

TAK Enterprises, Inc.



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PosiBlank Holder™

Instructions

For TAK Series 2000- thru- 2002 its

2 Instructional Pages

1 Machining Blue Print (#D-10-4-28)

1 Tool Holder Blue Print (#D-10-4-5)



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TAK POSIBLANK HOLDER INSTRUCTIONS

For Nilson Fourslide Models 0, 1 & 2 (S and F Series)

WARNING

Before working with your TAK product, please read the following instructions thoroughly and observe all safety precautions with the use of wire and machinery. DO NOT HANDLE COMPONENTS OF THE UNIT AROUND EXPOSED ELECTRICAL WIRES OR CIRCUITS. Be careful when working with fellow employees, do not work at the same time in a running machine.

Use standard lengths when making interchangeable tips. Do not place this unit anywhere in the upright position. It is very unstable (upright) and may fall causing serious damage to the unit. Oil all moving parts often. Do not over-tighten thumb screw adjustments. Do not use on other machines unless all variable dimensions have been considered for proper alignment. Provide proper clearance at the tool so as not to restrict the return of the rod by it's springs.

Steps 1,2,3,4,6&7 are necessary only for using the STYLE "A" rod.

Step #5 is necessary for all styles.

PREPARATION

1. Remove the front slide and machine per blue print provided. Step A (#1 thru #3).
2. Per the blue print, {style "A" view "A & B"} fill the adjusting screw hole with the proper sized recommended filler (soft threaded rod). Mill both ends even with the casting on the front slide.
3. Drill 1/8 diameter hole 1-1/8 deep per blueprint and install a 1/8 diameter soft pin. This will keep the filler threaded rod from turning.
4. Mill a 25/64 diameter slot into the casting and partially into the threaded rod per blueprint. This will give you clearance for the Style A rod.
5. Mill clearance at the back end of the slide (See view "D") 1/2 x 1-1/2 long as shown on the blueprint. This will give you clearance for the PosiBlank Holder cams. This is for "N1 & N2 only.
6. Drill and tap (2) 1/4-20 threaded holes as shown on blueprint (See view "C") to be used as the adjusting screws for the tool holder.
7. For use with Style A rod: Drill and tap (2) 1/4-20 x 5/8 deep holes down into the slide (See view "D") of the blueprint. The screws that fasten the tool holder when using the PosiBlank Holder can now be put into these holes. You will have to manufacture a tool holder specific to your needs.

See the Tool Holder Blue Print included for sample tool holder construction.

INSTALLATION

1. Remove the right side cut-off *Return Lever Shaft Bracket*. Replace with PosiBlank Holder mounting bracket as shown on print. Finger snug screws so bracket is free to align with the following steps.

FOR MACHINES WITH A BOX TYPE CUT OFF CAM:

Use the existing Return Lever Shaft Bracket screw holes that are drilled and tapped into bed of machine. These holes will secure the PosiBlank Holder mounting bracket. Finger snug the screws so the bracket is free to align using the following steps:

2. Mount the set-up block provided securely onto front slide.
3. Mount the PosiBlank Holder with Style B rod assembly onto the mounting bracket using the 5/16-18 x 1-3/4 Allen cap screw and hardened washer provided. Push the PosiBlank Holder assembly forward and tighten the 5/16-18 x 1-3/4 screw securely.
4. Push the PosiBlank Holder activating arm by hand to see if it works freely. If it is binding, adjust the mounting bracket until the activating arm works freely. At this time, tighten securely the (2) screws holding the mounting bracket. Keep checking the PosiBlank Holder activating arm so as not to bind. If there is any binding, the PosiBlank Holder unit will not function as designed nor will dependable interchangeability be guaranteed.
5. The mounting bracket is now permanently attached and should not be removed if alignment is to be maintained. The PosiBlank Holder body can now be added or removed from the mounting bracket easily at any time.
6. Install the pair of PosiBlank Holder cams provided onto the shaft keeping them together and in line with the cam follower on the PosiBlank Holder.
7. Relocate any oil lines as required using proper fittings so as not to interfere with the PosiBlank Holder unit.

TO CHANGE FROM STYLE B TO STYLE A

1. Loosen set screw in collar just behind the spring
2. Remove the Style B rod with adapter bracket and shaft.
3. Insert Style A rod through the PosiBlank Holder and into the spring. Re-tighten the collar approximately 1/8" from end of rod. Keep checking the PosiBlank Holder activating arm so as not to bind.



WARNING

The operator of the equipment offered herein must not be in or near the point-of-operation of any such machine or operating parts of any equipment installed on a machine, or bodily injury could result. The EMPLOYER must conspicuously display adequate warning signs on the machine with proper warnings for the machine and the specific application to which the machine and equipment are being applied.

OSHA Sections 1910.147, 1910.211, 1910.212 and 1910.217 contain installation information on the required distance between danger points and point-of-operation guards and devices. No specific references have been made to which paragraph of OSHA 1910.147, 1910.211, 1910.211, 1910.217 or any other applicable sections because the paragraphs may change with each edition of the publications of OSHA provisions.

All equipment manufactured by TAK Enterprises is designed to meet the construction standards of OSHA in effect at the time of sale, however, the EMPLOYER ultimately installs the equipment and is therefore responsible for installation, use, application, training and maintenance, as well as ensuring that adequate warning signs are visible on the machine onto which the equipment will be installed.

OSHA states that the EMPLOYER must ensure that safe operating methods designed to control or eliminate hazards to operating personnel are developed and employed, and that operators are trained in safe operation of the equipment.

It shall be the responsibility of the EMPLOYER to establish and follow a program of periodic and regular inspections and maintenance of machinery to insure that all their parts, auxiliary equipment and safeguards are in a safe operating condition and adjustment. Each machine should be inspected and tested no less than weekly to determine and confirm that the operating condition of the machine meets safety standards. Necessary maintenance or repairs to machinery, auxiliary equipment and safeguards shall be performed and completed before the machine is operated. The EMPLOYER shall maintain accurate records of these inspections and maintenance work performed.

It is not the responsibility of TAK Enterprises to provide notification to the user of this equipment concerning future changes in State or Federal laws, or construction standards.

SAFETY PROGRAM

Accident free operation will result from a well developed, management sponsored and enforced safety program.

Of vital importance to the success of a safety program is the proper selection of guards and devices. However, there is no safety device that will insure "automatic" or "fool proof" safety to your operation.

Of equal importance to the proper selection of machine guards and devices is effective training of operating personnel. Each individual must be trained in the proper operation in accordance with established standards developed for the guards or safety devices employed, with emphasis on why specific guards and safety devices have been provided on the equipment. Rules for safe operation should be in writing, available to company personnel and enforced at all times.

An effective safety program must include regularly scheduled inspections and maintenance of all equipment, with accurate records to reflect the successful completion of inspections and maintenance.

To ensure that a safe working environment is maintained at all times, management, supervisors, safety engineers and all production employees must assume their proper share of responsibility to establish and maintain an effective safety program. All members of the company community should be involved so that an accurate view of the specific areas within the facility that require attention are addressed.

To assist you in the development of and maintenance of an effective safety program, many trade groups and safety related organizations provide guidelines and recommendations that are available to you. However, you must know when and how to apply these guidelines. The equipment manufacturers provide information to assist you in properly adjusting and maintaining your equipment. It is recommended that the employer comply with these guidelines at all times.