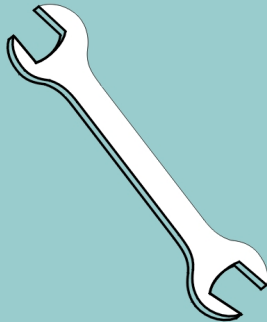


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# Kit Instruction— KUDSCS0100



**Read the  
separate  
safety  
manual  
before  
installing,  
operating,  
or servicing**

# Please Read

## About the Manual Identifying Information on the Cover

The front cover displays pertinent identifying information for this manual. Most important, are the published manual number (part number) /ECN (date code). Generally, when a replacement manual is furnished, it will have the same published manual number, but the latest available ECN. This provides the user with the latest information applicable to his machine. Similarly all documents comprising the manual will be the latest available as of the date the manual was printed, **even though older ECN dates for those documents may be listed in the table of contents.**

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## References to Yellow Troubleshooting Pages

This manual may contain references to "yellow pages." Although the pages containing troubleshooting procedures are no longer printed on yellow paper, troubleshooting instructions, if any, will be contained in the easily located "Troubleshooting" chapter or section. See the table of contents.

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## Comments and Suggestions

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Fax: (504) 469-1849

## KIT KUDSCS0100: CHANGE PRESS SLED DRIVE TO WELDED CLUTCH AND SLOW MOTOR

**APPLICABILITY:** Press models PRIOR to MP5031CL/ABP, MP5031CR/ABP, MP5031L/ABP, MP5031R/ABP (Presses manufactured prior to February 1988).

### BACKGROUND

Press models listed above were manufactured with sled drives consisting of a fast motor, a slow motor (P/N 39T010AAU), a slow clutch and a brake clutch. With this design, the fast motor drives the sled until it actuates the slow limit switch. This deenergizes the fast motor, energizes the slow motor and engages the slow clutch to slowly drive the sled to near the end of its travel where it actuates the home limit switch. This deenergizes the slow motor and engages the brake clutch to stop the sled motion.

It has been found that after 9 to 18 months, the slow clutch can wear enough to cause the sled to hit its mechanical stop, in turn causing the torque arm switch to actuate and shutting the press down. Referring to Figure 1, Press models now in production use a new 12 pole slow motor (P/N 39T007AAU) that need not be disengaged, eliminating the need for a slow clutch. A welded clutch or fixed pulley is installed where the brake clutch was located and the brake clutch is now moved to where the slow clutch was located.

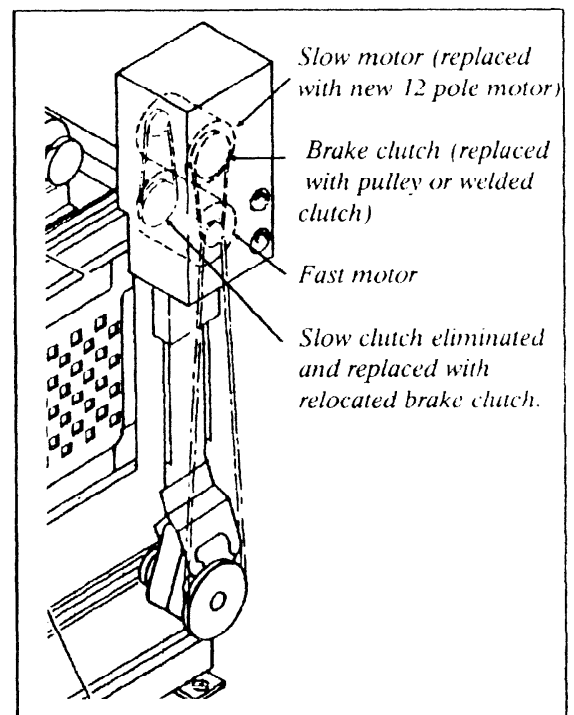


Figure 1 (MSSMD436AE)  
Press Sled Drive Assembly

**DANGER: LOCK POWER OFF AT THE EXTERNAL DISCONNECT BUX BEFORE BEGINNING THIS PROCEDURE.**

## PROCEDURE

1. Replace/relocate mechanical components in accordance with Figure 1.
2. Compare the two schematics W6PRSMC and W6PRSMCA supplied with the kit. W6PRSMC reflects how the machine was wired to accommodate the old slow motor and slow clutch. W6PRSMCA is the schematic, for the new welded clutch and slow motor scheme. Note that on schematic W6PRSMC the slow clutch circuitry (lines 02-04) is no longer used.
3. Reroute the output of the brake rectifier to correspond with the new physical location of the brake clutch.
4. Wire the auxiliaries of the sled fast contactor CSRFR and CSFFL (line 07) as shown on schematic W6PRSMCA.
5. Wire the brake safety override switch SHSC into the circuit as shown on line 08 and line 14 of schematic W6PRSMCA.
6. Run the Press manually, checking for proper operation, pulley alignment, etc., again locking power off to make any necessary adjustments.

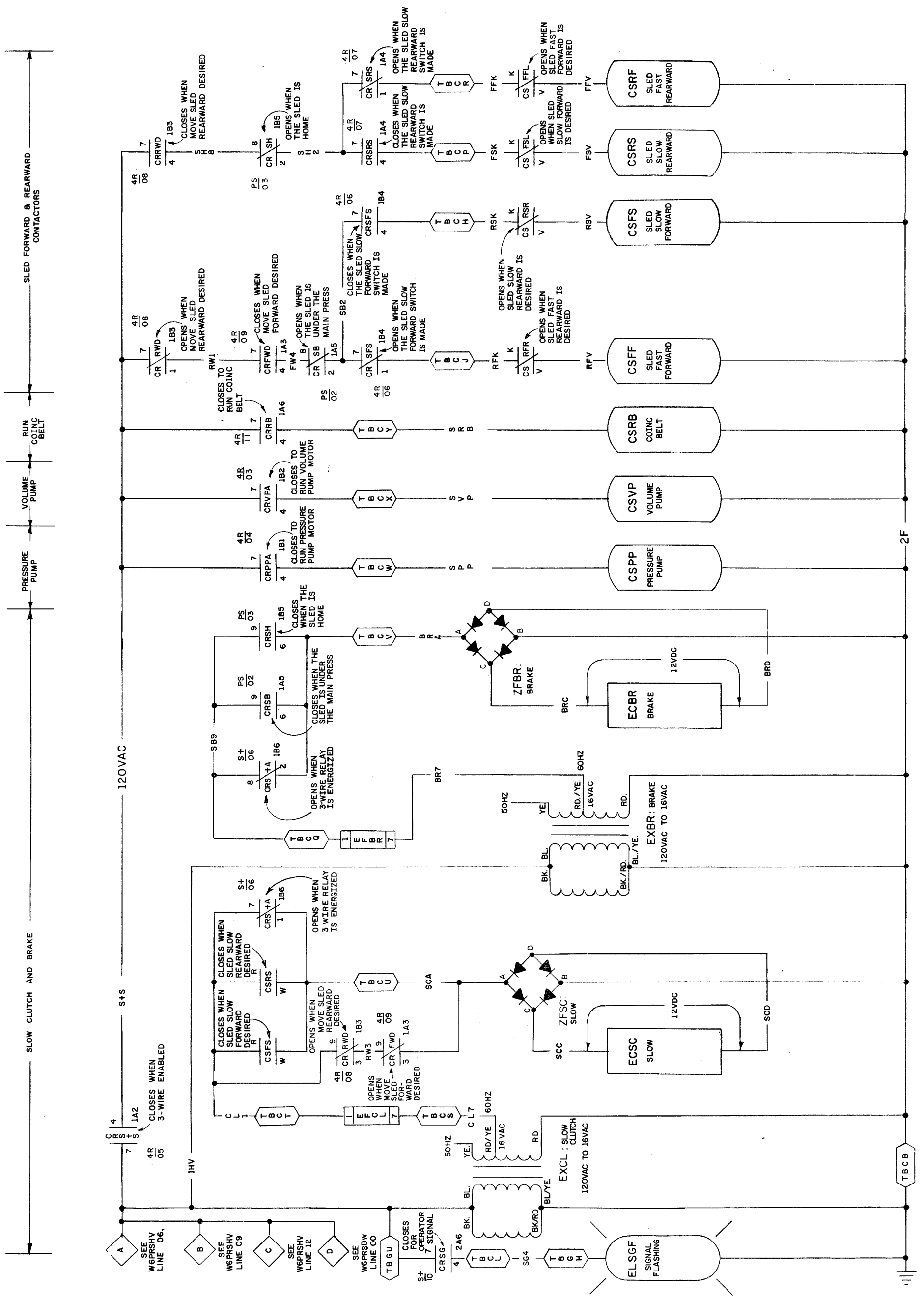
This completes the retrofit procedure.

# W6PRSMC MICRO 6 SYSTEMS SCHEMATIC : MOTOR CONTACTORS

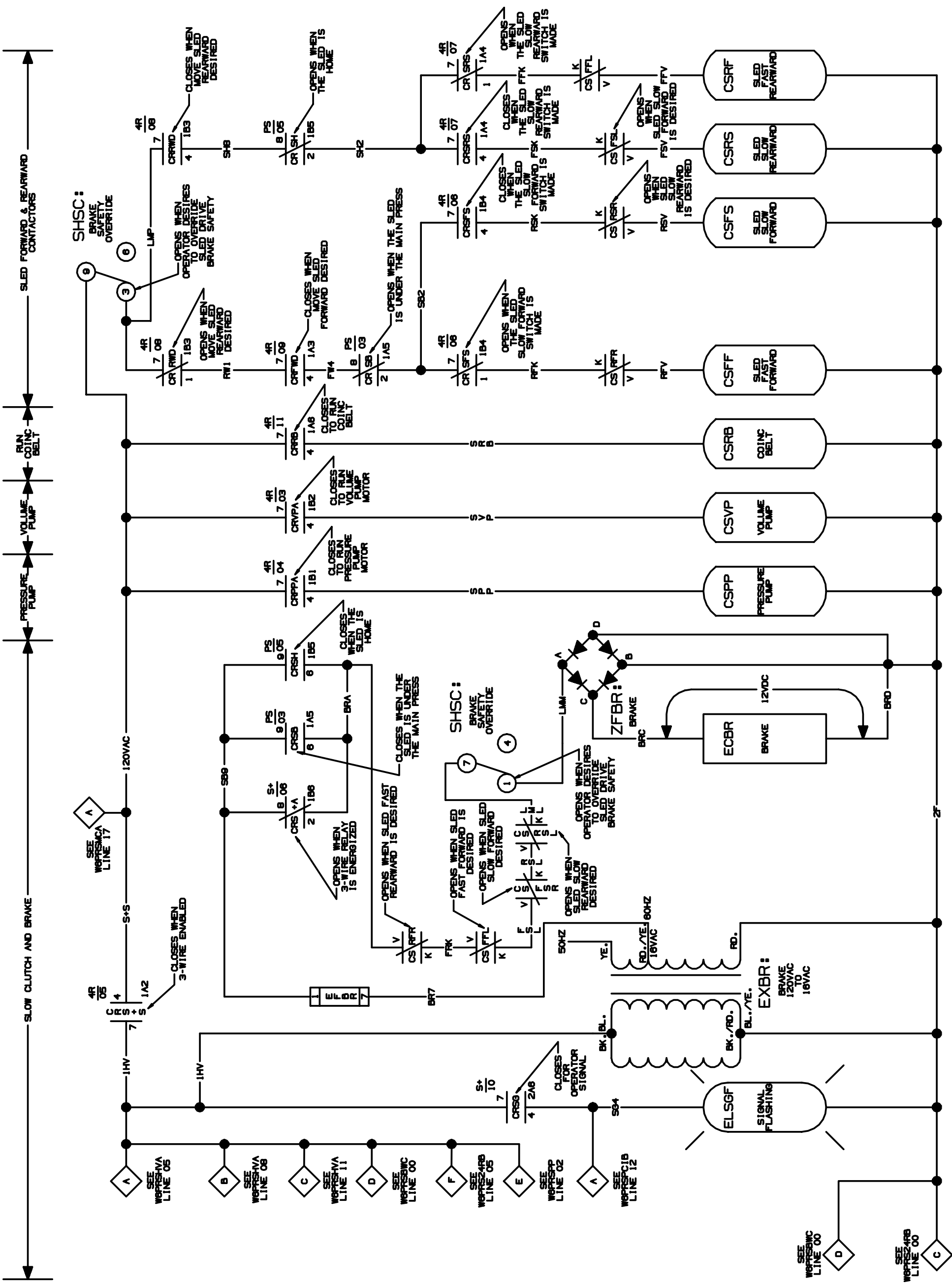
W6PRSMC  
87111D

- NOTES:**
1. TBC IS LOCATED IN HIGH VOLTAGE CONTROL BOX
  2. TB6 IS LOCATED IN LOW VOLTAGE CONTROL BOX

W6PRSMC  
87111D



00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18



**W6PRSMCA**  
**MICRO 6 SYSTEMS**  
**SCHEMATIC: MOTOR CONNECTIONS**  
**MODIFIED FOR 12 POLE SLED MOTOR**  
**110V1P50HZ/120V1P60HZ**  
**PELLERIN MILNOR CORPORATION**

W6PRSMCA  
93517B

W6PRSMCA  
93517B

00 01 02 03 04 05 06 07 08 09 10 11 12 13 14 15 16 17 18 19

