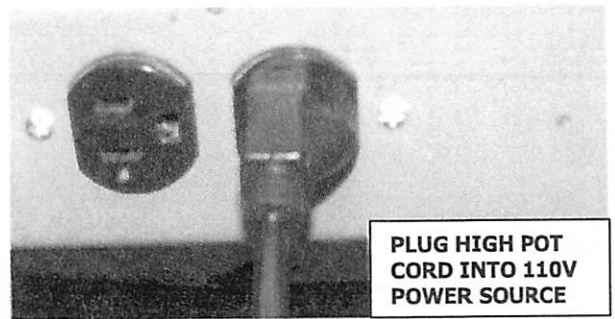


**ON/OFF POWER SWITCH & INPUT INLET**

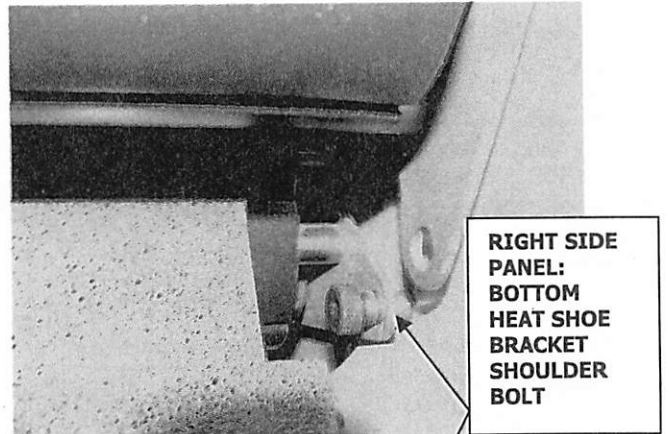
- 23) **B) PLUG THE OTHER END OF THE TESTER POWER CORD INTO A 110 VOLT POWER SOURCE. THE WHITE "TESTER GROUND" LAMP INDICATES THAT THE TESTER, ITSELF, IS GROUNDED. THE LAMP IS LOCATED RIGHT OF THE "INPUT" INLET AND IS ORANGE WHEN LIT. IF THE LAMP DOES NOT LIGHT AT THIS TIME THE POWER OUTLET IS UNSUITABLE, DO NOT CONTINUE. IF THE LAMP LIGHTS ORANGE, CONTINUE TEST.**



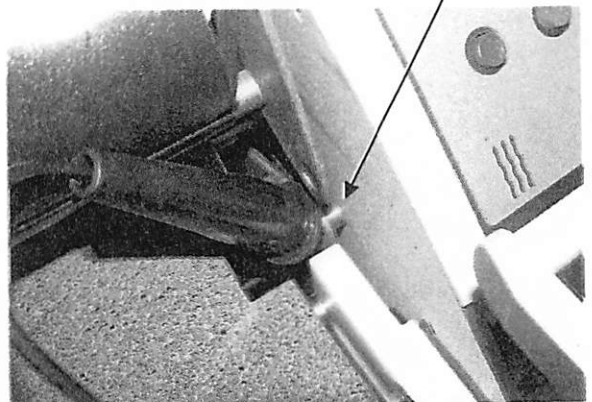
- 24) **C) *CLEAR THE AREA!! DO NOT TOUCH THE MACHINE OR THE CORD WHILE HIGH POT TESTING, AS SEVERE SHOCK MAY OCCUR IF THE MACHINE FAILS.***



- 25) **\*\* GOOD GROUNDING LOCATIONS MAY CHANGE FROM MACHINE TO MACHINE. A GOOD GROUND LOCATION USUALLY GOES THROUGH THE SIDE PANEL. THE GROUNDING LOCATION USED HERE ON ALL DIGITAL MACHINES CERTIFIED FOR ETL IS THE OUTER SHOULDER BOLT ON THE RIGHT SIDE PANEL HOLDING THE BOTTOM HEAT SHOE BRACKET.**

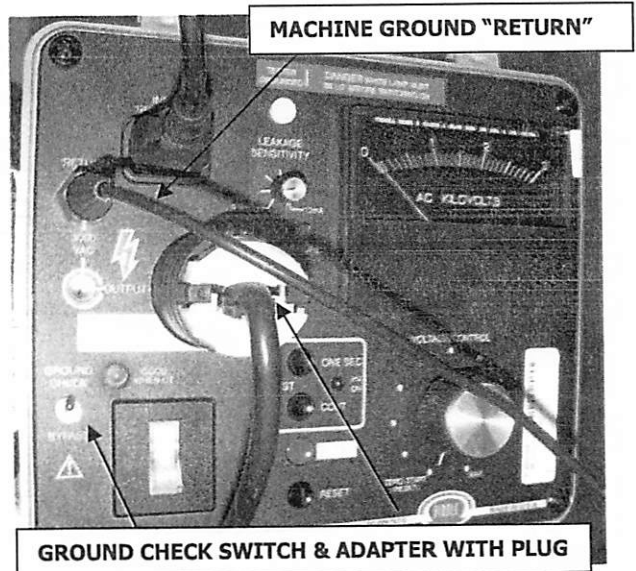


- 26) **D) SECURE THE TOOTHED MACHINE GROUND CORD CLAMP ON ONE END OF THE SMALLER BLACK TESTER CORD FROM THE HIGH POT UNIT TO THE SHOULDER BOLT HOLDING THE OUTER BOTTOM HEAT SHOE BRACKET ON THE RIGHT SIDE PANEL.**

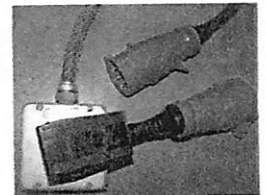
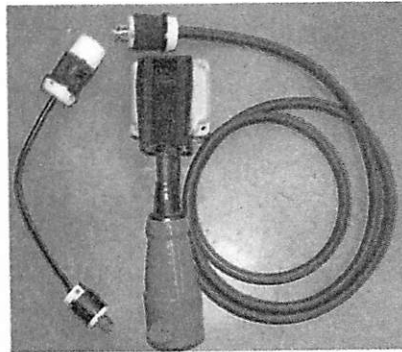


27) E) **PLUG THE TESTER END OF THE SMALLER BLACK MACHINE GROUND CORD INTO THE "RETURN" INLET ON THE HIGH POT TESTER. THE "GROUND CHECK" SWITCH SHOULD BE UPWARD.**

28) **THE VARIETY OF DIGITAL MACHINES DESIGNED FOR A 220 VOLT POWER SOURCE HAVE DIFFERENT POWER CORD PLUGS AND MUST USE AN APPROPRIATE ADAPTOR OR MORE THAN ONE ADAPTOR TO MATE WITH THE 110 VOLT TESTER INLET PLUG.**

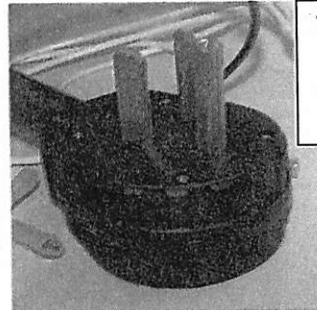


29) **THE DIGITAL 42 AND DIGITAL 60 THREE-PHASE LAMINATORS USE (3) ADAPTORS BEFORE PLUGGING INTO THE TESTER. CONNECT THE FIVE CONDUCTOR MACHINE POWER CORD PLUG INTO A 50 AMP ADAPTOR IN AN OUTLET BOX WITH, A 20 AMP ADAPTER ALSO COMING FROM THE OUTLET BOX. CONNECT ANOTHER 20 AMP ADAPTER WITH A 3-PRONG GROUNDED 110V PLUG THAT INSERTS DIRECTLY INTO THE TESTER BOX.**

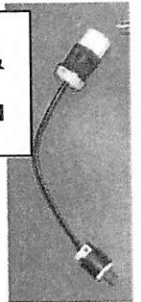


**3-PHASE 50 AMP 5 CONDUCTOR POWER CORD**

30) **THE DIGITAL 42 THERMOGLIDE HAS A 50 AMP POWER CORD PLUG WHICH CONNECTS TO A 50 AMP OUTLET BOX ALSO HAVING A 20 AMP ADAPTER COMING OUT OF THE OUTLET BOX. CONNECT A SECOND 20 AMP ADAPTER WITH A 3-PRONG GROUNDED 110V PLUG THAT WILL INSERT DIRECTLY INTO THE TESTER BOX.**



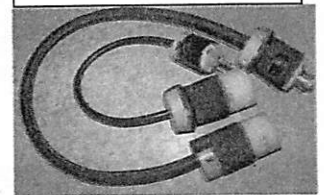
**THERMOGLIDE 50 AMP PLUG & 20 AMP ADAPTER WITH 110V PLUG**



31) **THE BASIC DIGITAL 60 HAS A 50 AMP POWER CORD: ADAPT POWER DOWN THE SAME AS THE THERMOGLIDE. A BASIC DIGITAL 42 HAS A 30 AMP POWER CORD. USE 30 AMP ADAPTOR WITH A 20 AMP PLUG AND A 20 AMP ADAPTER WITH A 3-PRONG GROUNDED 110V PLUG THAT WILL INSERT DIRECTLY INTO THE TESTER BOX.**

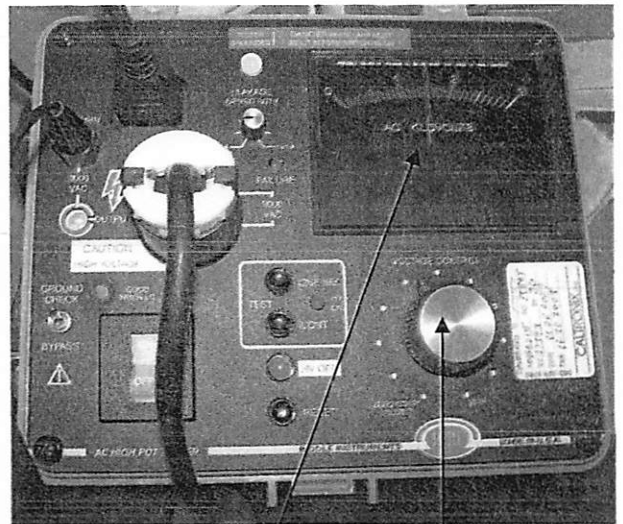


**30 AMP DIGITAL PLUG & 30 TO 20 ADAPTORS**

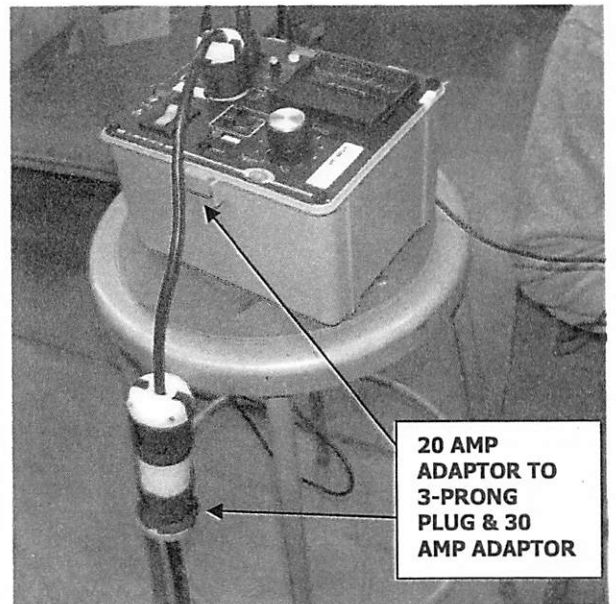




- 32) F) INSERT THE 3-PRONG GROUNDED 110V PLUG COMING FROM THE 20 AMP ADAPTOR ON ANY OF THE DIGITAL POWER CORDS INTO THE "OUTPUT" INLET OF THE TESTER.
- 33) G) PRESS THE HIGH POT TESTER ROCKER SWITCH TO THE "ON" POSITION. IF THE GROUND TO THE MACHINE IS ACCEPTABLE, THE "GOOD WHEN LIT" GREEN LIGHT COMES ON.
- 34) H) WITH VOLTAGE CONTROL DIAL ON ZERO/START, PRESS THE BLACK "RESET" BUTTON ON THE HIGH POT TESTER.
- 35) I) PRESS THE BLACK "CONT" (FOR CONTINUOUS) BUTTON AND THE RED "HV" LIGHT SHOULD COME ON.
- 36) J) WITH VOLTAGE CONTROL STILL AT ZERO/START POSITION, INCREASE AC "KILOVOLT CONTROL" DIAL CLOCKWISE UNTIL READING 1.6 KILOVOLTS ON THE REGISTER SCREEN. MAINTAIN 1.6 AC KILOVOLTS FOR TWO SECOND. IF MACHINE *FAILS HIGH POT TEST*: AN AMBER "FAILURE" LIGHT COMES ON AND A "BEEP" WILL SOUND.
- 37) K) TO END TEST RETURN VOLTAGE DIAL TO ZERO/START, PRESS THE "HV OFF" BUTTON, "HV ON" LIGHT WILL GO OUT.
- 38) L) TURN OFF HIGH POT TESTER SWITCH, UNPLUG "INPUT" POWER CORD, THEN UNPLUG THE REMAINING CORDS.
- 39) CLEAN MACHINE.



1.6 AC KILOVOLT ON SCREEN & VOLTAGE CONTROL



20 AMP ADAPTOR TO 3-PRONG PLUG & 30 AMP ADAPTOR

