

1. Picker Body Installation

1-1 . Picker Assembly. (Step 1)

1. Read all instructions prior to starting.
 2. Unpack the Picker and check contents.
 3. Fix base to rigid bench top using C clamp. (Figure 1-1-1)
 4. Disconnect 4 bolts from rotational plate of picker body
 5. Lift upper assembly in to position, noting the cutout for clamp handle in the base. (Figure 1-1-2)
 6. Secure using cap screws provided. (The use of locking adhesives is recommended.)
 7. Connect air hoses and wire (Figure 1-1-3). Do not remove cable tie on the swing cylinder at this time.
- Note : Use caution when removing the picker body from the box. The swing rotation makes handling difficult. Two suggested methods are shown below in figures 1-1-4 and 1-1-5. When a hoist is available the method shown in fig 1-1-5 is recommended. The picker body weights about 80 lbs. Use caution selecting lifting points.

Figure 1-1-1

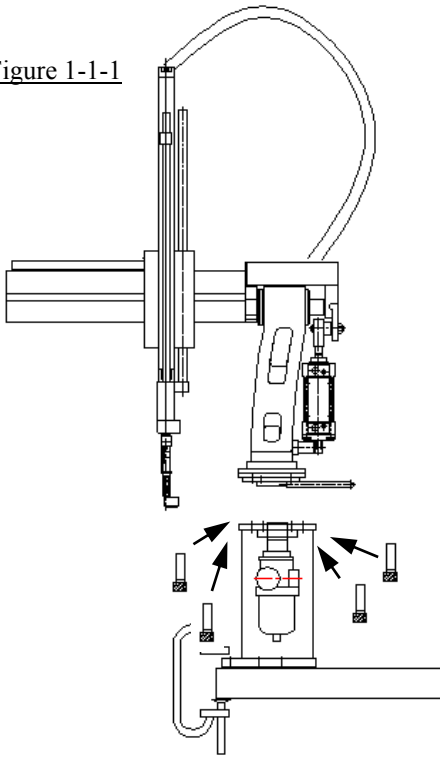


Figure 1-1-2

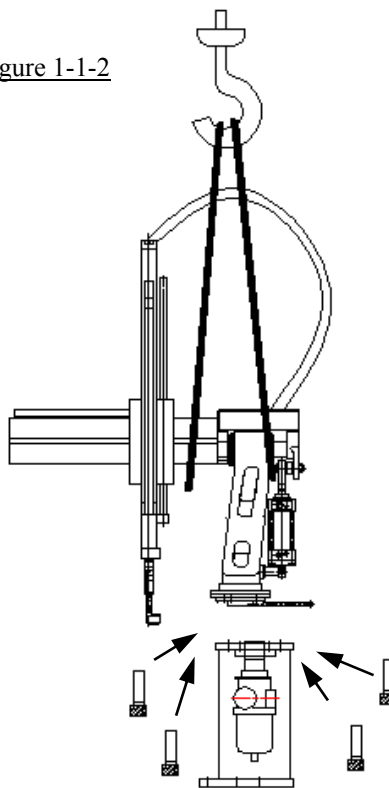


Figure 1-1-3

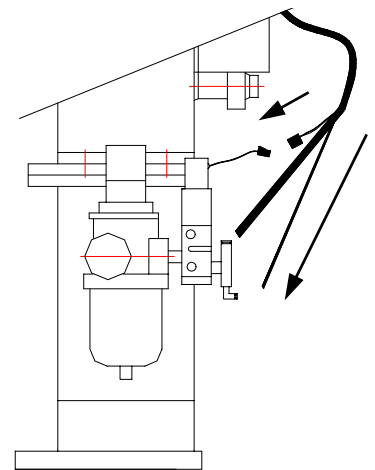


Figure 1-1-4 (# Be careful of your back , picker weight is 80 lbs)



Figure 1-1-5 (# Make sure the ropes are fixed tight)

1-2 Drill and Tap. (Step 2)

- Read all the installation instructions prior to starting.
 - Please follow the directions carefully.
1. Place the template on the stationary platen as shown in Figure 1-2-2. Use the transfer punch and hammer to mark the hole locations.
 2. You may use either pattern A or B. (Figure 1-2-1)
 3. Use a Magnetic Base drill to drill 4 locations (either pattern A or Pattern B) to a depth of more than 1.5 inches. (Figure 1-2-1)
 4. Tap 5/16-18 and de-burr.
- Note: M 8 may be substituted for 5/16-18 thread.

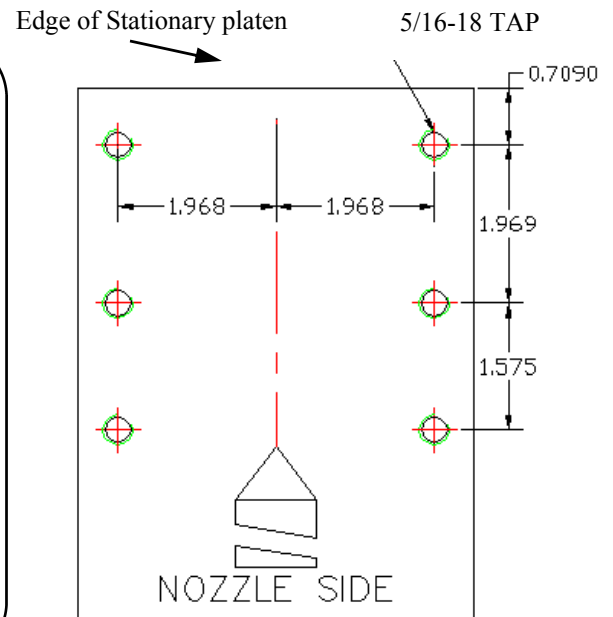
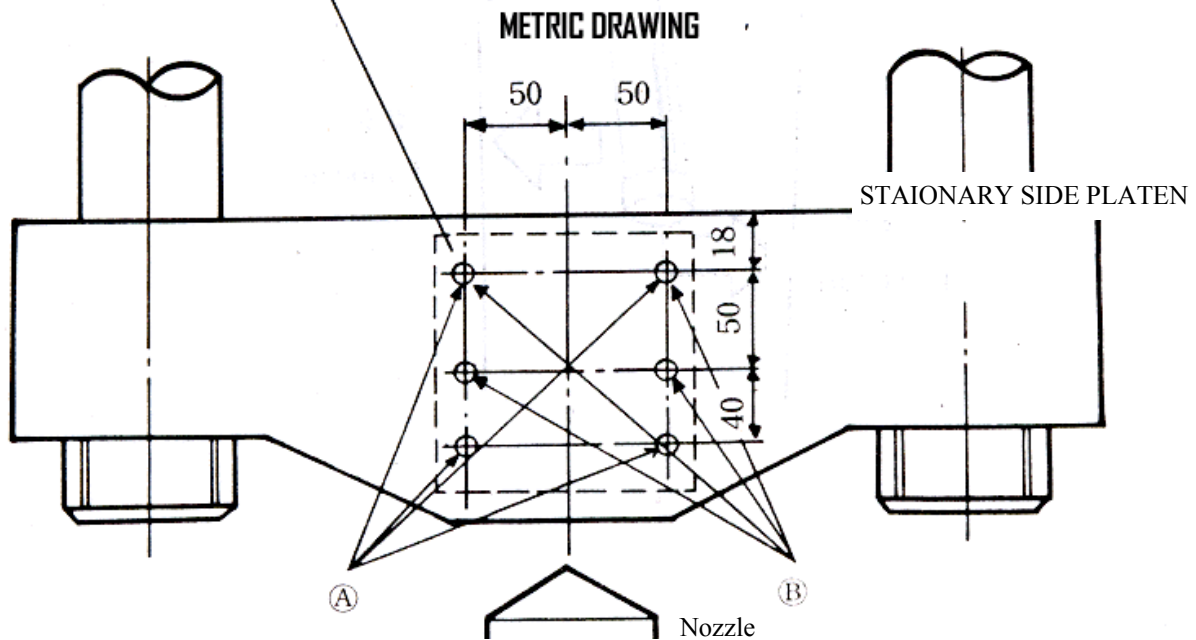


Figure 1-2-2

Figure 1-2-1

Drill and Tap 5/16"-18

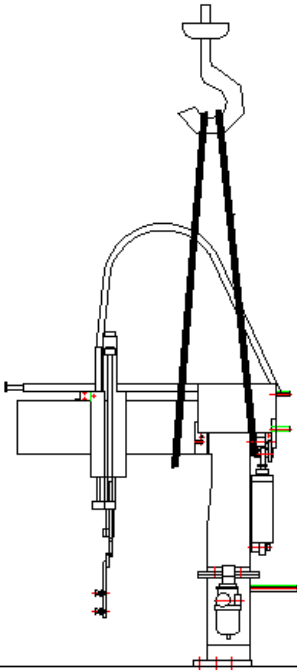


Included	1. Hole Pattern template
Required	1. Hammer, 2. Tape, 3. A Center punch, 4. Magnetic Base Drill , 5 Drill 0.2770 "(J) Tap, 6. 5/16-18" Tap, 7. Tap Handle

1-3. Picker Attachment. (Step 3)

- The picker weights about 100 lb.

Figure 1-3-1



1. Rig as shown. (Figure 1-3-1)
2. Slowly lift up and stand the picker vertically.
3. Put the picker on the molding machine as shown. (Figure 1-3-2)
4. Place the Heat shield plate between the picker base and stationary platen. (Figure 1-3-3)
5. Using lock washers, flat washers and 5/16-18 x 1.5 grade 5 bolts, secure the base of the picker firmly to the stationary platen in four or more locations.
6. Make sure the picker installed as shown. (Figure 1-3-4)
7. Remove the cable tie on the swing cylinder .

Figure 1-3-2

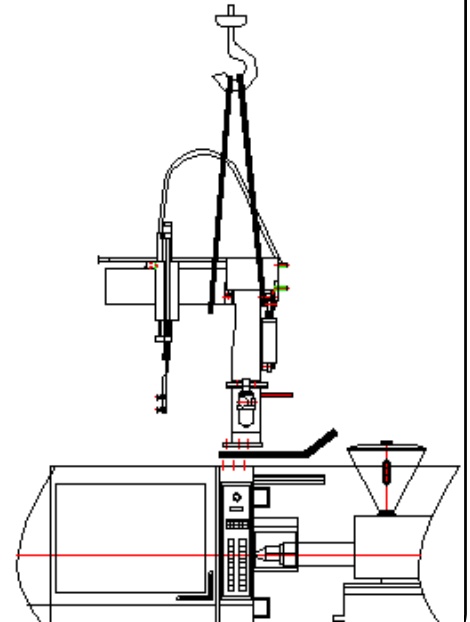


Figure 1-3-3

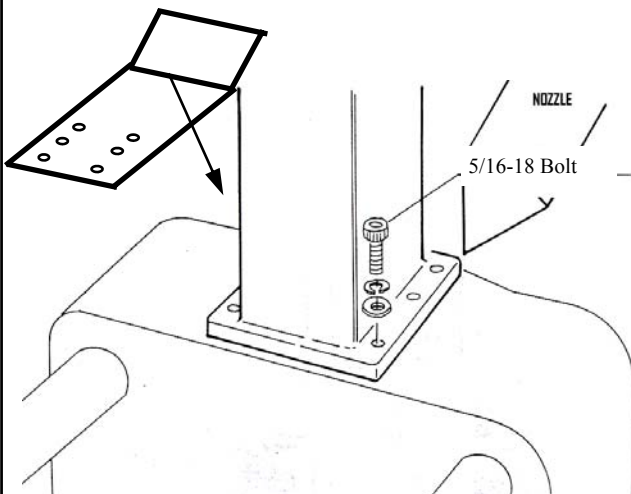
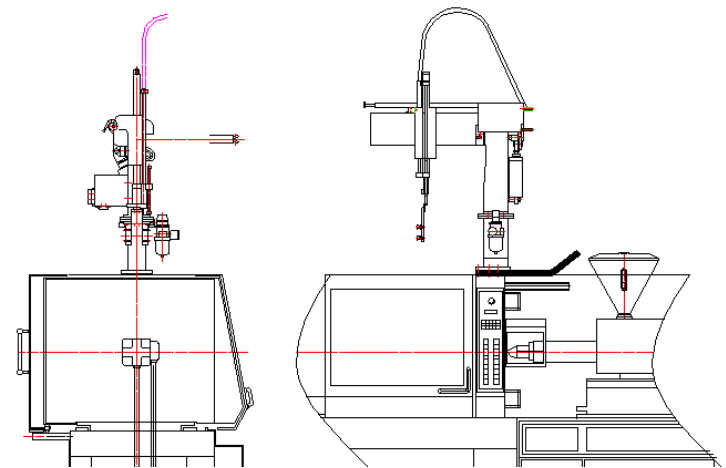


Figure 1-3-4



Supplied	1. Picker 2. Heat shield plate 3. <u>5/16-18" grade 5 Bolts (4 or 6 Pcs.)</u>
Required	4. Crane 5. Lifting Straps. 6. Wrench for 5/16 "