

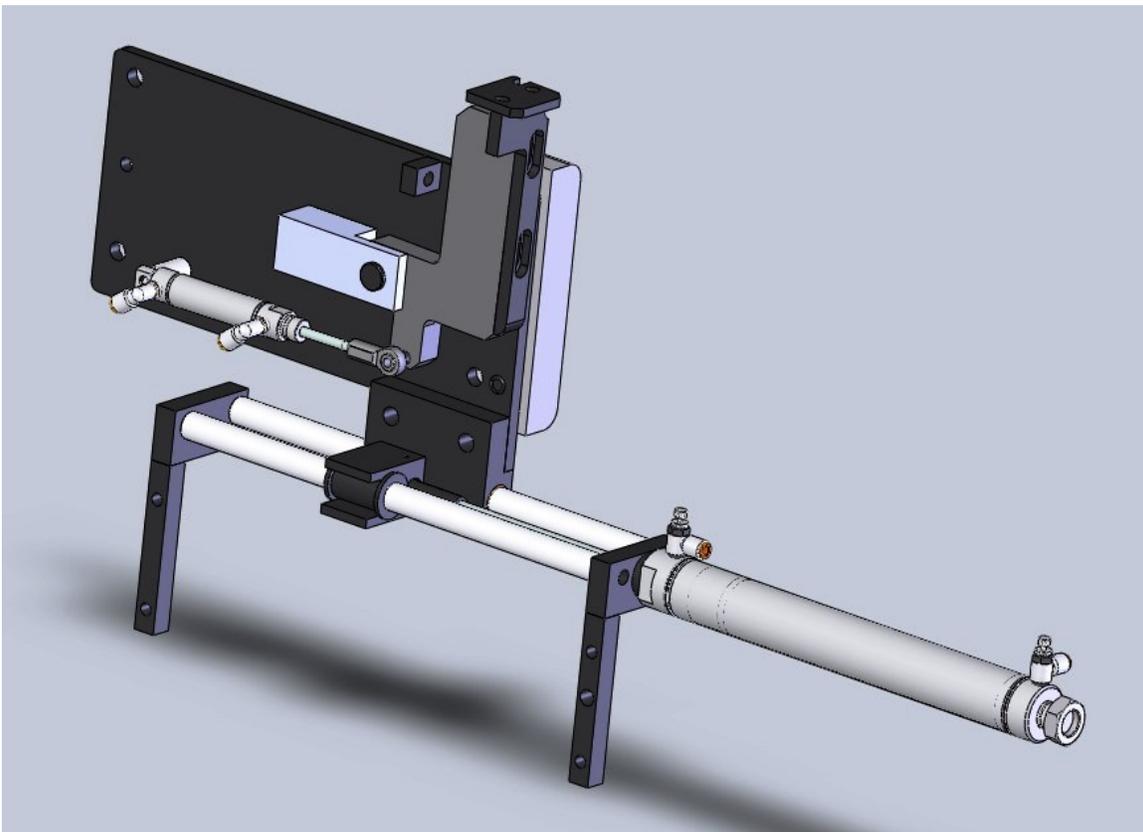
# 540 Header Clamp Upgrade

(SERVICE KIT 26-8820-01)

This upgrade replaces the header clamp assemblies on all 540 assembly machines.

All previous versions of the header clamp assembly utilized a header up stop that was pivoted between two other pivoting members. This made it difficult to consistently and accurately position the header.

This version uses only one pivoting member that is lifted into position by a cylinder. This design allows the header up stop to be positioned accurately every time.



Header Clamp Assembly

## **Installation on machines that do not have cylinders that lift the header up stop:**

Most of the 540 machines have a version of the header clamp assemblies that lift the header up stop mechanically through a series of levers. The following instructions are for these machines.

### Parts List:

- 4      5125-001      Alignment Insert
- 2      8820-718      Header Clamp Assembly
- 2      8820-719      Header clamp Assembly

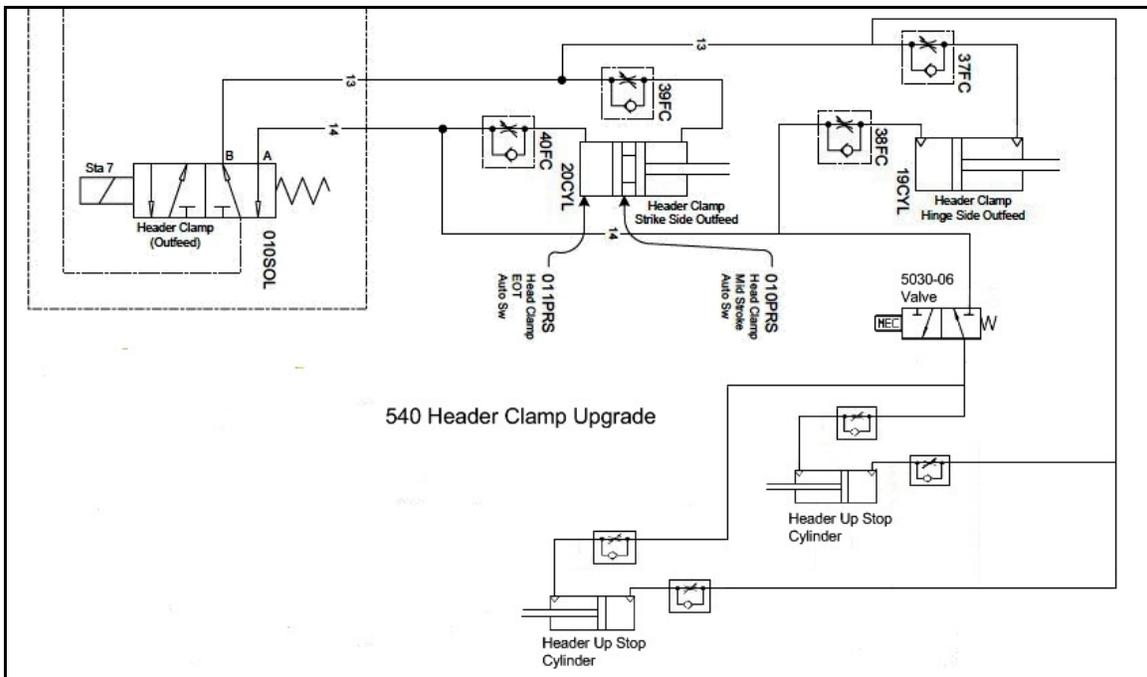
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540 MACHINES W/OUT EXISTING HEADER UP-CLAMP CYLINDERS

- 4 21-264 ¼" Union Tee
- 4 21-268 ¼" Union Y
- 2 21-267 5/32" Union Y
- 8 21-252 ¼ x 5/32 Plug-in Reducer
- 2 21-220 5/32 Male Connector
- 2 21-230 5/32 Male Elbow
- 30' TUBING,5/32 5/32 Black Hose
- 1 17-564 Instructions

1. Remove the old header clamp assembly.
2. Install the new header clamp assembly.
3. Install the stop block with the valve mounted to it. (In-feed strike and out-feed hinge locations only.)
4. Repeat steps 1 through 3 at the other three header clamp locations.

**Connecting the air lines:**



Schematic for Header Up Stop Cylinders

The following instructions will help you connect the air lines as shown in the schematics above.

1. At all 4 locations locate the air line at the rod end of the header clamp cylinder.
2. Cut the air line and install a ¼" Tee. Insert into the third port on the Tee a ¼" to 5/32 reducer and connect it to the bottom (non rod end) of the header up stop cylinder.

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3. At the 2 locations with the valve (In-feed strike and out-feed hinge locations only.) Locate the air line that is connected to the bottom of the header clamp cylinder. Cut this line and install a 1/4" Y fitting.
4. Connect the third port on the Y to the valve. You will need to use a reducer as in step #2. This hose should be connected to the port on the valve that is on the side of the valve with two ports and is closer to the plunger end of the valve.
5. Connect the port, on the side of the valve with one port, to the rod end of both of the header up stop cylinders that are at the same end of the machine.

### **Adjustments:**

- 1. Adjust the valve plunger bolt.**

When the header clamp assembly is fully retracted the bolt should lack 1/32" from pushing the valve all the way in.

- 2. Adjust the Main Clamp Body Angle.**

Adjust the stop bolt for the main clamp body so that the face of the clamp body is vertical.

- 3. Adjust the Header Up Stop.**

Adjust the header up stop so that it is approximately the same height as the jamb leg stops on the top of the staple gun assemblies.

Clamp a door unit into the machine and adjust the header up stops as necessary to line up the top of the header with the top of the legs.