

INSTALLATION INSTRUCTIONS

MODELS LT16 and LT12 SL KIT UPGRADE
202026 Rev. B
2016-12-22

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INTRODUCTION

Prior to installation, review Figures 1 and 2, Table 1 and drawing 201996 (located at the back of this document) to familiarize yourself with the components of the LT-12-16 SL Kit Upgrade. The kit supports systems with either six or eight lamps. The drawings in this document and show the eight lamp variant. Installation is identical for both systems with the exception of the number of TL102A/L lamps installed on the light blocks. Many of the figures in this document are part of drawing 201996 and may be more readable in the drawing itself.

When installing screws and bolts, use thread locking compound in accordance with best practices for your machine.

1. Remove old halogen lamps and illumination system.
2. Install the adapter plate (item1) using the instructions below in Detail A. See Table 1 and Figures 3 and 4 for part identification.
3. Install the mounting brackets with hardware (items 2 through item 19) as shown below.
4. Note that there are two TL102ALs in a six lamp configuration and four TL102ALs in an eight lamp configuration. The TL102AL has a Fresnel lens and the LEDs appear blurred. The TL102A does not have a Fresnel lens and the LEDs are clearly visible. The model numbers are also marked on the subassembly. Populate item 2, the top and bottom assemblies, with TL102A/Ls before installing them into the system.
 - a. For a 6 lamp configuration install top: 2x TL102A + bottom: 2x TL102A + sides: 2x TL102AL.
 - b. For an 8 lamp configuration install top: 2x TL102A, 1x TL102AL + bottom: 2x TL102A, 1x TL102AL + sides: 2x TL102AL.
 - c. Use heatsink compound (not supplied) between the entire bottom surface of the TL102A/TL102ALs and their respective heatsinks and mounting brackets. The compound should be spread thinly and used sparingly to only fill any minute gaps between the surfaces. Slide the mating surfaces slightly back and forth to expel any excess. Also use heat sink compound between the surfaces of the two 202007 blocks their respectively heatsinks and mounting brackets.
5. After installation insure there is sufficient clearance between all fixed and moving parts. Adjust as necessary to correct. The shapes of the heat sinks may be altered as necessary to achieve this end. However, they should remain flat where they contact other parts of the lighting system to insure adequate heat transfer.

| ITEM | QTY with 6 lamps | QTY with 8 lamps | PART # | DESCRIPTION |
|------|------------------|------------------|--------------|-----------------------------|
| 1 | 1 | 1 | 201997 | PLATE, BRACKET MOUNT |
| 2 | 1 | 1 | 201999 | BRACKET, UPPER LIGHT |
| 3 | 2 | 2 | 202000 | BRACKET, SIDE LIGHT |
| 4 | 1 | 1 | 202001 | PEDESTAL, LOWER LIGHT |
| 5 | 6 | 6 | 202002 | SPACER, BRACKET MOUNT PLATE |
| 6 | 2 | 2 | 202007 | BLOCK, LIGHT MOUNT |
| 7 | 4 | 4 | TL102A | TL102 TEST LIGHT |
| 8 | 2 | 4 | TL102AL | TL102L TEST LIGHT |
| 9 | 16 | 16 | 201922 | WASHER, LOCK .250 |
| 10 | 8 | 8 | 201923-0.750 | SHCS .250-20 X 1.38 |
| 11 | 16 | 24 | 201923-1.375 | SHCS .250-20 X 1.38 |
| 12 | 8 | 8 | 201923-2.250 | SHCS .250-20 X 2.25 |
| 13 | 12 | 12 | 201924-1.250 | SHCS .375-16 X 1.25 |
| 14 | 6 | 6 | 201924-3.750 | SHCS .375-16 X 3.75 |
| 15 | 16 | 16 | 201925 | WASHER, FLAT .250 |
| 16 | 8 | 8 | 101356 | NUT, HEX .250-20 |
| 17 | 18 | 18 | 201927 | WASHER, FLAT .375 |
| 18 | 8 | 8 | 202003-0.375 | SHSS .313 X .25 |
| 19 | 8 | 8 | 202004 | WASHER, FLAT .313 |
| 20 | 18 | 18 | 202005 | WASHER, LOCK .375 |
| 21 | 2 | 2 | 202019A | TL102A TRIPLE FLAT HEATSINK |
| 22 | 2 | 2 | 202020A | TL102A TRIPLE BENT HEATSINK |
| 23 | 2 | 2 | 202018A | TL102A FLAT HEATSINK |

Table 1

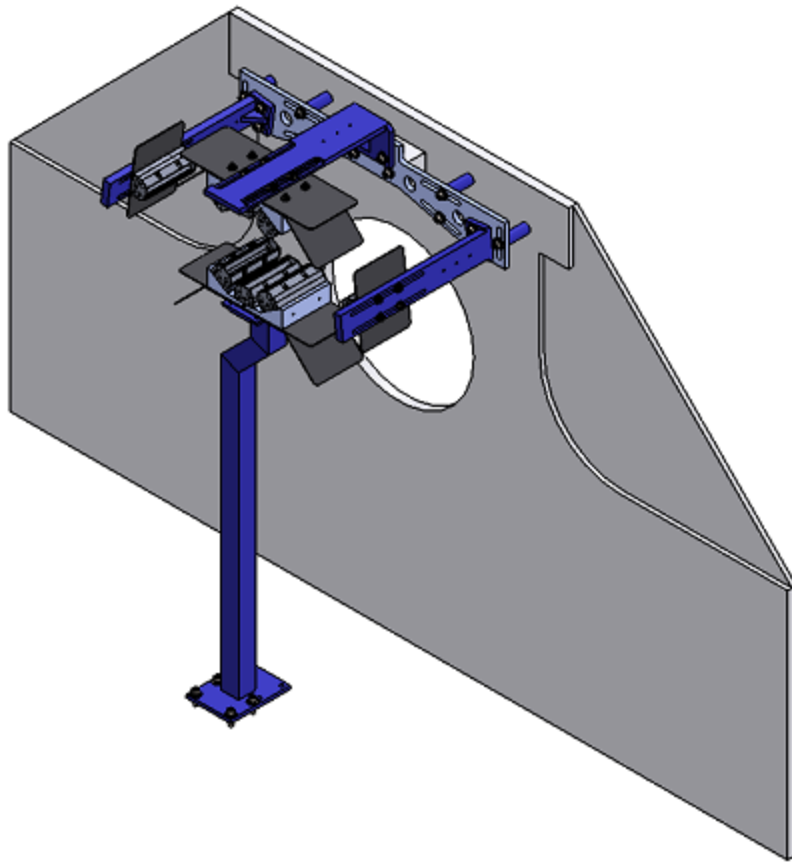


Figure 1

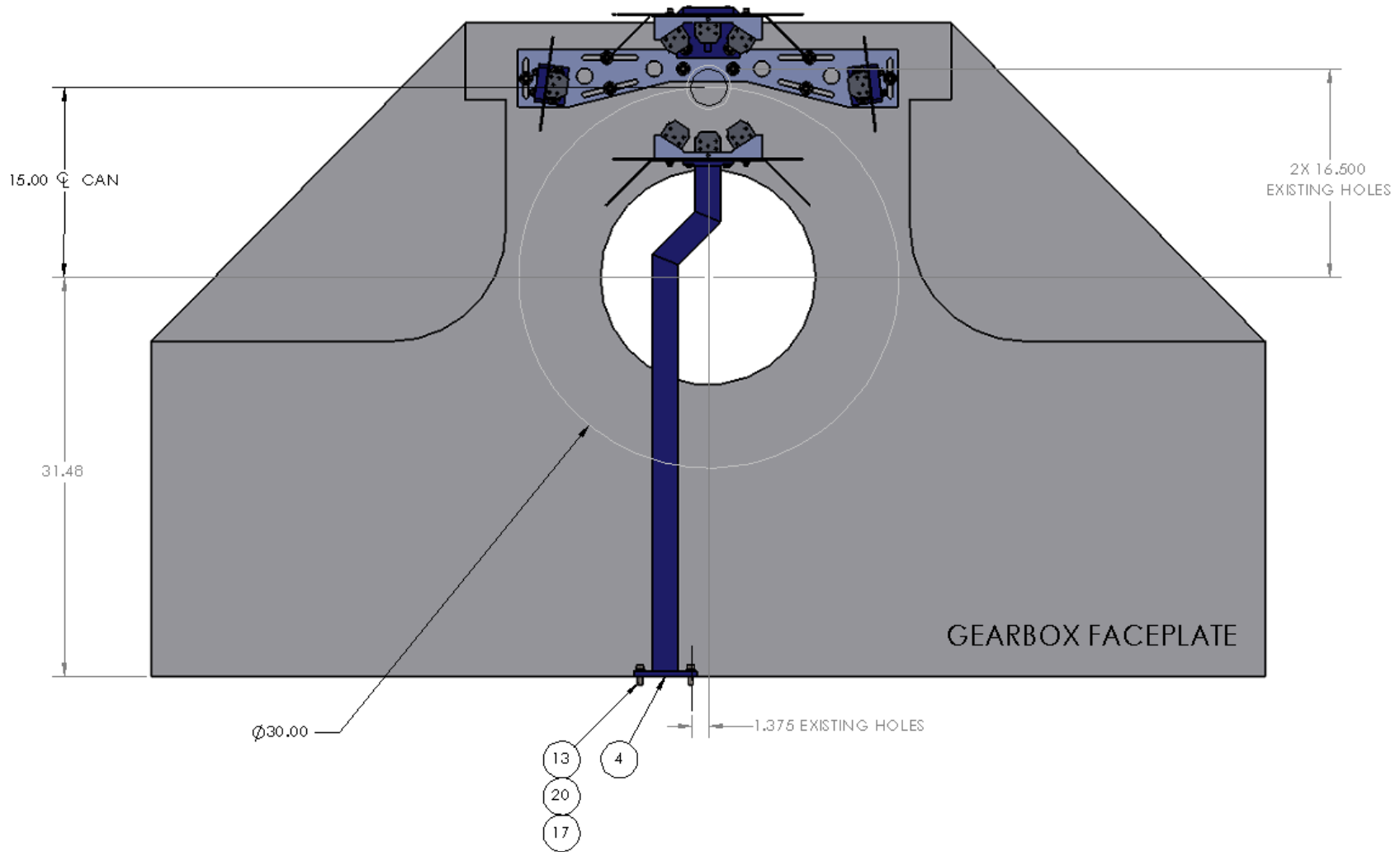
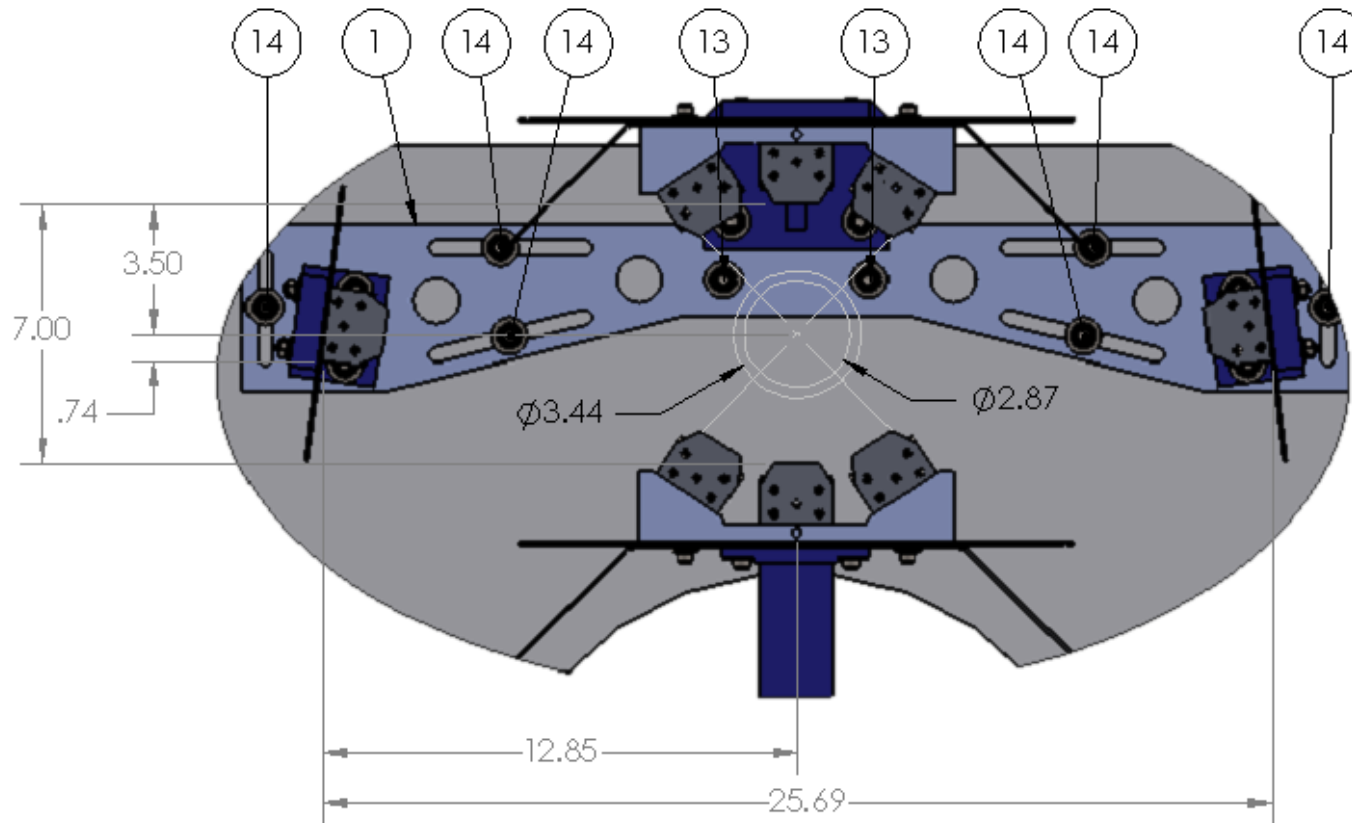


Figure 2

ASSEMBLY NOTES:

- 1) BOLT THUR ITEM 1 USING (2) EXISTING 3/8-16 TAPPED HOLES MARKED "13" ON EXISTING 2.5" RISER BLOCK
- 2) DRILL AND TAP (6) 3/8-16 HOLES IN GEARBOX FACEPLATE MARKED "14"
- 3) USE A HOLE LOCATION TRANSFER PUNCH TO TRANSFER HOLES (REF MCMMASTER-CARR P/N 3374A33)
- 4) USE ITEM 5 AND SLOTS IN ITEM 1 TO HELP GUIDE THE TRANSFER PUNCH
- 5) HOLE LOCATIONS NOT CRITICAL. SLOTS IN ITEM 1 ALLOW FOR HOLE LOCATION ADJUSTEMENT TO AVOID EXISTING MACHINE FEATURES



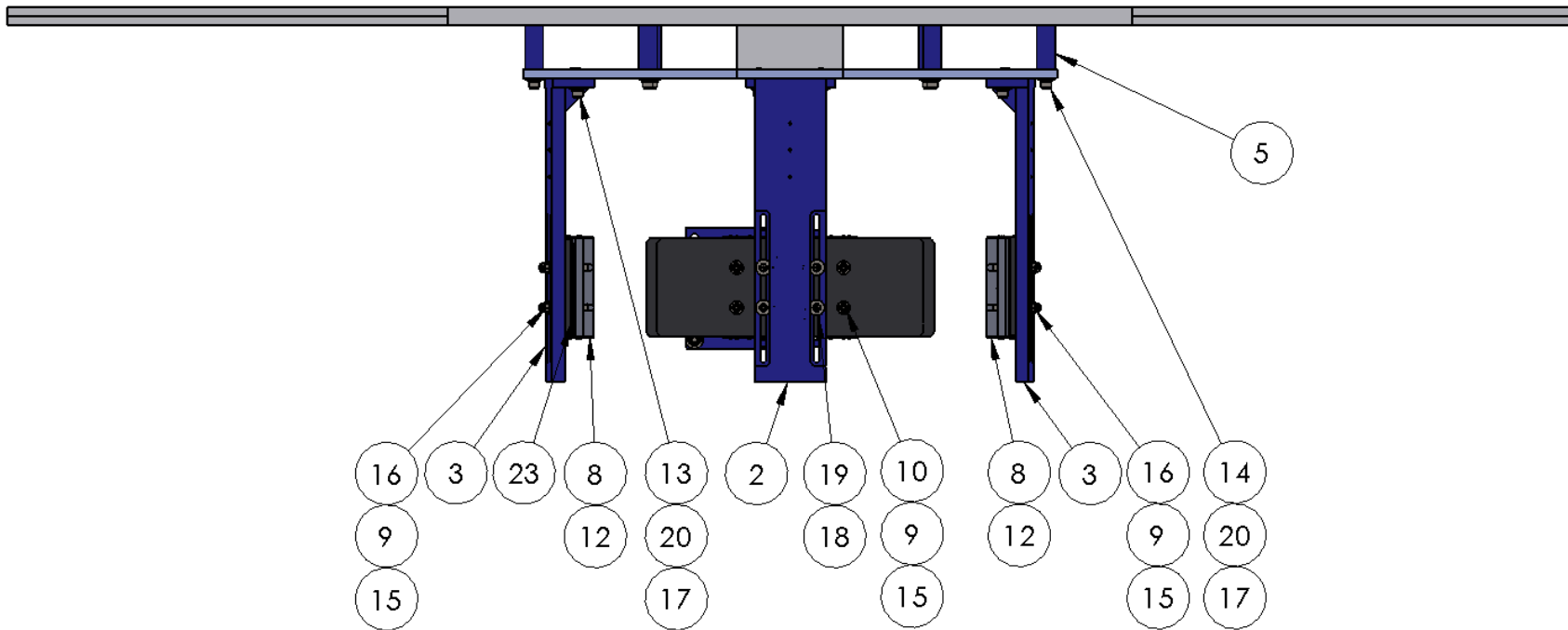


Figure 3

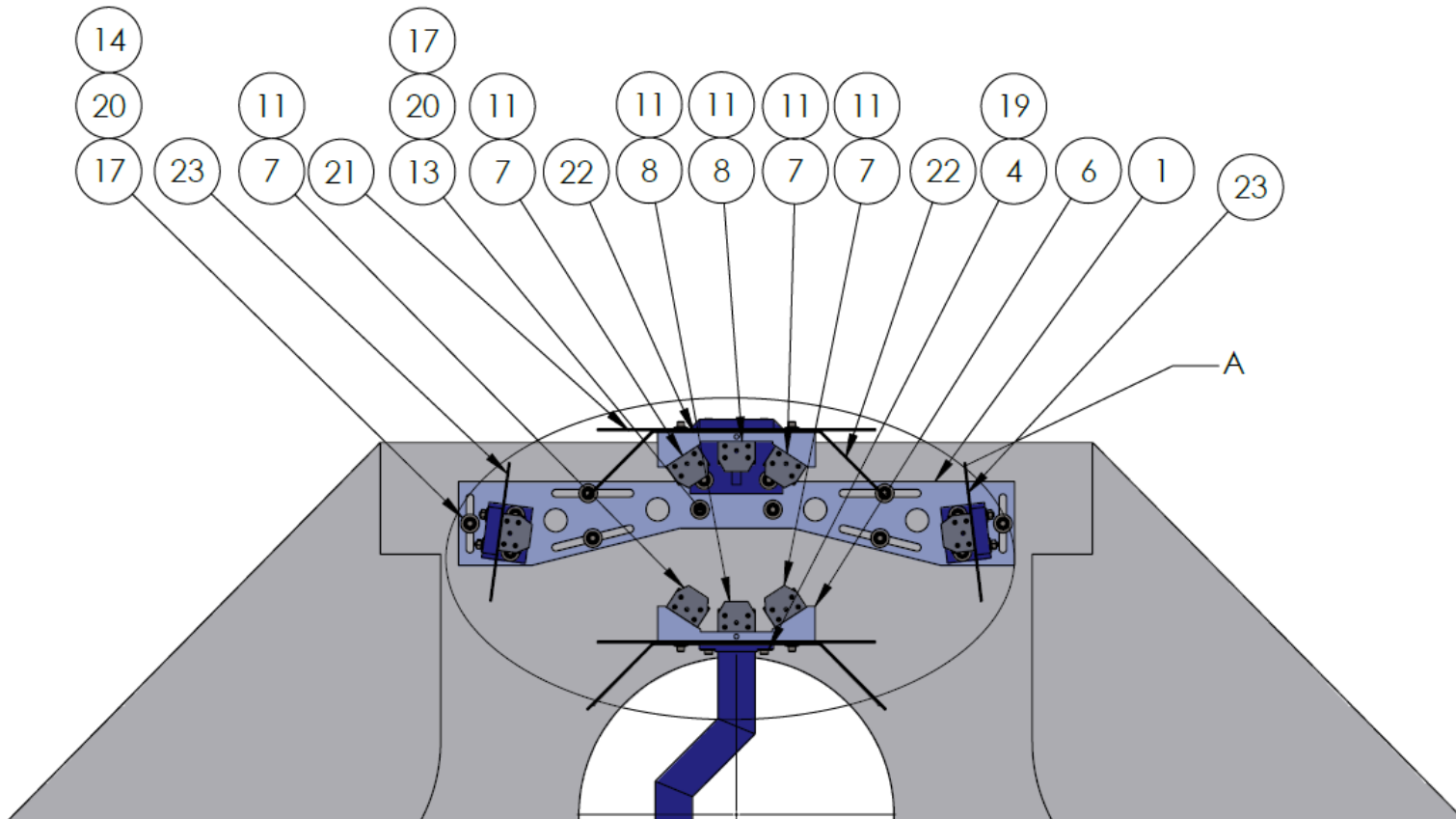


Figure 4

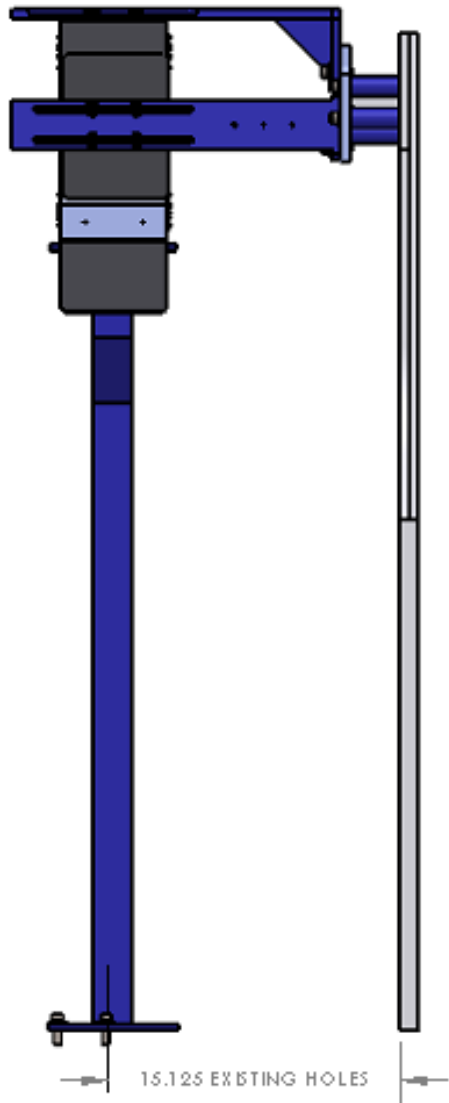


Figure 5

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6. Install Items 24 through 32 with adequate gauge wiring to support 1.25 amps per each TL102/L. DIN rail mounting is recommended. The dimmer circuit is optional. Leave the DIM connector on the TL102/L open with no connection if the dimmer is not installed. Wiring diagrams for the section updated with and without DIM are shown below.
 - a. Install a total of 6 connectors for a 6 lamp configuration: top:2xTL102A + bottom:2xTL102A + sides:2xTL102AL.
 - b. Install a total of 8 connectors for an 8 lamp configuration: top:2xTL102A,1xTL102AL + bottom:2xTL102A,1xTL102AL + sides:2xTL102AL.
7. Prime Controls requires disabling power to the TL102A/Ls when the tester is idle.

| ITEM | QTY | PART # | DESCRIPTION | Mfr | Mfr P/N |
|------|-----|--------|---|------------|----------------|
| | | | Circuit Breaker Assembly | | |
| 24 | 1 | 201947 | Circuit Breaker, 1P 4A D Curve | Altech | 1DU4R |
| 25 | 1 | 201889 | Auxiliary Contact Switch | Altech | H1COR |
| 26 | | | Relay assembly | | |
| 27 | 1 | 201943 | Relay, 120V Coil 16A(DC) DPDT | Magnacraft | 788XBXM4L-120A |
| 28 | 1 | 201944 | Relay Socket | Magnacraft | 70-788EL11-1 |
| 29 | 1 | 201945 | Relay Clip | Magnacraft | 16-1351 |
| 30 | 1 | 201946 | Relay Protection Diode | Magnacraft | 70-BSMD-250 |
| 31 | 1 | 201897 | Alternate Relay, 24V coil 16A(DC) DPDT | Magnacraft | 788XBXM4L-24D |
| 32 | 1 | 201901 | Pot, LED Lamp Dimmer | Eaton | M22-R10K |
| 33 | 1 | 201948 | Power Supply, 90-264VAC, 24VDC 20A | TDK Lambda | DPP480-24-1 |

Table 2

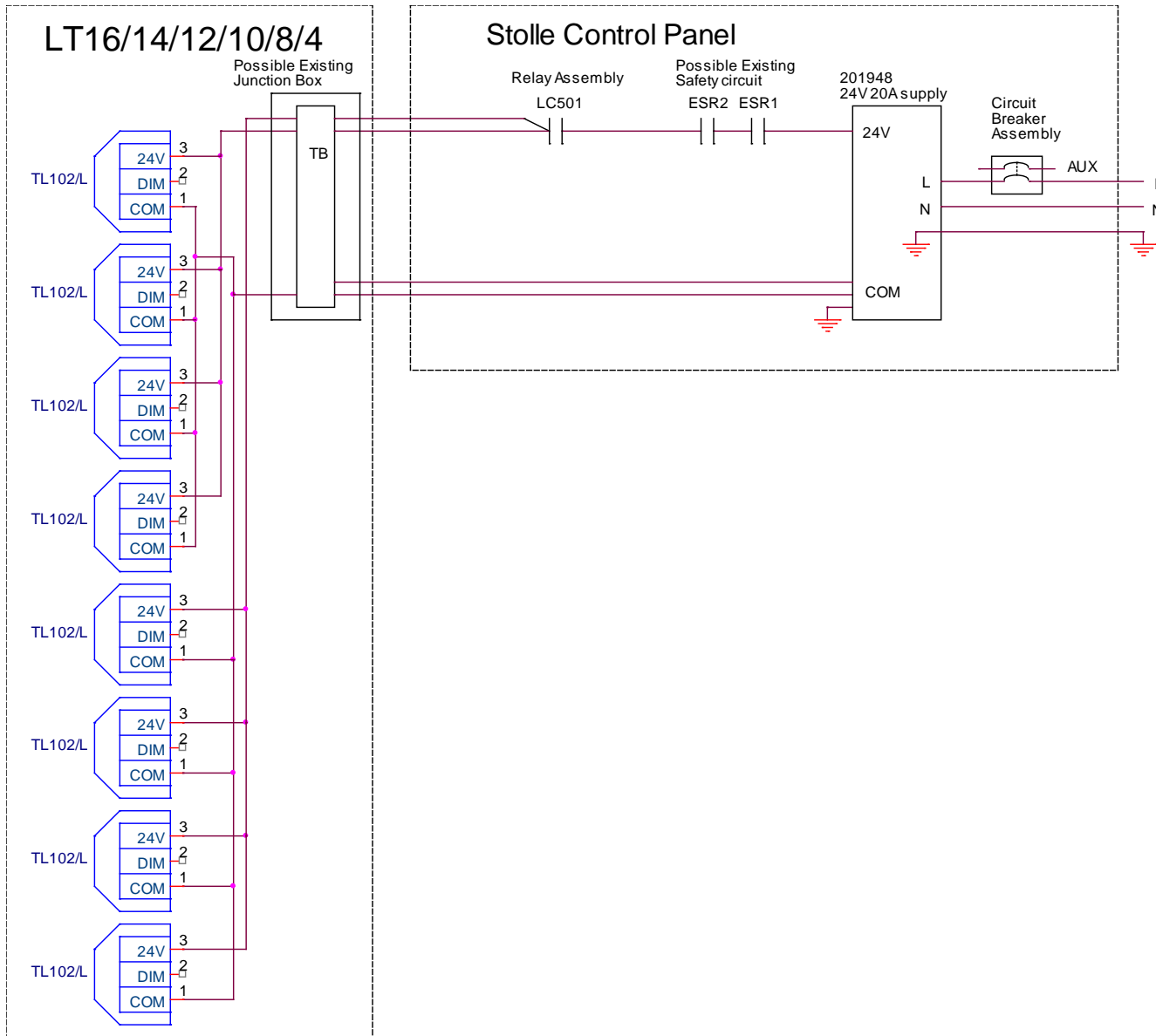


Figure 6

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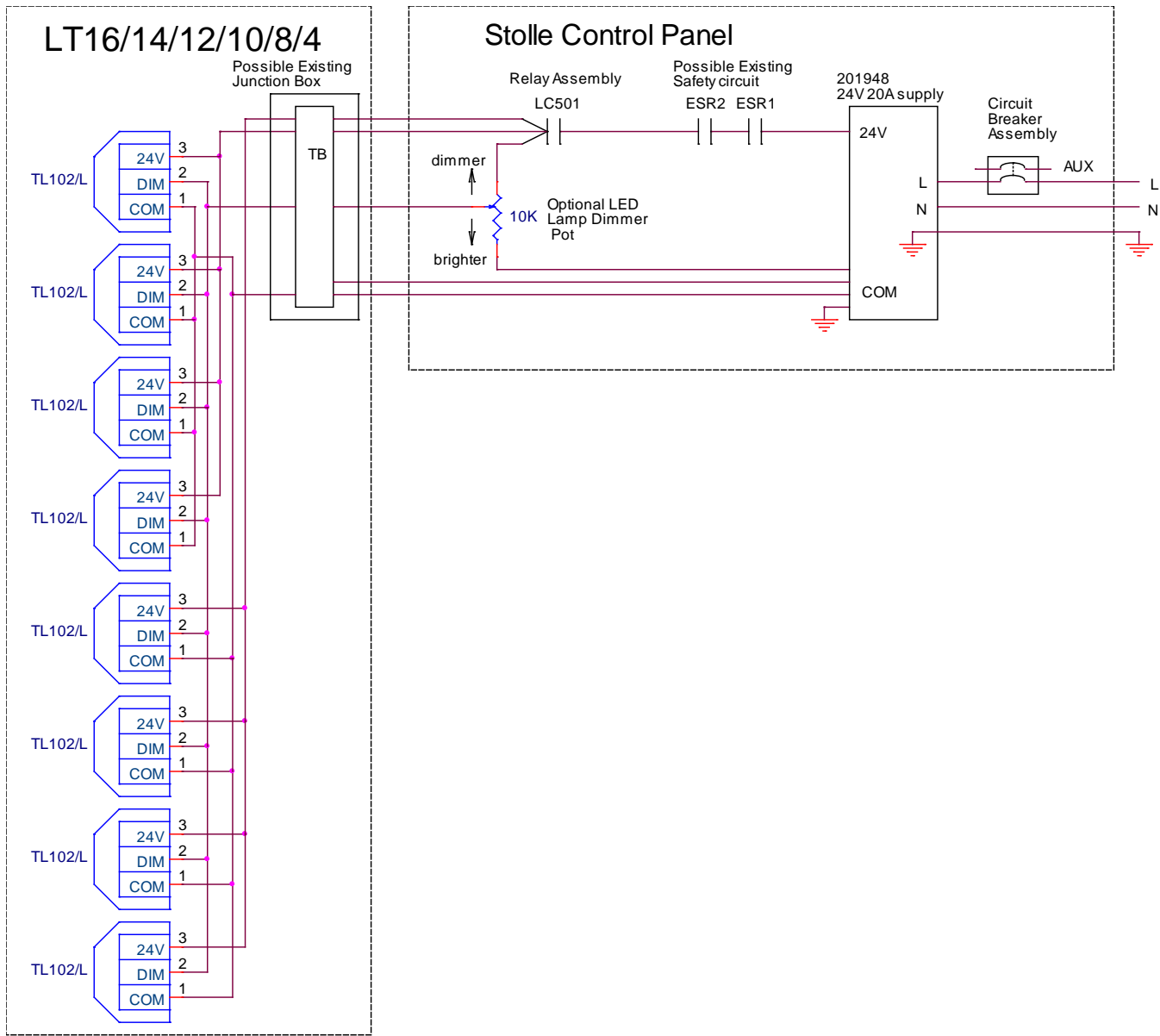


Figure 7

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8. It is critical to adjust the slide mounts so the TL102As and the TL102ALs are centered with the can. That will make the TL102As and the TL102ALs all the same distance from the plate.
9. It is also critical that the TL102As and the TL102ALs are in position and centered with the can in its top most position as shown in Detail A above. That will make corresponding TL102As and the TL102ALs equidistant from the can in its top most position.
10. Anchor all cables and check that there are no mechanical interference issues with parts before jogging or running the system.
11. Modify the shroud as needed to allow function of interlocks and proper fit.
12. Power up the TL102A/Ls and verify all are functional with their indicator lights on and all LEDs lit. The indicator light will not illuminate if there is no power, or if there is an internal fault with the lamp. A cell phone camera may be used to check to see if the individual LEDs are on. Be aware that some cell phones do not detect infrared light or may only dimly show the infrared light.
13. If necessary, number the pockets starting with 1 on the wheel of the machine near the LT20s; in the same order and correlation as the display on the user interface. Check a can at each pocket for a fit that is not too loose to give false indications or too tight to cover up cracked flanges.
14. Calibrated leakers may be run or jogged through the system by watching the error log at the user interface. Verify the hole drilled in the can is flattened to the curve of the can so that there are no shadows cast on the calibrated orifice. Please also verify that the orifice is clear and free of debris.

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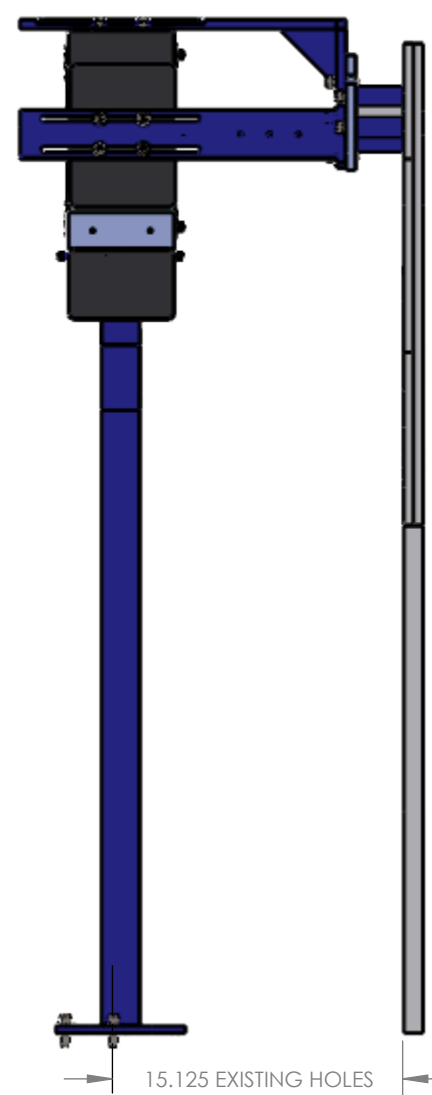
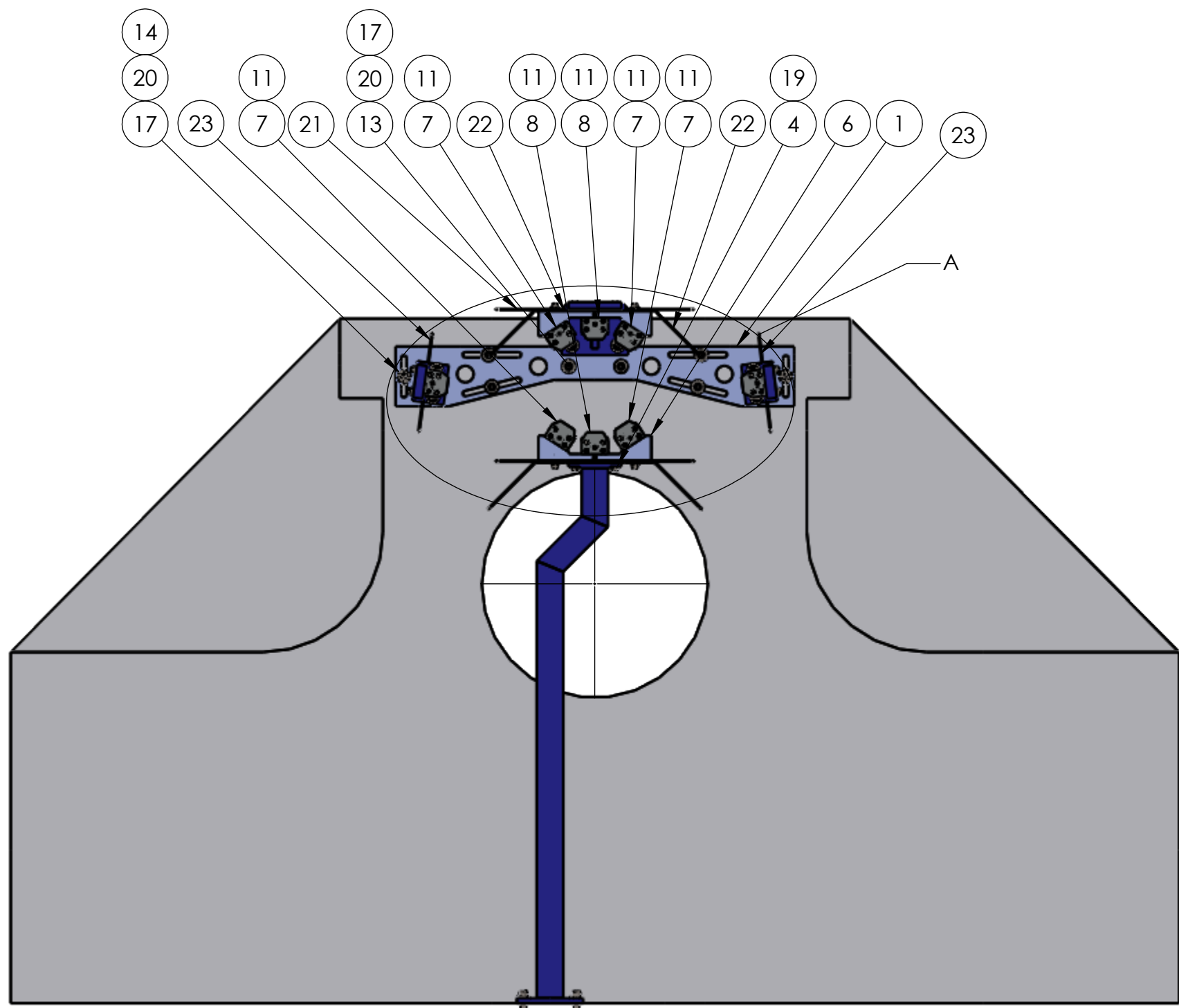
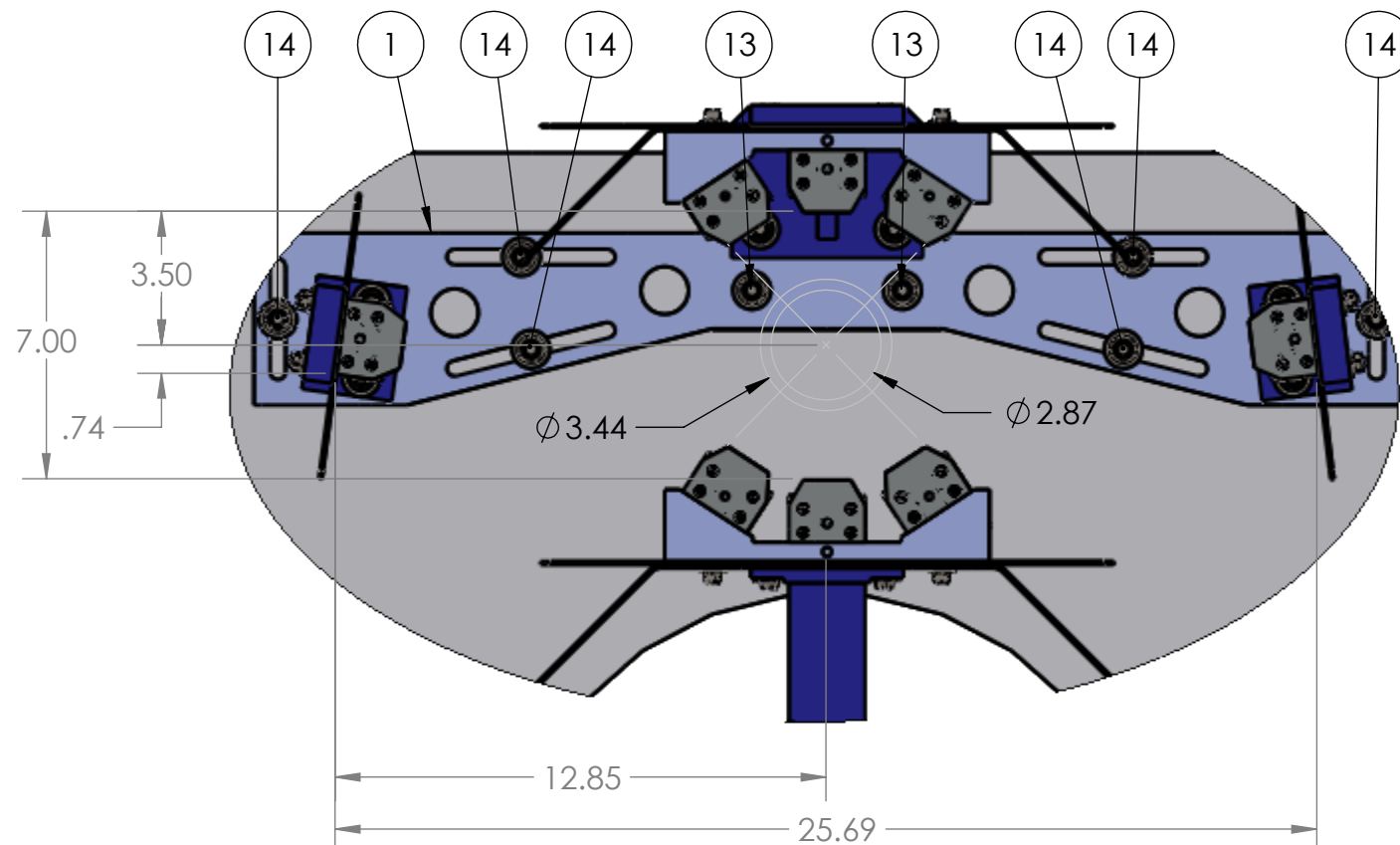
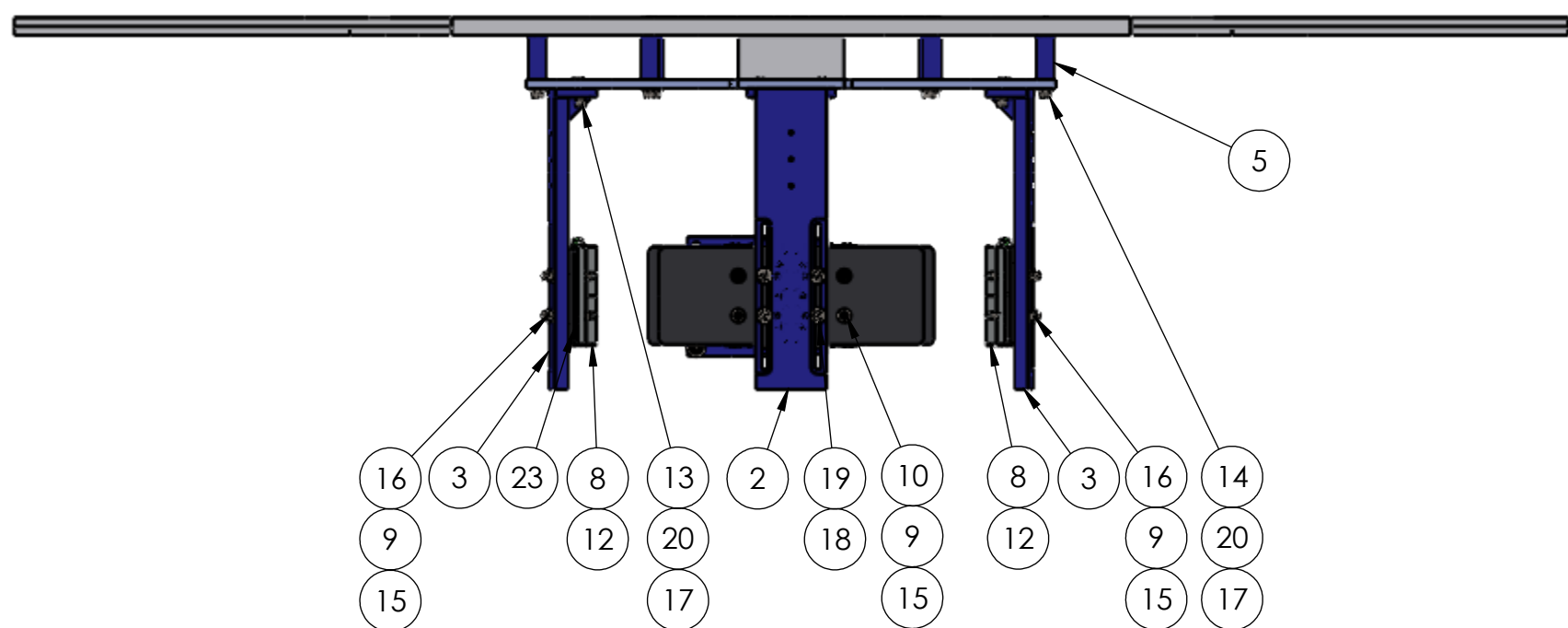
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ASSEMBLY NOTES:

- 1) BOLT THRU ITEM 1 USING (2) EXISTING 3/8-16 TAPPED HOLES MARKED "13" ON EXISTING 2.5" RISER BLOCK
- 2) DRILL AND TAP (6) 3/8-16 HOLES IN GEARBOX FACEPLATE MARKED "14"
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DETAIL A
SCALE 1 : 5

| ITEM | QTY | PART NUMBER | DESCRIPTION |
|------|-----|--------------|-----------------------------|
| 1 | 1 | 201997 | Plate, Bracket Mount |
| 2 | 1 | 201999 | Bracket, Upper Light |
| 3 | 2 | 202000 | Bracket, Side Light |
| 4 | 1 | 202001 | Pedestal, Lower Light |
| 5 | 6 | 202002 | Spacer, Barcket Mount Plate |
| 6 | 2 | 202007 | Block, Light Mount |
| 7 | 4 | 201183C | TL102A |
| 8 | 4 | 201855A | TL102AL |
| 9 | 16 | 201922 | WASHER, LOCK 0.250 |
| 10 | 8 | 201923-0.750 | SHCS, 0.250-20 x 0.750 |
| 11 | 24 | 201923-1.375 | SHCS, 0.250-20 x 1.38 |
| 12 | 8 | 201923-2.250 | SHCS, 0.250-20 x 2.25 |
| 13 | 12 | 201924-1.250 | SHCS 0.375-16 x 1.250 |
| 14 | 6 | 201924-3.750 | SHCS 0.375-16 x 3.750 |
| 15 | 16 | 201925 | WASHER, FLAT 0.250 |
| 16 | 8 | 101356 | NUT, HEX 0.250-20 |
| 17 | 18 | 201927 | WASHER, FLAT 0.375 |
| 18 | 8 | 202003-0.375 | SHSS, 0.313 x 0.375 |
| 19 | 8 | 202004 | WASHER, FLAT 0.313 |
| 20 | 18 | 202005 | WASHER, LOCK 0.375 |
| 21 | 2 | 202019A | TL102A Triple Flat Heatsink |
| 22 | 2 | 202020A | TL102A Triple Bent Heatsink |
| 23 | 2 | 202018A | TL102A Flat Heatsink |

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| | | |
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| UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES: ANGULAR: MACH±0.5° BEND ±1.0° TWO PLACE DECIMAL ±0.01 THREE PLACE DECIMAL ±0.005 BREAK ALL SHARP EDGES | NAME RMC | DATE 11/11/16 |
| MATERIAL | CHECKED | ENG APPR. |
| FINISH | MFG APPR. | Q.A. |
| NEXT ASSY | USED ON | COMMENTS: |
| APPLICATION | DO NOT SCALE DRAWING | |

TITLE:
LT12-16 Production Mounting Brackets

SIZE DWG. NO. REV
C 201996 A
 SCALE: 1:10 WEIGHT: SHEET 1 OF 8

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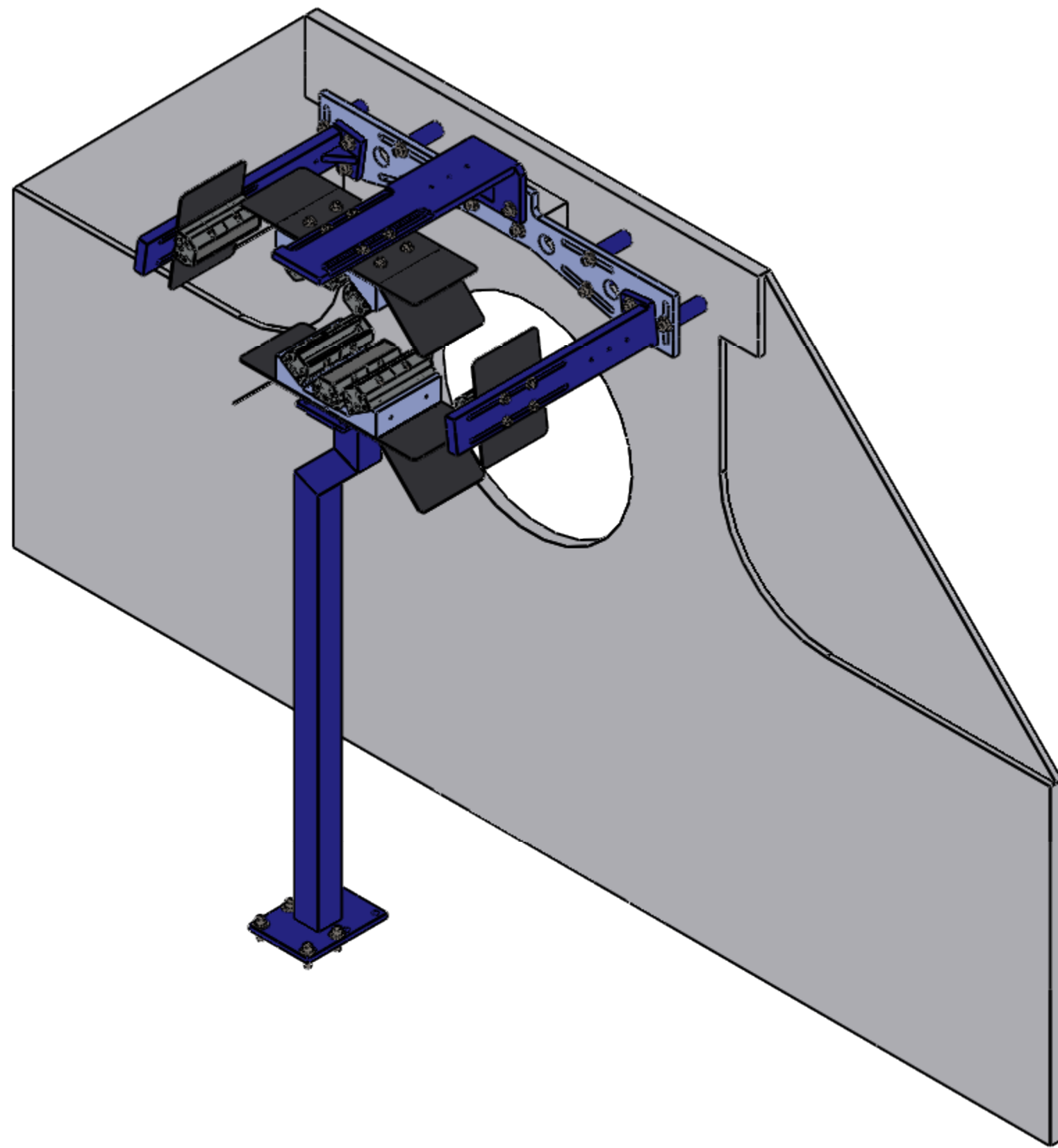
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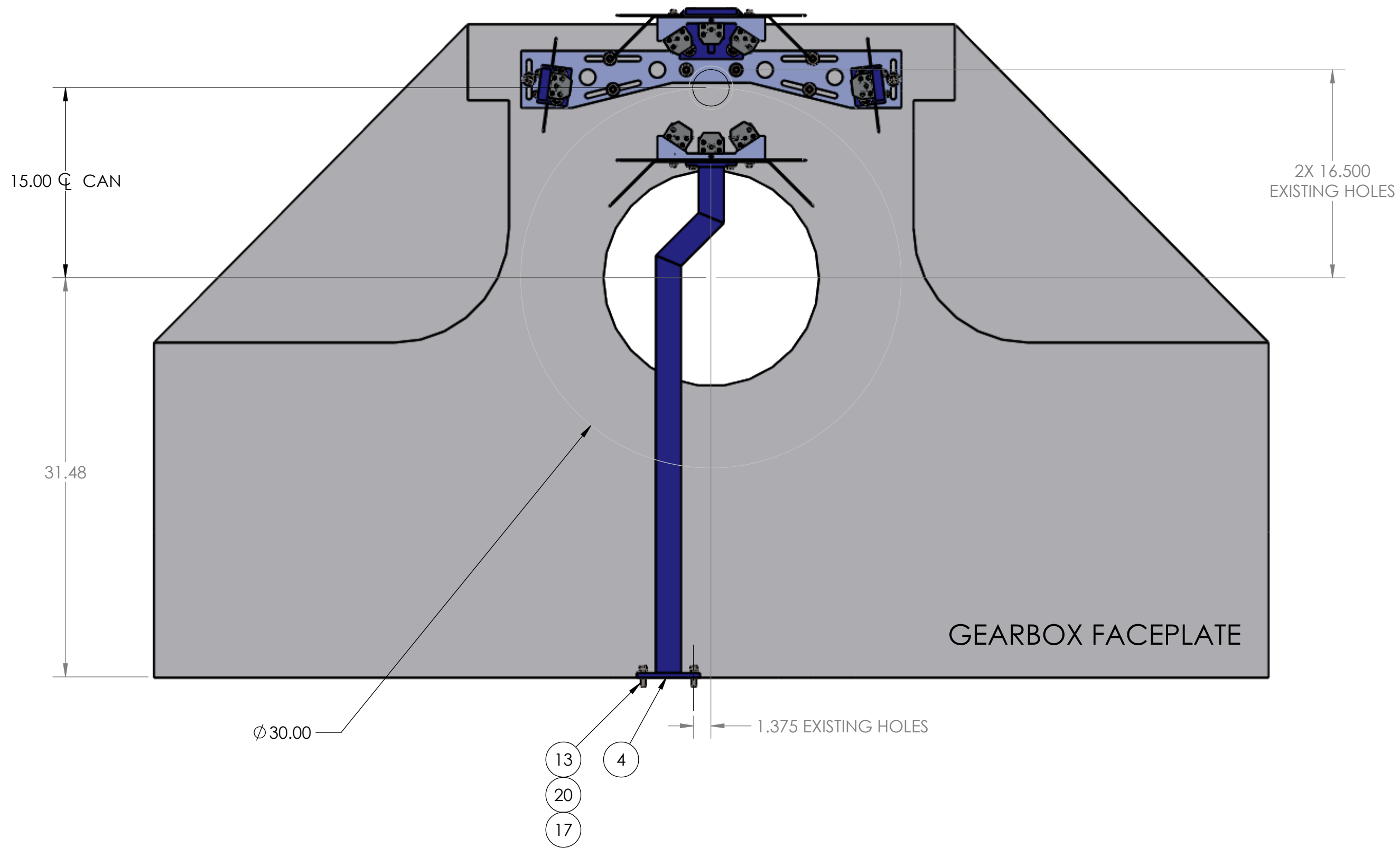
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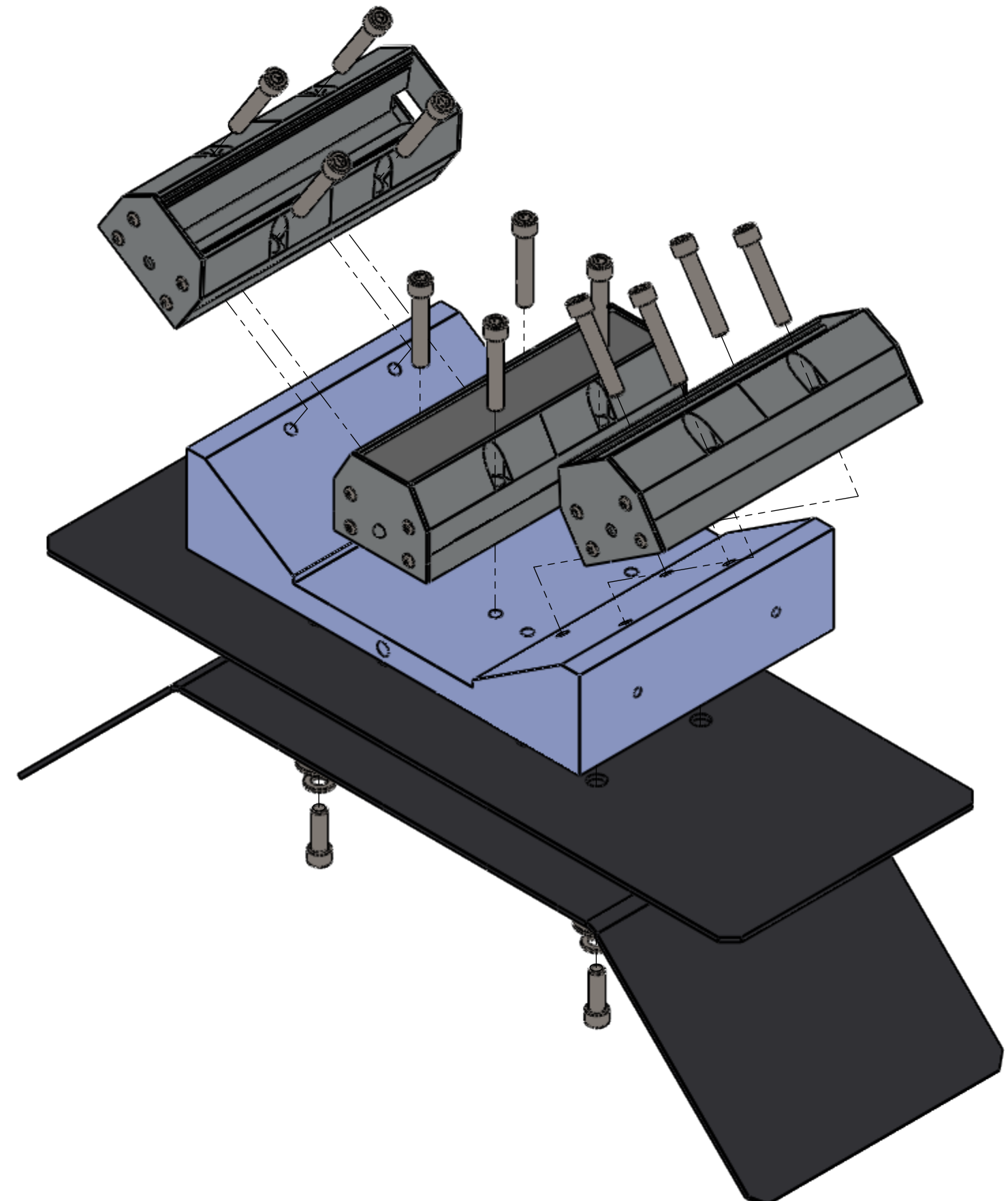
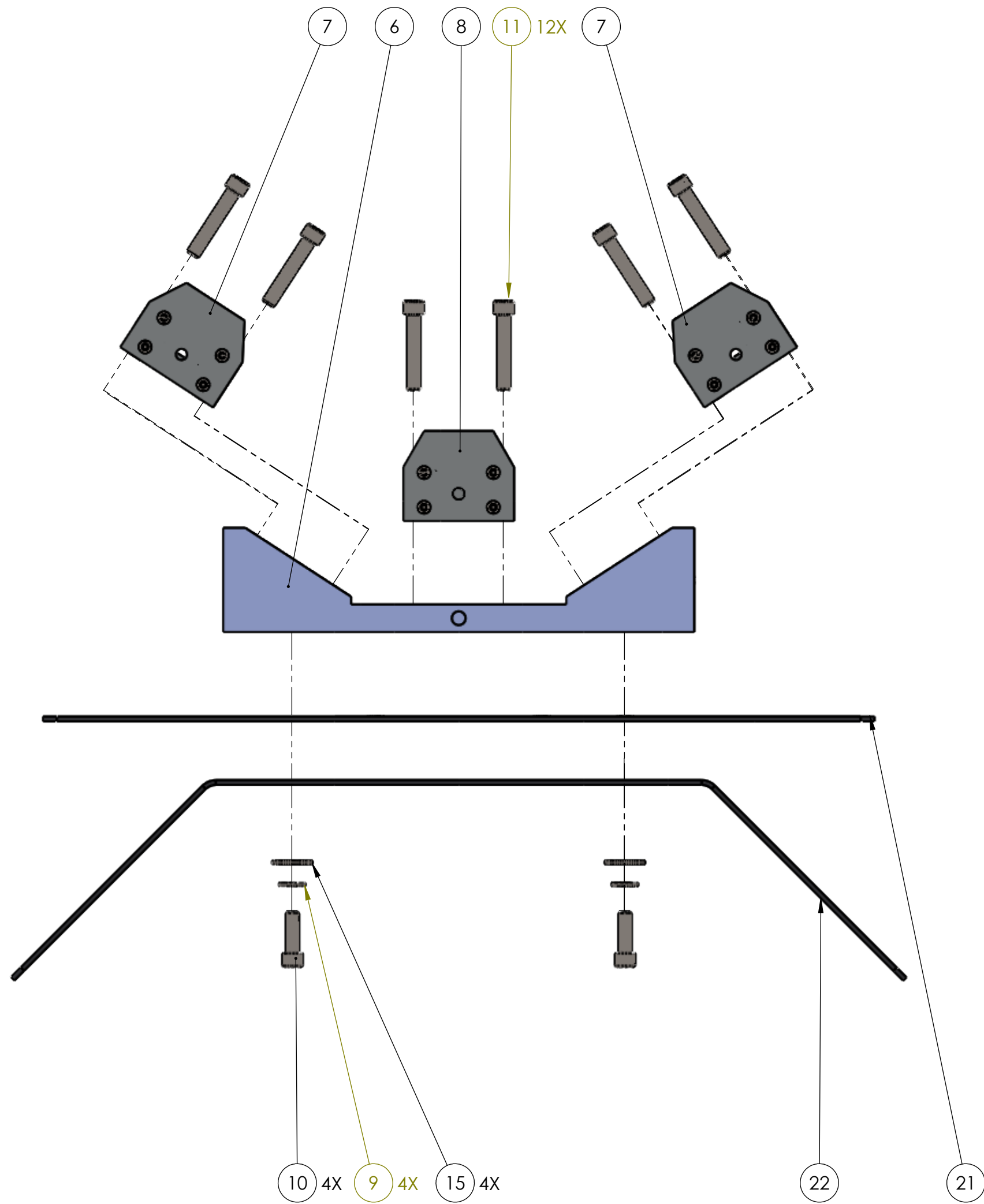
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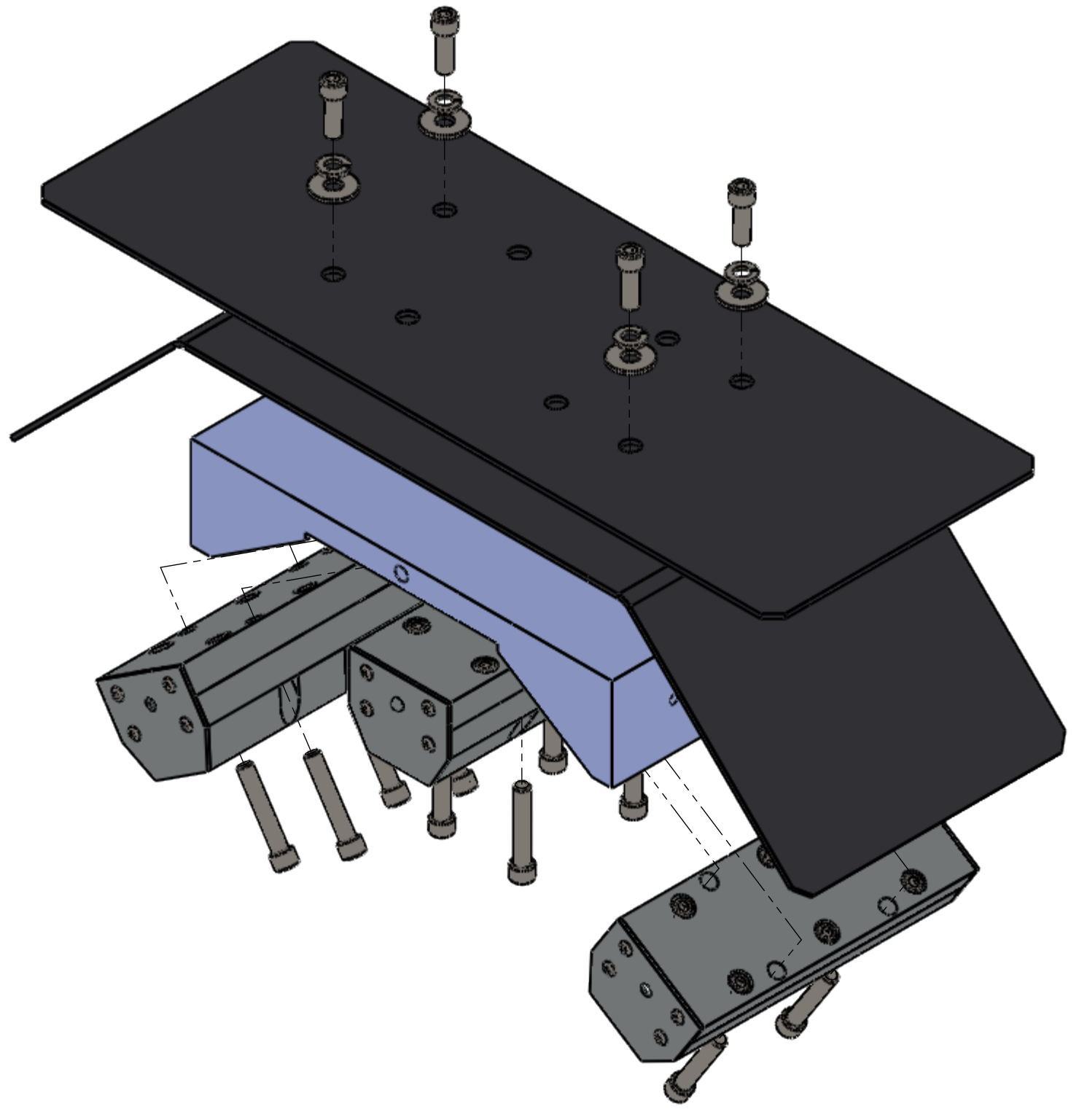
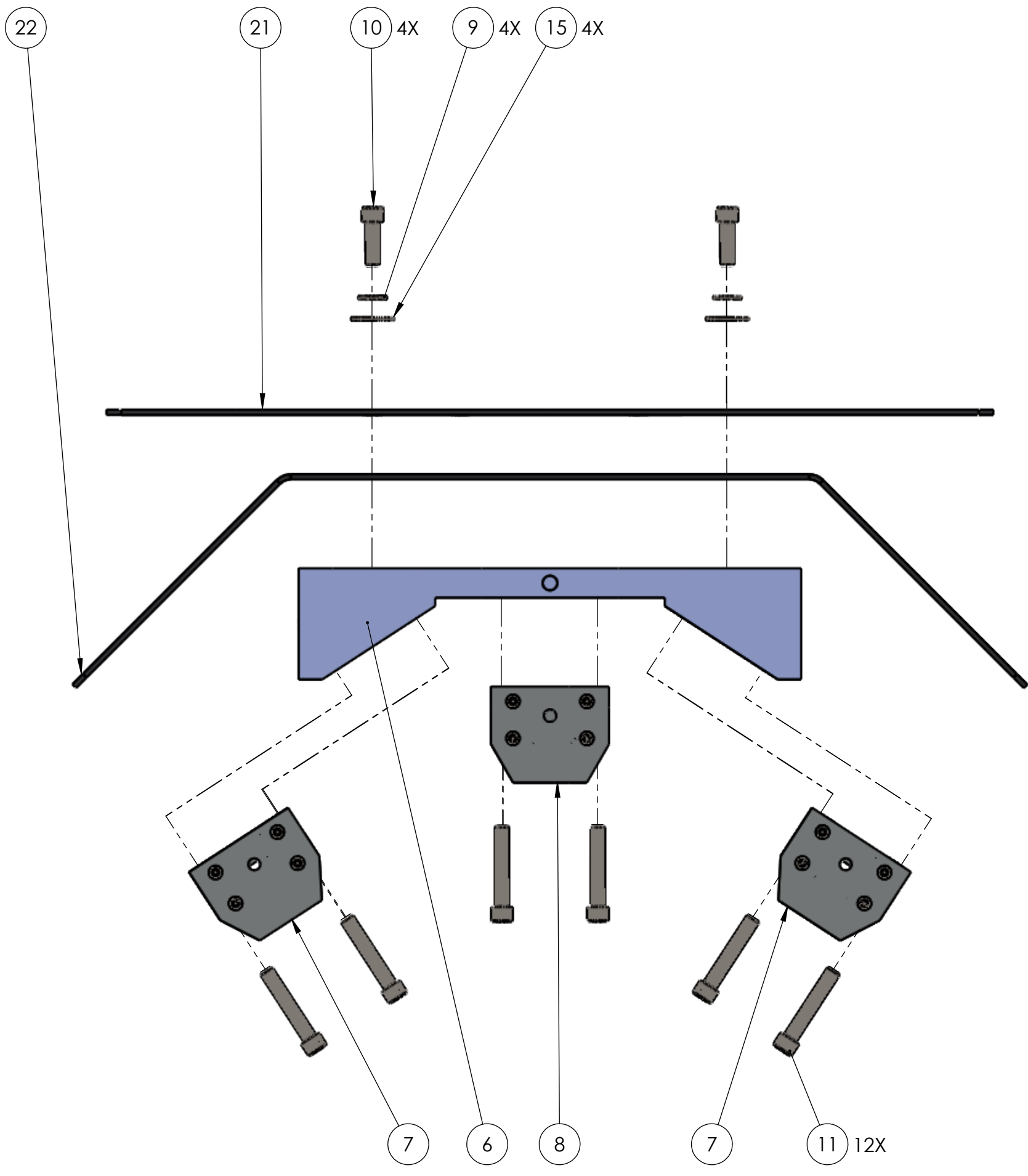
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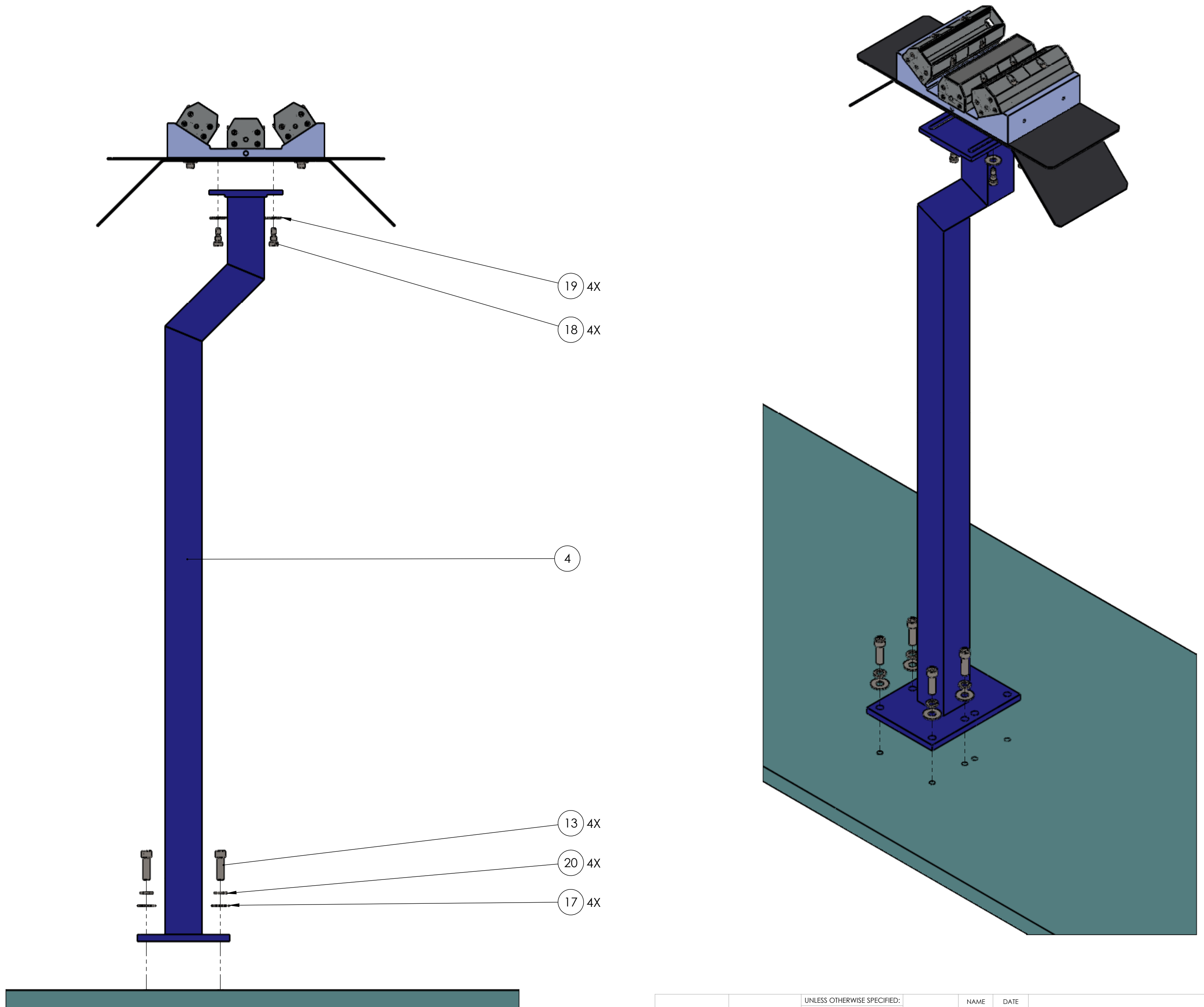
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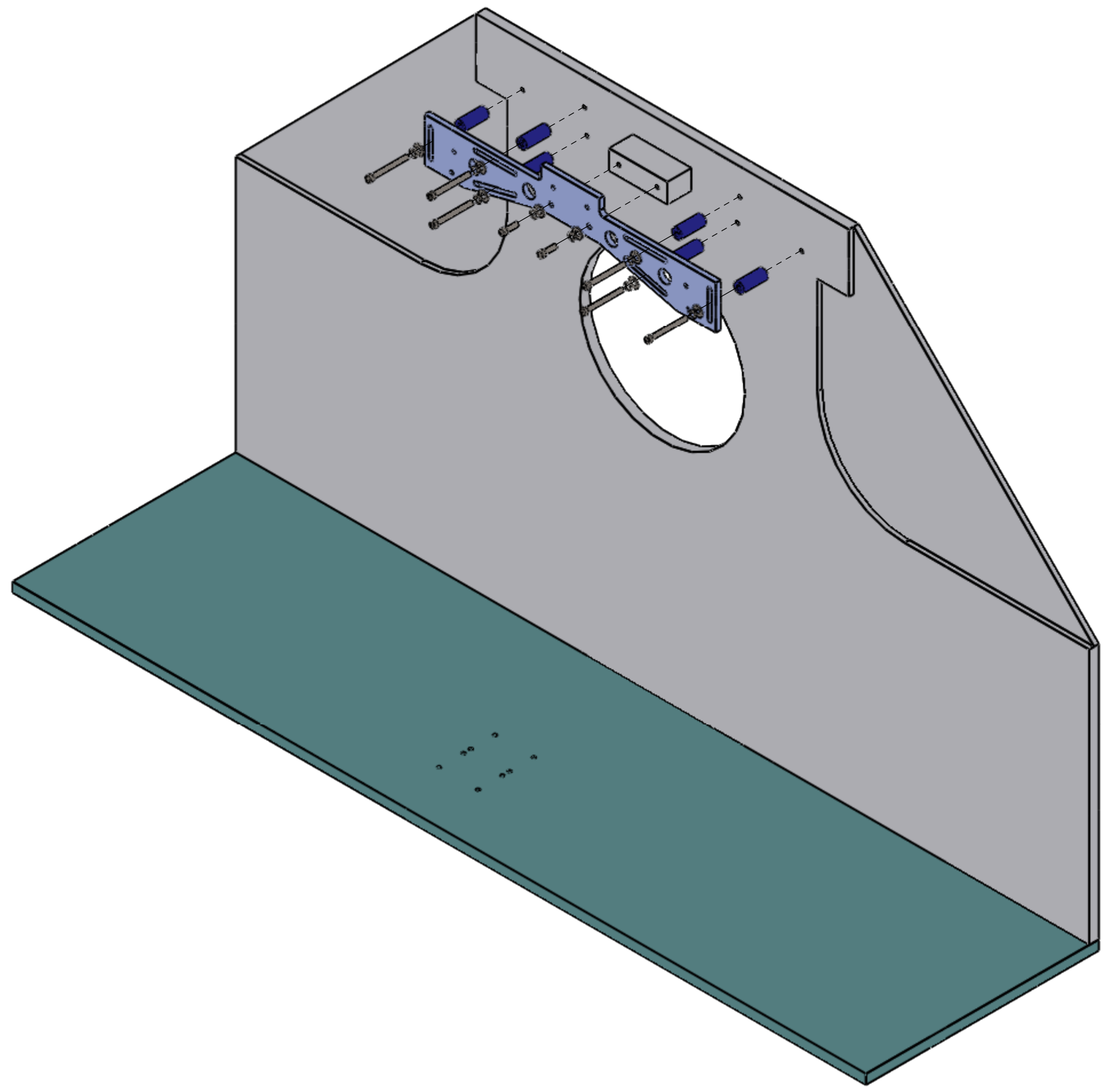
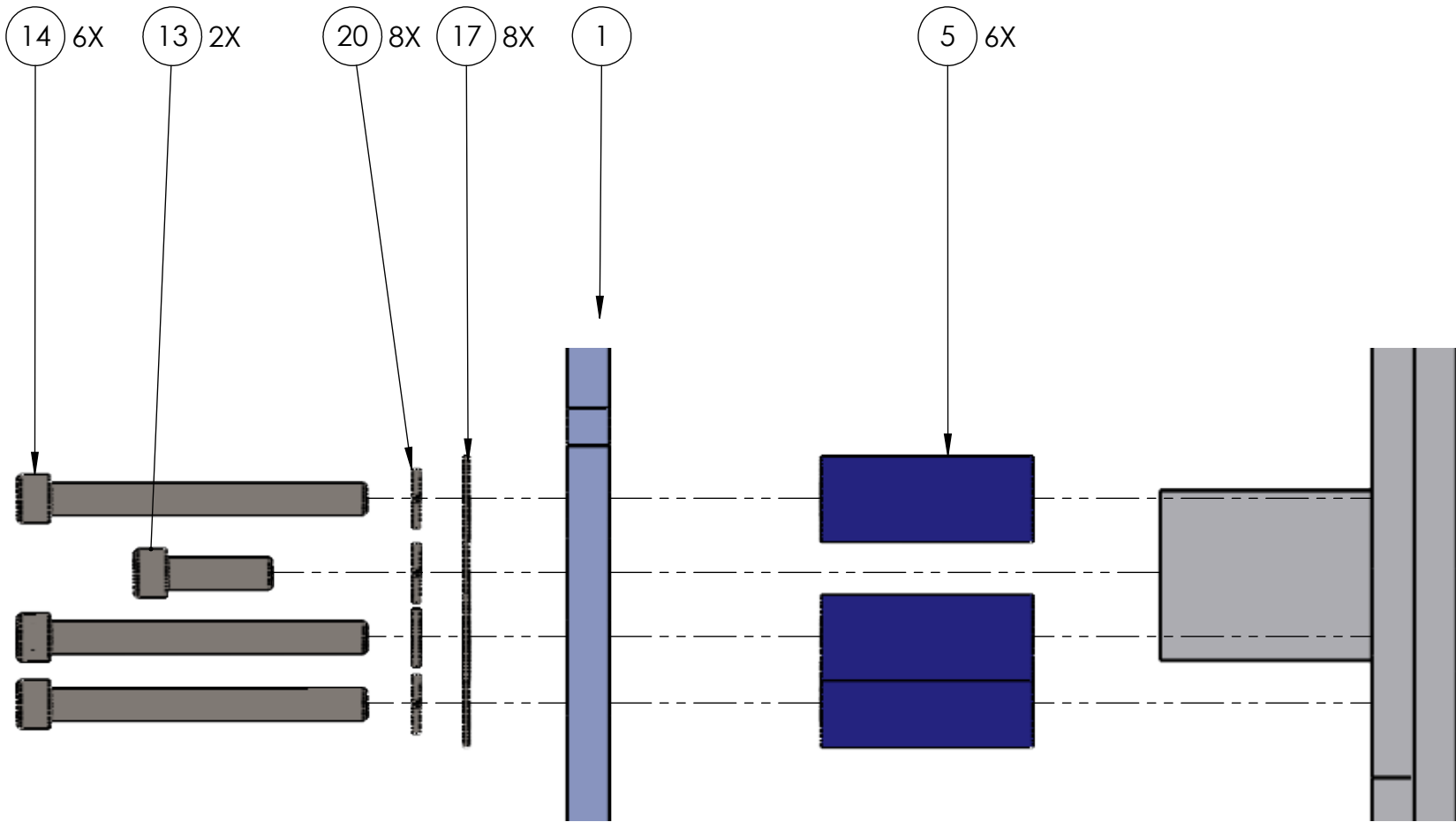
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| | | ANGULAR: MACH ± BEND ± | | MFG APPR. | |
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| | | THREE PLACE DECIMAL ± | | COMMENTS: | |
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| | | MATERIAL | | | |
| | | FINISH | | | |
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| | | SIZE | DWG. NO. | REV | |
| | | C | 201996 | A | |
| | | SCALE: 1:4 WEIGHT: | | SHEET 7 OF 8 | |

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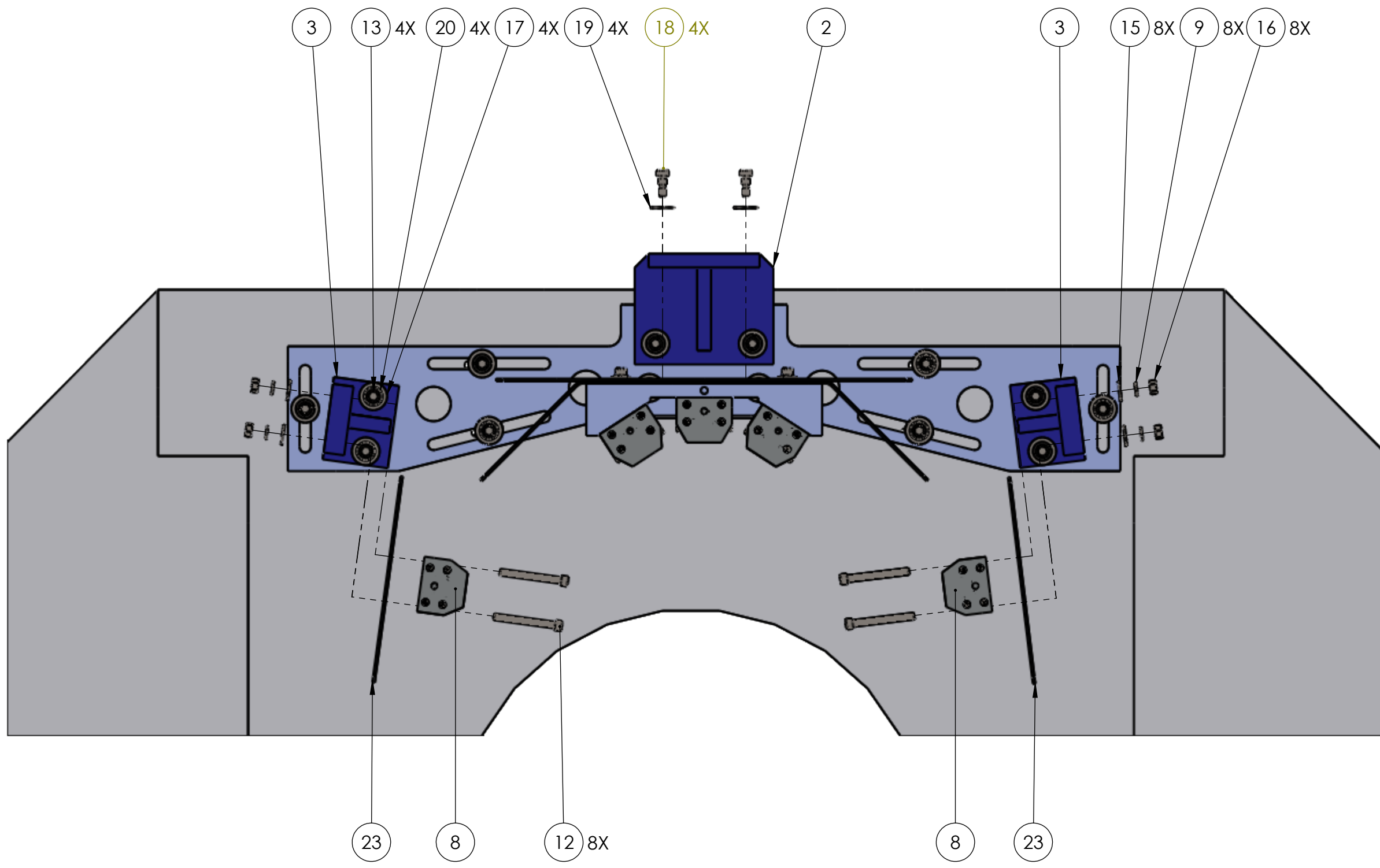
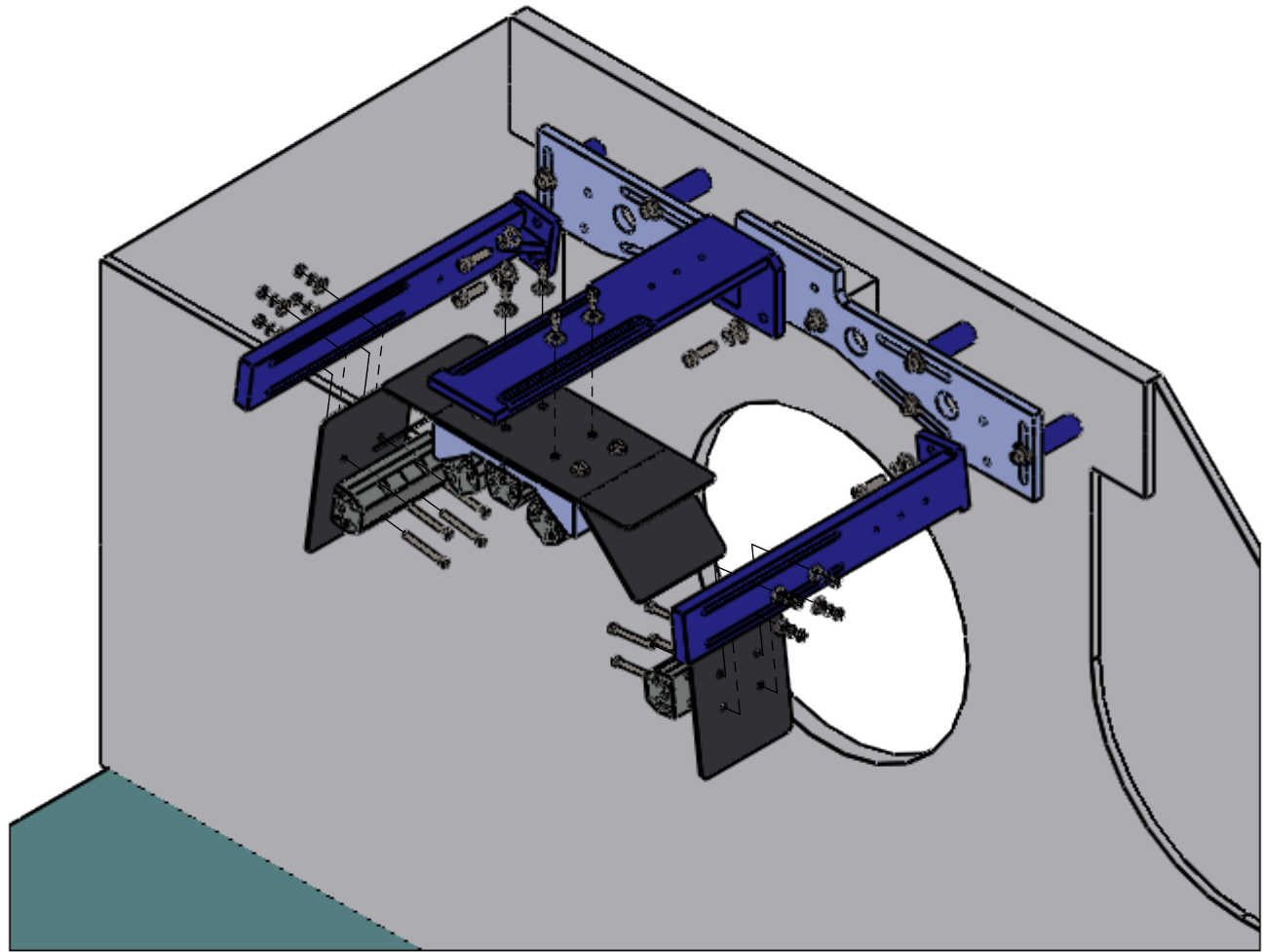
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| | | | | | | | |
|-----------|---------|--------------------------------------|--|-----------|------|----------|--------------------------------------|
| | | UNLESS OTHERWISE SPECIFIED: | | NAME | DATE | | |
| | | DIMENSIONS ARE IN INCHES | | DRAWN | RMC | 11/11/16 | TITLE: |
| | | TOLERANCES: | | CHECKED | | | LT12-16 Production Mounting Brackets |
| | | FRACTIONAL ± | | ENG APPR. | | | SIZE DWG. NO. REV |
| | | ANGULAR: MACH ± BEND ± | | MFG APPR. | | | C 201996 A |
| | | TWO PLACE DECIMAL ± | | Q.A. | | | SCALE: 1:12 WEIGHT: SHEET 8 OF 8 |
| | | THREE PLACE DECIMAL ± | | COMMENTS: | | | |
| | | INTERPRET GEOMETRIC TOLERANCING PER: | | | | | |
| | | MATERIAL | | | | | |
| | | FINISH | | | | | |
| NEXT ASSY | USED ON | APPLICATION | | | | | |
| | | DO NOT SCALE DRAWING | | | | | |

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