

Screw Reference

Each Xandex Actuator type can be installed on multiple Xandex Holder assemblies. The Actuator is installed using a Bracket (or the Plunger Stop Bracket) to the Holder Body using two screws. It is critical that the screws are the correct length. If the screws are too long, they can protrude into the Actuator coil and contact the coil windings.

Screw contact with the coil winding generally results in non-repairable coil failure.

The Xandex warranty does not cover damage to the Actuator caused by incorrect installation. This includes installing screws directly into the Actuator and Bracket without the screws first passing through the Holder body or when damage is caused by attempting to install an Actuator on a non-Xandex Holder.

Table 1* describes which screws to use when installing any Actuator and Bracket, including the Plunger Stop Bracket Assembly, to a Xandex Holder.

**Table 1 may list obsolete Holder models. This information provided for reference only.*

Table 1. For Holder Type (left column) use screw listed in right column to install actuator and bracket on holder.

Screw Reference for Actuator / Bracket Installation on Different Holder Types

HOLDER TYPE	SCREW PART NUMBER
H1	510-1106
H2	510-1106
H2R	510-1106
H3	510-1203
H4	510-1106
H5	510-1106
H6	510-1203
H7	510-1203
H11	510-1106
H14	510-1203
H16	510-1219

Note: 510-1106 = 1/72 x 3/8", 510-1203 = 1/72 X 3/16", 510-1219 = 1/72 X 7/16"



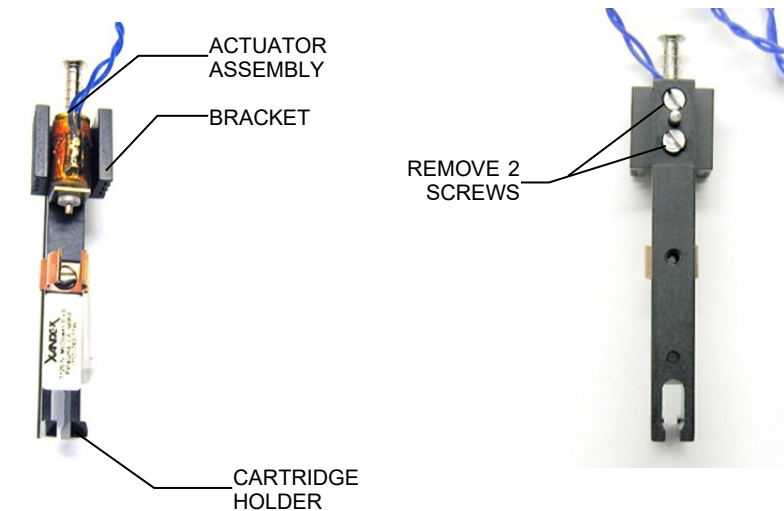
1360 Redwood Way, Suite A
Petaluma, CA. 94954
(707) 763-7799

Installation and Setup Instruction
820-0206 for 3 mil / 5 mil Plunger
Stop Bracket Assembly
P/N 210-0016

Plunger Stop Bracket Installation and Setup

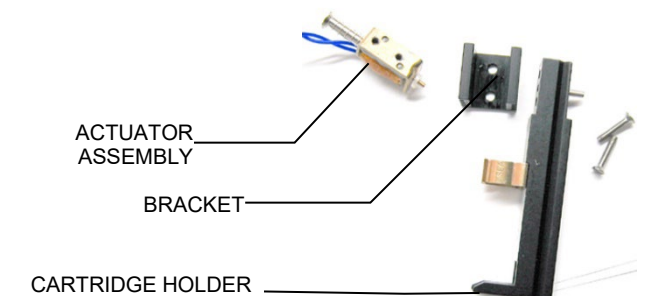
Pre-Installation Disassembly

1. Remove the holder assembly from probing equipment or inker base.
2. Unthread the two screws that retain the Actuator Assembly and Bracket to the Cartridge Holder and remove the Actuator Assembly and Bracket from the Cartridge Holder.



3. Remove the Actuator Assembly from the Bracket. The Plunger Stop Bracket will replace the existing Bracket.

Note: The assembled open frame coil, plunger, plunger return spring and plunger washer is called an Actuator Assembly. See items with an * in Figure 1.



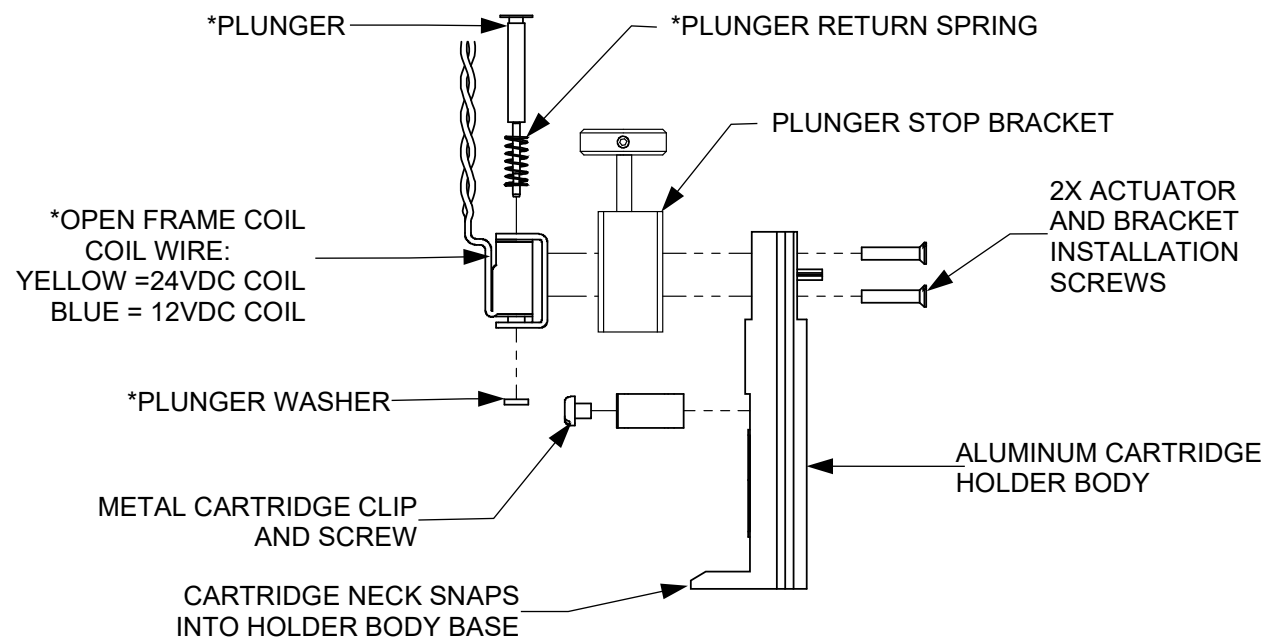


Figure 1. Exploded view of Plunger Stop Bracket, Actuator Assembly (items with *) and Cartridge Holder Body. Install screws through Holder Body first or non-repairable damage to coil will occur.

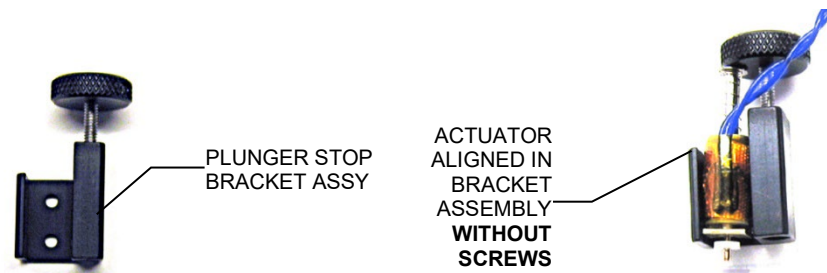
POTENTIAL DAMAGE & VOID WARRANTY NOTICE:

DO NOT INSTALL SCREWS DIRECTLY INTO THE COIL AND BRACKET ! THE COIL AND BRACKET MUST BE ALIGNED ON THE HOLDER BODY BEFORE SCREWS ARE INSTALLED. NON-REPAIRABLE COIL DAMAGE WILL RESULT IF SCREWS ARE INSTALLED WITHOUT PASSING THROUGH THE HOLDER BODY! SEE Figure 1.

Plunger Stop Bracket Installation

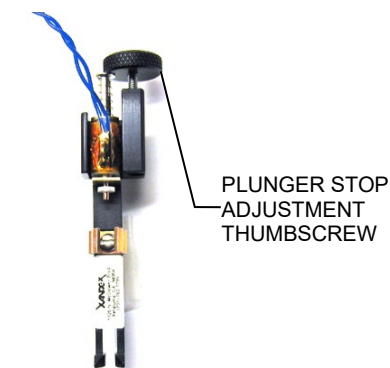
- Place the Actuator Assembly into the Plunger Stop Bracket Assembly and align the screw holes on the Plunger Stop Bracket and the Actuator Assembly.

DO NOT INSTALL SCREWS UNTIL MOUNTING THE ACTUATOR AND BRACKET ON THE HOLDER BODY. SEE **FIGURE 1** FOR CORRECT ASSEMBLY.



Plunger Stop Bracket Setup

- Orient the Actuator and Plunger Stop Assembly on the cartridge Holder as shown and re-install the two screws through the Holder body.
- Re-install the cartridge Holder on the inker base or probing equipment and proceed to Plunger Stop Bracket Setup. below.



- Install an opened, vacuum or manually primed* 3 mil or 5 mil DM-1 cartridge on the cartridge holder (see the cartridge opening and priming instructions included on the cartridge packaging insert).
- Turn the plunger adjustment thumbscrew clockwise until the thumbscrew stops (tighten the thumbscrew all the way down). From this point, back the plunger adjustment thumbscrew off 1 ¼ turns (counterclockwise). The wire/filament will no longer be visible at the cartridge tip.
- Complete cartridge priming, if required, by actuating the solenoid repeatedly until ink is present at the filament tip. The inker is ready for operation.
- Some additional fine adjustment may be necessary. Fine tuning adjustments should not exceed ¼ turn in either direction.

** Use manual movement of the main guide/ filament ONLY to prime the cartridge. Do not actuate the solenoid to prime the cartridge until AFTER the plunger stop assembly is installed and adjusted.*