

M4.5-001/002 ARC2000

P-1554
819-0513

Installation & Operating Instructions



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⚠ WARNING Failure to follow these instructions may result in product damage, equipment damage, and serious or fatal injury to personnel.

Handling

Handle and install with care. This is a precision assembled unit with close internal clearances. The magnetic materials used in this product are brittle by nature. Avoid damaging protective housing and subjecting to severe shock loads. Do not drop. Do not use a hammer on any surface of this product.

Installation

Please refer to included drawing. The upper spring assembly is mounted to the machine spindle by 1 1/4-12 internal thread on end opposite clutch. An upper assembly installation tool has been provided to insert into and tighten the upper assembly to the machine. The clutch assembly is threaded and mounts to the base of the upper assembly with radial spanner wrenches (not provided). The output capper chuck (cap gripper) is secured to the threaded output shaft of the clutch. Please refer to included drawing.

Adjustment

The top spring force can be adjusted using the instructions provided on page 3.

The torque setting can be adjusted using the instructions provided on page 4.

Cogging

With magnetic clutches there can be a slight memory effect on the internal magnetic disc when changing from a high torque to a low torque setting. This can result in "magnetic lobes" which are felt as a minor cogging when the magnetic disc is turned. This cogging effect can be avoided by making sure that the input or output shaft is rotating when an adjustment is made from a high torque to a low torque setting. If cogging has already been developed, it can be corrected. To correct, start at the maximum torque setting and then while rotating the shaft at about 25 to 250 RPM, adjust the unit from maximum torque to minimum torque.

Setting Top Load Spring Force

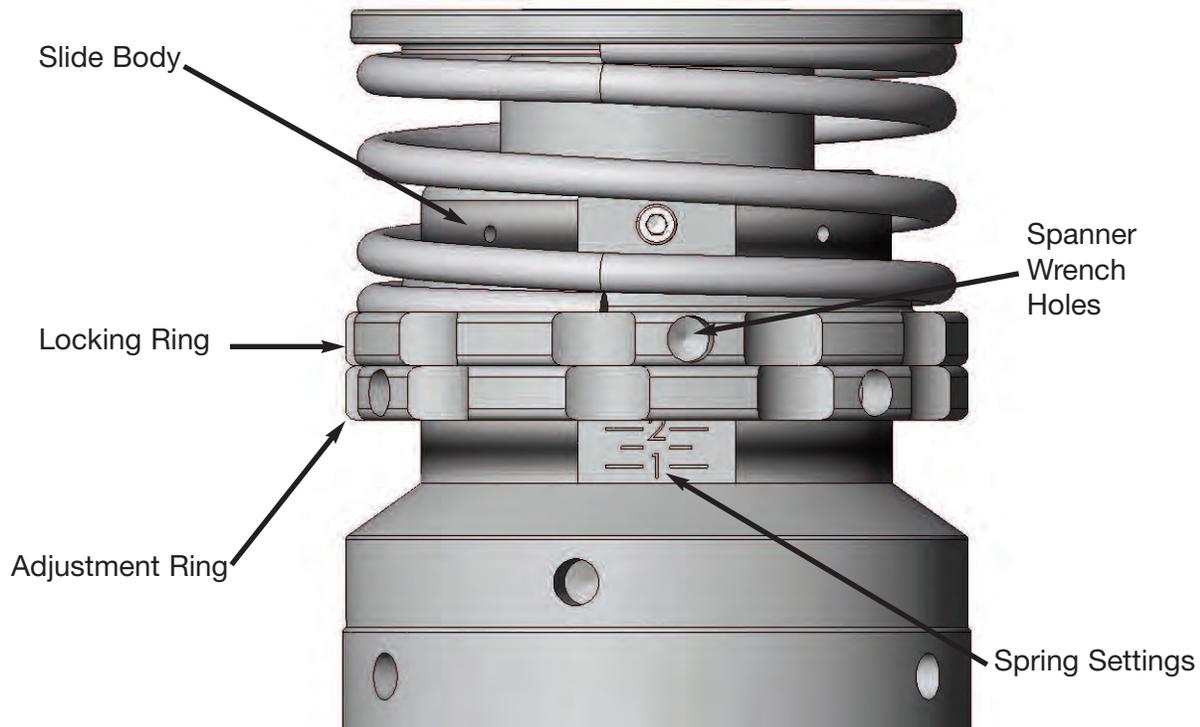
1. Determine initial spring setting from the spring force chart at the right.
2. Rotate the locking ring counter-clock-wise to compress the spring so that the adjusting ring can be rotated to the correct setting on the scale.
3. Align the bottom side of the adjusting ring to the desired setting.
4. Bring the locking ring down and tighten the two rings together with a spanner wrench.

Note: While the machine is running, and caps are being applied, the bottle should not spin. If the bottle does spin, it may be necessary to increase spring pressure.

Spring Setting	Top Load Force @ 0.200 Compression
Min.	27
1.0	30
1.5	33
2.0	38
2.5	41
Max.	44

Tools Required

- (2) Adjustable head pin style spanner wrench with 1/4" pins.



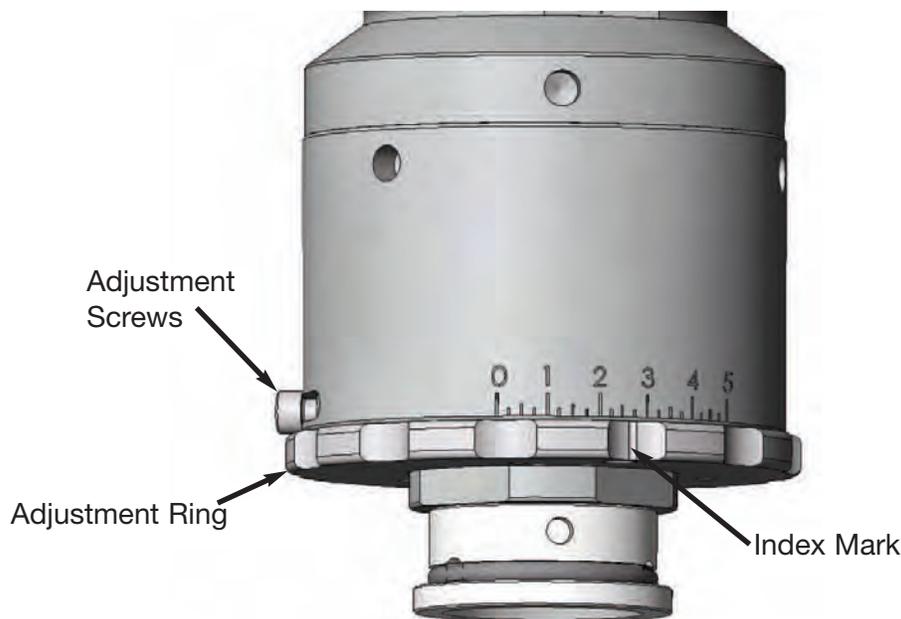
Setting Application Torque

1. Determine Initial clutch setting from torque chart at the right.
2. Loosen torque adjustment screws. Rotate adjustment ring to desired setting and retighten torque adjustment screws.
3. For optimum results, check setting with a torque wrench.

Tools Required

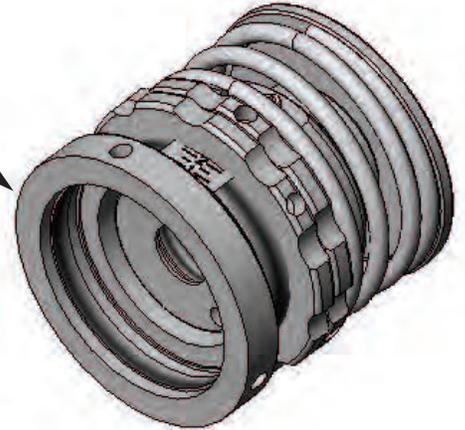
- 5/32 Hex key wrench
- Torque wrench with adapter (optional)

Clutch Setting	Application Torque (lb.in.)
0.00	3.00
0.25	3.00
0.50	3.00
0.75	3.50
1.00	4.00
1.25	5.00
1.50	6.50
1.75	8.00
2.00	9.50
2.25	11.50
2.50	13.50
2.75	15.00
3.00	17.00
3.25	18.50
3.50	20.00
3.75	21.50
4.00	22.50
4.25	23.50
4.50	24.00
4.75	25.00
5.00	25.50



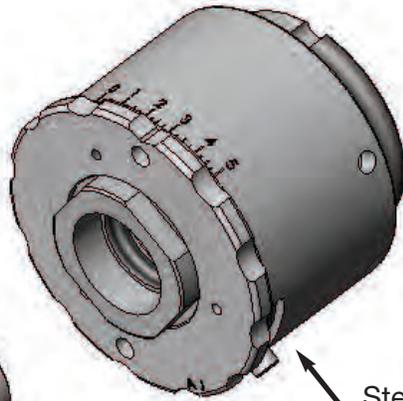
M4.5

Step 1 - Install top load spring assembly onto machine spindle, use round tool provided. Remove tool after unit is installed.

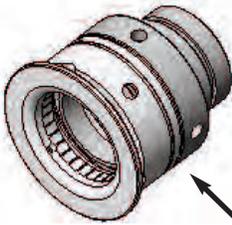


Round Tool

Step 2 - Install clutch onto top load spring assembly. Use radial spanner wrenches.

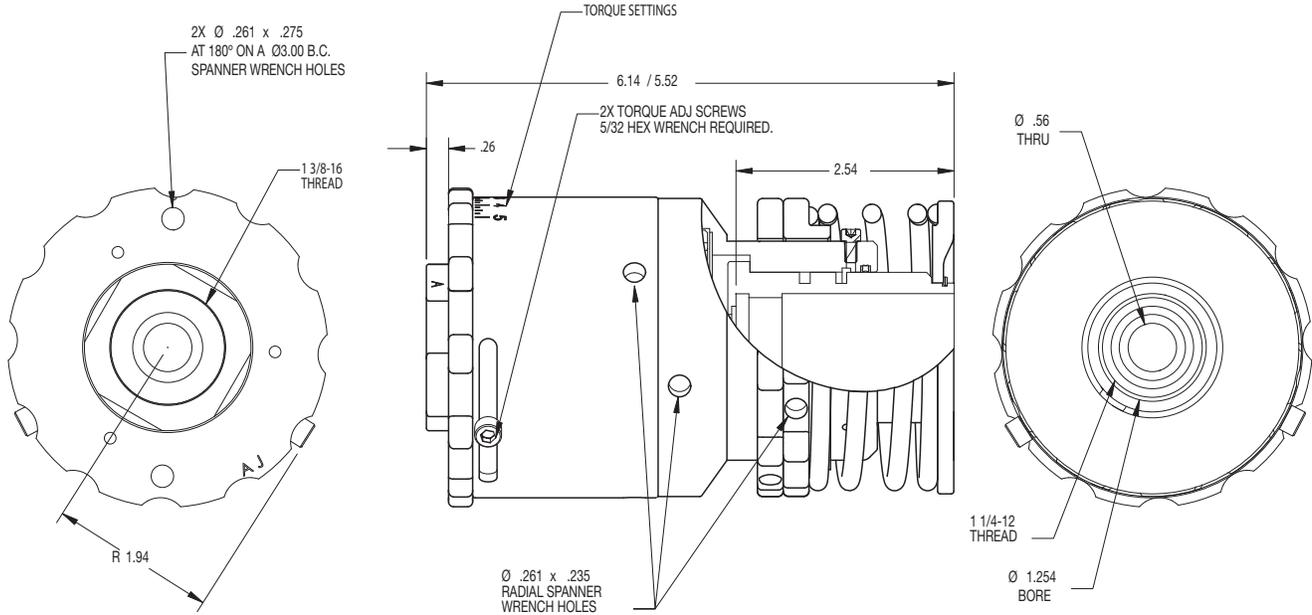


Step 3 - Thread capper chuck into clutch.



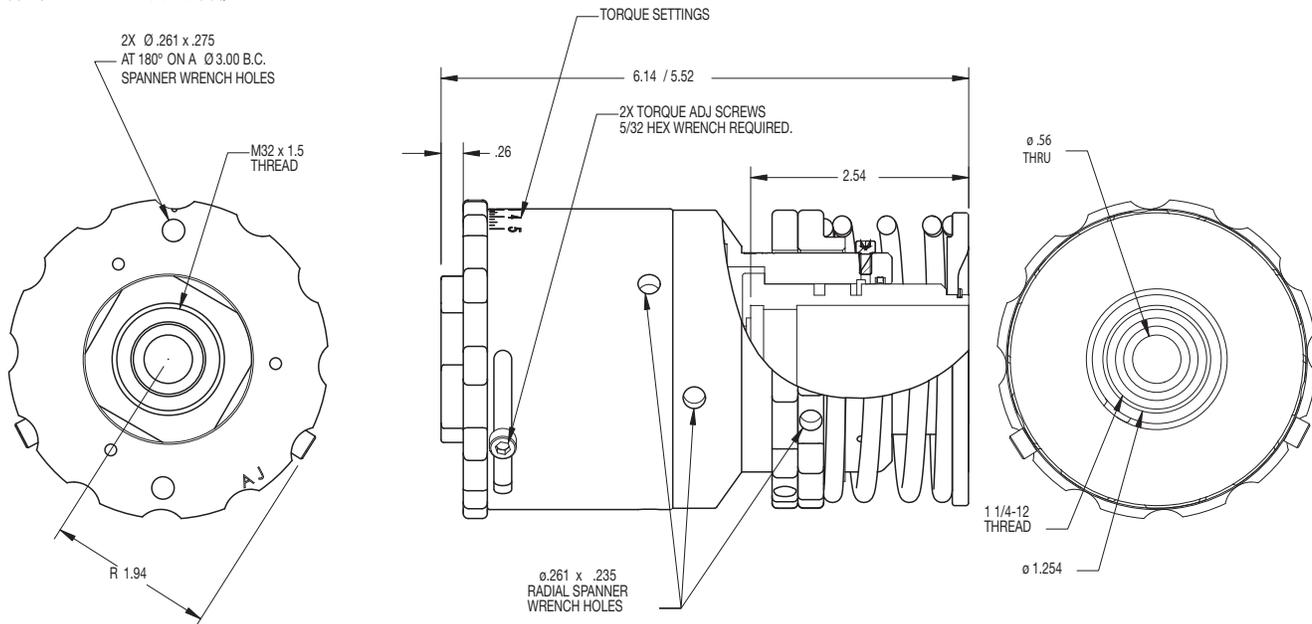
M4.5-001

TORQUE RANGE: 2 - 25 LB-IN
 OUTPUT INERTIA: 1.4013 LBS SQ IN



M4.5-002

TORQUE RANGE: 2 - 25 LB-IN
 OUTPUT INERTIA: 1.4013 LBS SQ IN





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