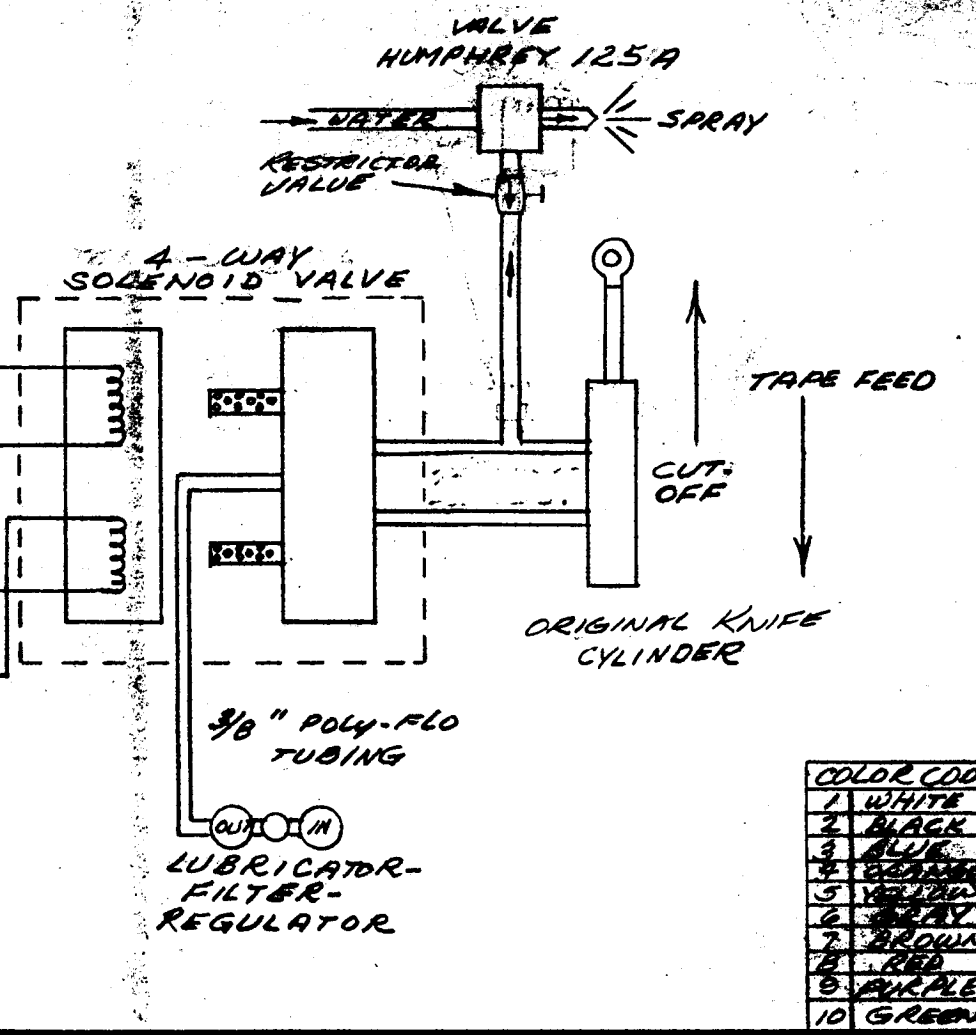


SECOND SET OF LIMIT SWITCHES
CAUTION: "B"
LIMIT SWITCHES MUST BE WIRED TO INPUT PLUGS AS SHOWN, TO PREVENT DAMAGE TO CONTROL CIRCUIT COMPONENTS.

FIRST SET OF LIMIT SWITCHES
"A"



COLOR CODE	
1	WHITE
2	BLACK
3	BLUE
4	GREEN
5	YELLOW
6	GRAY
7	BROWN
8	RED
9	PURPLE
10	GREEN

TAPER CONVERSION		
SCALE: —	APPROVED BY:	DRAWN BY K.A.B.
DATE: 1-31-77		REVISED 3/27/78
UNIVERSAL JET - DOUBLE CONTROL		
ELECTRICAL-PNEUMATIC		DRAWING NUMBER TC-108

**UNIVERSAL JET SPRAY TAPER CONVERSION
INSTALLATION INSTRUCTIONS**

1. REMOVE ORIGINAL SOLENOID VALVE FROM TOP OF ORIGINAL AIR CYLINDER AND REPLACE WITH MANIFOLD ADAPTOR SUPPLIED. IF OLD AIR CYLINDER IS WORN OUT, USE THE NEW ONE SUPPLIED WITH KIT.
2. MOUNT THE SUPPLIED 4-WAY SOLENOID VALVE HORIZONTALLY ON MACHINE NEAR THE AIR CYLINDER AND ELECTRICAL JUNCTION BOX. KEEP AIR LINES AS SHORT AS POSSIBLE BETWEEN VALVE AND CYLINDER.
2. MOUNT SUPPLIED FILTER-REGULATOR-LUBRICATOR IN PLACE OF OLD UNIT.
4. REMOVE ENTIRE ELECTRICAL CONTROL PANEL THAT ORIGINALLY CONTROLLED THE AIR CYLINDER SOLENOID VALVE.
5. MOUNT OUR MAIN CONTROL PANEL IN THE AREA WHERE OLD PANEL WAS MOUNTED, THE ORIGINAL WIRING WILL BE USED. MOUNT THE PHOTOEYE JUNCTION BOX ON LOWER COMPRESSION RAIL AS SHOWN ON DRAWING.
6. INSTALL THE HUMPHREY 125A VALVE AND SPRAY NOZZLE IN POSITION TO SPRAY WATER MIST ON TAPE. THIS VALVE DOES NOT MIX AIR AND WATER IT IS A PILOT PRESSURE OPERATED VALVE USED TO TURN WATER SPRAY OFF AND ON.
7. FOLLOWING THE ELECTRICAL SCHEMATIC, HOOK UP WIRING BETWEEN CONTROL PANEL AND 4-WAY VALVE, NORMALLY , EXISTING WIRES CAN BE REUSED.
8. INSTALL AIR LINES AND RESTRICTOR VALVE PER DRAWING, THE ARROW ON VALVE SHOULD POINT AWAY FROM PILOT PRESSURE PORT ON 125A VALVE. INTEGRAL FITTINGS ON VALVE ARE THE PUSH-IN TYPE, TO REMOVE TUBING FROM FITTING, PUSH IN ON SLEEVE WHILE PULLING ON TUBING.
9. ADJUST AIR PRESSURE TO 50-60 PSI, TURN ON POWER AND CHECK FOR PROPER OPERATION OF FEED AND CUTOFF. IF REVERSED, SWITCH WIRES ONTERMINALS 7 AND 10.
10. #10 WEIGHT OIL SHOULD BE USED IN LUBRICATOR, ADJUST FOR ABOUT ONE DROP EVERY 15-20 BOXES. DO NOT OVER LUBRICATE.

PARTS LIST FOR UNI-JET TAPER CONV.

- TC300-J1 TC300-JZ
- 1 CONTROL BOX - SINGLE _____ DOUBLE _____ WITH
FLAT MOUNTING PLATE / CABLES / BRACKETS & 90° ADAPT.
- 1 SMC 4-WAY VALVE
- 1 S-B AIR CYLINDER W/MANIFOLD ADAPTOR / O-RINGS
- 1 F-R-L
- 1 FLOW CONTROL VALVE
- 1 125A VALVE W/TEEJET NOZZLE
- 2 1/4" MUFFLERS
- 18' 3/8" TUBING
- 3' 1/4" TUBING
- 18" PLASTIC CONDUIT W/FITTINGS

6 115 CLAMPS

4 10-32 X 1 SHCS

2 10-32 X 1 1/2 "

6 10-32 X 1/2 "

12 10-32 NUTS

9 1/4-20 X 3/8 BHCS W/WASHERS

3 QUENCHARC SUPP.

4 3/8 X 1/4" STR.

1 3/8 - 1/4" RED. TEE (TUBE)

1 3/8 - 1/8" STR.

1 3/8 - 1/8" 90°

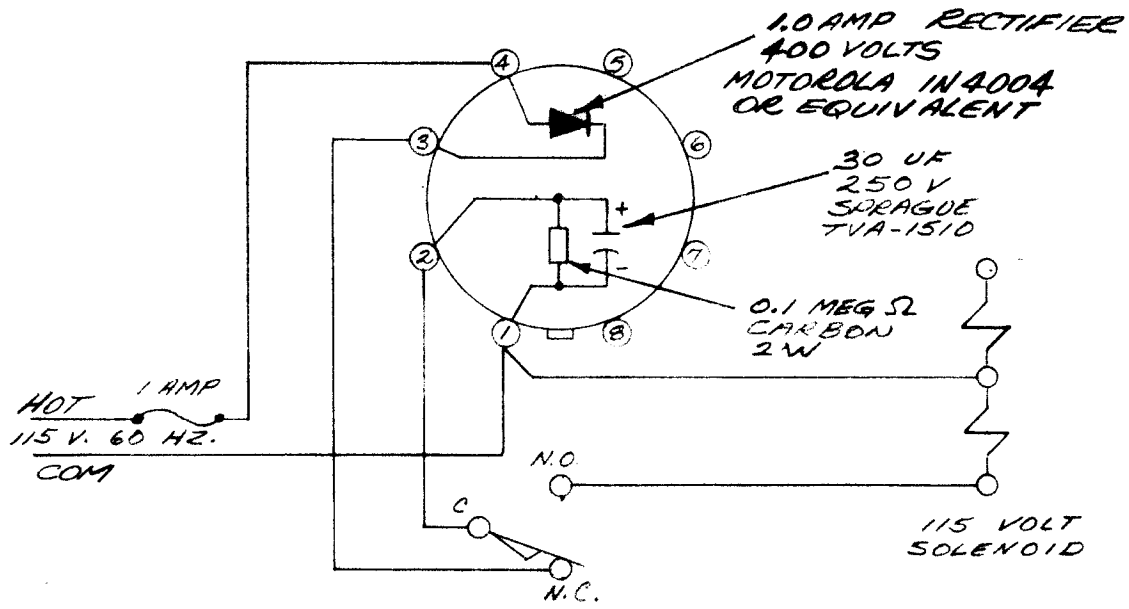
1 1/4 - 1/8" STR.

1 1/8" CLOSE NIPPLE

1 SET DWGS. / SCHEMATICS & INST.

BE SURE TO MARK AND
AFFIX NAMEPLATES TO
BOXES AND TAPE ROTARY
SWITCH POSITION MARKINGS
TO BOX.

2/5/91



TAPER CONTROL MODULE

TAPER CONTROL MODULE		
SCALE:	APPROVED BY:	DRAWN BY <i>K.A.B.</i>
DATE: <i>6-16-78</i>		REVISED <i>4/1/86</i>
		DRAWING NUMBER
		<i>TC-200</i>