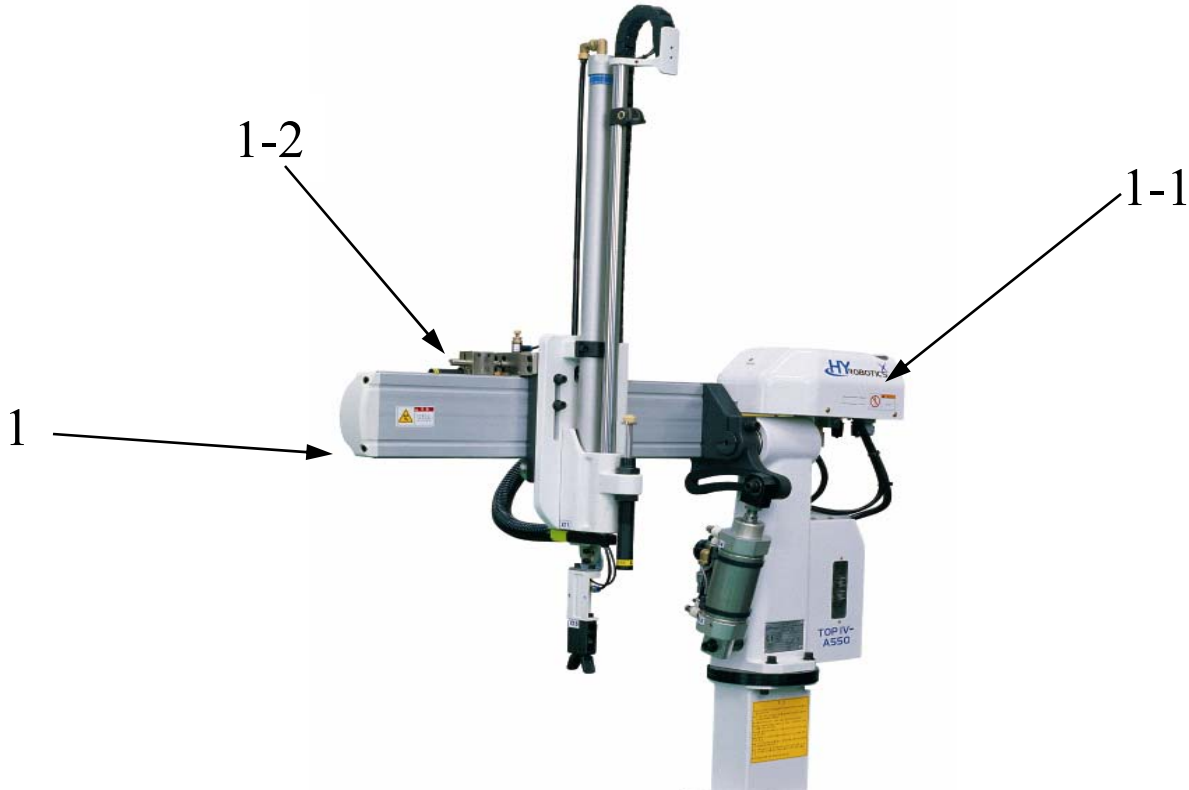
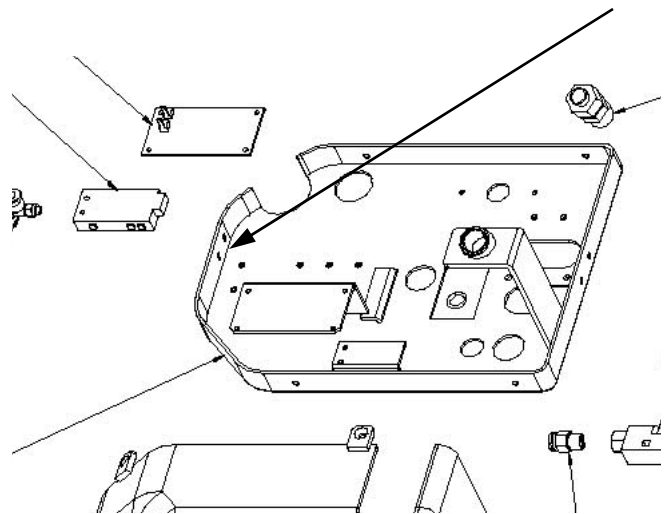
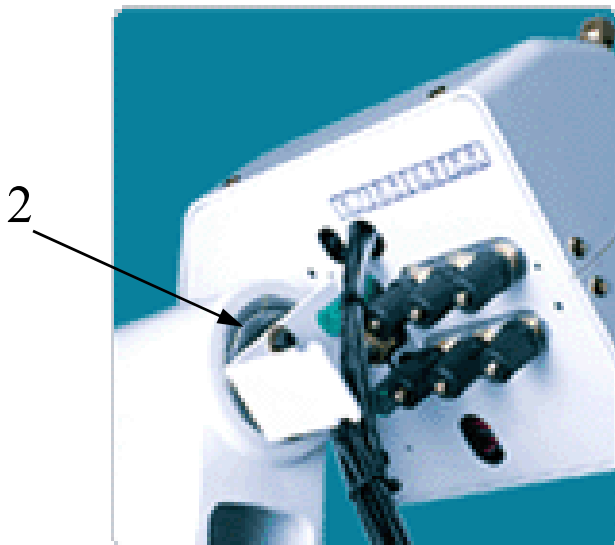


PART REPLACEMENT DESCRIPTION 1

Please process this job with the robot is in work table not on injection molding machine.

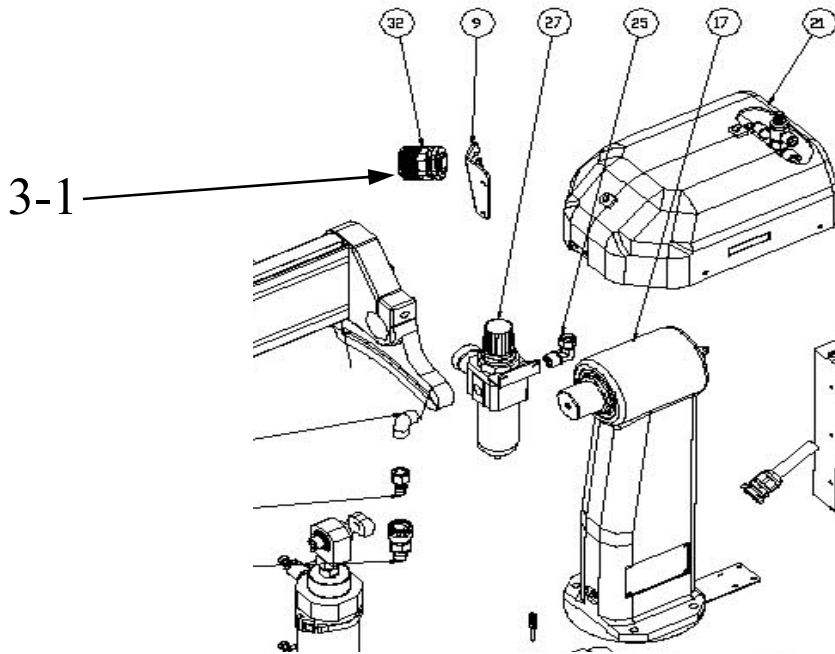


- Remove the cover at the end of kick slide (at 1)
- Remove the Two cover on the Solenoid Box (at 1-1)
- Loosen bolt :1-2 (Kick Stroke) and remove sliding assembly . Sliding assembly will still be attached by hoses. Might required to loosen some other bolts. Place sliding assembly in a secure place.
- Loosen Bolts at 2 and 2-1 and Place Solenoid Box in a Secure Place

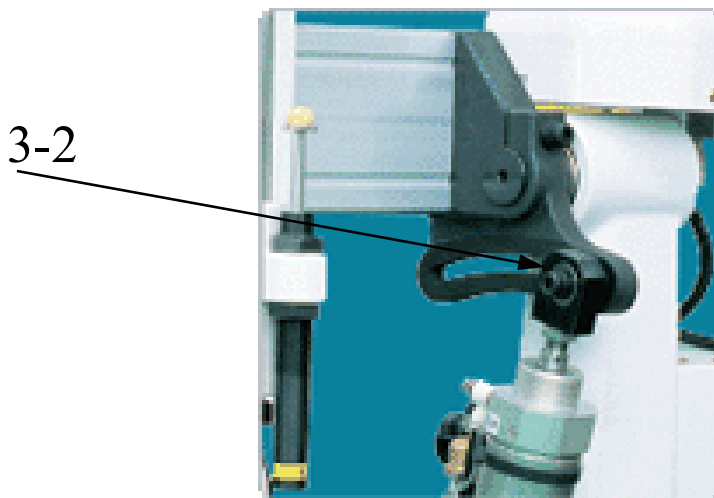


PART REPLACEMENT DESCRIPTION 2

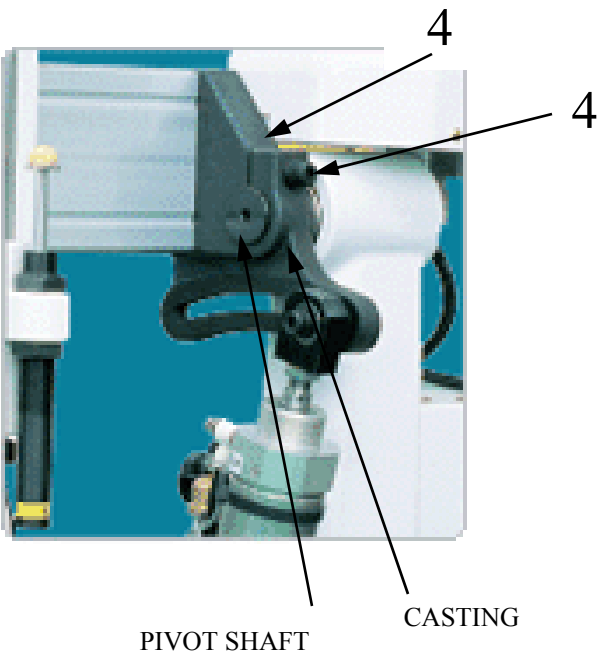
- 3-1 Bracket (Cable Carrier Bracket) need to be removed if kick sliding assembly can not be removed from Kick Frame (Aluminum Extrusion File)



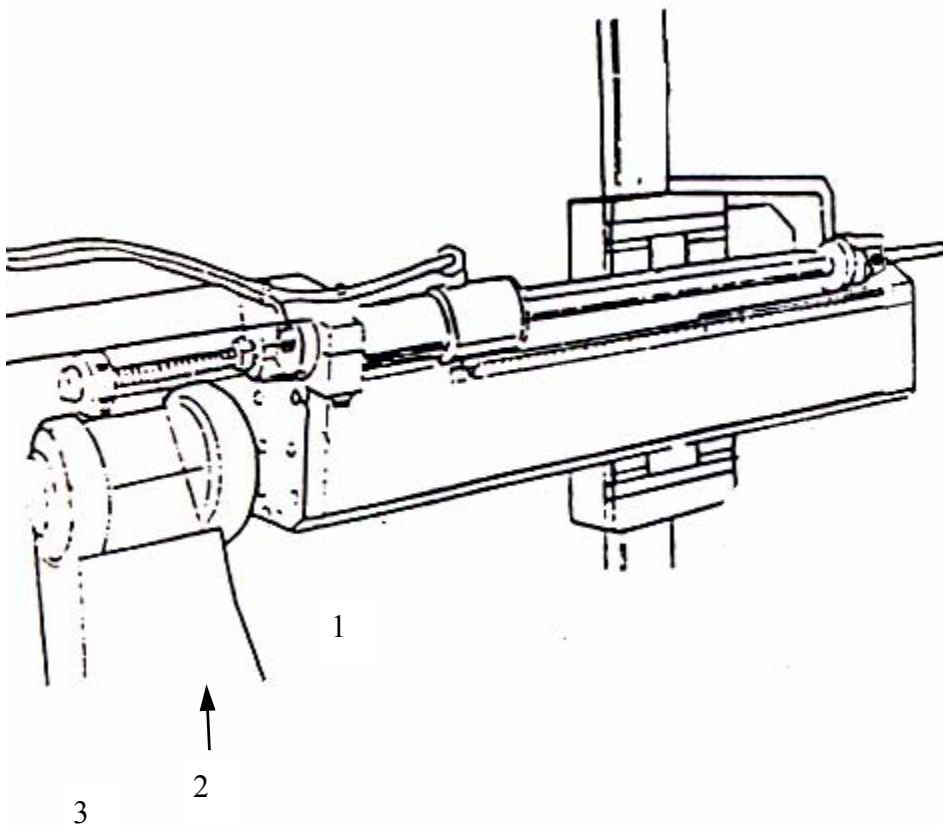
- Mark on the Swing Casting Parts with Pivot shaft location before disassemble.
- Loosen the bolts in Swing Cylinder Swivel Units (3-2)
- Swing Cylinder will be free from bracket.



PART REPLACEMENT DESCRIPTION 3



- Loosen the bolts at 4, Use a Flat screw driver to make little space on 4-1 .
- Hold Sliding frame and use rubber hammer and slightly hit the Casting to other side of pivot shaft.
- The Casting may be broken to remove it from the shaft.



Remove the cap screw that attach that the aluminum arm to the casting. (Not required this time) Attach the new casting to the aluminum arm using Loctite (ft/lbs torque) . Reverse Disassemble process.)

PART REPLACEMENT DESCRIPTION 4

REVERSE

1. Slowly push casting and aluminum extrusion file on Pivot Shaft.
2. Rotate to line up with the mark you made.
3. Tight slowly the bolts on pivot shaft.
4. Assemble Swing Cylinder
5. Assemble Kick Sliding Assembly.
6. Attach the Solenoid box
7. Before covering or tight all the bolts. Use Loctite and rotate by hand make sure robot arm rotate smoothly.
8. Tight all the bolts with Loctite.
9. Cover the Plastics case and finish assemble process.

There might be some other assemble and adjusting process might required.