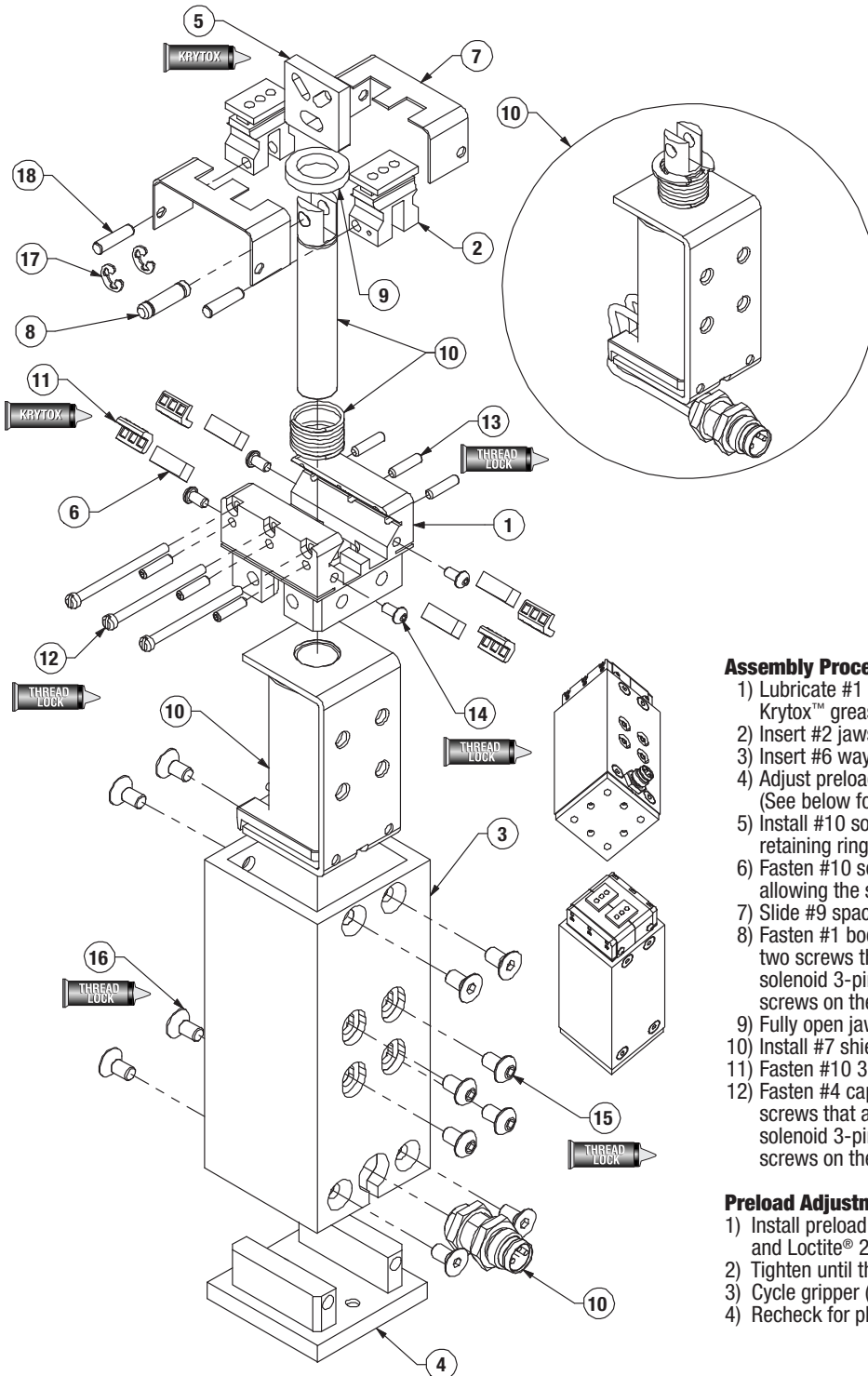


RPE Series Exploded View



Item	Qty	Name
01	1	Body
02	2	Jaw
03	1	Housing
04	1	Cap
05	1	Wedge
06	4	Way
07	2	Shield
08	1	Clevis Pin
09	1	Spacer
10	1	Solenoid
11	4	Kit, Roller Bearing and Cage
12	3	Preload Screw
13	6	Set Screw-Way Locating
14	4	BHCS-Shield Mounting Screw
15	4	BHCS Solenoid Mounting Screw
16	8	FHCS-Housing Mounting Screw
17	2	Retaining Ring
18	2	Dowel Pin

NOTE: Contact the DE-STA-CO Customer Service for a complete spare parts list with order numbers and prices.

Assembly Procedure

- 1) Lubricate #1 body, #5 wedge, and #11 bearings using Krytox™ grease.
- 2) Insert #2 jaws and #5 wedge into body.
- 3) Insert #6 way and #11 bearings into each end of the body. (See below for procedure)
- 4) Adjust preload by adjusting #12 preload screws.
- 5) Install #10 solenoid plunger with #8 clevis pin and #17 retaining rings.
- 6) Fasten #10 solenoid to housing. Do not tighten yet, allowing the solenoid to freely move within slots.
- 7) Slide #9 spacer and #10 solenoid spring onto plunger.
- 8) Fasten #1 body into #3 housing. Completely fasten the two screws that are located on the same side as the #10 solenoid 3-pin connector then fasten the two remaining screws on the opposite side.
- 9) Fully open jaws and tighten #15 screws securely.
- 10) Install #7 shields to gripper.
- 11) Fasten #10 3-pin connector.
- 12) Fasten #4 cap into housing. Completely fasten the two screws that are located on the same side as the #10 solenoid 3-pin connector then fasten the two remaining screws on the opposite side.

Preload Adjustment Procedure

- 1) Install preload screws (12) with Loctite® 7649 primer and Loctite® 242 thread locker on threads.
- 2) Tighten until there is no side play in the jaws.
- 3) Cycle gripper (w/finger assembly)
- 4) Recheck for play in jaws & tighten or loosen as needed.



Seal Kit Items



Thread Locker



Krytox™ Lubricant



Lightweight Machine Oil



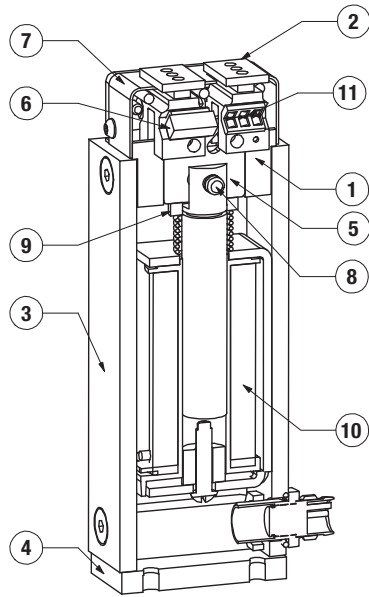
Teflon™ Based Grease



Super Bonder



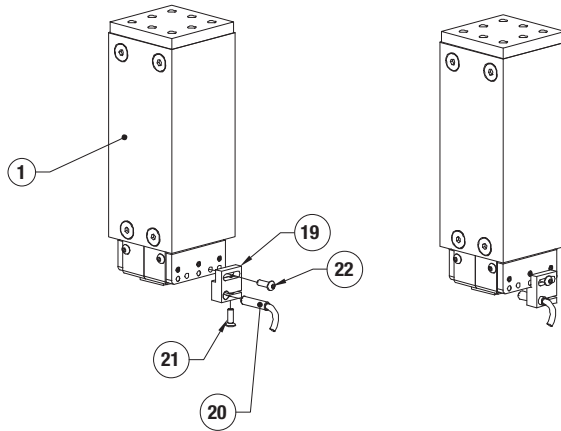
Third Angle Projection



Item	Qty	Name
01	1	Body
02	2	Jaw
03	1	Housing
04	1	Cap
05	1	Wedge
06	4	Way
07	2	Shield
08	1	Clevis Pin
09	1	Spacer
10	1	Solenoid
11	4	Kit, Roller Bearing and Cage

NOTE: Contact the DE-STA-CO Customer Service for a complete spare parts list with order numbers and prices.

Accessory Installation & Adjustment Instructions



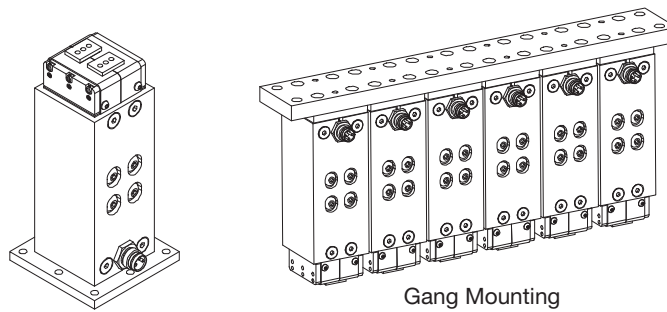
Installation*

- 1) Install sensors as shown.
- 2) Adjust for desired end of stroke detection.

* Fingers should be designed to act as target for inductive sensor. Sensing range is 0.031 [0.8]. The center line of the sensor diameter is located 0.094 [2.4] off of jaw mounting surface.

Fingers supplied by customer.

Flange Mounting Plate, Gang Mounting and more...



Flange Mounting Plate

Gang Mounting

Drawings shown are for concept only. Contact DE-STA-CO Tech Support with project requirements.

<p>SK Seal Kit Items</p>	<p>THREAD LOCKER Thread Locker</p>	<p>KRYTOX Krytox™ Lubricant</p>	<p>O Lightweight Machine Oil</p>	<p>G Teflon™ Based Grease</p>	<p>GLUE Super Bonder</p>	<p>Third Angle Projection</p>
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