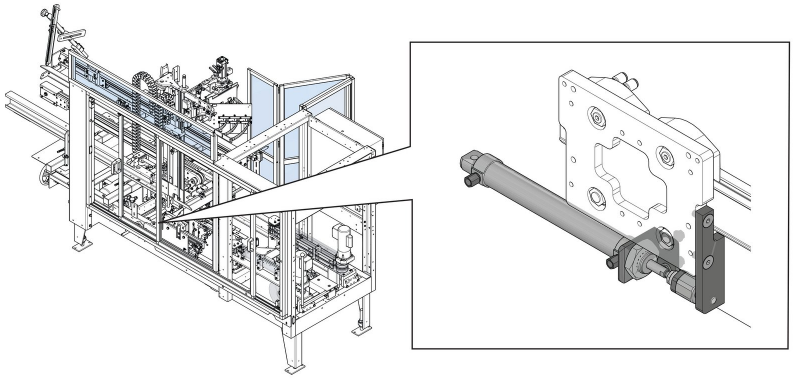
Discharge Pusher Cylinder Replacement Guide (SMC-FESTO)

Instructions for replacing the discharge pusher SMC cylinder with a FESTO cylinder.

Written By: Wexxar WISE Admin



TOOLS:

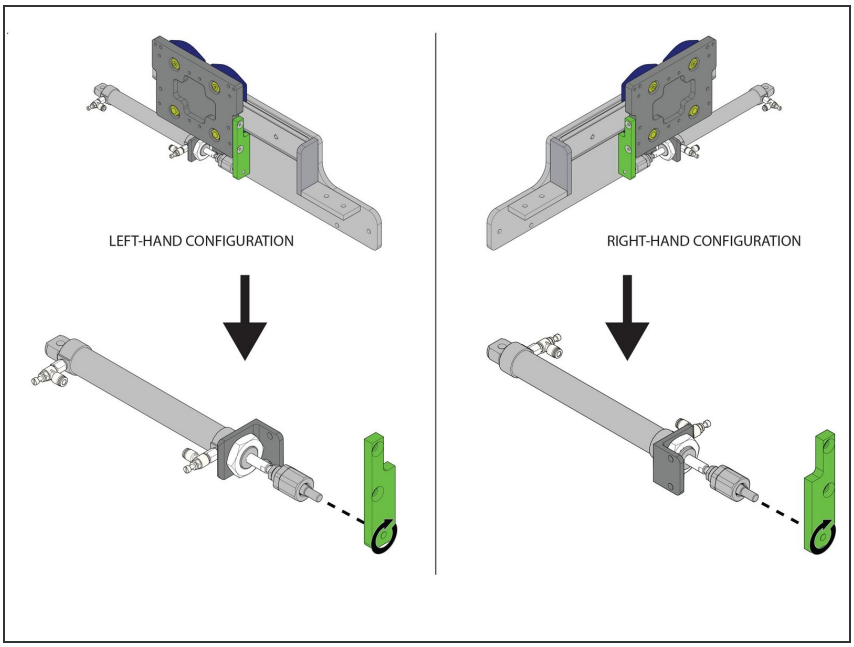
- 3/16" Allen Key (1)
- 7/32" Allen Key (1)
- Crescent Wrench (1)

PARTS:

- 15-785 (1)
- 531-10080 (1)
- 17-421 (2)
- 1/4"-20x1 1/4" Socket Head Cap Screw (2)
- 1/4" Lock Washer (4)
- 1/4" Flat Washer (4)
- 1/4"-20 Jam Nut (2)
- 3/8"-16x1" Flat Head Socket Cap Screw (2)

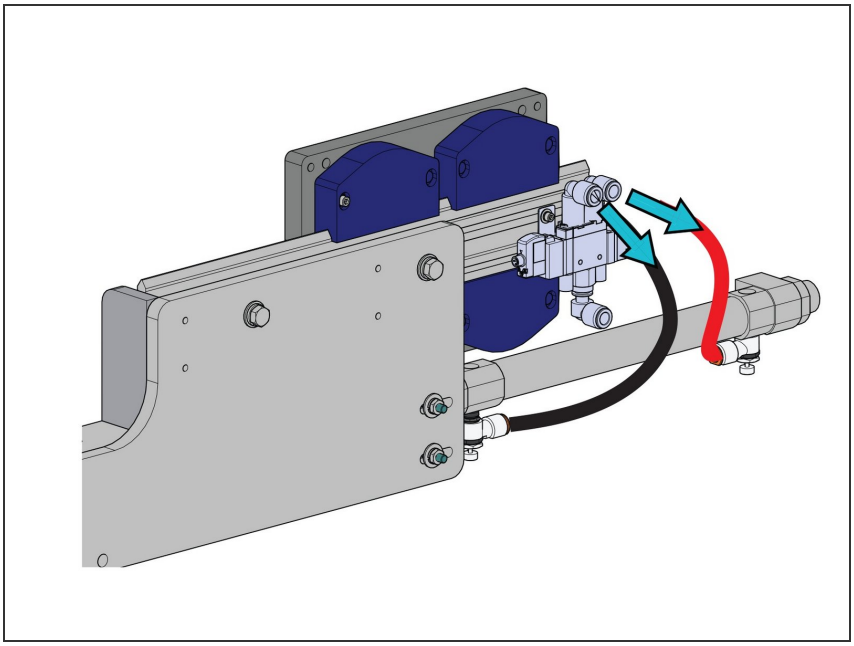
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Step 1 — Before Starting



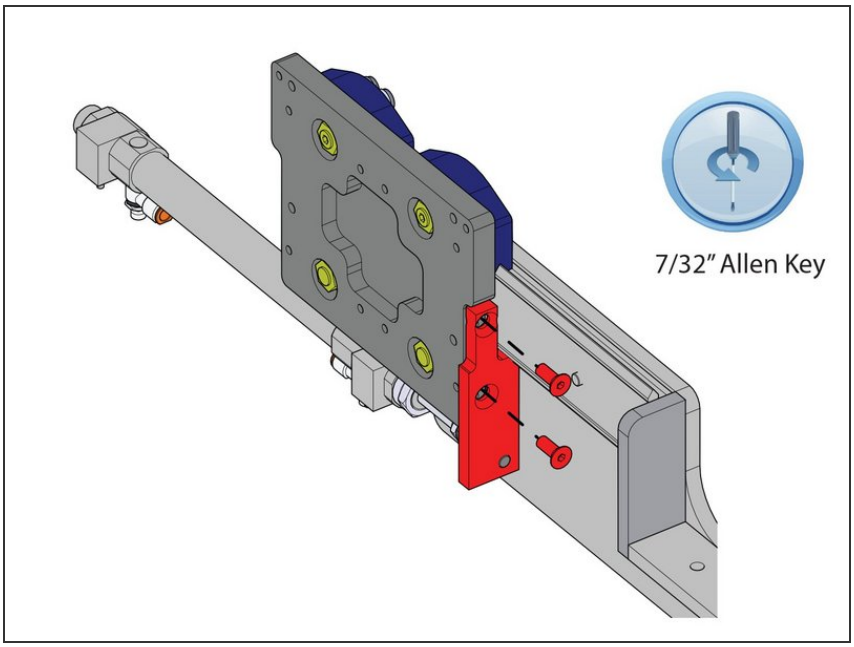
ⓘ You need to attach the discharge plate (531-10080) in the correct orientation for your case former's confguration: LEFT-HAND or RIGHT-HAND.

Step 2 — Remove the Existing Cylinder (SMC)



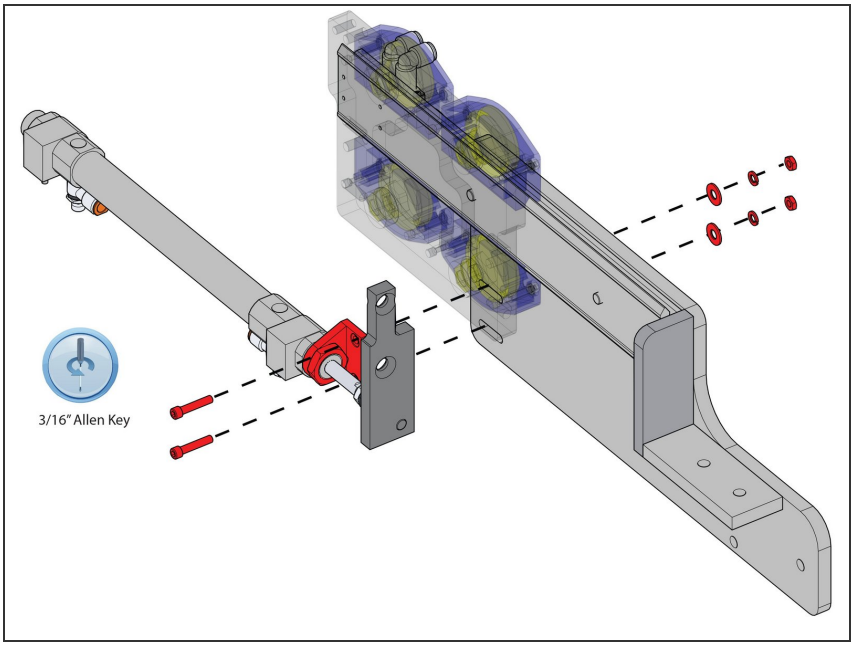
- Disconnect the cylinder's pneumatic tubing from the valve.

Step 3



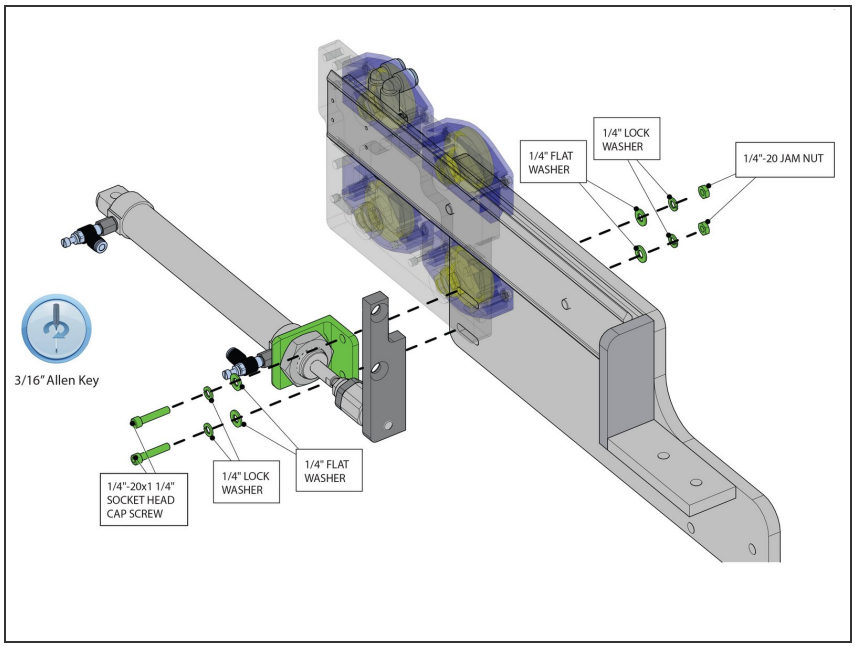
- Unscrew the discharge pusher plate.

Step 4



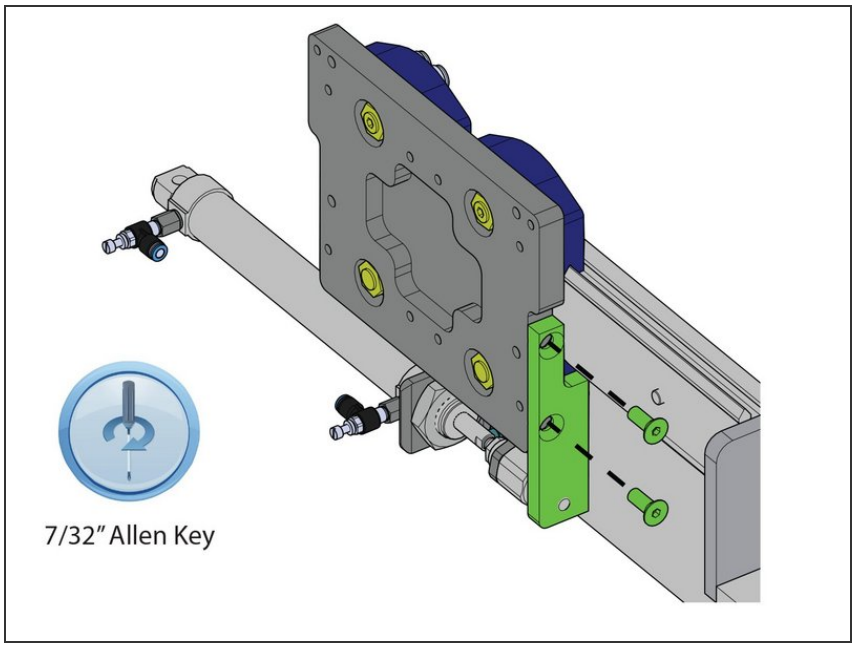
- Unscrew the foot mounting and remove the cylinder.

Step 5 — Install the Replacement Cylinder (FESTO)



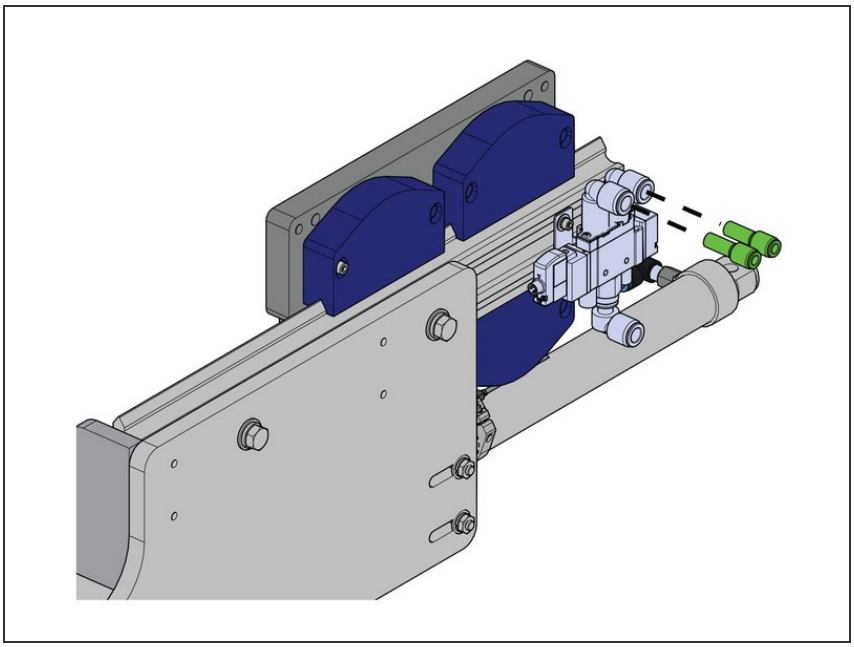
- Attach the foot mounting to the discharge pusher track with the supplied fasteners (see parts list) and tighten to 13.8 lb-ft.

Step 6



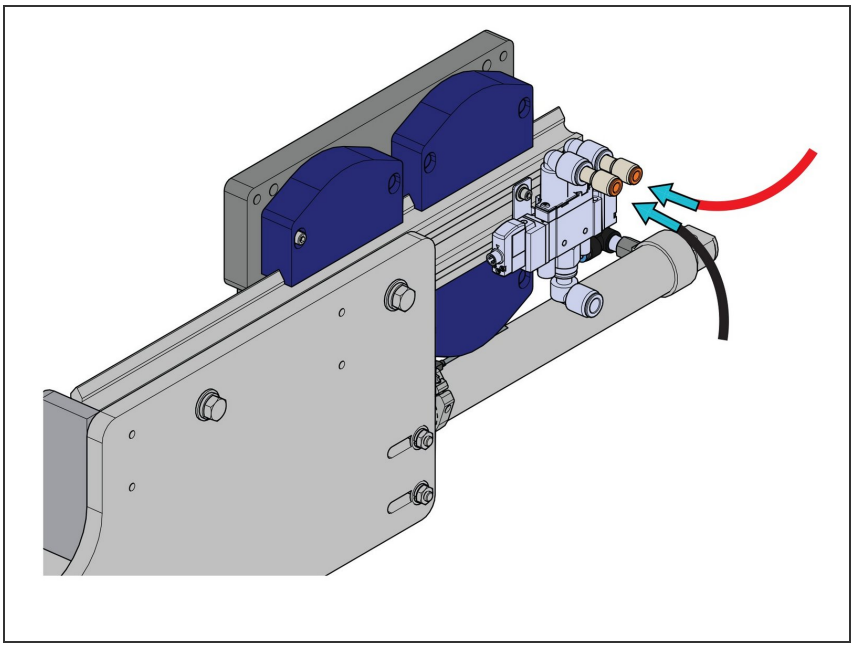
- Attach the discharge pusher plate to the carriage and tighten to 20 lb-ft.

Step 7



- Insert 1/4” tube adapters into the valve.

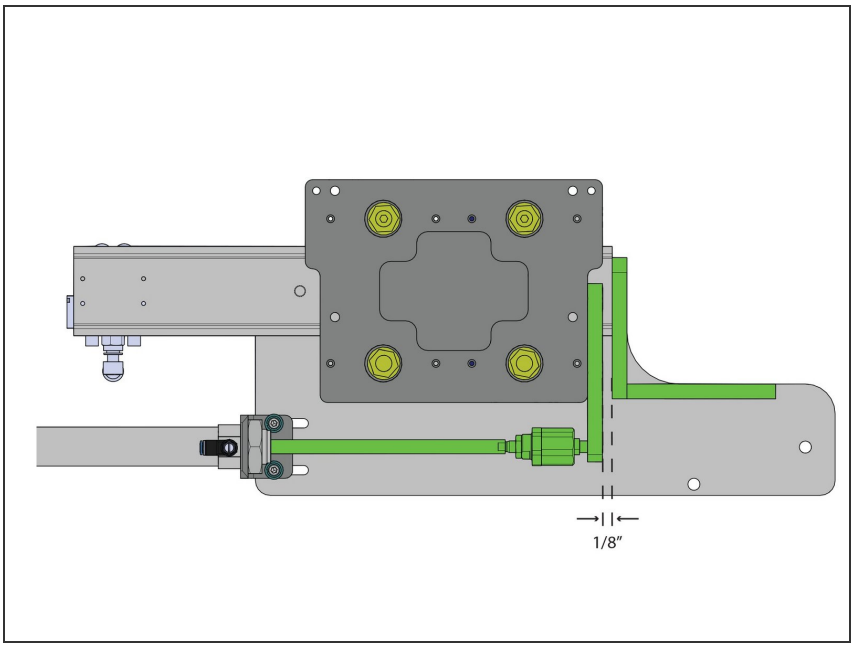
Step 8



- Connect the cylinder to the pneumatic valve using 1/4” pneumatic tubing.

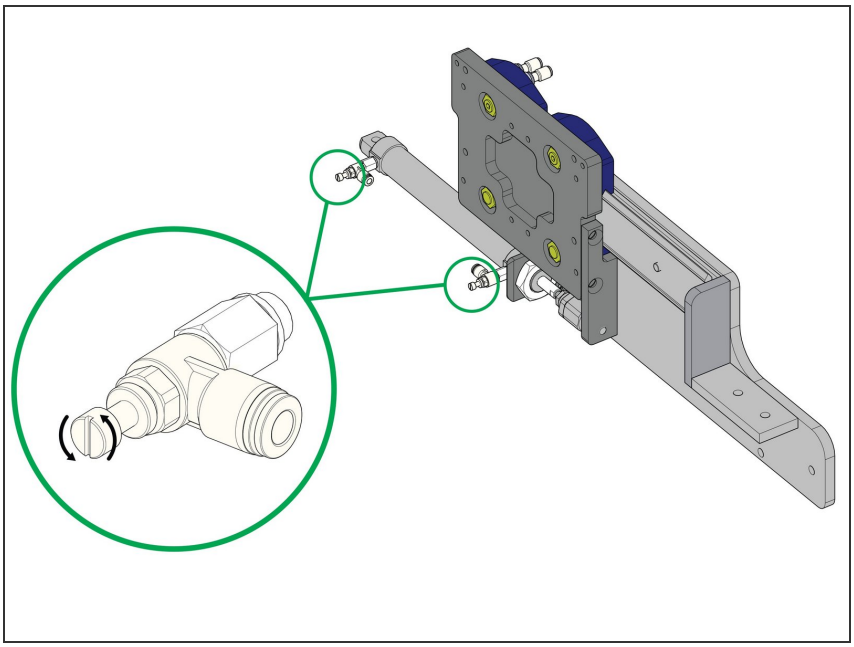
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Step 9



- Set the maximum stroke of the cylinder so it leaves a minimum 1/8" gap between the carriage and the weldment.

Step 10



- Adjust the speed of the cylinder using the valve flow controls:
  - ⓘ To increase speed, turn the adjustment screw counterclockwise.
  - ⓘ To decrease speed, turn the adjustment screw clockwise.
- Check the cylinder speed with each adjustment until the rate is satisfactory.
- Lock the flow control knobs by tightening the locking nut on each of them.

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