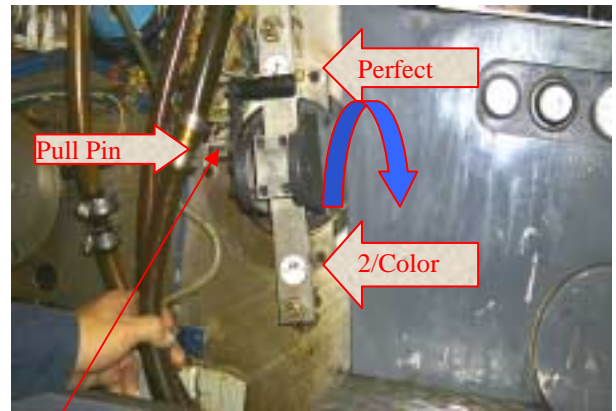
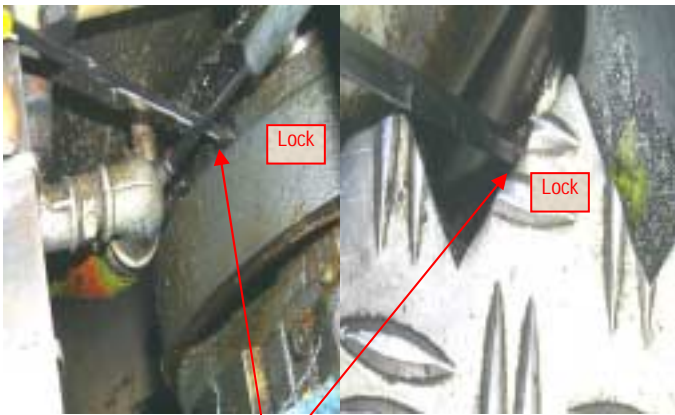


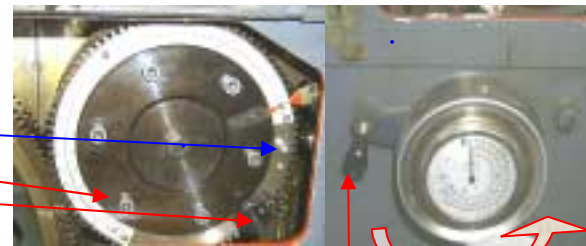
CHANGE OVER FROM 2 COLOR TO PERFECT



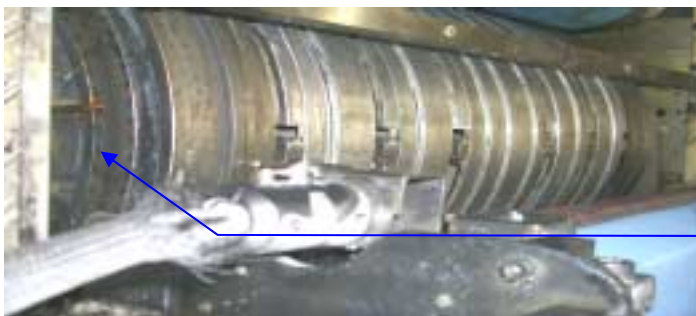
- 1.) Align red marks on #3 transfer cylinder gear. Perfecting cylinder grippers should be facing 12:00.



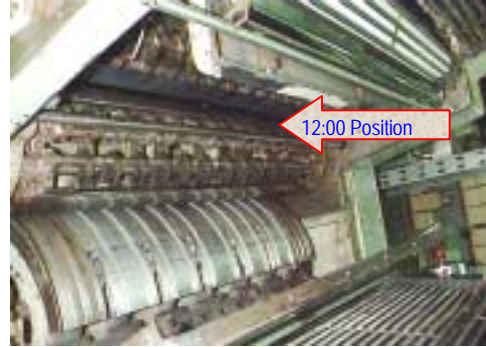
- 2.) Loosen locks for bolts for horseshoe cam (6mm Allen) located on horseshoe cam and hole in side frame drive side of press. On operator side pull pin and move
- 3.) Retighten lock bolts that were loosened in step 2.
- 4.) Remove 1 taper pin in #3 transfer cylinder gear.
- 5.) Loosen six 8mm Allen bolts in #2 transfer cylinder gear.
- 6.) Pull out knob on #3 transfer cylinder gear and turn 180 degrees.
- 7.) Hand crank press to sheet size.(measure sheet).
- 8.) Tighten 6 bolts loosened in step 5.
- 9.) Pull black knob on #2 transfer cylinder cam lock and move to top in counter clockwise direction, move chrome hand wheel to sheet size and reposition black knob in original position.
- 10.) Loosen 2 8mm allen bolts located on #2 transfer cylinder journal 1 bolt on each side.
- 11.) Move sucker heads by hand to sheet size going by scale on operator side of #2 transfer cylinder.
- 12.) Tighten two bolts loosened in step 10.



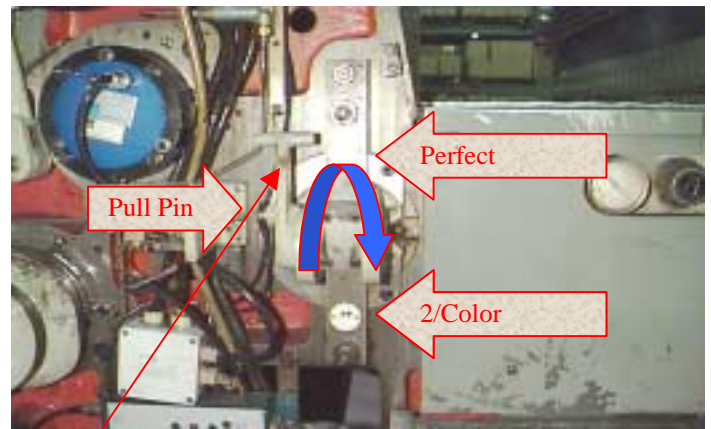
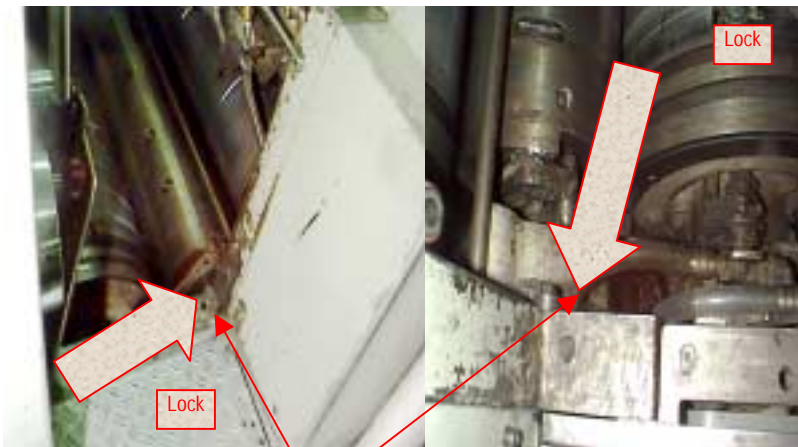
- 13.) Inch sheet in press and check gripper bite on 2nd unit.



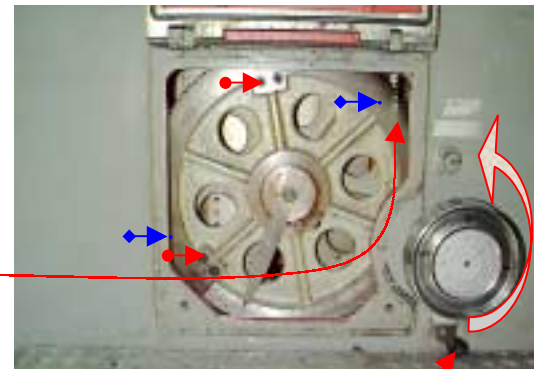
CHANGE OVER FROM 2 COLOR TO PERFECT



- 1.) Align red marks on #2 transfer cylinder gear.
Perfecting cylinder grippers should be facing 12:00.



- 2.) Loosen locks for bolts for horseshoe cam (6mm Allen) located on horseshoe cam and hole in sideframe driveside of press. On operator side pull pin and move handle to the label of arrows pointing to each other.
- 3.) Retighten lock bolts that were loosened in step 2.
- 4.) Remove 2 taper pins in #2 transfer cylinder gear. ↔
- 5.) Loosen six 8mm Allen bolts in #2 transfer cylinder gear. →
- 6.) Pull out knob on #2 transfer cylinder gear and turn 180 degrees. ↻



- 7.) Hand crank press to sheet size.(measure sheet).
- 8.) Tighten 6 bolts loosened in step 5.
- 9.) Pull black knob on #2 transfer cylinder cam lock and move to top in counter clockwise direction,move crumehandwheel to sheetsize and reposition black knob in original position.
- 10.) Loosen 2 8mm allen bolts located on #2 transfer cylinder journal 1 bolt on each side.
- 11.) Move sucker heads by hand to sheet size going by scale on operator side of #2 transfer cylinder.
- 12.) Tighten 2 bolts loosened in step 10.
- 13.) Inch sheet in press and check gripper bite on 2nd unit.**



CHANGEOVER FROM 2 COLOR TO PERFECT

- 1.) Align red marks on #2 transfer cylinder gear. Perfecting cylinder grippers should be facing 12:00.
- 2.) Loosen locks for bolt for horseshoe cam located on horseshoe cam.
Loosen lock nuts for horseshoe cam (on O.S.) and push in cam all the way, then tighten lock nuts.
- 3.) Retighten lock bolts that were loosened in step 2.
- 4.) Remove 2 taper pins in #2 transfer cylinder gear.
- 5.) Loosen six Allen bolts in #2 transfer cylinder gear.
- 6.) Pull out knob on #2 transfer cylinder gear and turn 180 degrees.
- 7.) Hand crank press to sheet size. measure sheet).
- 8.) Tighten 6 bolts loosened in step 5.
- 9.) Move cam handle to red side (D.S. by #2 Transfer cylinder)
- 10.) Loosen #2 transfer cylinder cam lock small sheet size wheel) and move to sheet size.
- 11.) Retighten lock.
- 12.) Rotate press with hand crank 180 Degrees.
- 13.) Remove 2 3/8" Allen bolts for perfecting cam assembly behind perfecting cylinder drive gear.
- 14.) Hand crank cam assembly 180 Degrees and remove Allen bolts holding 2/Color cam (**GREY**).
- 15.) Remove **GREY** cam and replace it with **RED** Cam.
- 16.) Reinstall cam bolts, return cam assembly to original location replace and retighten 2 3/8" bolts behind gear.)
- 17.) Loosen 2 Allen bolts located on #2 transfer cylinder journal 1 bolt on each side.
- 18.) Move sucker heads by hand to sheet size going by scale on operator side of #2 transfer cylinder.
- 19.) Tighten 2 bolts loosened in step 17
- 20.) Inch sheet in press and check gripper bite on 2nd unit.

CHANGEOVER FROM PERFECT TO 2 COLOR

- 1.) Align red marks on #2 transfer cylinder gear. Perfecting cylinder grippers should be facing 12:00.
- 2.) Loosen locks for bolt for horseshoe cam located on horseshoe cam.
Loosen lock nuts for horseshoe cam (on O.S.) and pull out cam all the way, then tighten lock nuts.
- 3.) Retighten lock bolts that were loosened in step 2.
- 4.) Loosen six Allen bolts in #2 transfer cylinder gear
- 5.) Pull out knob on #2 transfer cylinder gear and turn 180 degrees. should go in hole half way)
- 6.) Hand crank press to red mark for inline printing, knob in step 5 should go in all the way.
- 7.) Install 2 large Taper pins in #2 Transfer cylinder gear large double gear)
- 8.) Tighten 6 Allen bolts for #2 Transfer cylinder gear.
- 9.) Move cam handle to grey side (D.S. by #2 Transfer cylinder)
- 10.) Rotate press with hand crank 180 Degrees.
- 11.) Remove 2 3/8" Allen bolts for perfecting cam assembly behind perfecting cylinder drive gear.
- 12.) Hand crank cam assembly 180 Degrees and remove Allen bolts holding Perfecting cam (**RED**).
- 13.) Remove **RED** cam and replace it with **GREY** Cam
- 14.) Reinstall cam bolts, return cam assembly to original location replace and retighten 2 3/8" bolts behind gear.