

Digital Combo Twin Shuttle Assembly Instructions

The Digital Combo Twin Shuttle can be added to the DC16 swing away press, and also the DC16AP Air Operated press.

There are 4 steps to adding the shuttle to the Digital Combo press. Follow these steps carefully, and read through the entire instructions before attempting installation. Please note the warnings mentioned during certain steps, as injury or damage can occur during installation.

STEP 1 - Prepare press

Remove the original table from the machine.

The bottom table is a “drop-on” table, which means it is readily pulled off the press pedestal. Also, completely remove the pedestal and slide gibbs from the base. The base should be empty without the pedestal, slide gibbs, screws and bottom table.

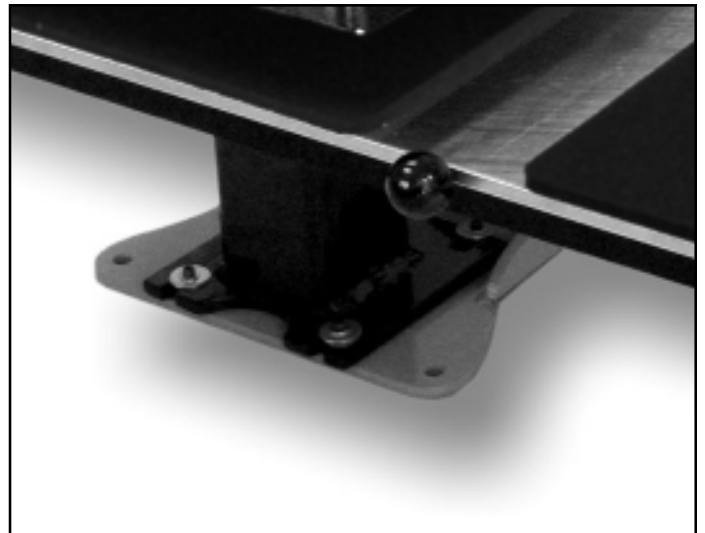


STEP 2 - Attach shuttle assembly

Bolt the shuttle assembly to the base of the press.

CAUTION: Keep the aluminum shuttle plate centered. Until locked in place, the main aluminum shuttle plate can cause the assembly to fall over! If the shuttle is not balanced, it will tip until the assembly is well screwed in place.

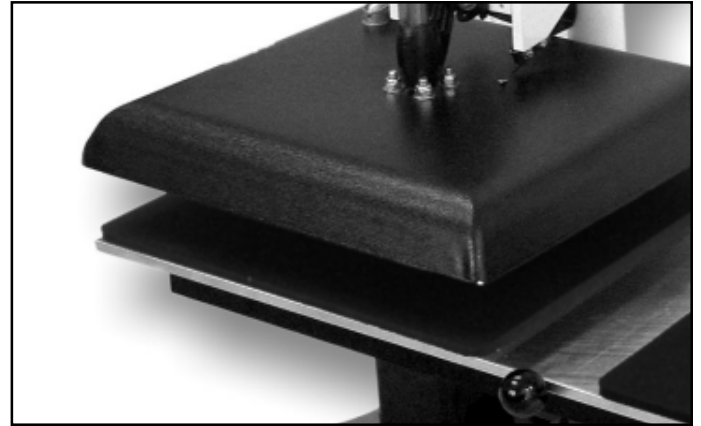
There are 4 screws that must hold the shuttle pedestal down. There are 2 sets of washers for each screw, large & small. Attach them, but do not completely tighten until the shuttle is positioned and straightened to match the heat platen.



STEP 3 Squaring Off with Heat Platen

Slide the shuttle to one side. Lower the heat platen and check for straightness along the front and back edge. You may need to slide the shuttle forward or backward for alignment.

Turn the entire shuttle assembly clockwise or counterclockwise slightly (there is a little allowance for this) to make sure the edges are relatively lining up.



STEP 4 Minor Alignment

Wrap double sided velcro to stopping posts if desired. (Not required)

The shuttle should slide within 1/4" to 3/8" of the heat platen, left to right. It is normal for there to be a slight variance and this is acceptable. Although the press will properly perform right to the edge, it is recommended to keep the image area within a minimum 1/2" away from the edges of the rubber.

Use the double sided velcro supplied to wrap around the posts on the shuttle assembly. The Roller Bearings hit 2 of these posts on the shuttle. Depending on the amount of velcro used, the position where the shuttle stops can be adjusted and fine-tuned. Add more velcro around the stop post to make the silicone pad stop earlier if desired. This also dampens the contact sound of the roller bearings.