

TUNING TIPS

Appleton Mfg. Division - helping you keep your equipment productive.

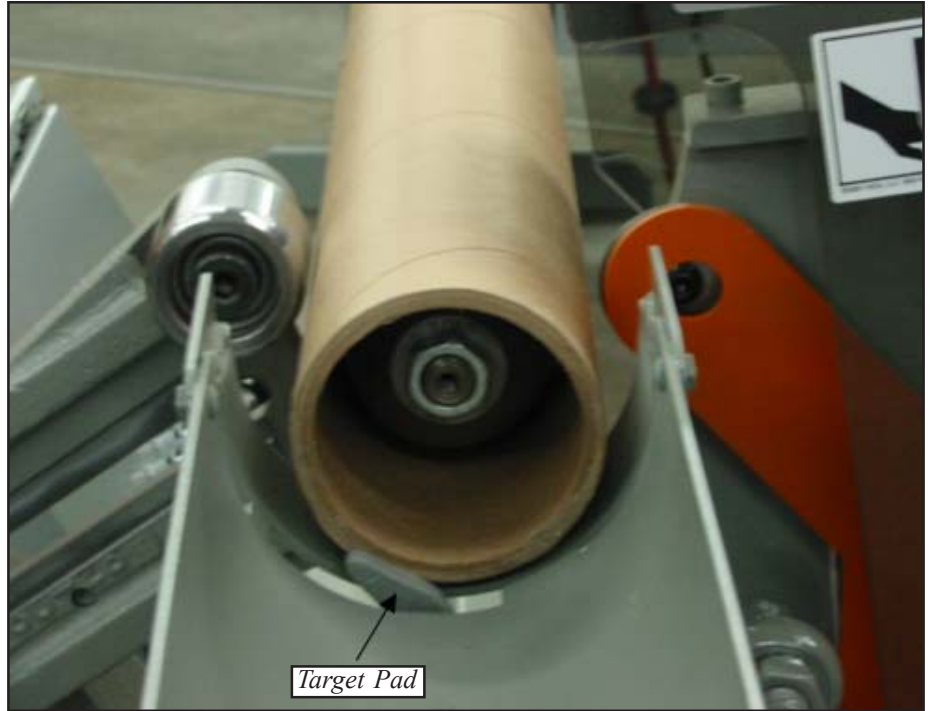
Target Adjustment

Automatic Core Cutters

These instructions apply to Appleton Mfg. Target style Core Cutters excluding "S" series cutters.

The reliability and accuracy of Appleton Mfg. Division automatic core cutters are dependent on a properly adjusted target. Cut length accuracy, consistent operation, and solenoid life are all dictated by these adjustments.

We recommend that the target adjustment be checked at least annually, and at any point in time when cut length tolerance appears to be degrading.



Parts-Fax support is available for this assembly. This program provides you with a fax identifying the current part number of each part on this assembly. Contact your Appleton Customer Representative at **1-800-531-2002** and ask for the **Target Group Fax** for your specific model.

Proper target set-up

The drawing on the back of this sheet is number referenced to the instructions below. Follow the steps below to ensure that your target assembly is adjusted to factory specifications. Prior to making these adjustments check to ensure that the target parts are not bent or broken.



De-power the core cutter before making these adjustments. Contact with solenoid wire leads will cause electrocution and unexpected movement will result in pinched or cut fingers.

1- Check to ensure that centerline of the target actuating screw is 0.030" above the centerline of the limit switch plunger.

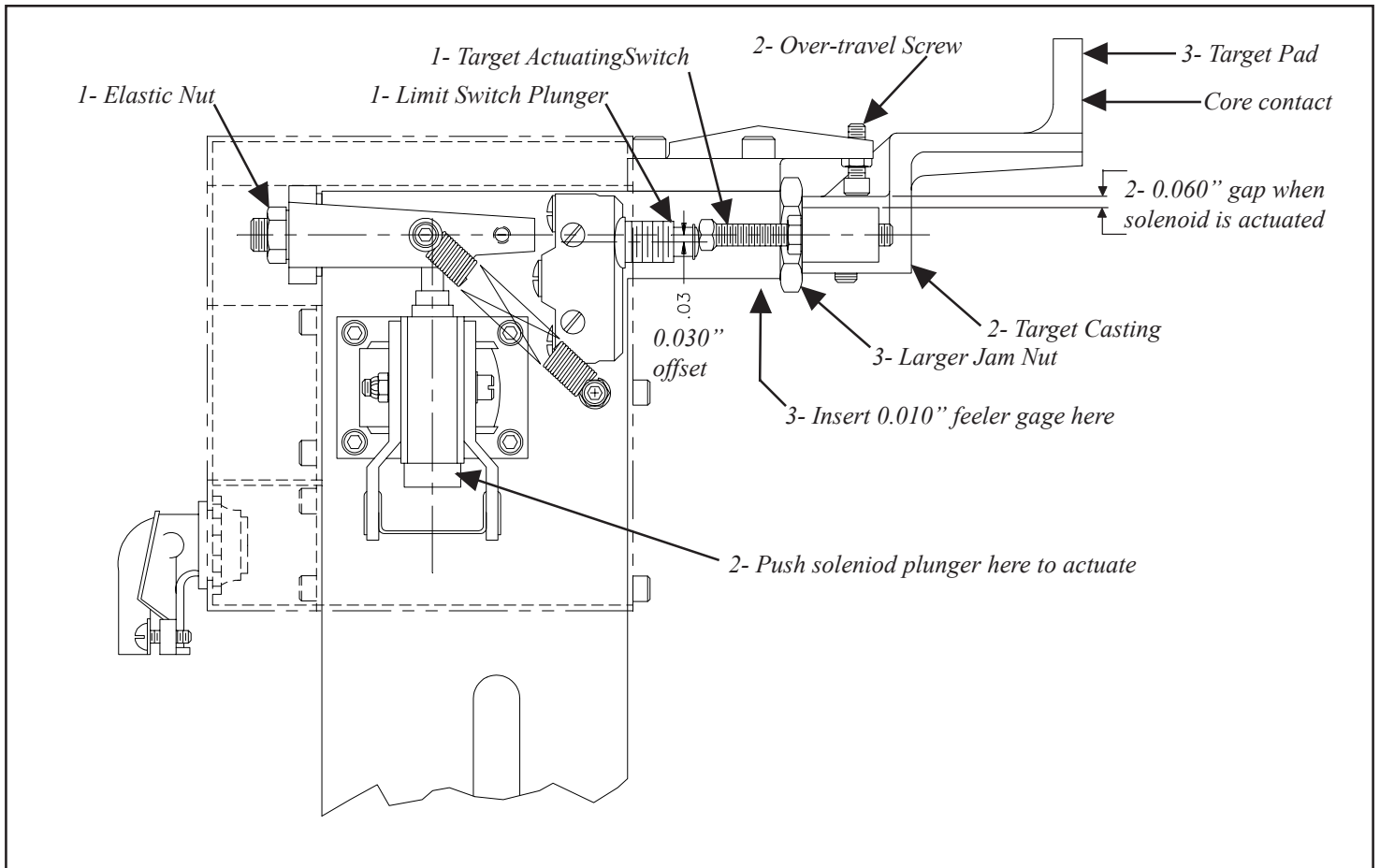
If not, check for worn bushings or worn target shaft, replace both if the shaft fits loosely and can be tilted.

Check the elastic nut that retains the target assembly, retighten if loose.

Check to ensure that the limit switch is aligned and fastened tightly.

2- Check for a 0.060" gap between the over-travel stop screw and the target casting. Push on the bottom of the solenoid plunger to fully extend the solenoid while taking this measurement.

If not 0.060" gap, adjust the over-travel screw and jam-lock it. If this adjustment is not correct, the solenoid will prematurely burn out. The solenoid must be free to fully extend. Check for interference with the core scoop and adjust the scoop to correct.



3- Insert a 0.010" feeler gage between the large jam nut and the target frame. Push on the target pad. The feeler gage should prevent the limit switch from actuating.

4- Remove the feeler gage and push on the target pad. The limit switch should now actuate (audible click).

5- Check the position of the target relative to a core on the mandrel. The pad should be positioned high enough to engage about 0.125" minimum to 60% of the wall thickness of the core as shown in photo on page one. The scoop should then be adjusted on the target assembly to just touch the bottom surface of the core. Two slots with fasteners are provided in the scoop mounting bracket to aid in making this adjustment.

6- The core cutter is now ready to be re-powered.

Appleton Help

For the correct replacement parts, field service or additional assistance, call your Appleton Customer Representative. *We're here to help keep your equipment productive!*

Appleton
MFG. DIV.

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"INGENUITY AT WORK"

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