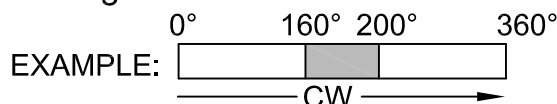


Rotating Cam Limit Switch Cam Adjustment Procedure 6" Aluminum Cams

1. Units are shipped with cams set at the minimum dwell of 4° inline with the switch roller follower and plunger and should be reading zero at the top position.
2. The machine should be in the start cycle position. Couple the input shaft to the driving member ensuring proper shaft alignment. Flexible type couplings are recommended.
3. Establish a timing chart for each desired limit switch setting with specified angular settings. A timing chart is provided on the back of this form.
4. Determine the direction of rotation of the cam shaft (CW or CCW), looking at the right hand side of the cam box when viewing the switch terminal screws.
5. Proceed with the desired cam settings at the top of the cam as shown below.
6. Loosen locking collars on each side of cams using a 3/32" hex wrench. Locking collars can be rotated independently from cams so screws can be accessed for tightening. Rotate cams to required position and tighten locking collar screws to 3 in/lbs maximum.

Settings for CLOCKWISE Shaft Rotation (CW)

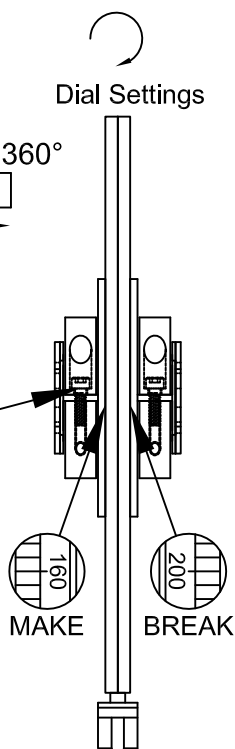
Settings LESS than 180°



Use "A" CONTACT

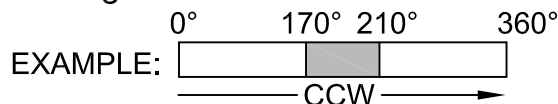
1. Set "Make" with BLACK dial
2. Set "Break" with RED dial

MAXIMUM RECOMMENDED TORQUE FOR CLAMP SCREWS IS 3.0 IN/LBS.



Settings for COUNTERCLOCKWISE Shaft Rotation (CCW)

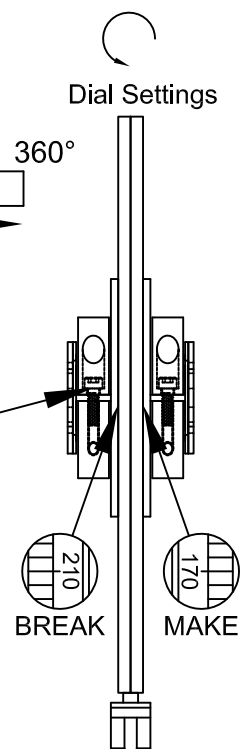
Settings LESS than 180°



Use "A" CONTACT

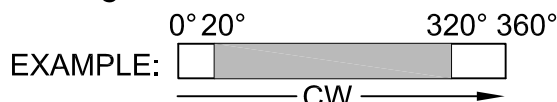
1. Set "Make" with WHITE dial
2. Set "Break" with YELLOW dial

MAXIMUM RECOMMENDED TORQUE FOR CLAMP SCREWS IS 3.0 IN/LBS.



Settings for CLOCKWISE Shaft Rotation (CW)

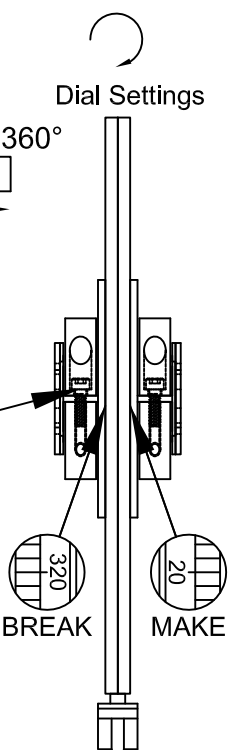
Settings MORE than 180°



Use "B" CONTACT

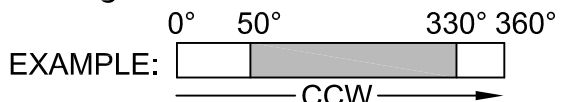
1. Set "Make" with RED dial
2. Set "Break" with BLACK dial

MAXIMUM RECOMMENDED TORQUE FOR CLAMP SCREWS IS 3.0 IN/LBS.



Settings for COUNTERCLOCKWISE Shaft Rotation (CCW)

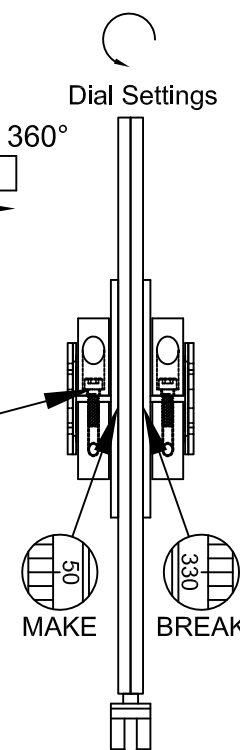
Settings MORE than 180°



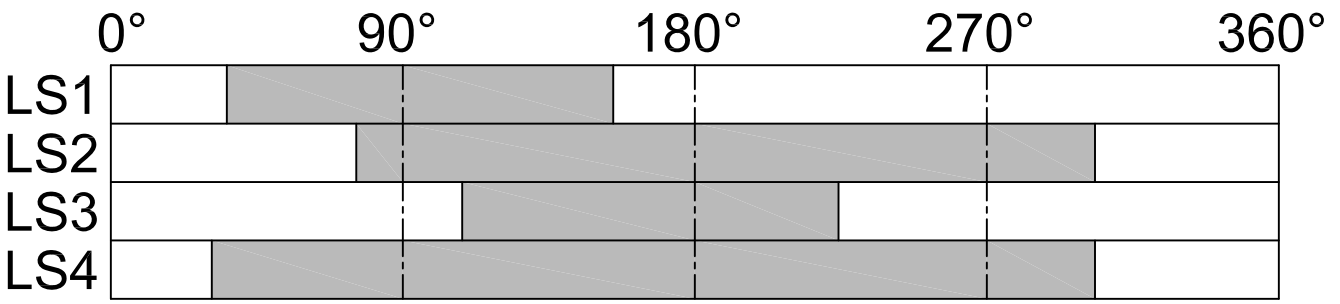
Use "B" CONTACT

1. Set "Make" with YELLOW dial
2. Set "Break" with WHITE dial

MAXIMUM RECOMMENDED TORQUE FOR CLAMP SCREWS IS 3.0 IN/LBS.



TIMING CHART EXAMPLE



DIRECTION OF ROTATION



LIMIT SWITCH NUMBER	START CYCLE POSITION	90°	180°	270°	360°
	0°				