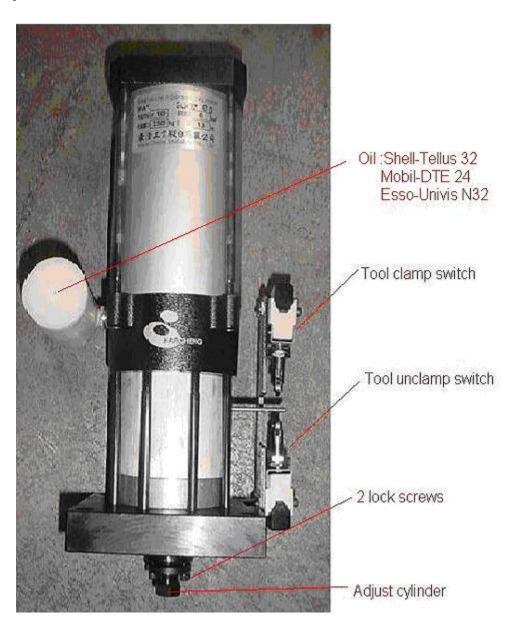


Tool clamp / unclamp switches

- 1. Open right side ship metal cover. There are two switches on the boost cylinder, tool clamp and tool unclamp switch.
- 2. Push Tool release button, the cylinder moves down push the tool unclamp switch down and draw bar open jaw to release tool. The cylinder touches tool unclamp switch, the plc knows tool unclamp right now. If control says, "waiting tool unclamp" that means the switch does not touch by cylinder or switch bad or the wire is broken, loosen.
- 3. Release Tool release button, the cylinder moves up push the tool clamp switch up and draw bar close jaw to hold the tool holder.



Rev. Sep 2014

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