

DKP-TWIN 16" X 20" TWIN SHUTTLE ATTACHMENT INSTRUCTIONS

The DKP-TWIN attachment was shipped completely assembled. The attachment was designed to attach to your DK20/A Clamshell or DK20S Swinger "All Thread" style press. We recommend that your machine be bolted to either the work bench or stand to prevent the assembly from dipping while shuttling back and forth.

Tools needed:

- 3/16" Allen Key wrench * (Included)
- 1/2" Hex Nut Driver * (Included)

1. Remove the 16" x 20" ALL-THREAD style table from the machine. This is done by simply removing the pull-pin from under the table and lifting the table vertically up and off the machine.



DK20/A CLAMSHELL



DK20S SWINGER

2. With the table removed, you will see the ALL-THREAD mounting brackets.



DK20/A CLAMSHELL



DK20S SWINGER

3. Using the 3/16" Allen wrench, loosen and remove the (2) shoulder bolts located in the center of the bracketing.

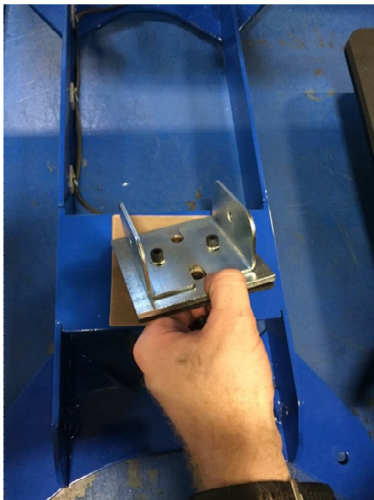


DK20/A CLAMSHELL

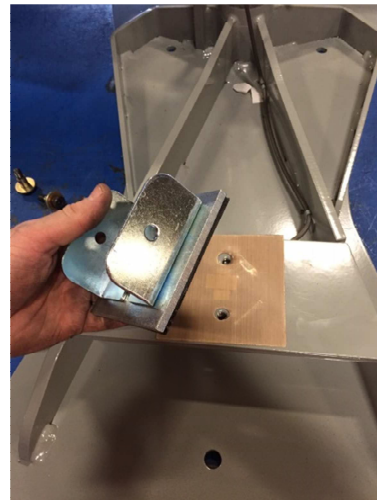


DK20S SWINGER

4. Remove the ALL-THREAD bracketing and 1/4" steel press plate with black rubber pad. (You should store these in a save place for future use with standard tables.)



DK20/A CLAMSHELL



DK20S SWINGER

5. Lift up the teflon pressure sensor pack in the upper left hand corner. Disconnect the pressure sensor wire harness by simply pulling it off the Teflon pressure sensor connector. (Store this pressure sensor with the bracketing in a safe place.)

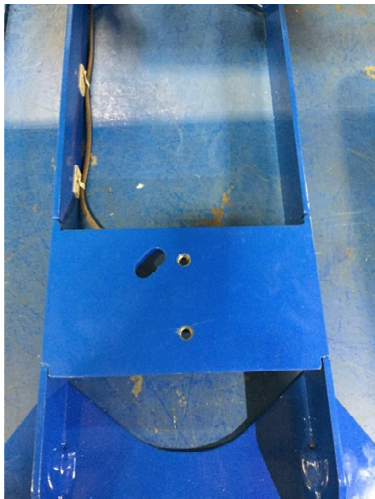


DK20/A CLAM SHELL



DK20S SWINGER

6. With the Teflon pressure sensor pack removed, you will now have just the painted base remaining in this area of the press.

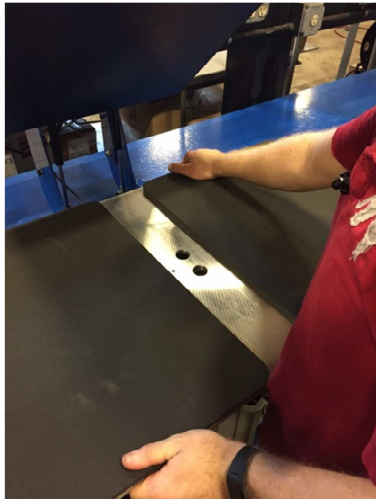


DK20/A CLAM SHELL

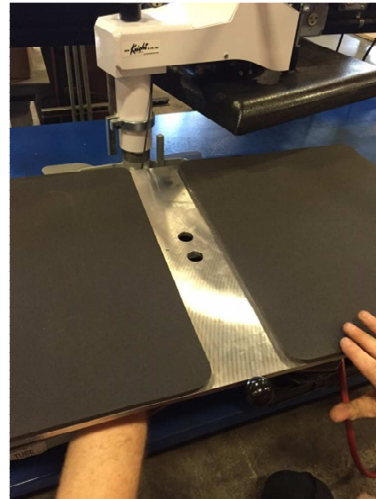


DK20S SWINGER

7. With the DKP-TWIN attachment un-packed, lift the unit up and place the lower black shuttle assembly onto the painted base. The goal is to have the large 1" holes in the center of the aluminum shuttle plate, the 1" holes in the lower black roller bearing fixture plate and the 5/16-18 tapped holes in the painted base all lined up with each other to screw in some bolts.

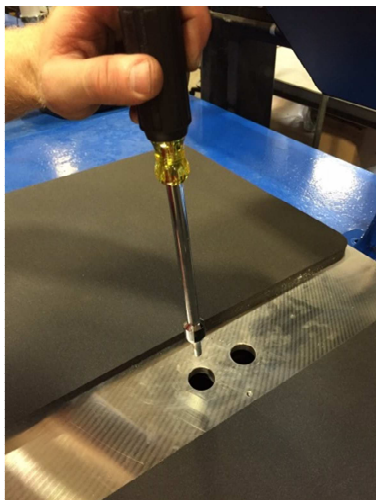


DK20/A CLAM SHELL



DK20S SWINGER

8. Using the 1/2" Nut Driver that was included, insert and tighten the 5/16-18 hex bolts that were supplied into the 1" holes and tighten. Get both bolts inserted and started before tightening fully. Try to make sure the lower black bearing fixture is square with the frame of the machine to insure proper operation. (To keep the hex bolt attached to the nut driver while inserting into the holes and not falling off, place a piece of electrical tape across and in the end of the nut driver to keep the bolt stuck to the nut driver while inserting.)

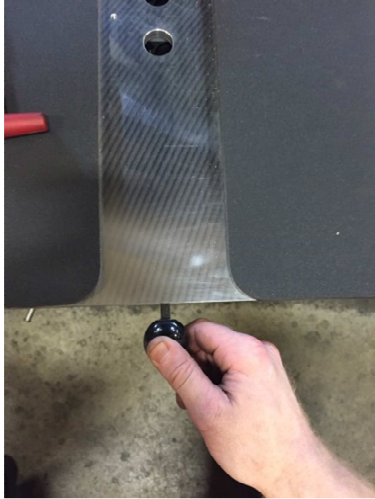


DK20/A CLAM SHELL



DK20S SWINGER

9. Screw in the Black Ball into the front edge of the aluminum shuttle plate. The Ball is what you grab to move the plate left to right while shuttling. Screw the Ball in fully right against the aluminum plate.



Screw Black Ball into plate.



Black Ball fully screwed in.

With the DKP-TWIN attachment is now firmly attached to the machine, you are ready to test the unit to make sure it works properly. Move the table fully to the left and then to the right. We have designed shuttling stations to go beyond the edge of the heater block just a bit. This is to allow you to fine tune the stopping points to match your machine. We have included a roll of Velcro tape that if needed, you can wrap around the silver pipe spacers that are between the aluminum shuttling plate and the steel roller bearing bars in the lower corners of the assembly. Wrap the amount of Velcro tape around the pipe spacer to insure the shuttling aluminum plate will stop and line up with the left and right edges of the heater block.



Velcro tape wrapped around corner pipe spacer for adjusting stop location

Please contact the factory at 1-800-525-6766 if you have any questions.