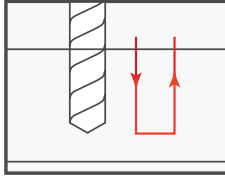




Dwell control unit

Part number 92372



Original instructions.

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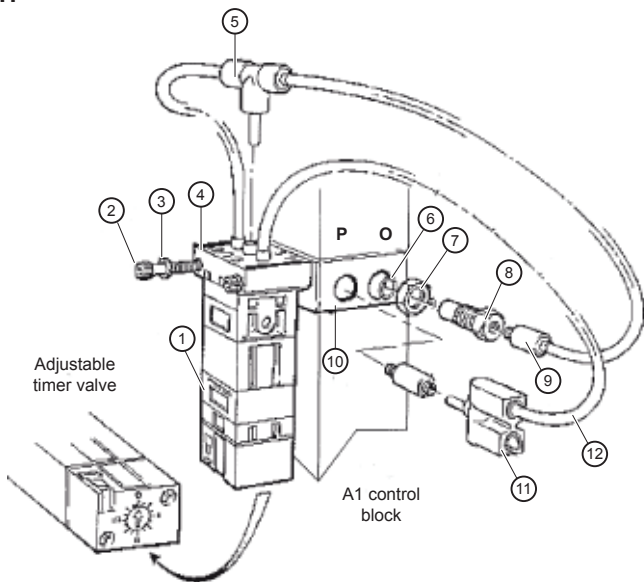
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Software and documentation available at:

<http://cadfiles.desouttertools.com>

No login/password required.

COMPLETE KIT



Item	Description	Part No	Qty	Wear		
				High	Medium	Low
1	Timer	286793	1			X
2	Screw	236313	2			X
3	Washer	186283	2			X
4	Base	279313	1			X
5	Y piece 4 mm	72082	1			X
6	O'ring	250913	1			X
7	Locknut	257033	1			X
8	Adaptor	257023	1			X
9	Stud fitting M5/4mm	62392	2			X
10	Bracket	324783	1			X
11	OR gate	255313	1			X
12	Tubing 4 mm	62862	0.5 m			X
13	Elbow 4 mm	72062	2			X
14	Stem connector 4mm	62732	2			X

ASSEMBLY INSTRUCTIONS

- Make sure the air supply is disconnected from the tool.
- Screw the timer (1) into the base (4), a peg prevents incorrect assembly.
- Remove the plugs from the 'P' and 'O' ports on the tool control top,. Screw the locknut (7) fully onto adaptor (8). Into the 'O' port bore place the O ring (6). Fit bracket (10) across the P and 'O' ports and tighten the adaptor onto the o' ring in port 'O' to obtain a seal and then tighten the locknut onto the bracket.
- Screw the stud fittings (9) into adaptor (8) and also directly into the 'P' port. Push the OR gate (11) into the 'P' port fitting. Push the Y piece (5) into the middle port on the base (4).
- Mount the dwell control unit onto the bracket (10) and cut and connect the tubing as per the diagram.
- Reconnect the air supply to the tool.

Note:

- The spare connection on the OR gate is for an emergency retract signal if required for the application.
- The elbow (13) and stem connector (14) are not shown but can be used eliminate acute bending of the tube.
- To release the tubing from the fittings, depress the sleeve whilst pulling on the tube.

OPERATING

- With the tool set up as per the service sheet, carry out a trial operation and adjust the regulator to obtain the required period of dwell (0-10 seconds).



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