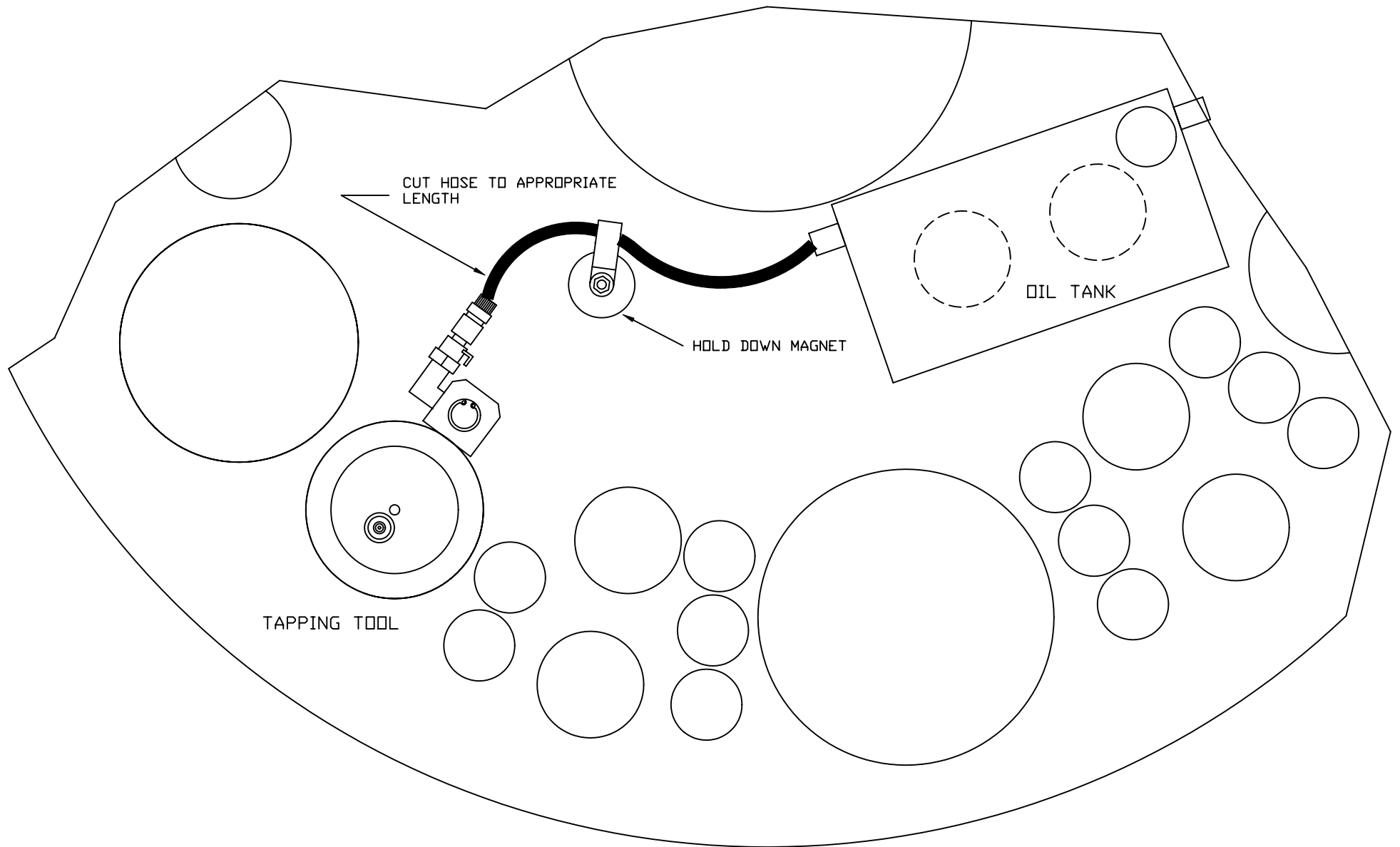
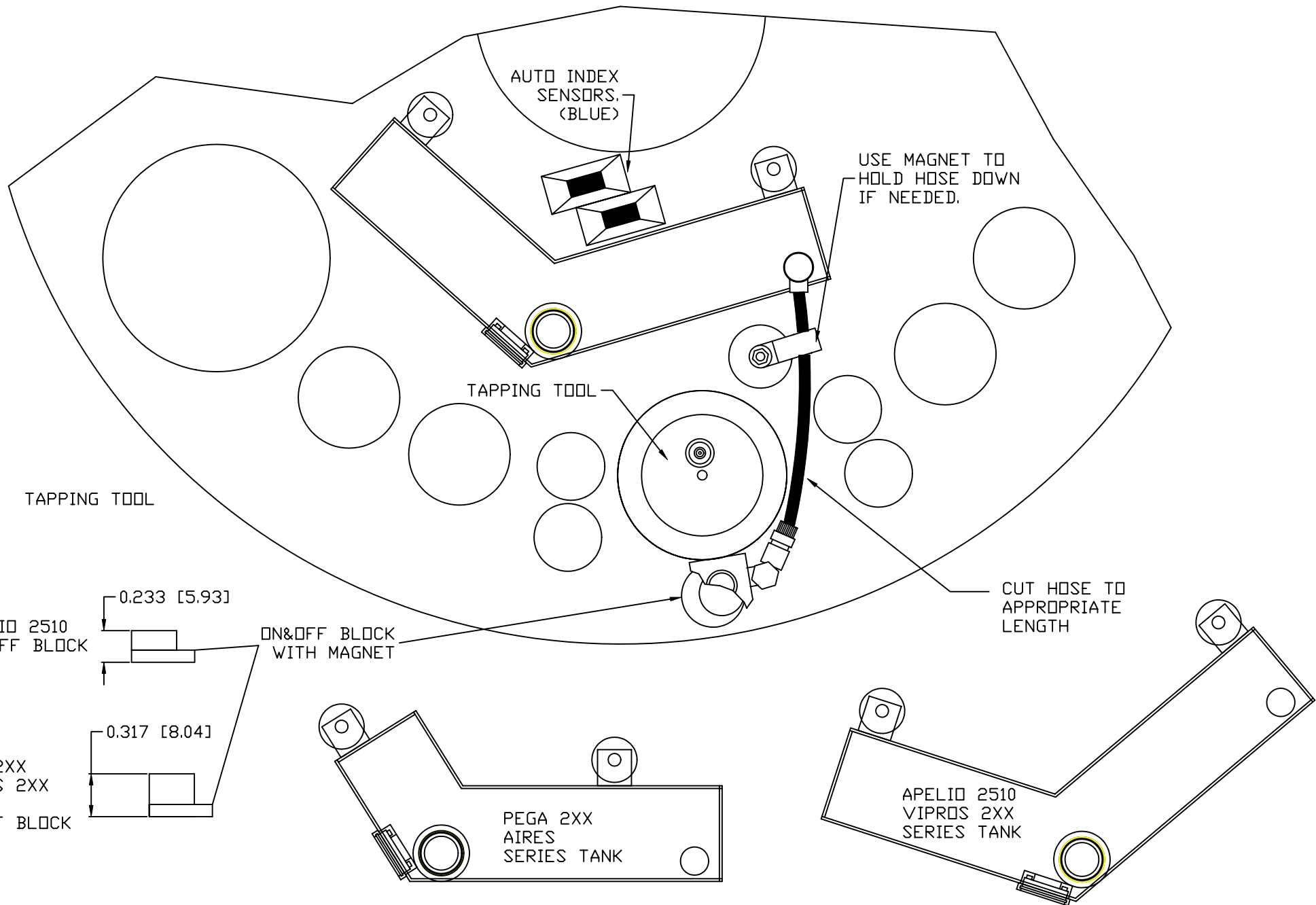


AMADA TRIPLE TRACK FIG#1



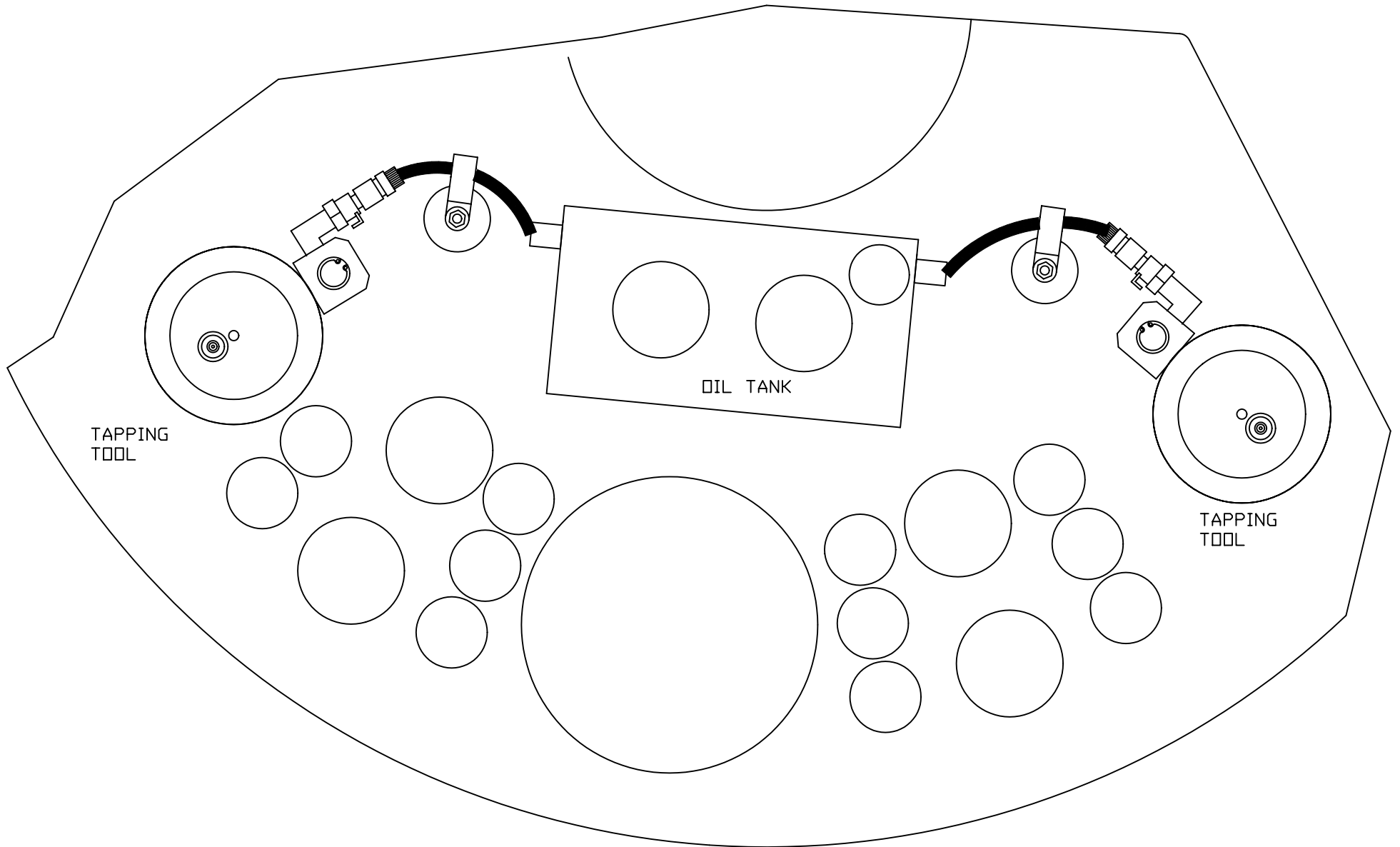
APELID 2510, VIPROS 2XX, PEGA 2XX AND ARIES

FIG#2



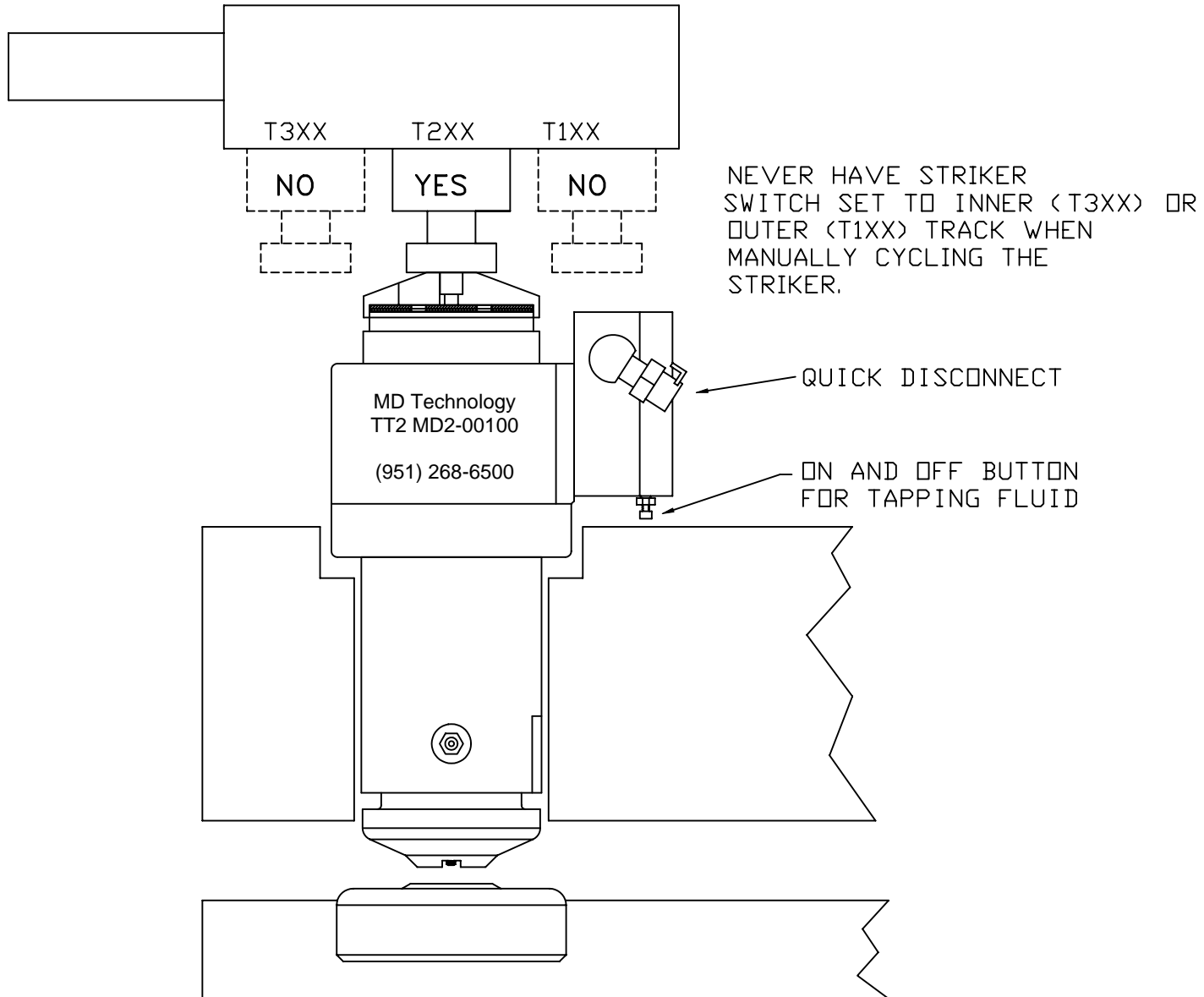
TWO TAPPING TOOLS
WITH ONE OIL TANK.

FIG#3



FIG#4

POSITION FOR STRIKER



FIG#5

NORMAL
HEIGHT

UNDER
STRIKER

STRIKER

3.038 [77.18]

0.122 [3.10]
CLEARANCE WHEN
NOT UNDER THE
STRIKER

0.069 [1.76]

CLEARANCE WHEN
UNDER THE STRIKER
REMOVE SHIMS
DIM WILL BE
.308 (8.0mm)

REMOVABLE CAP IS
OPTIONAL ON SOME
MODELS.

10-32 SHCS P/N 22-00116
MSX16 SHCS P/N 17-00191

CAP P/N 17-00196

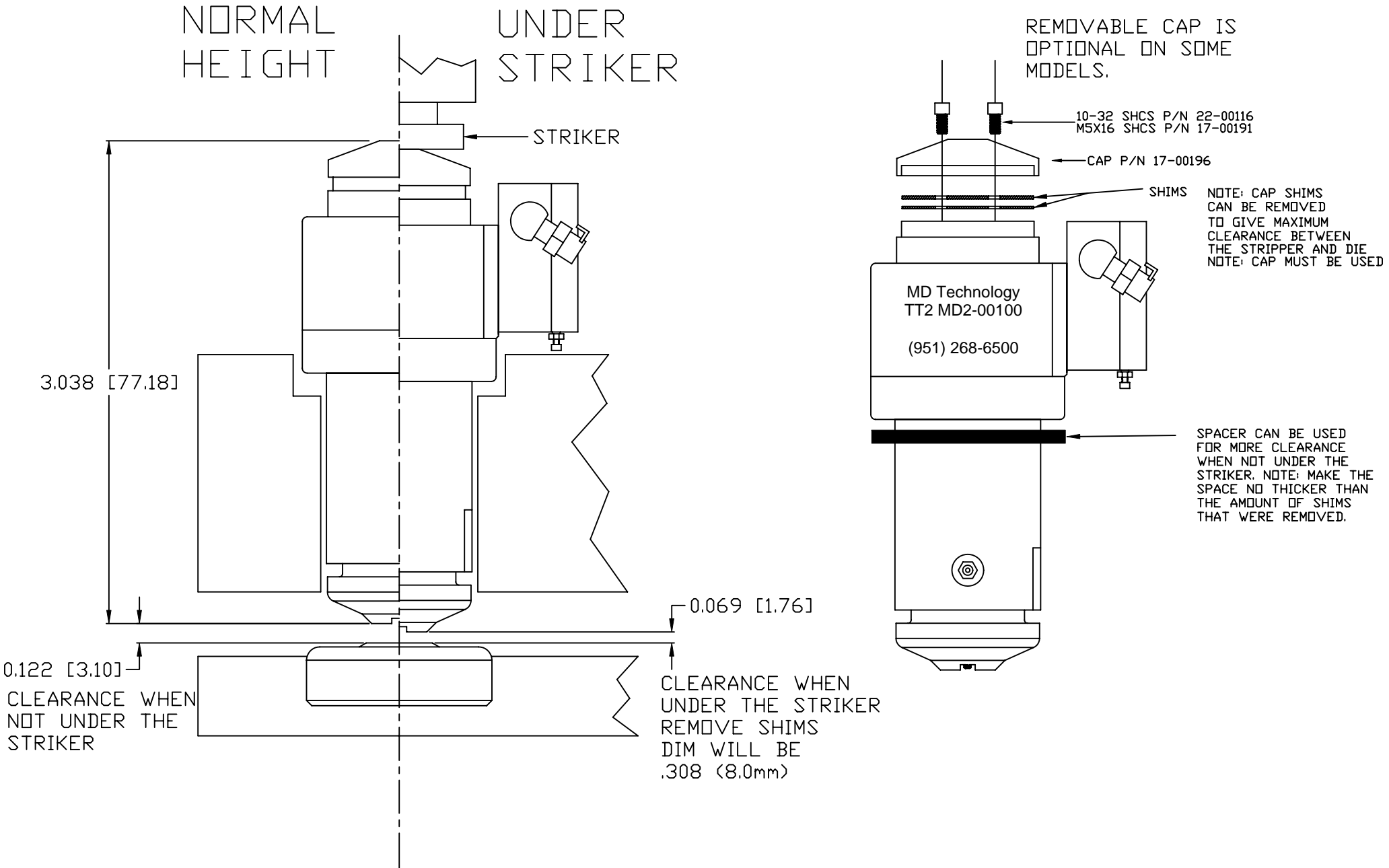
SHIMS

NOTE: CAP SHIMS
CAN BE REMOVED
TO GIVE MAXIMUM
CLEARANCE BETWEEN
THE STRIPPER AND DIE
NOTE: CAP MUST BE USED

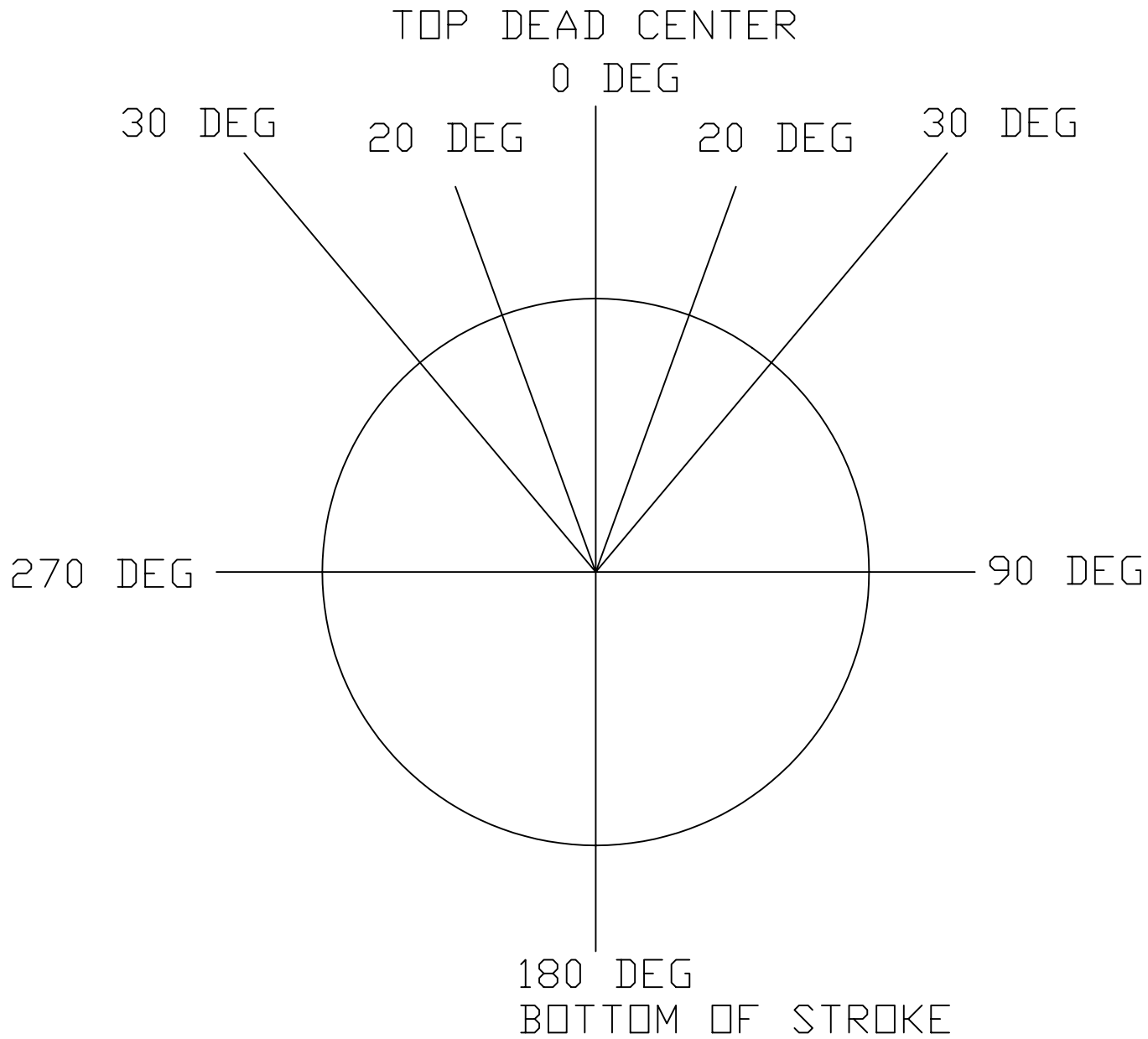
MD Technology
TT2 MD2-00100

(951) 268-6500

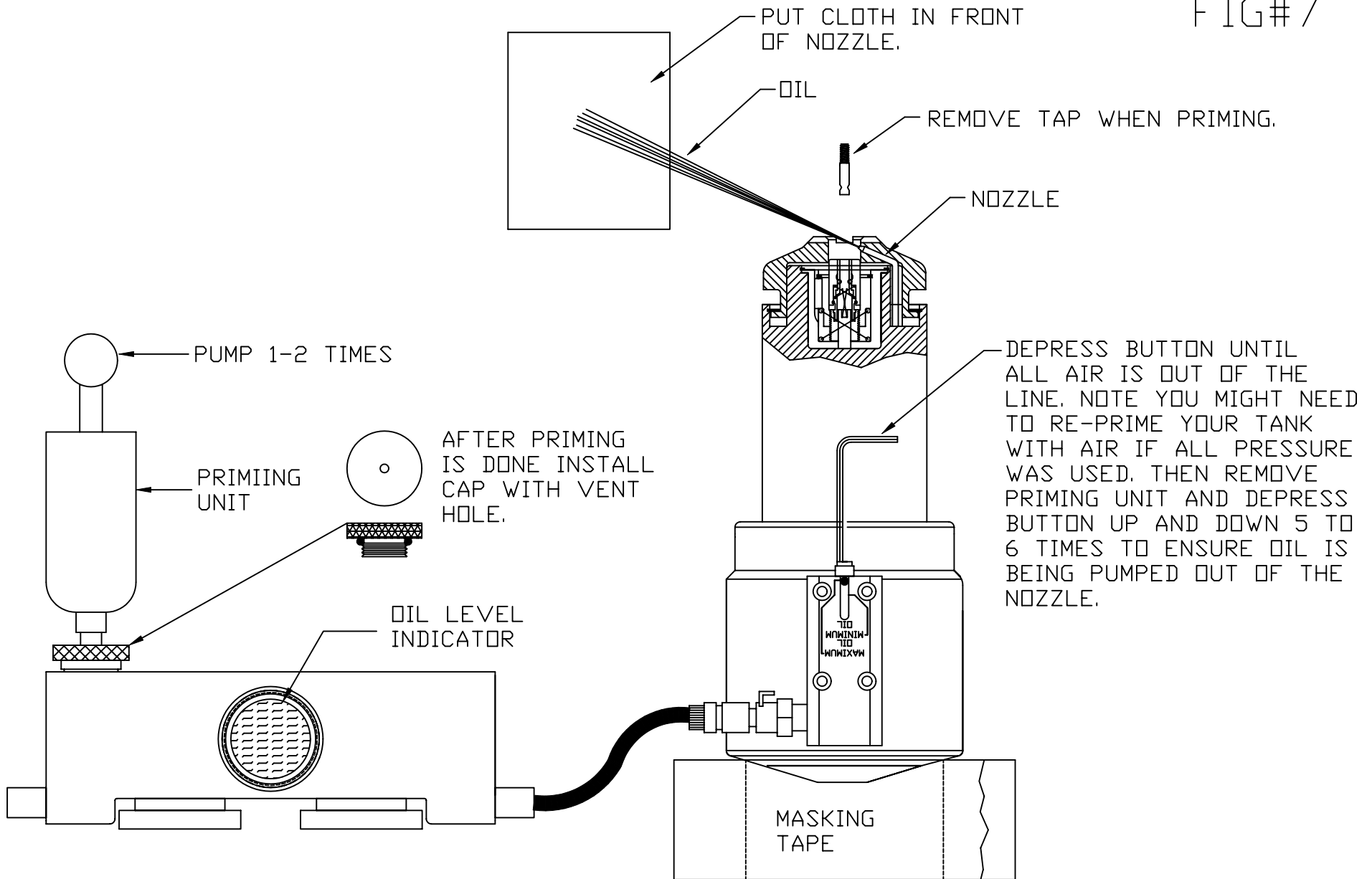
SPACER CAN BE USED
FOR MORE CLEARANCE
WHEN NOT UNDER THE
STRIKER. NOTE: MAKE THE
SPACE NO THICKER THAN
THE AMOUNT OF SHIMS
THAT WERE REMOVED.



FIG#6



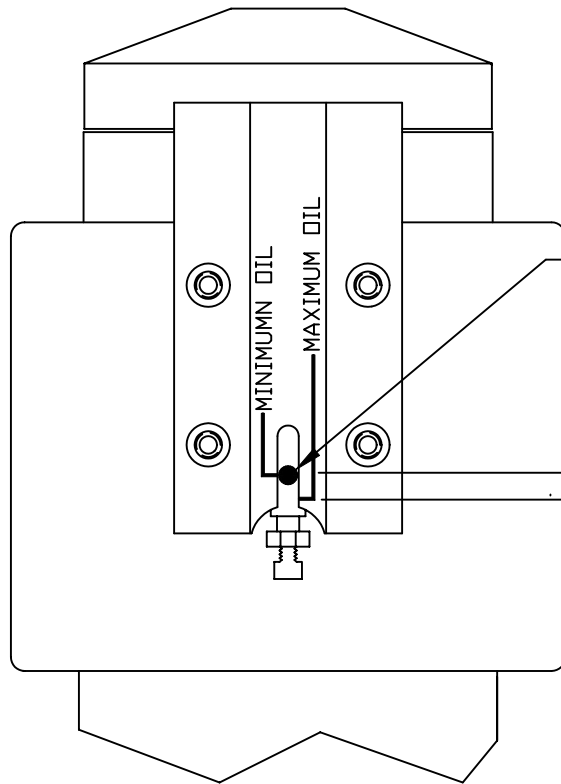
FIG#7



ADJUSTING THE ON AND OFF VALVE

FIG#8

TURN HANDLE
CLOCKWISE FOR
MINIMUM OIL.

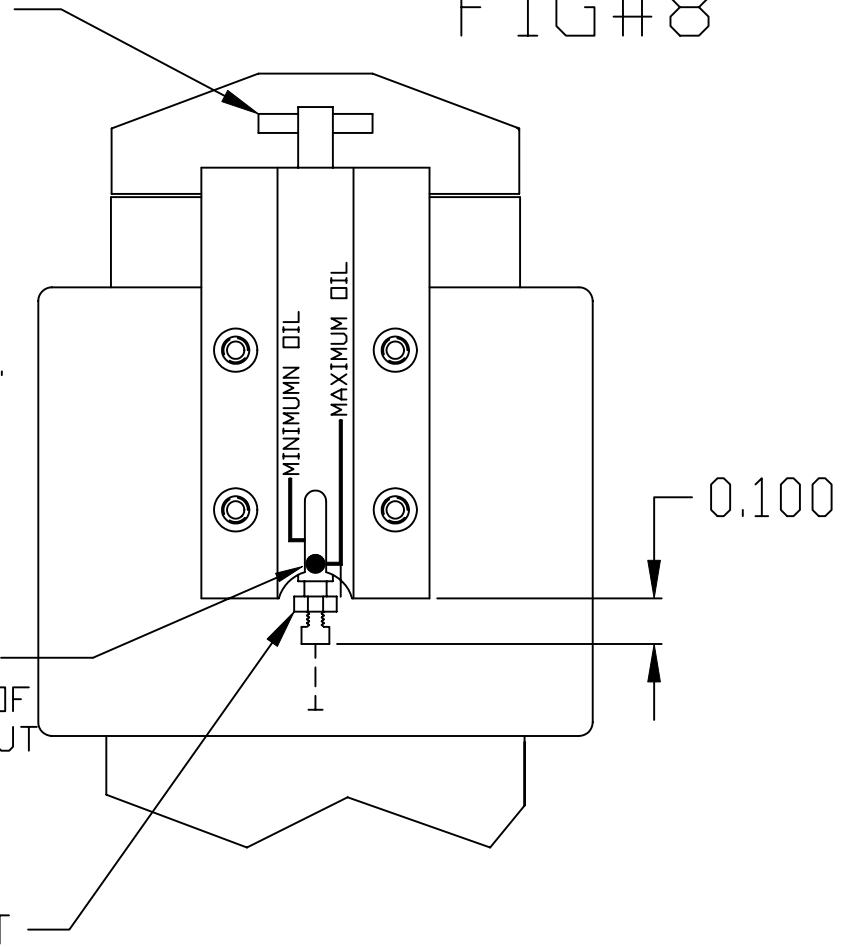


IN THIS POSITION NO
OIL WILL FLOW OUT,
TO THE TAP

OIL ADJUSTMENT
TRAVEL

IN THIS POSITION
MAXIMUM AMOUNT OF
OIL WILL FLOW OUT
TO THE TAP

M5.5 NUT



0.100

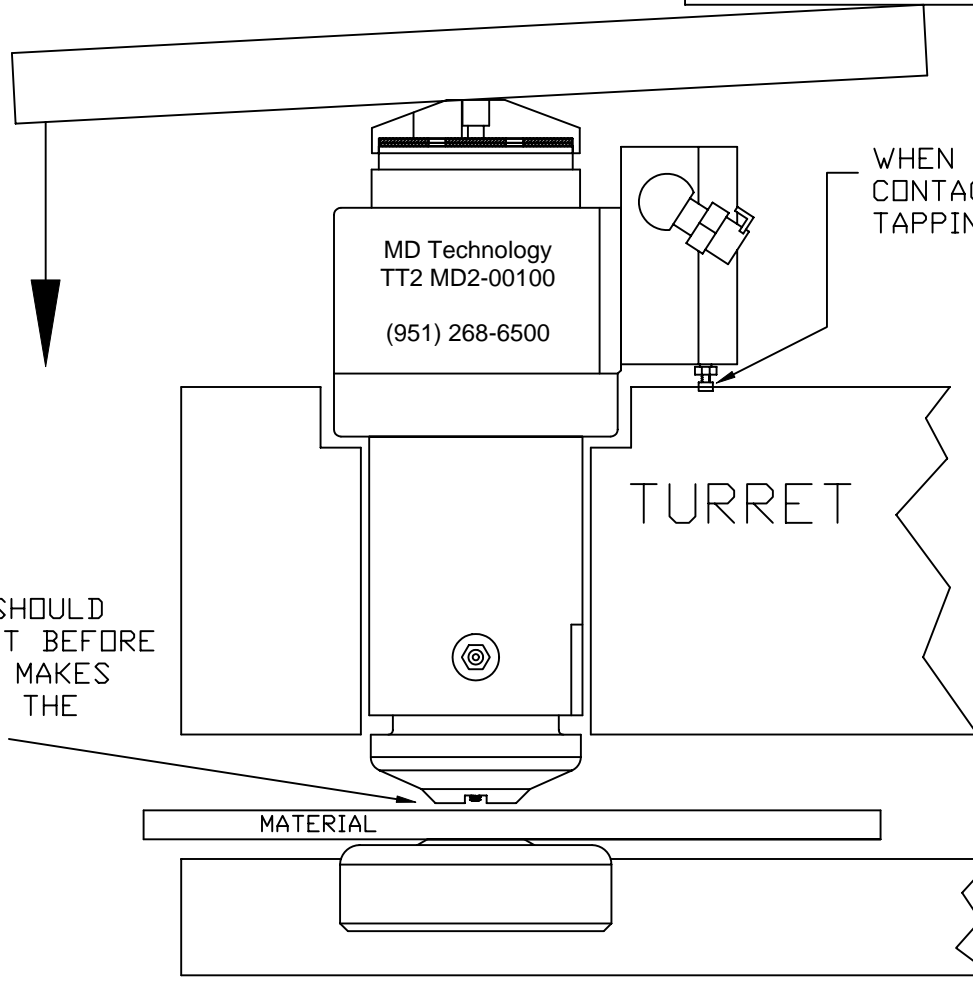
CHECKING THE TIMING OF WHEN THE TAPPING FLUID COMES OUT.

WEDGE A BAR OR WOOD BETWEEN THE UPPER
FRAME OF THE MACHINE AND ON TOP OF THE
TAPPING TOOL. PUSH DOWN ON THE BAR TO
OVER RIDE THE LIFTER SPRINGS. THIS IS
DONE AT THE TOOL DOOR.

VIPROS 300N
PEGA 30 TON
COMA 50 TON

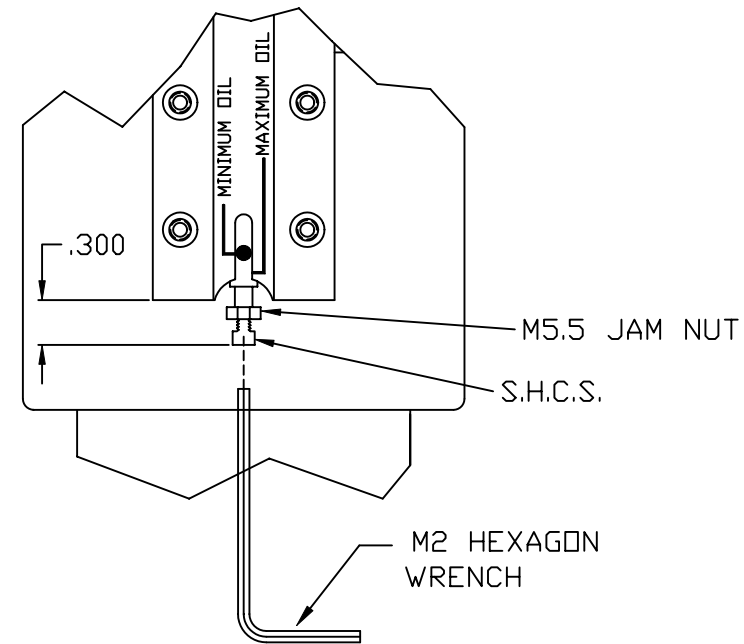
FIG#8A

UPPER
FRAME



WHEN THE ON&OFF BUTTON MAKES
CONTACT WITH THE TURRET THE
TAPPING OIL WILL COME OUT.

TAPPING OIL SHOULD
COME OUT JUST BEFORE
THE STRIPPER MAKES
CONTACT WITH THE
MATERIAL.



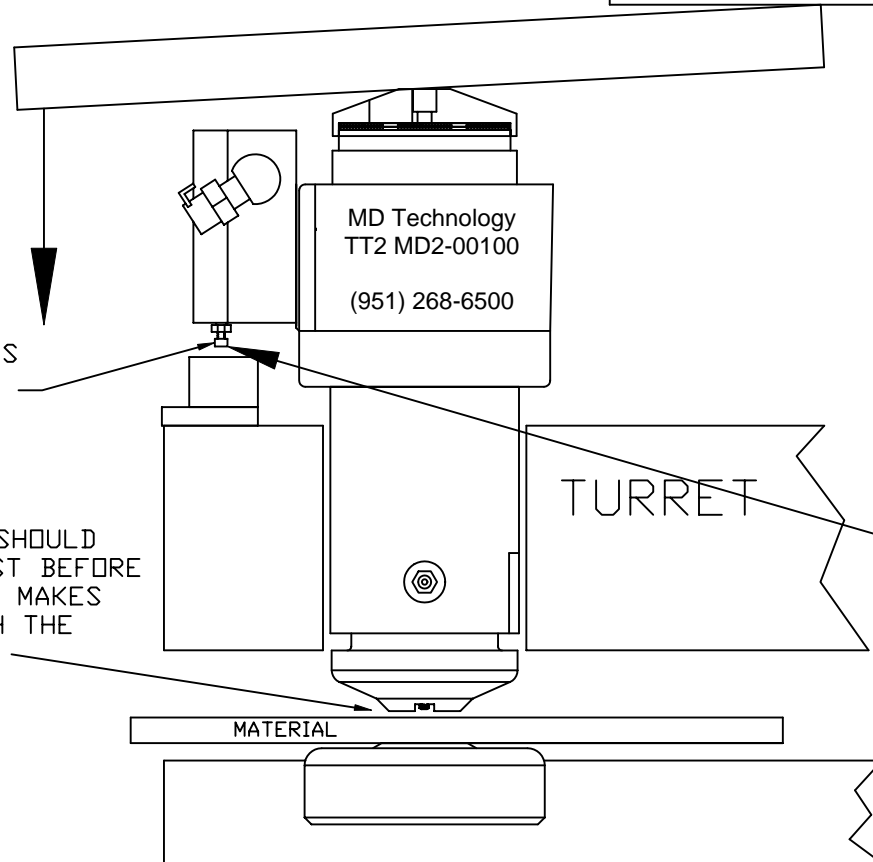
CHECKING THE TIMING OF WHEN THE TAPPING FLUID COMES OUT.

WEDGE A BAR OR WOOD BETWEEN THE UPPER
FRAME OF THE MACHINE AND ON TOP OF THE
TAPPING TOOL. PUSH DOWN ON THE BAR TO
OVER RIDE THE LIFTER SPRINGS. THIS IS
DONE AT THE TOOL DOOR.

UPPER
FRAME

FIG#8B

VIPROS 20TON
PEGA 20TON

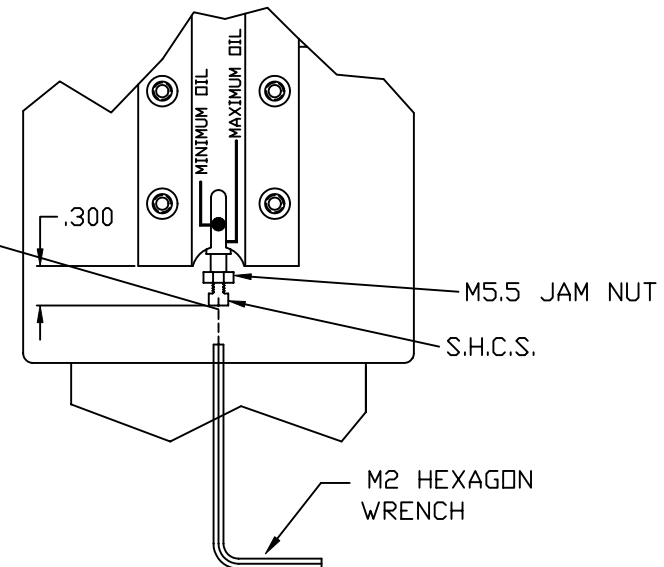


WHEN THE ON&OFF BUTTON MAKES
CONTACT WITH THE TURRET THE
TAPPING OIL WILL COME OUT.

TAPPING OIL SHOULD
COME OUT JUST BEFORE
THE STRIPPER MAKES
CONTACT WITH THE
MATERIAL.

TURRET

MATERIAL



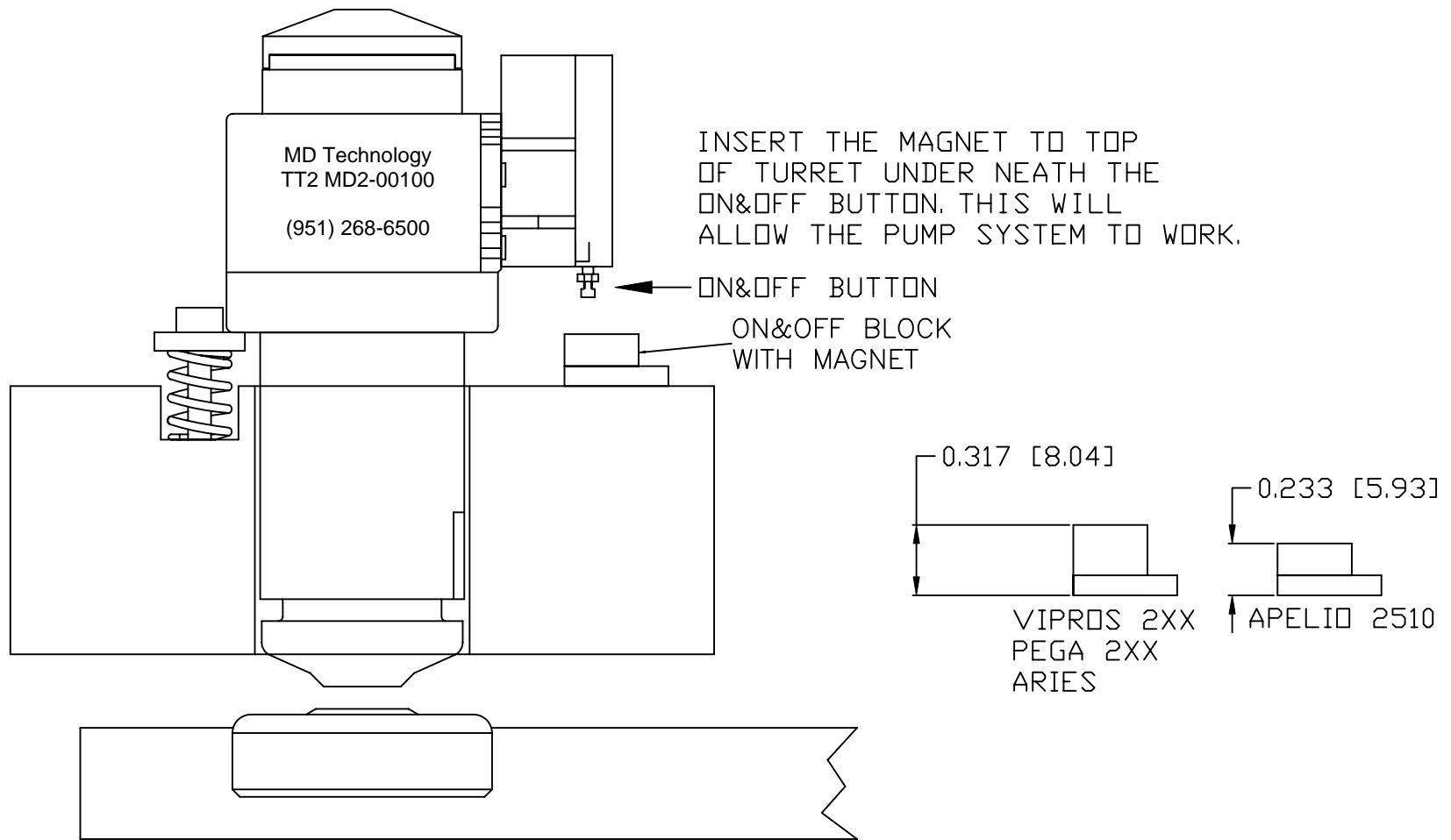
M5.5 JAM NUT

S.H.C.S.

M2 HEXAGON
WRENCH

APELIO 2510, VIPROS 2XX, PEGA 2XX AND ARIES

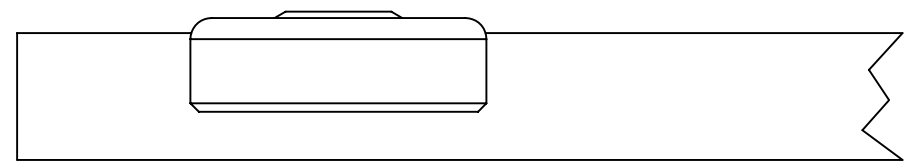
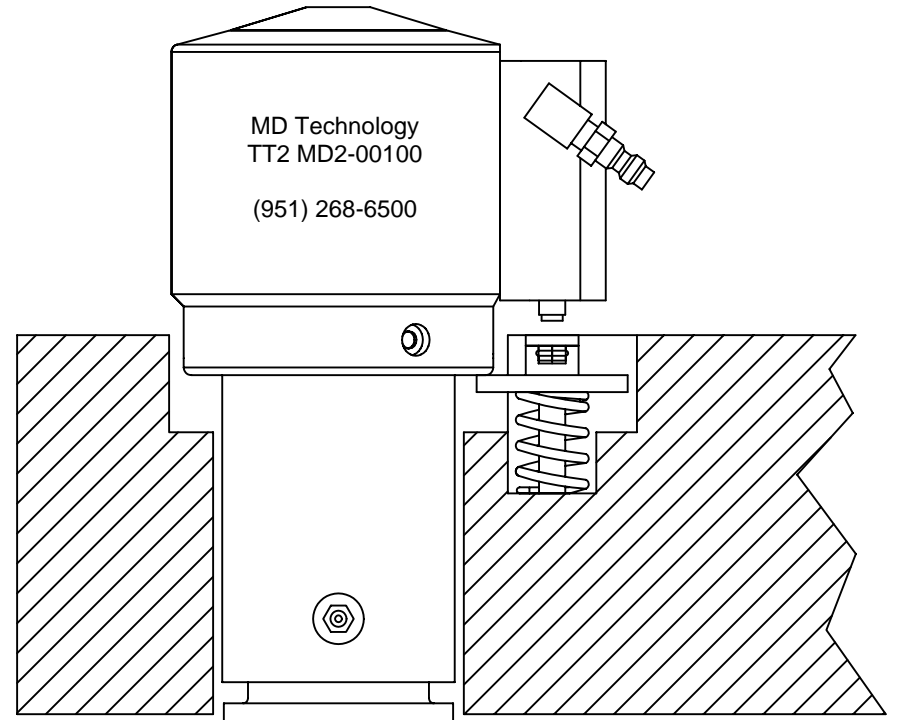
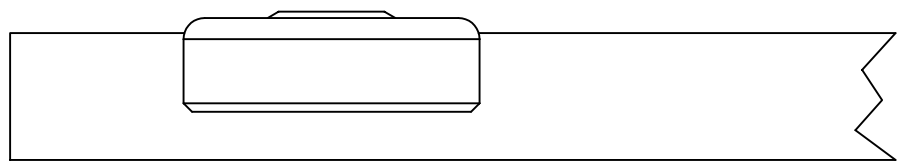
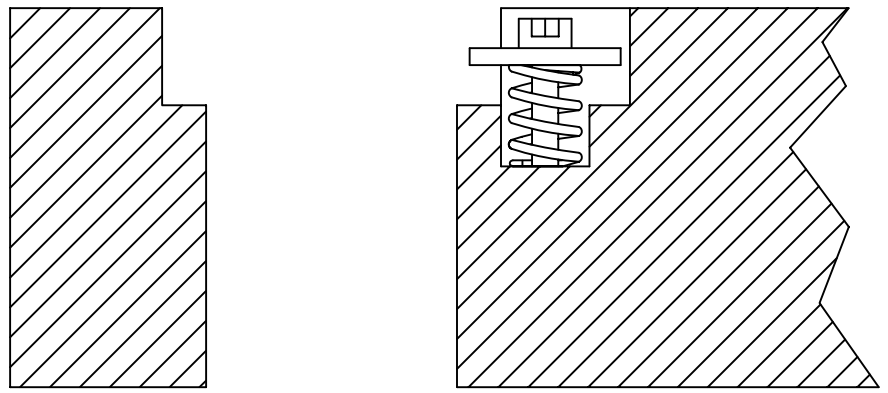
FIG#9



FIG#10

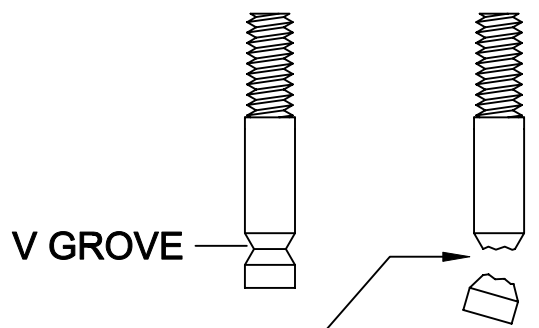
FOR VIPROS KING ONLY
WITH PRESSURIZED TANK SYSTEMS

INSERT CAP TO TOP OF LIFTER
BOLT. THIS WILL ALLOW THE ON
AND OFF BUTTON TO WORK.
D/K PART # 17-00198

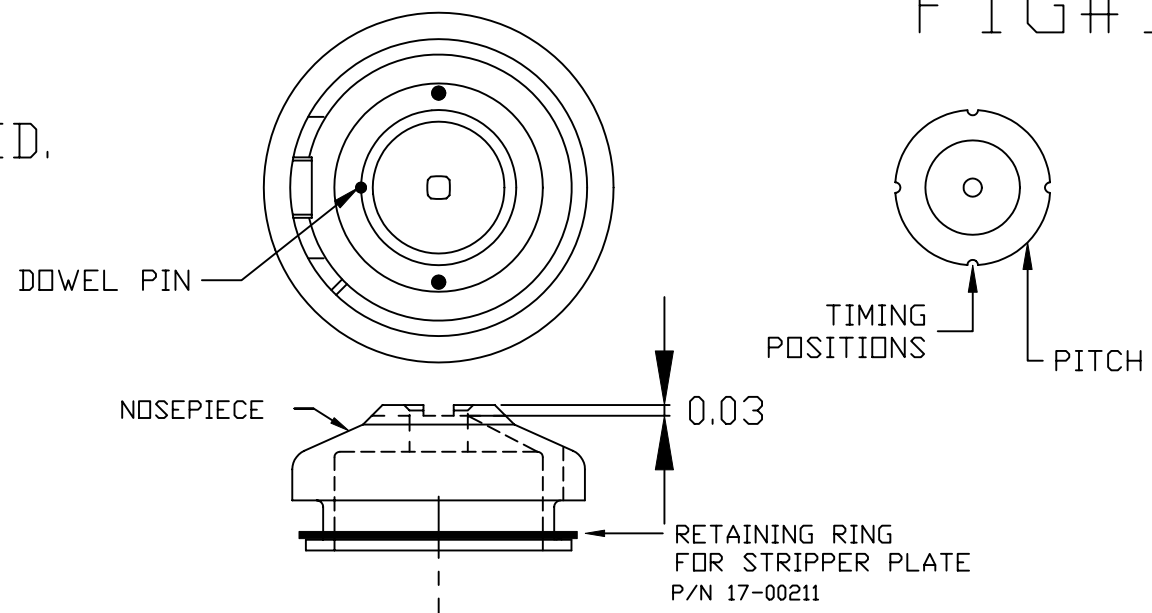


FIG#11

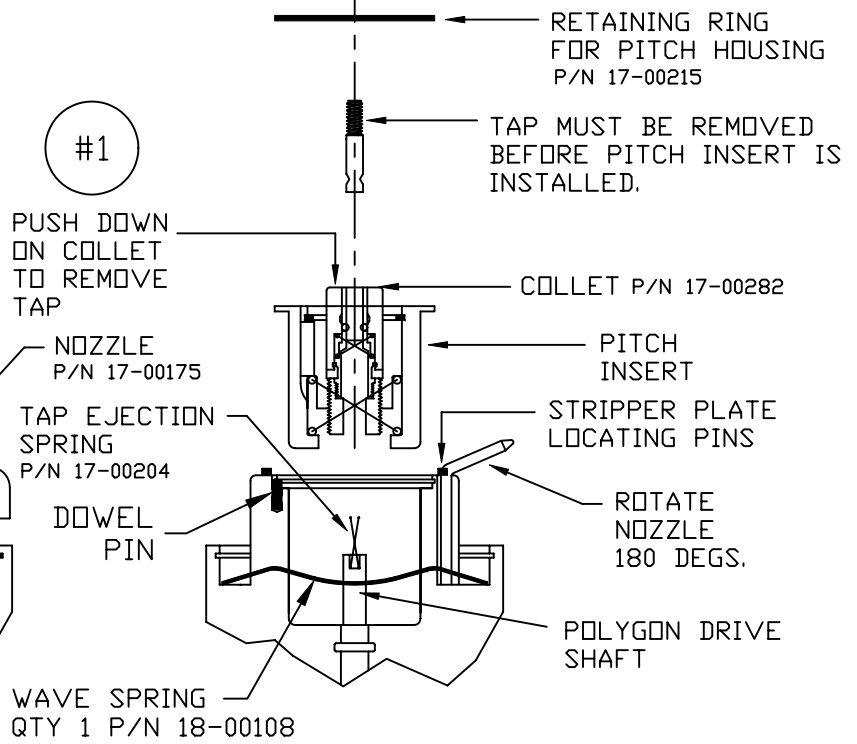
PITCH INSERT & TAP INSTALLED AND REMOVED.



IF TAP BREAKS AT V GROOVE, PITCH WILL NEED TO BE REMOVED. THIS WILL ALLOW THE REMOVAL OF THE BROKEN PART OF TAP THAT IS STILL IN PITCH. FAILURE TO DO SO COULD CAUSE DRIVE SHAFT TO MUSHROOM.



#1



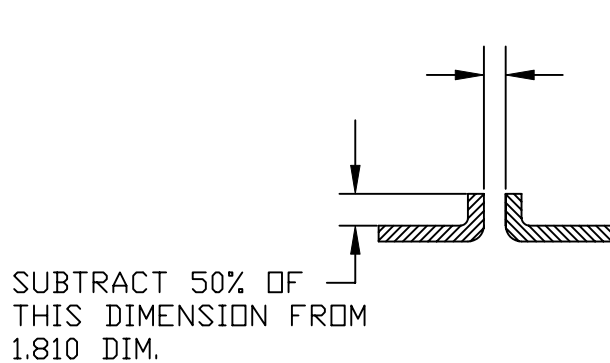
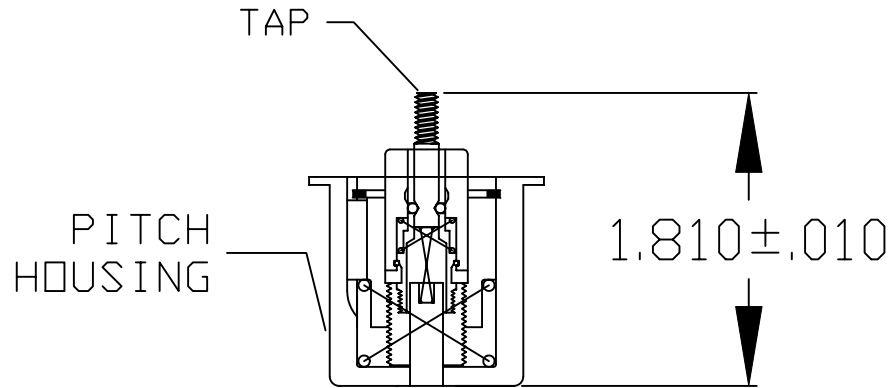
RETAINING RING FOR PITCH HOUSING IN PLACE P/N 17-00215

RETAINING RING FOR STRIPPER PLATE IN PLACE P/N 17-00211

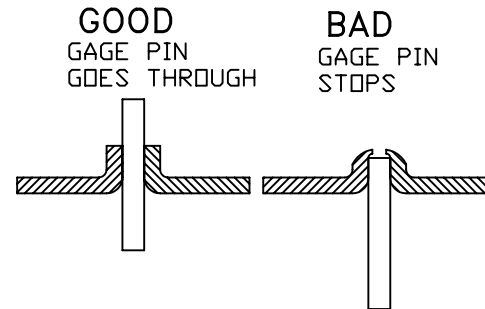
TAP HEIGHT ADJUSTMENT

TO ADJUST TAP HEIGHT,
ROTATE TAP WHILE
HOLDING PITCH HOUSING.

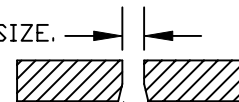
FIG#12



FOR EXTRUDED
HOLE SIZE USE
FLAT MATERIAL
PREHOLE, IF
MULTIPLE
PREHOLE
DIAMETERS ARE
LISTED USE 0-.08



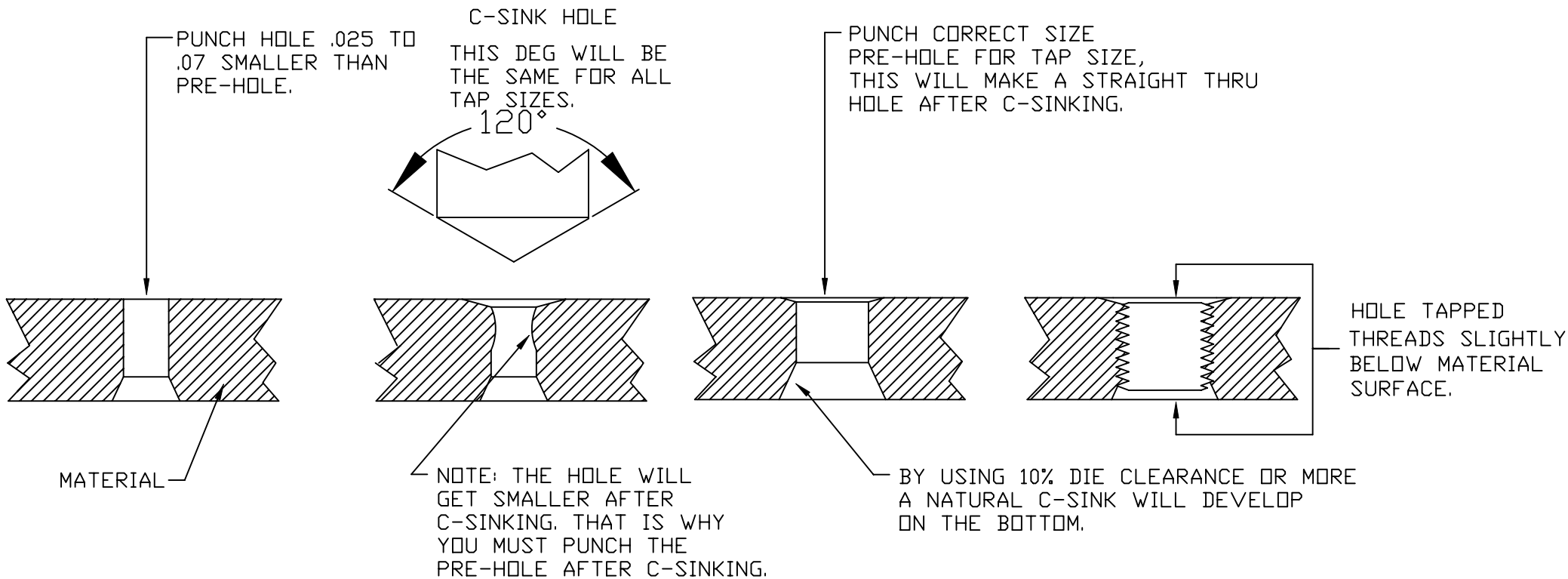
SEE PAGE #8
FOR THRU HOLE SIZE.



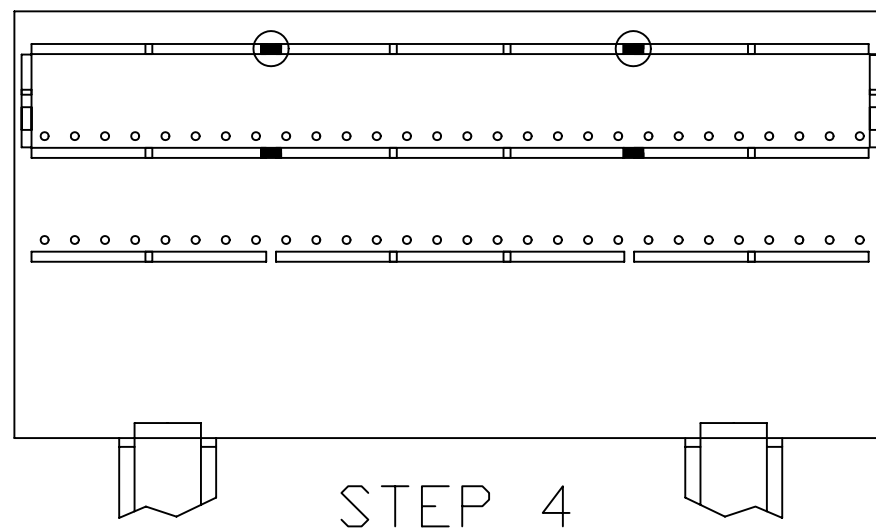
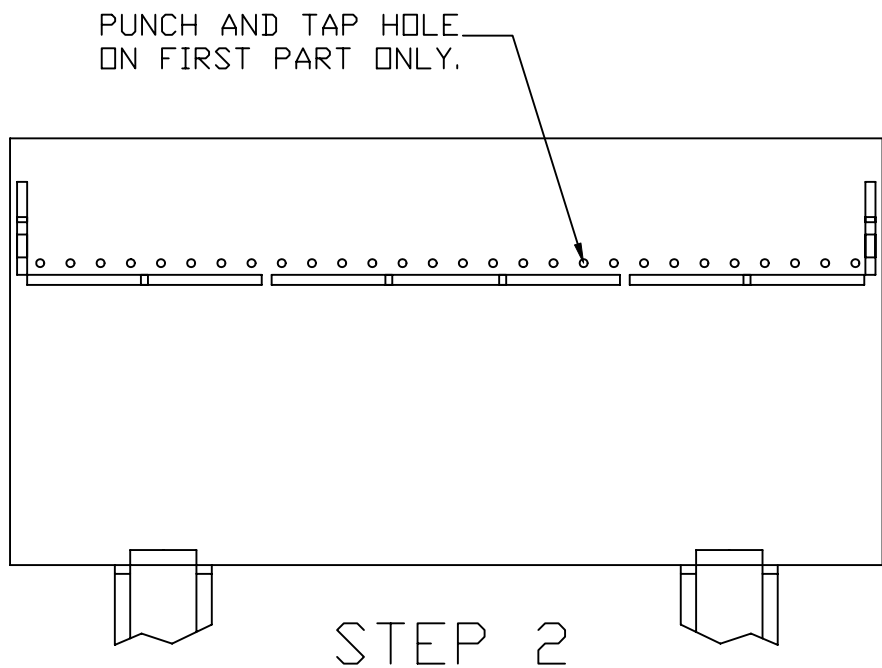
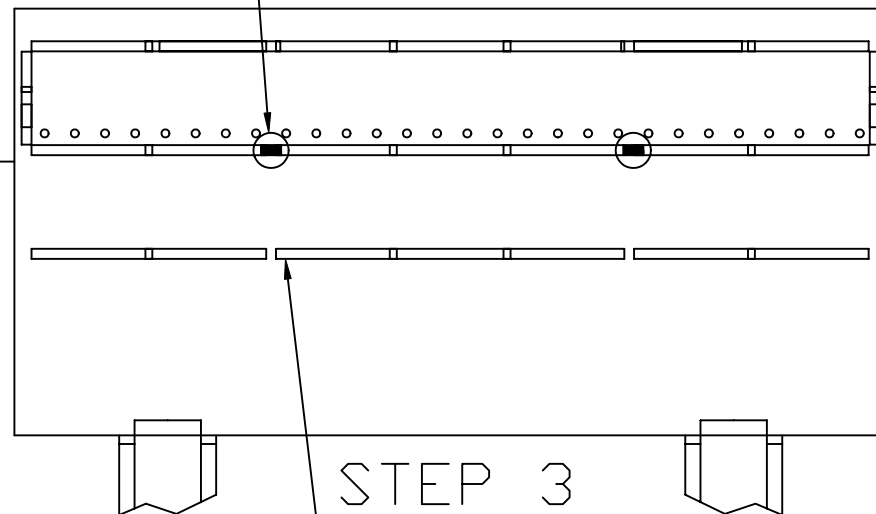
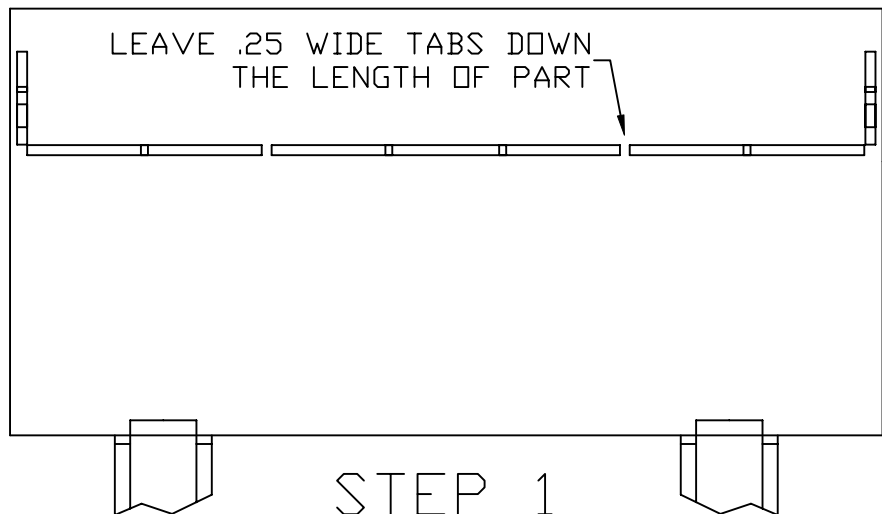
USE 10% DIE CLEARANCE OR MORE
FOR THRU HOLES WITH
OUT EXTRUDED HOLE.

FIG#13

USING A COUNTERSINK TO KEEP
THREADS FROM PROTRUDING
ABOVE THE MATERIAL.

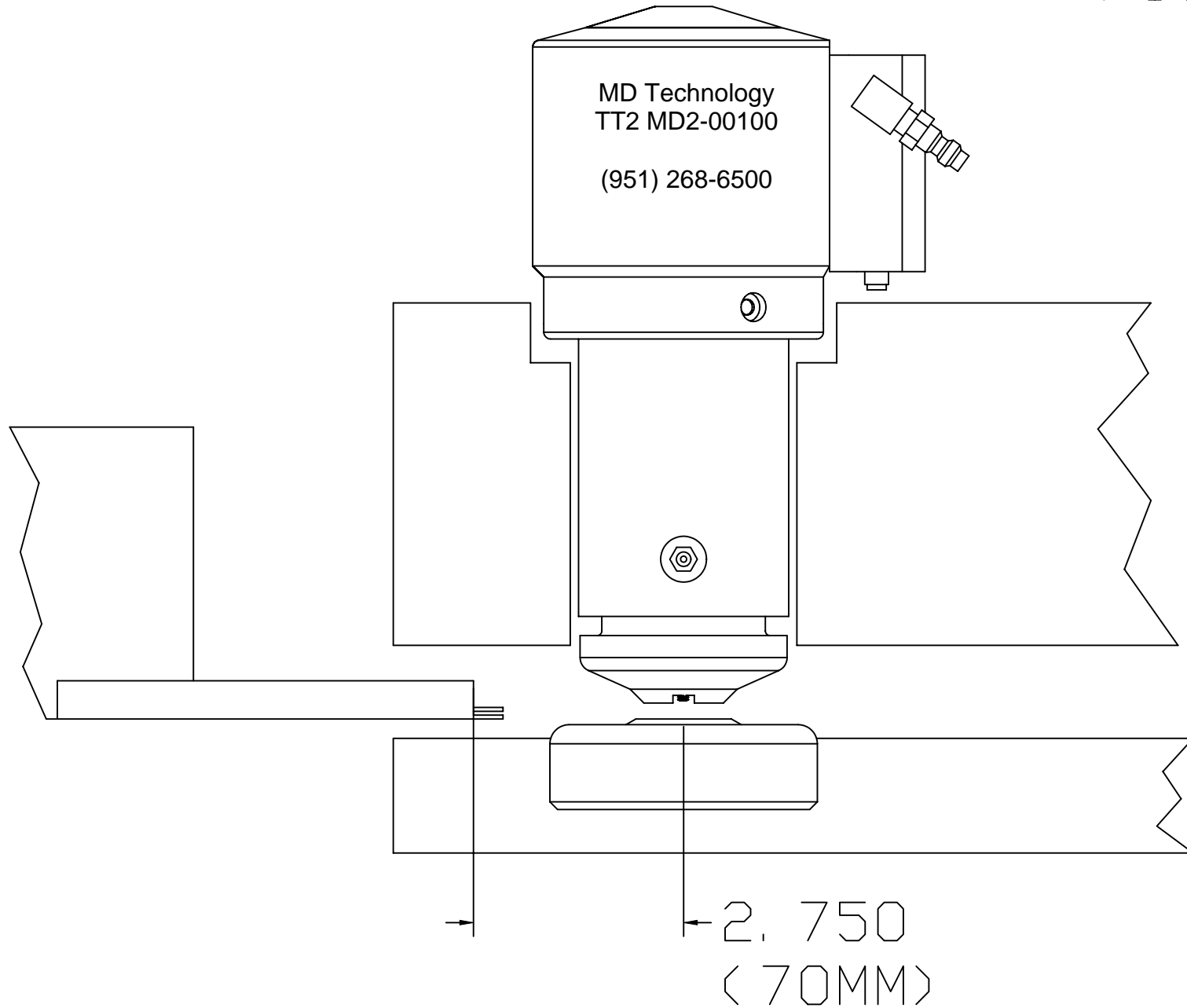


PUNCH OUT TABS WITH 1/2
OR 1 1/4 STATION TOOL



CLAMP SAFETY ZONE

FIG#15



FIG#16

LUBRICATION POINTS

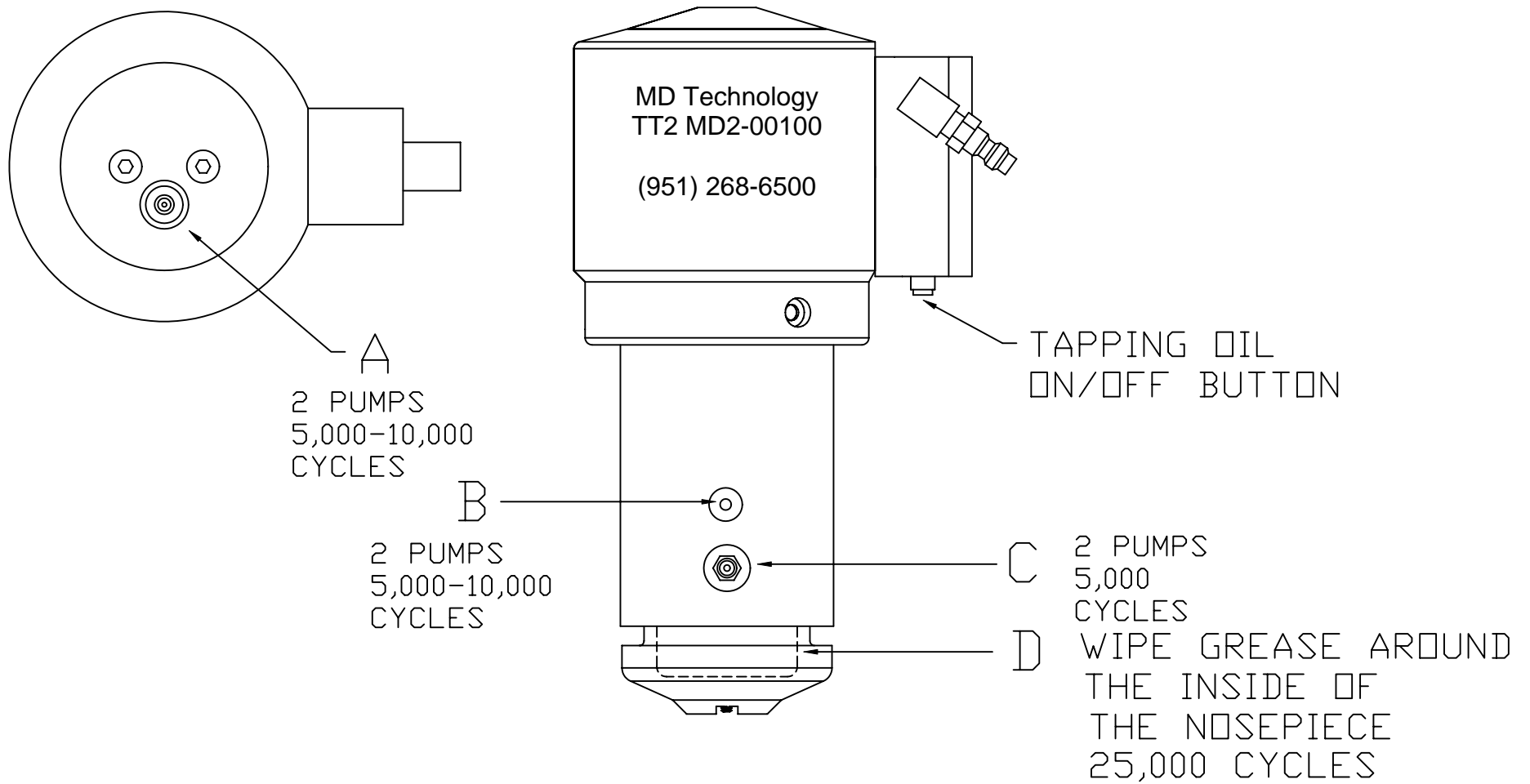


FIG #17

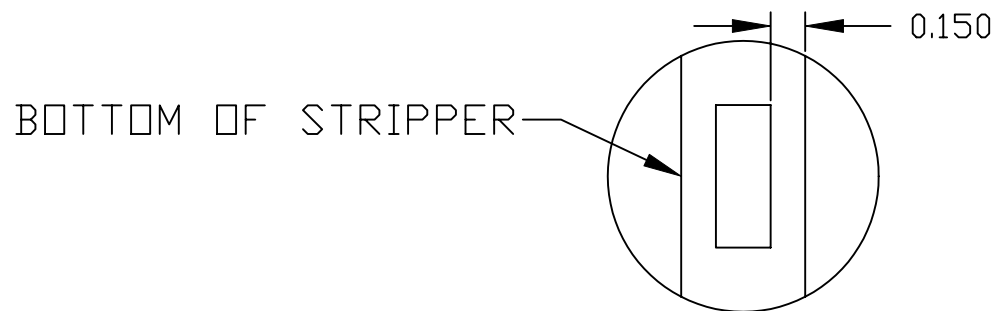
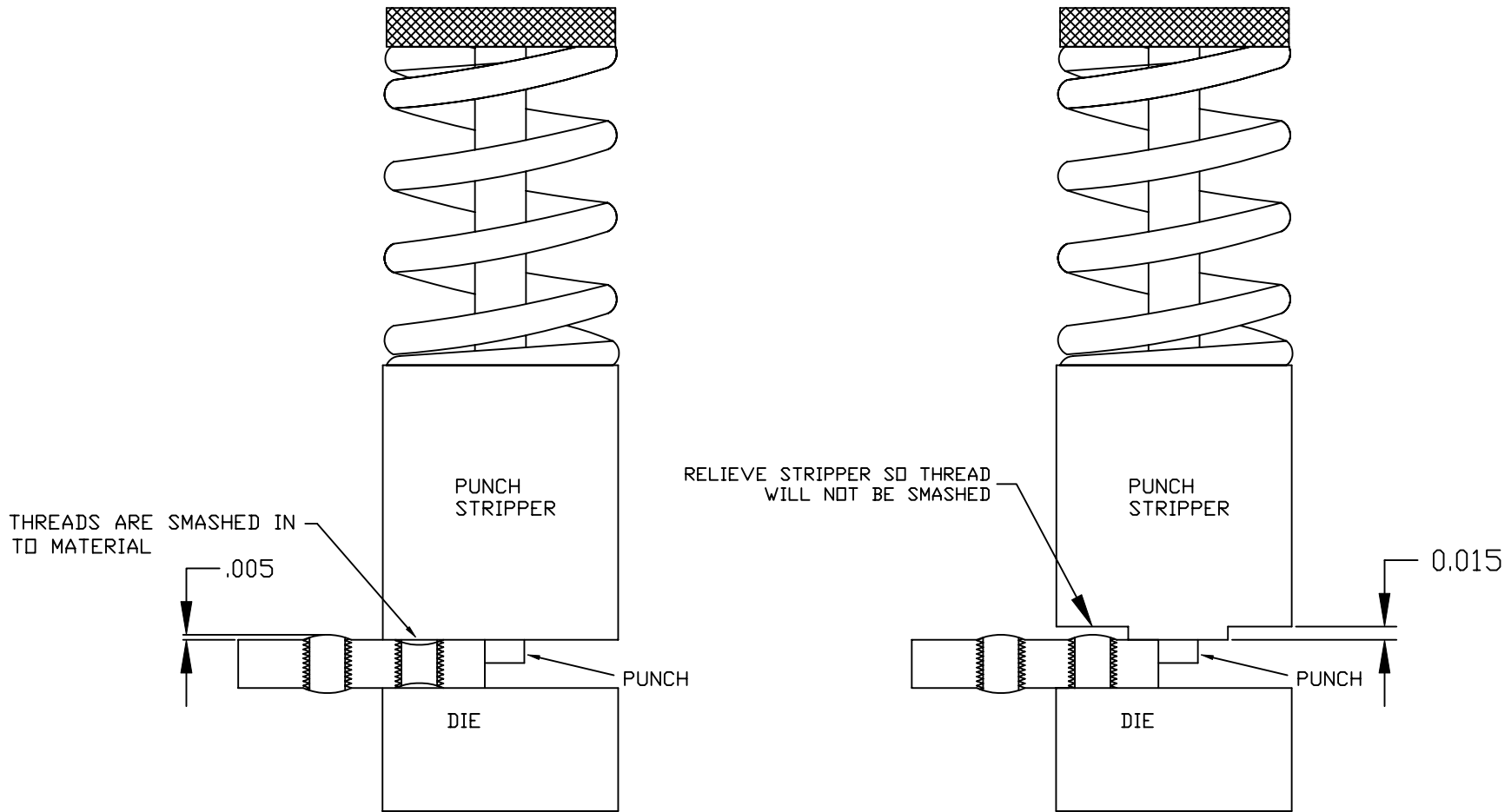
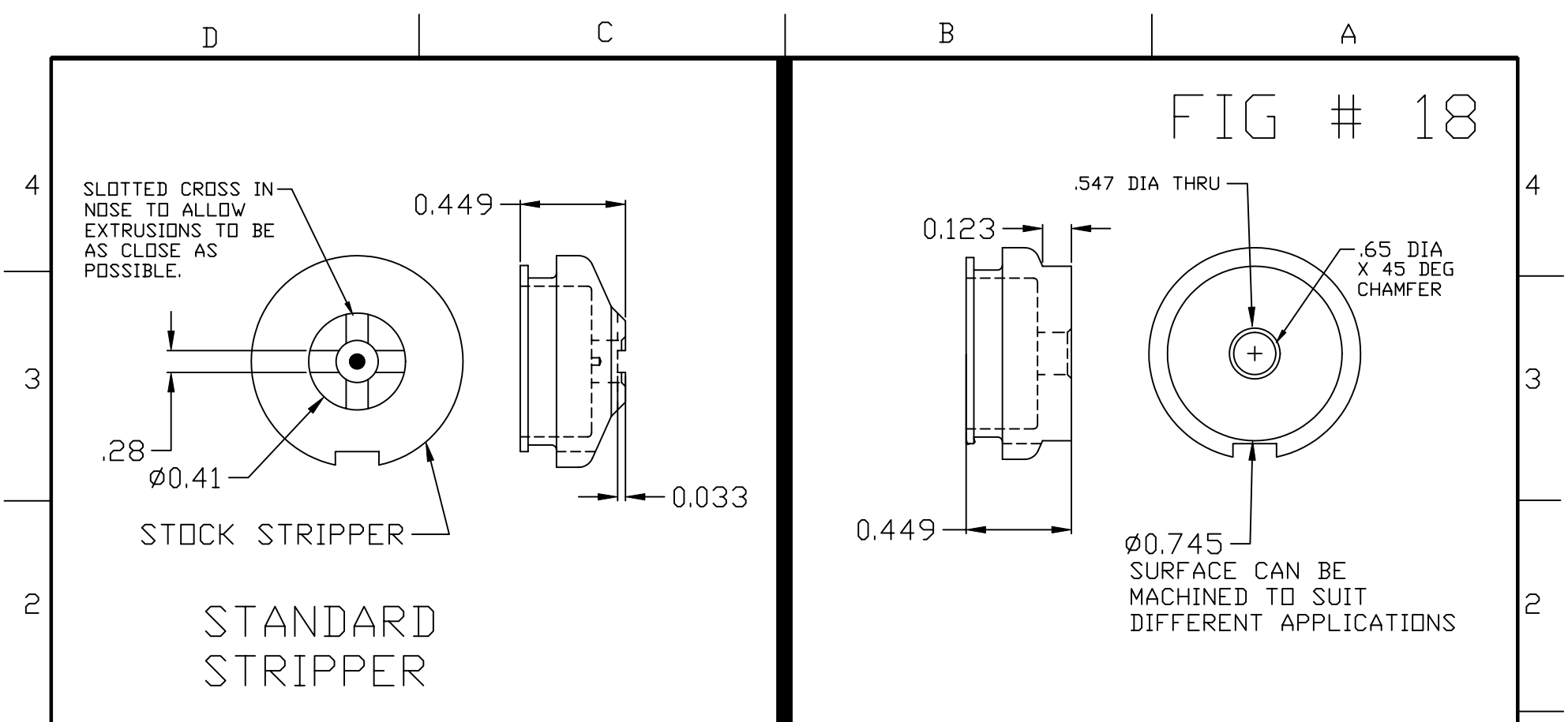


FIG # 18



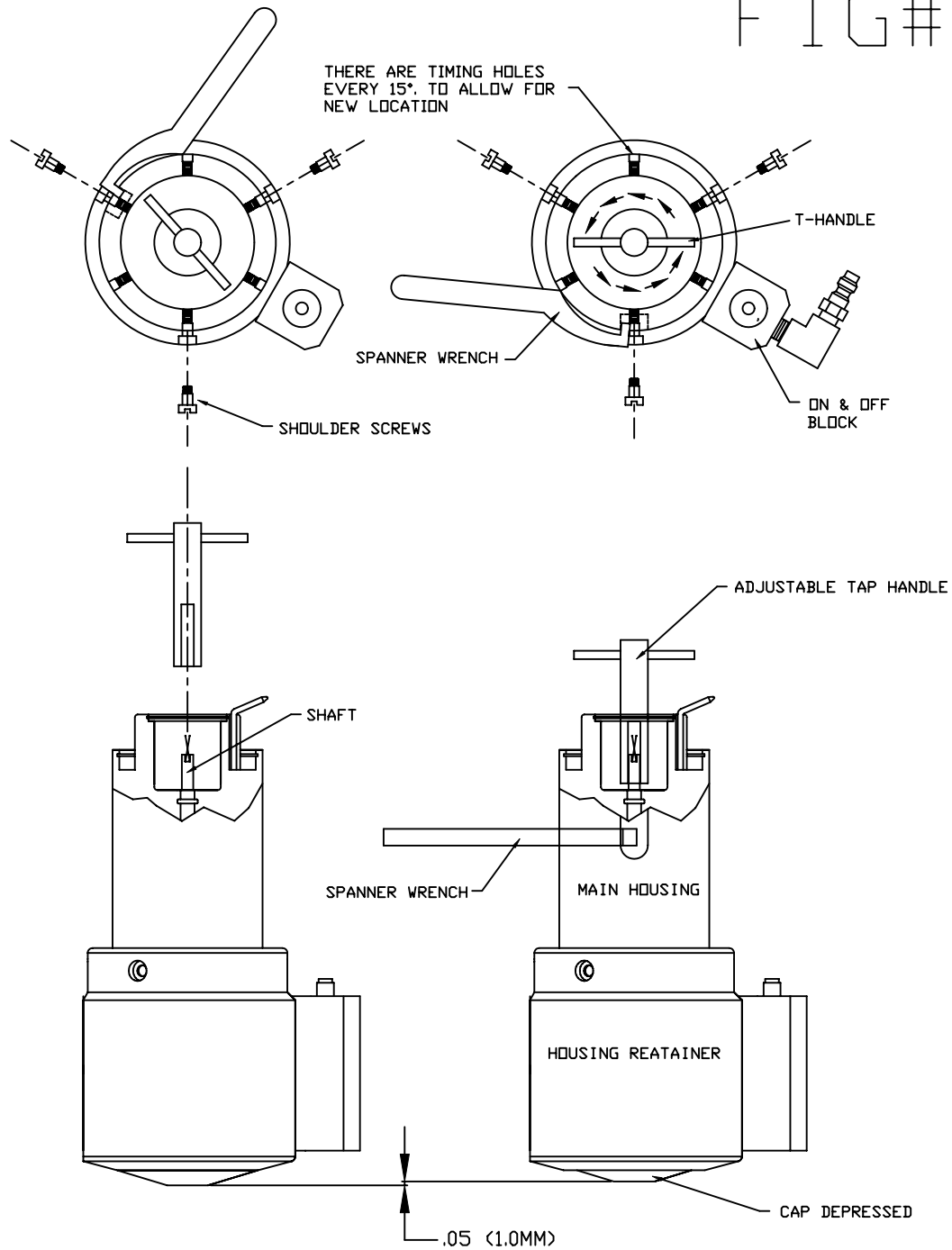
STANDARD STRIPPER

- 2) HEAT TREAT TO 56-60 ROCKWELL
 - 1) MATERIAL A-2 TOOL STEEL
- NOTES: UNLESS OTHERWISE SPECIFIED.

DIMENSIONS ARE IN INCHES TOLERANCES UNLESS OTHERWISE SPECIFIED XXX ± .005 XXXX ± .002 ANGLES: ± 0.5° ALL MACHINED SURFACES ✓	MD Technology TT2 MD2-00100 (951) 268-6500		CUSTOMER: NCT3	
	DR CHK ENGR		TITLE: UNFINISH STRIPPER PLATE P/N 17-00177	
	DO NOT SCALE DRAWING WORK TO DIMENSIONS SHOWN		SIZE B	CODE IDENT NO. 0201105
		SCALE: 3=1		REV SHEET OF

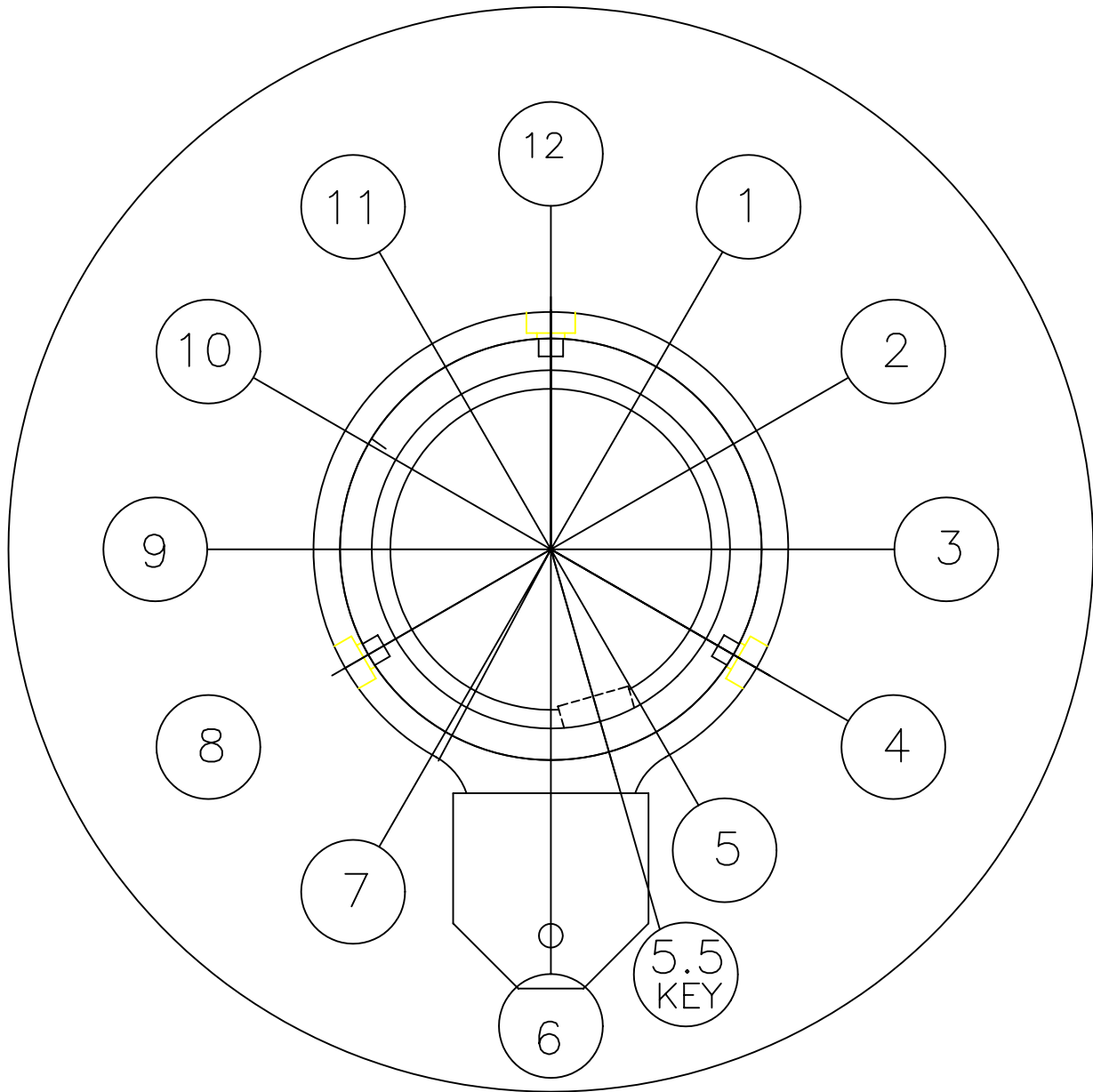
HOW TO ROTATE THE ON AND OFF BLOCK FOR A PEGA 2XX, ARIS OR ARCADE.

FIG#19

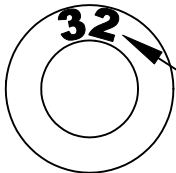


TOOL UPSIDE DOWN
AMADA 2510 APELIO, VIPROS 2XX
WITH NEW PUMP BLOCK

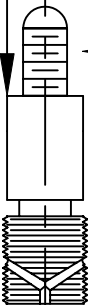
FIG# 19A



FIG#20



PITCH SIZE
ETCHED ON TOP.



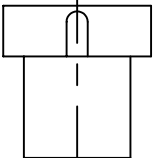
TAP

TAP ASSEMBLY (99)

MALE PITCH



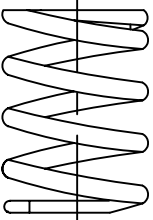
RETAINING RING (89)



FEMALE PITCH

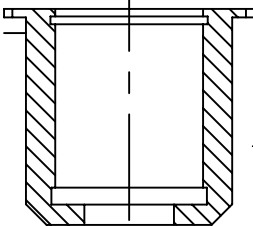


KEY (87)



NO HOLE SPRING (97)
WIRE DIA

33 IN/LB	.080	P/N 18-00100
55 IN/LB	.090	P/N 18-00111
110 IN/LB	.100	P/N 18-00110
143 IN/LB	.107	P/N 18-00155

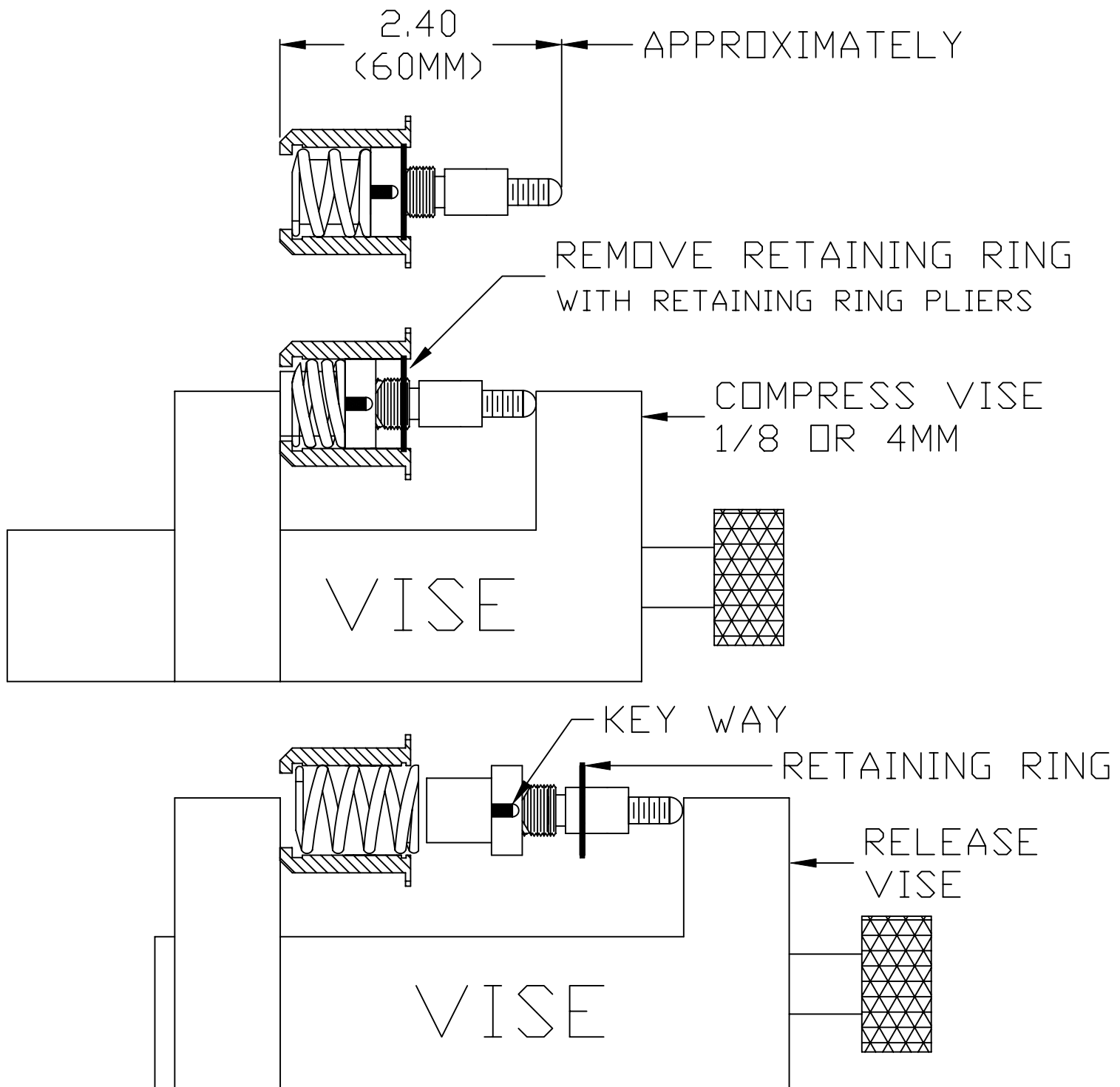


PITCH HOUSING (96)

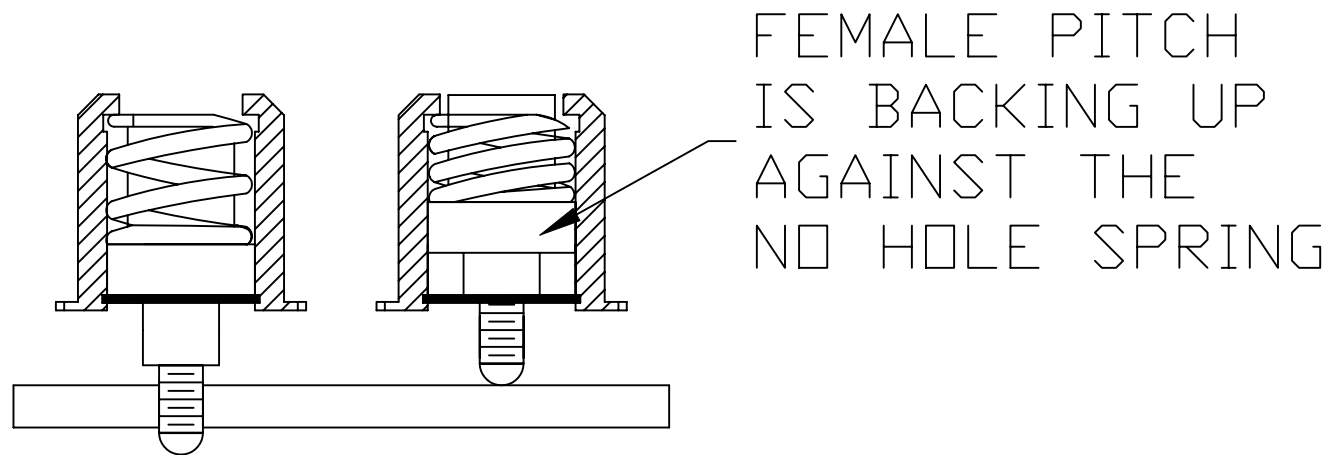
(SEE PAGE 27-29 FOR
ITEM PART NUMBER)

CHANGING NO HOLE SPRING

FIG#20A



NO HOLE PROTECTION

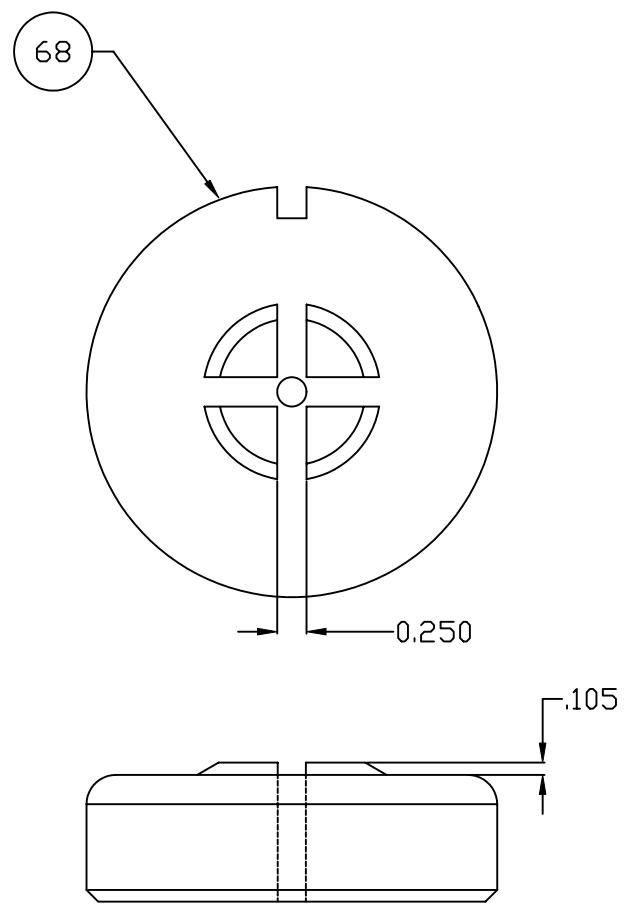
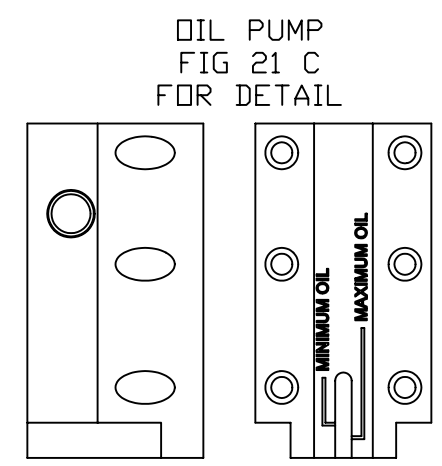
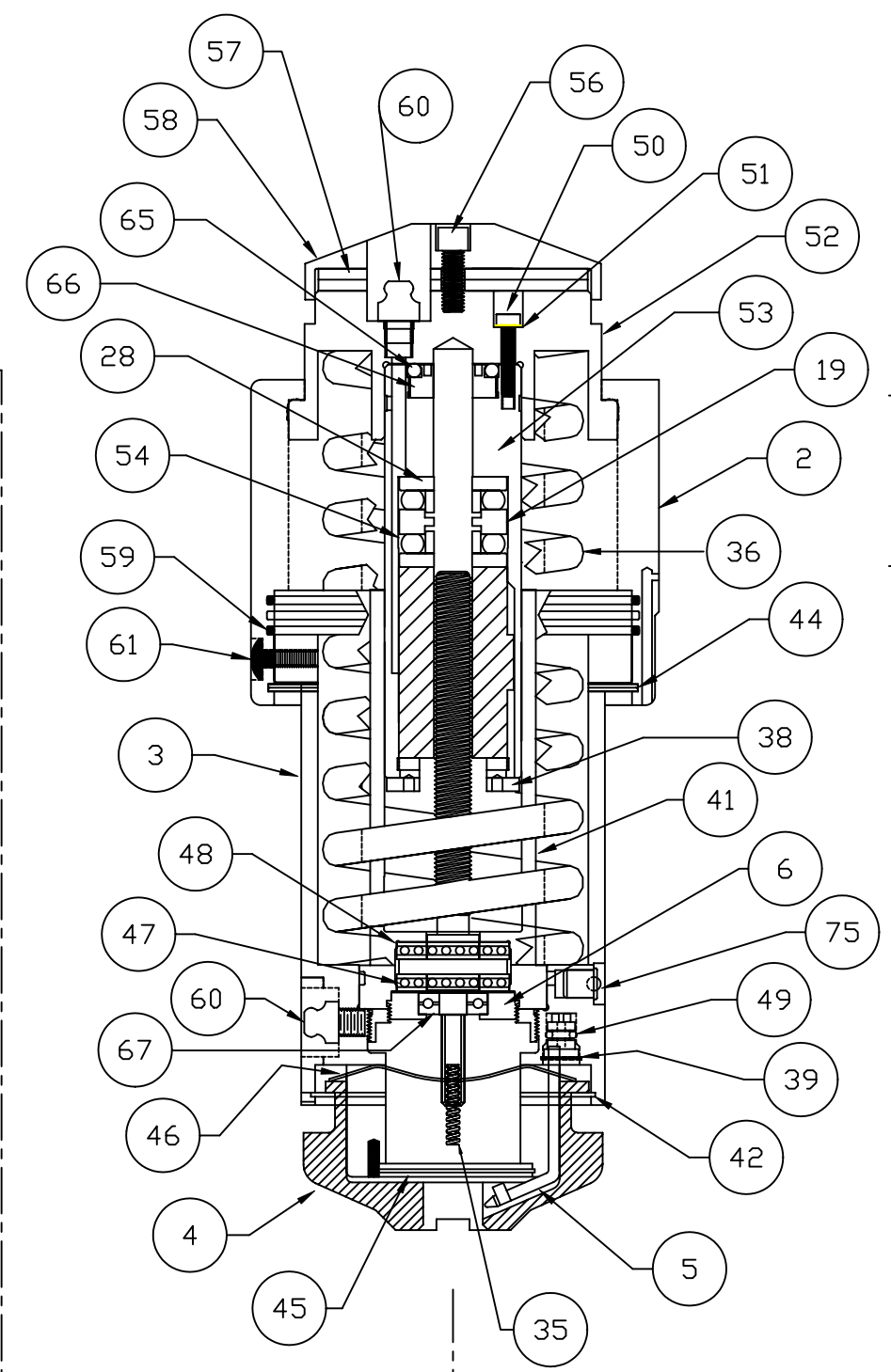
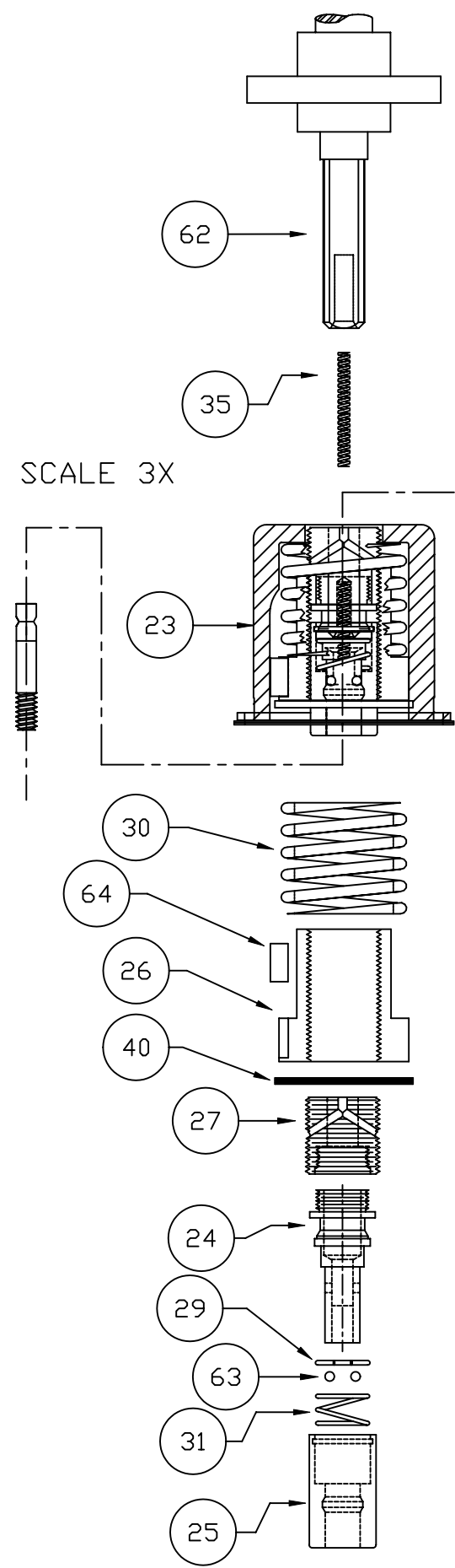


TAP THRU
THE HOLE
PRE-HOLE
IS PRESENT

NO PRE-HOLE
CONDITION

REVISIONS		
LTR	DESCRIPTION	DATE

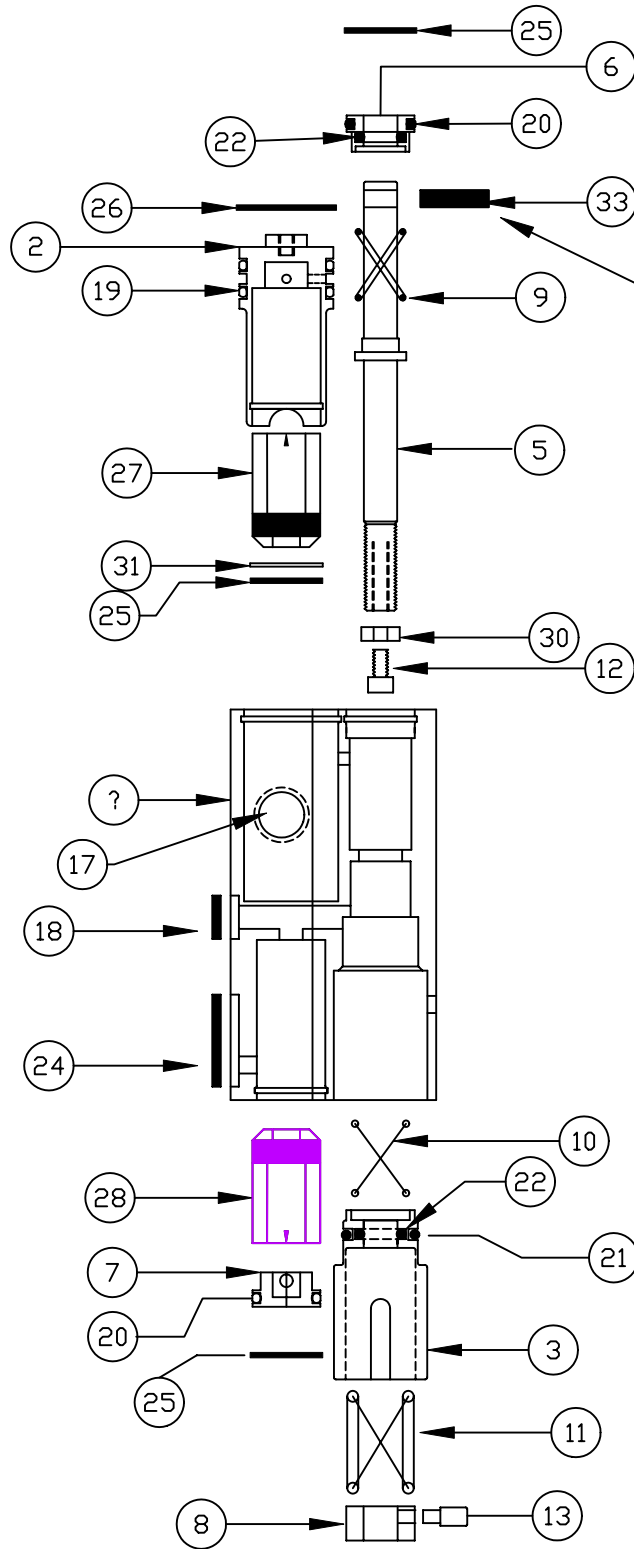
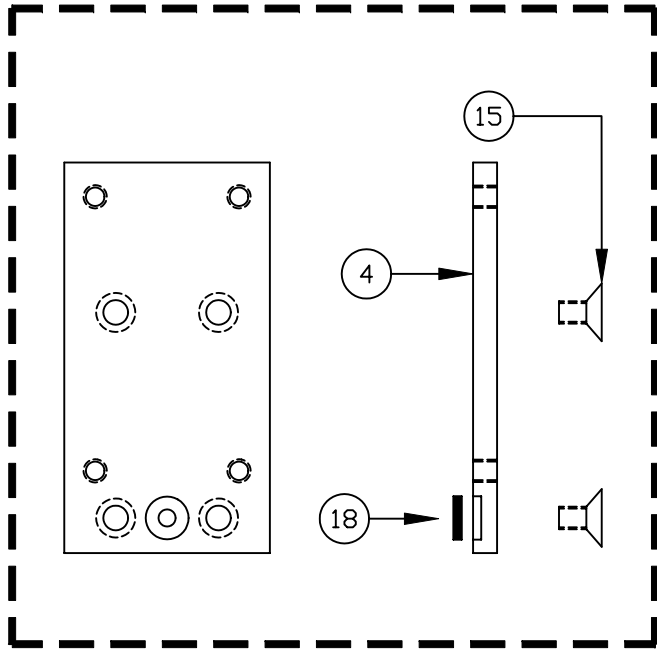
FIG# 21 A



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or disclosed in whole or in part to any
one without the permission of D/K TECH

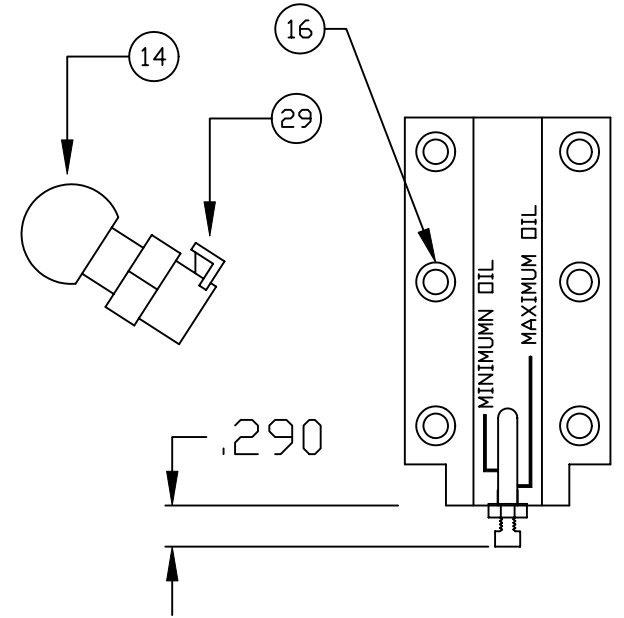
QTY	PART NO.	DESCRIPTION	ITEM
PARTS LIST			
DIMENSIONS ARE IN INCHES TOLERANCES UNLESS OTHERWISE SPECIFIED: XX ± .010 XXX ± .005 XXXX ± .002 ANGLES: ± 0.5°		MD Technology TT2 MD2-00100 (951) 268-6500	TITLE: <h1 style="margin: 0;">NCT3 ASSY</h1>
#	N/A	DR	
QTY	NEXT ASSY.	CHK	
		REL.	
ALL MACHINED SURFACES # ✓		DO NOT SCALE DRAWING WORK TO DIMENSIONS SHOWN	SIZE D CODE IDENT NO. 0202026 DWG. NO. 0202026 REV # SCALE: FULL SHEET # OF #

ADAPTER PLATE
FOR RETAINERS
WITH 4 HOLES

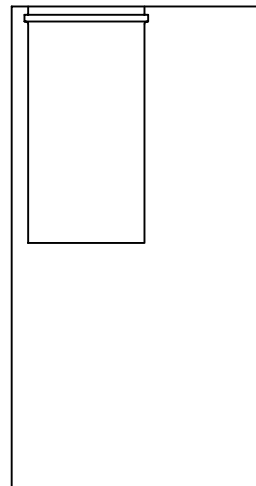
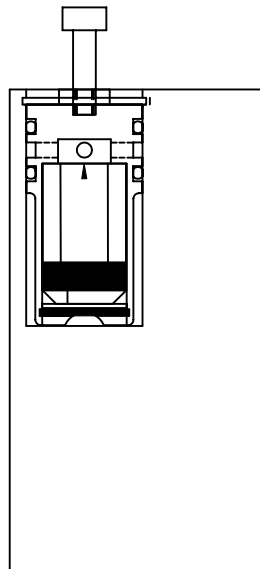
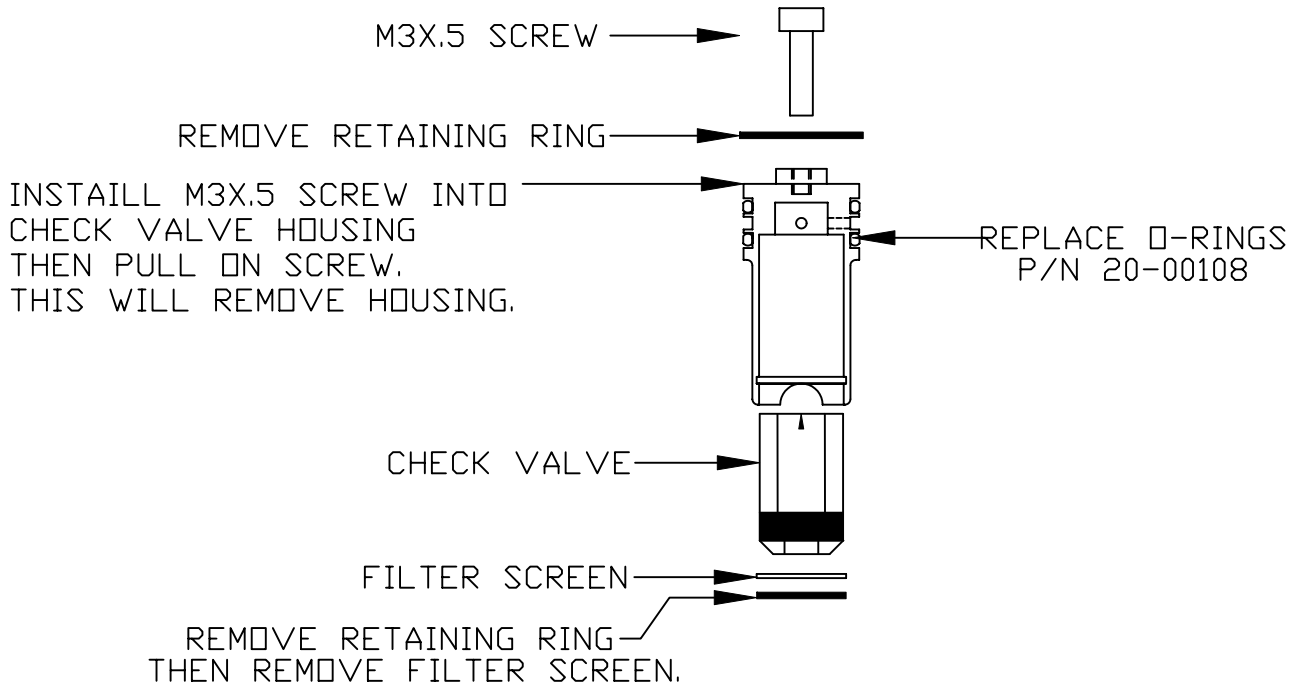


FIG#21C

SECOND GENERATION
ADJUST OIL FROM TOP
OF OIL PUMP.



FIG#21D



D

C

B

A

4

4

3

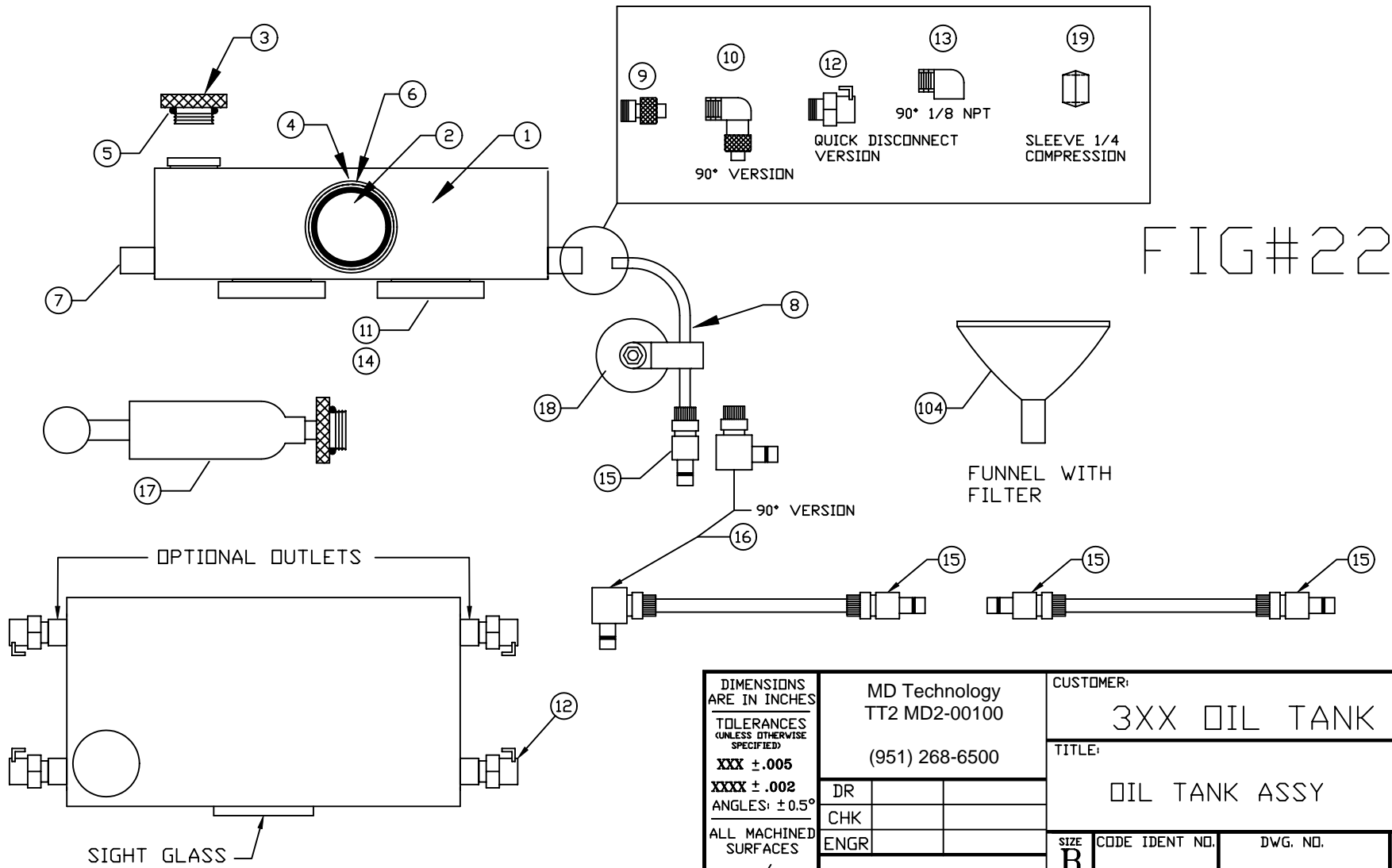
3

2

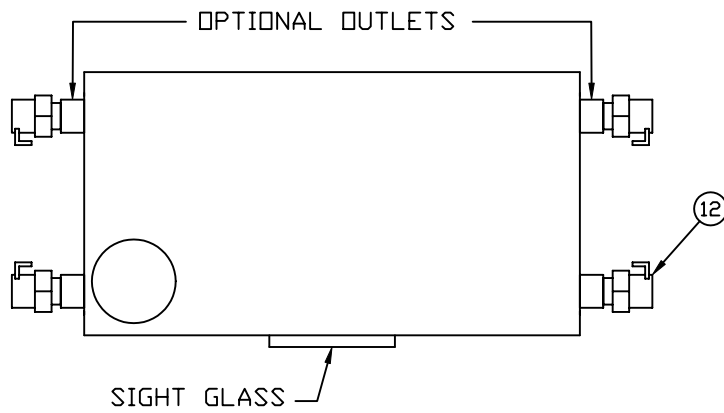
2

1

1



FIG#22



DIMENSIONS ARE IN INCHES TOLERANCES (UNLESS OTHERWISE SPECIFIED) XXX ± .005 XXXX ± .002 ANGLES: ± 0.5° ALL MACHINED SURFACES ✓	MD Technology TT2 MD2-00100 (951) 268-6500		CUSTOMER: 3XX OIL TANK		
	DR CHK ENGR		TITLE: OIL TANK ASSY		
	DO NOT SCALE DRAWING WORK TO DIMENSIONS SHOWN		SIZE B	CODE IDENT NO.	DWG. NO.
			SCALE: 3=1		SHEET OF

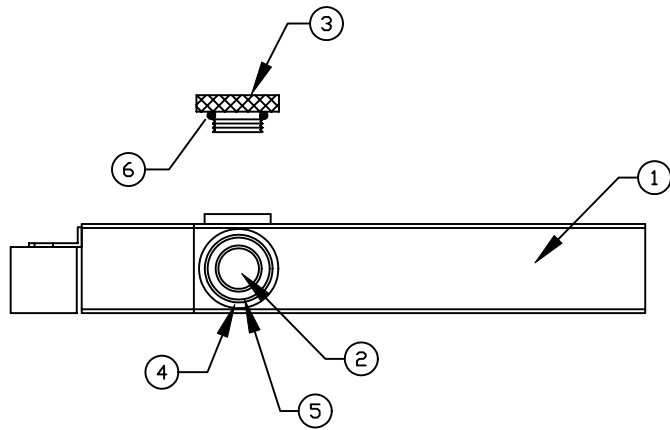
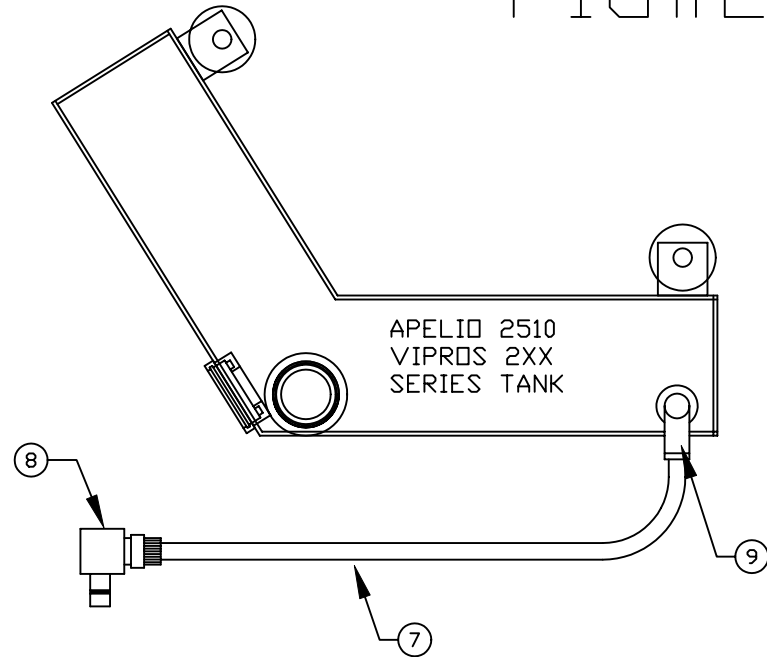
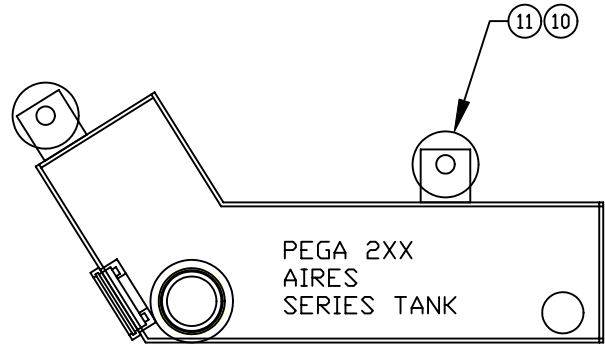
D

C

B

A

FIG#22A



DIMENSIONS ARE IN INCHES TOLERANCES (UNLESS OTHERWISE SPECIFIED) XXX ± .005 XXXX ± .002 ANGLES: ± 0.5° ALL MACHINED SURFACES ✓	MD Technology TT2 MD2-00100 (951) 268-6500		CUSTOMER: 2XX OIL TANK		
	DR CHK ENGR		TITLE: OIL TANK ASSY		
	DO NOT SCALE DRAWING WORK TO DIMENSIONS SHOWN		SIZE B	CODE IDENT NO.	DWG. NO.
			SCALE: 3=1		SHEET OF

D

C

B

A

D

C

B

A

4

4

3

3

2

2

1

1

RELOCATE ON&OFF PUMP FOR AMADA

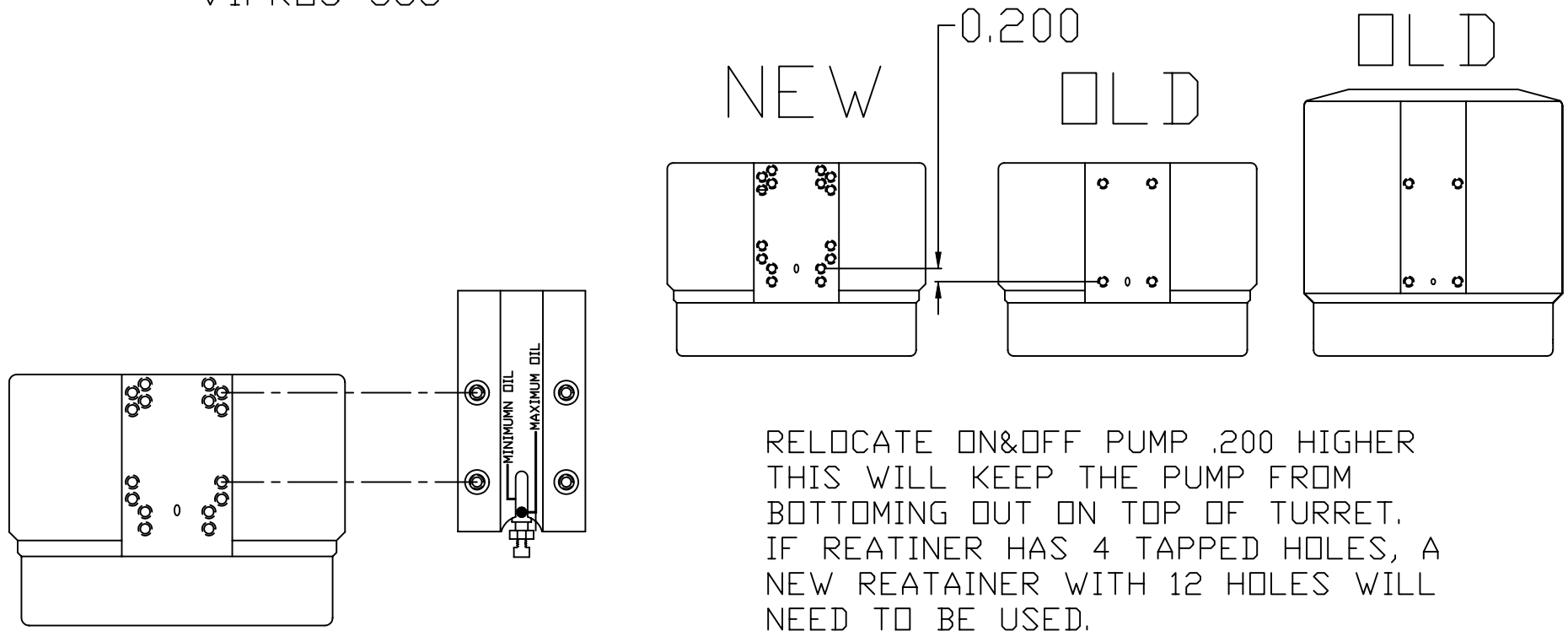
EM2510, EMK3610, EMLK3610

VIPROS 3510NT, 3510NTZ

VIPROS 3610NT, 3610NTZ

VIPROS 568

FIG#23



EM2510, EMK3610, EMLK3610

VIPROS 3510NT, 3510NTZ

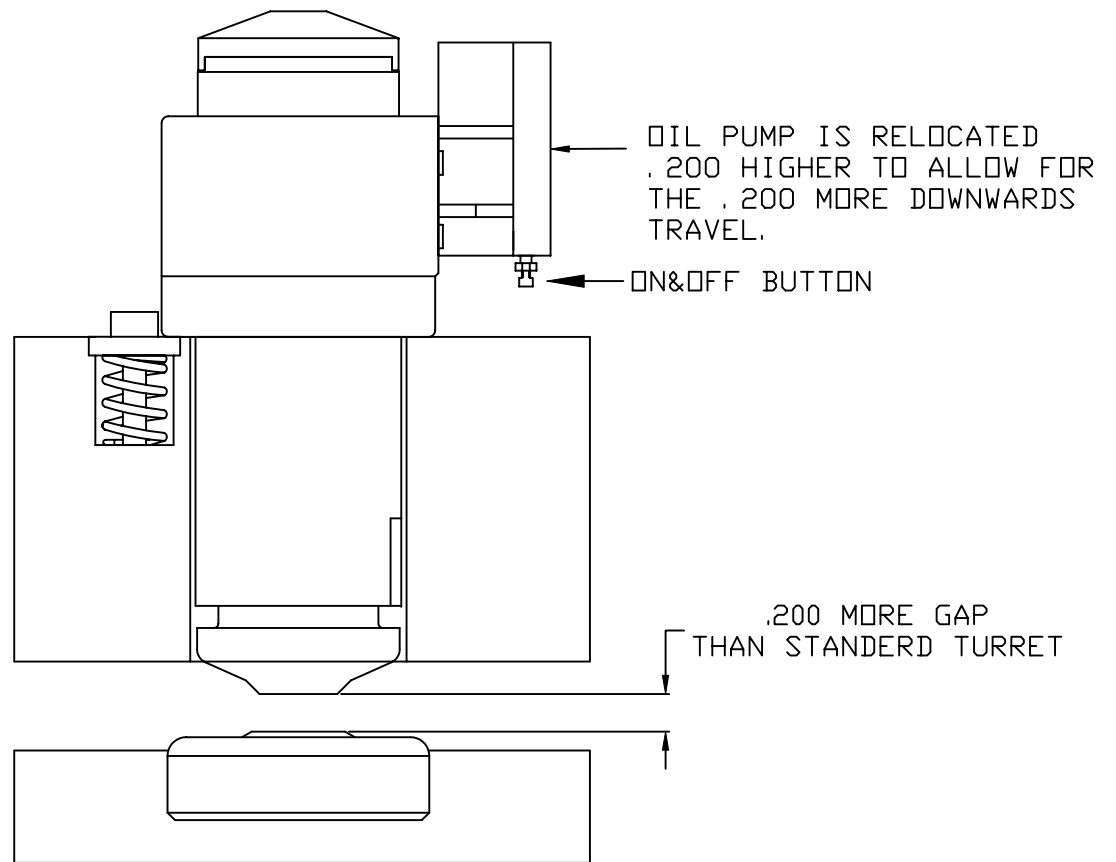
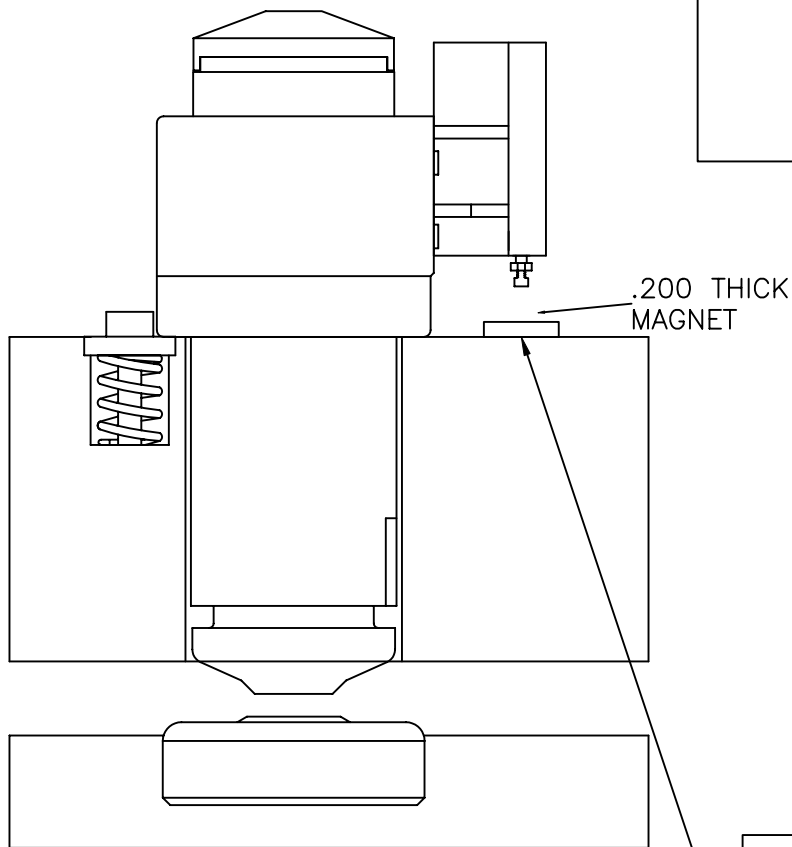
VIPROS 3610NT, 3610NTZ

VIPROS 568

MACHINE WITH **.200
WIDER GAP BETWEEN
UPPER AND LOWER TURRET.
NOTE: DO NOT USE MAGNET
ON THIS TYPE OF MACHINE

FIG#24

STANDARD TURRET



USE A THIN PIECE OF PLASTIC OR
CARDBOARD UNDER THE MAGNET WHEN PLACING
THE MAGNET ON THE TURRET THEN SLIDE THE
PLASTIC OR CARDBOARD OUT.

OPTIONAL ACCESSORIES
KIT P/N 11-00075

FIG#25

PITCH INSERT HOLDER
P/N 21-00138



SPRING POLYFON
QTY 5 P/N 18-00106



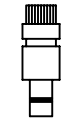
GEL GLUE
QTY 1 P/N 17-00450



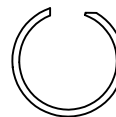
FEMALE QUICK DISCONNECT
QTY 2 P/N 21-00124



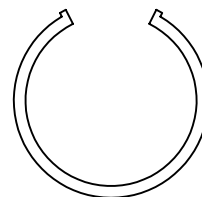
90° MALE QUICK DISCONNECT
QTY 1 21-00135



MALE QUICK DISCONNECT
QTY 1 P/N 21-00125



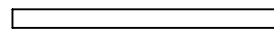
RETAINING RING FOR PITCH INSERT
QTY 1 19-00108



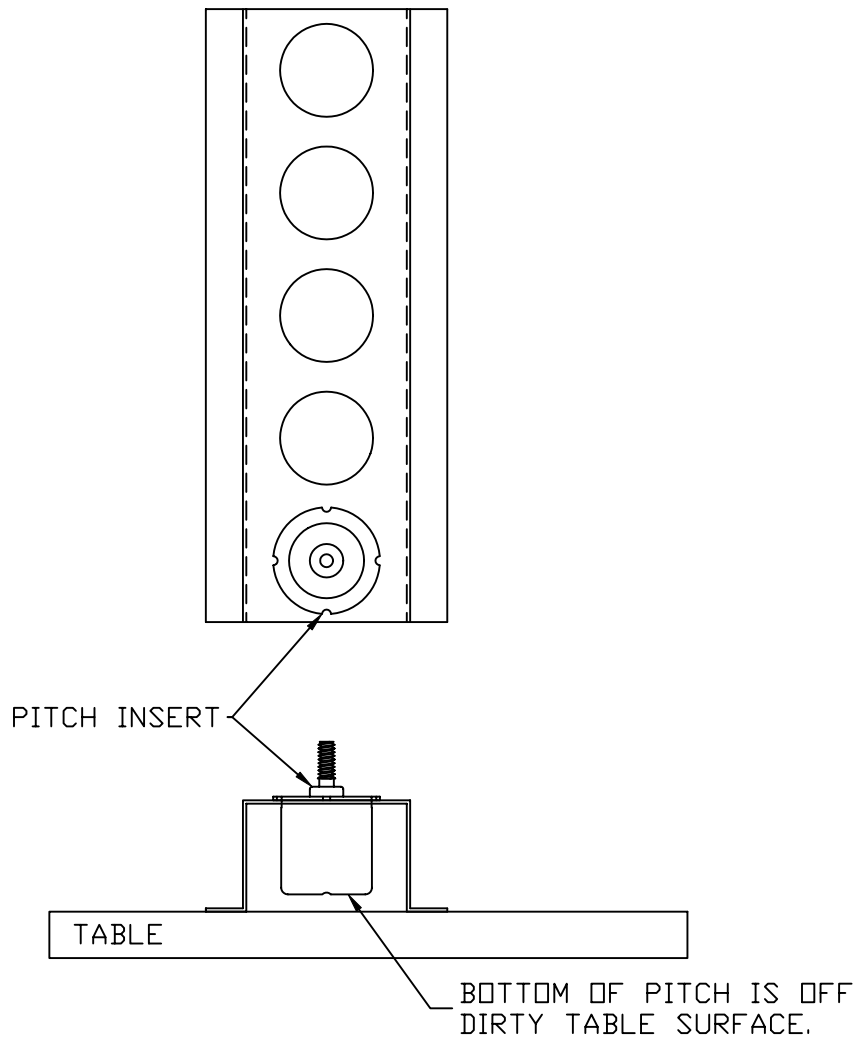
RETAINING RING FOR STRIPPER
QTY 1 P/N 19-00104



WAVE SPRING
QTY 1 P/N 18-00108



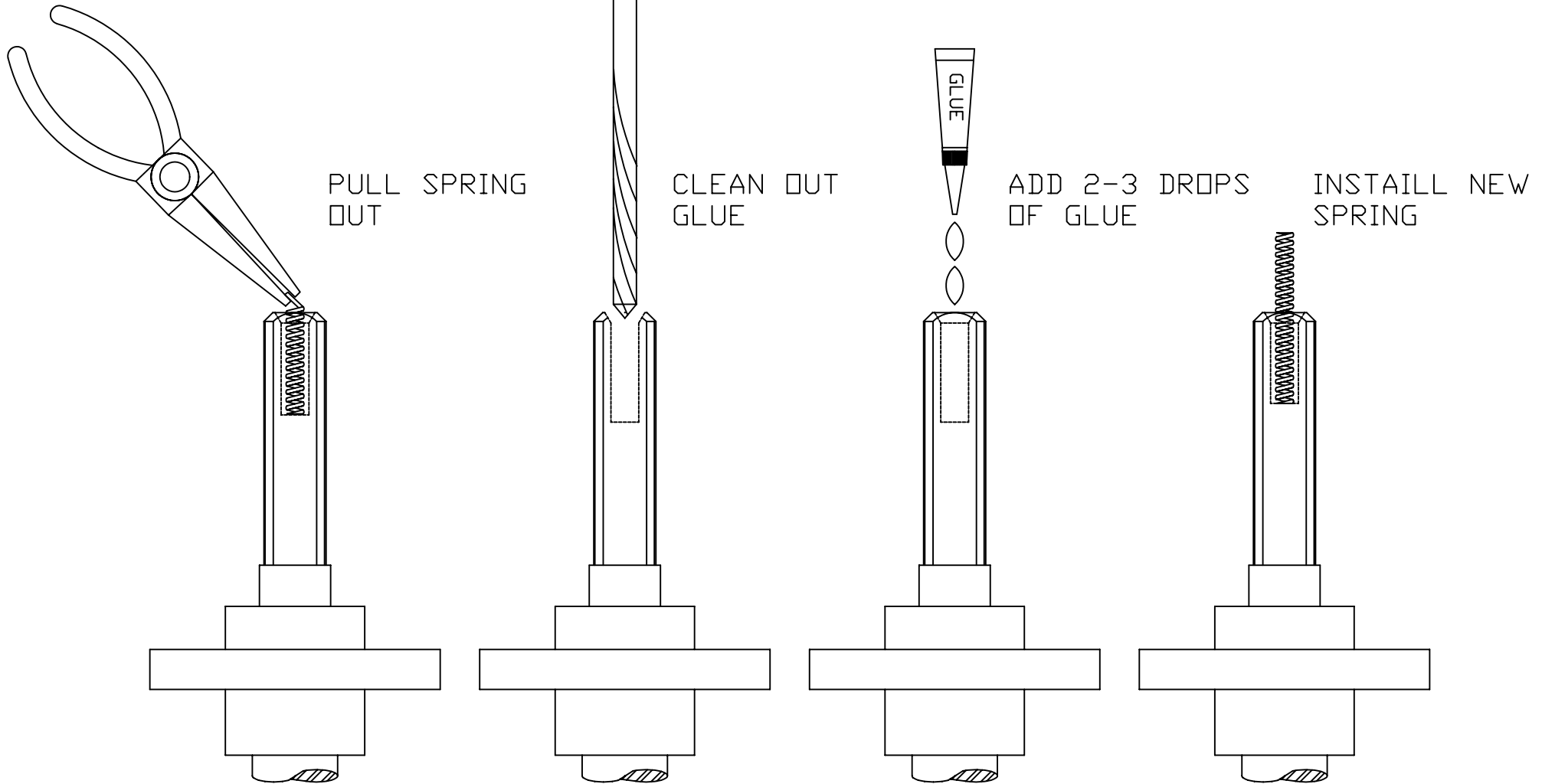
1/4 POLY HOSE
QTY 3 FEET 21-00128



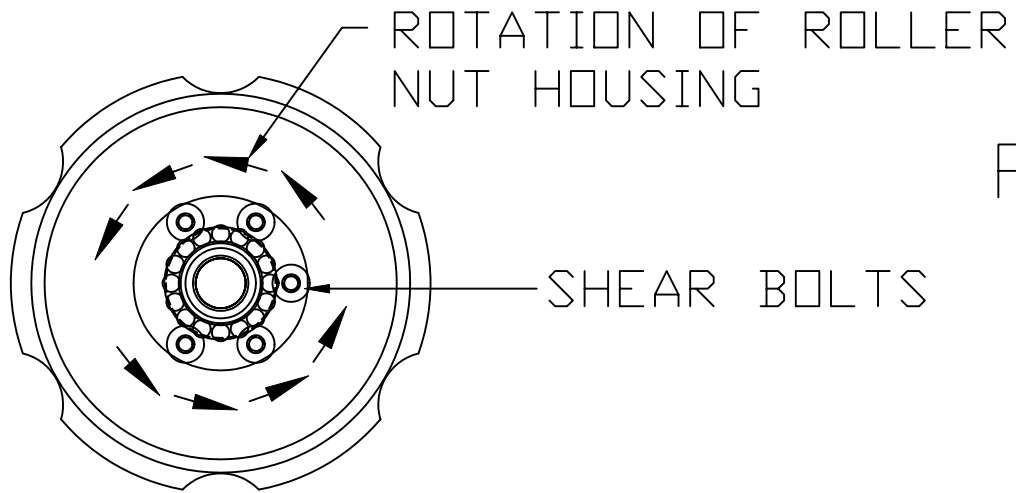
REPLACING TAP EJECTOR SPRING

FIG#26

SPRING REPAIR KIT
P/N 18-00106 5 SPRING
P/N 17-00450 GEL GLUE



OVERLOAD PROTECTION



FIG#27

