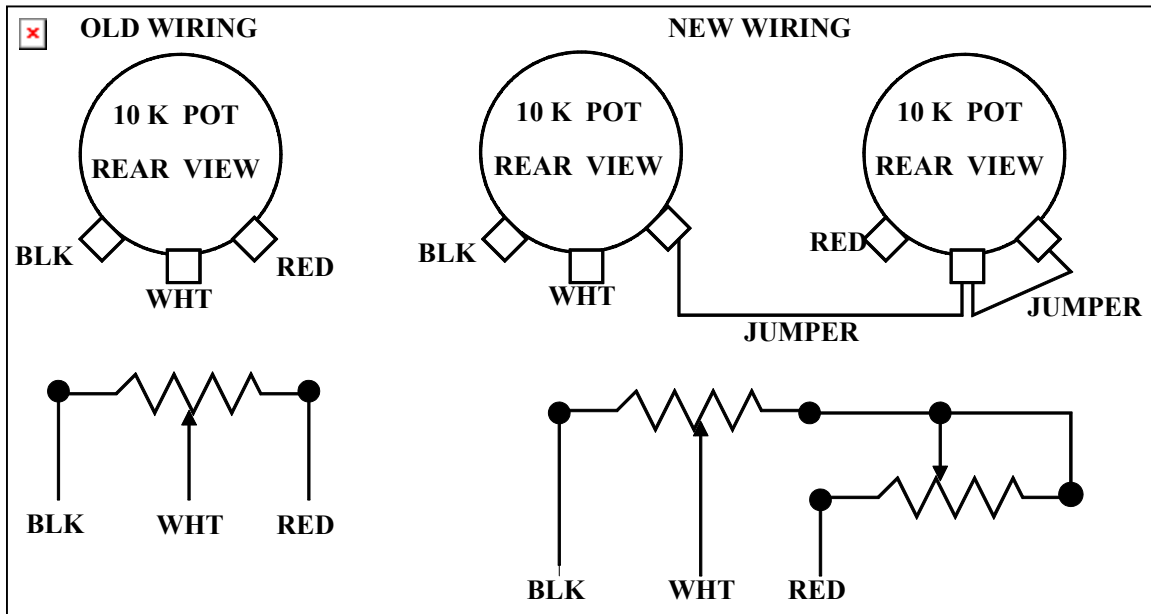


HEATH CUSTOM PRESS  
MAXIMUM PRESS SPEED MODIFICATION  
FOR MICROPROCESSOR TURRET PRESS  
03 JUNE 2001



**This modification is for those Microprocessor presses that do not have a maximum press speed limiting potentiometer adjustment on the motor controller board. This modification requires the installation of a second 10K potentiometer. The new pot can be mounted to the divider panel of the power box. It may be necessary to extend the length of the old red wire. It will be necessary to have a short length of 22 gauge wire for the additional added jumpers.**

1. Remove the power to the press.
2. Remove the main power box front cover.
3. Locate the existing speed control pot behind the speed control knob.
4. Add a second pot like the original (10K value) pot to the divider panel either by drilling a hole, or using double stick tape on the new pot.
5. Modify the wiring with the following instructions:
  - a. Remove the red wire from the old pot.

- b. Add a jumper from where the red wire was attached on the old pot to the center tab on the new pot. (Shown in the above wiring diagram).
  - c. Add a jumper from the right hand tab on the new pot to the center tab of the new pot. (Shown in the above wiring diagram).
  - d. Place the red wire, removed from the old pot, in the left hand tab of the new pot. (Shown in the above wiring diagram).
  - e. Solder all connections at the pots. It is recommended to use shrink tubing over the soldered connections.
6. Turn on the power to the press.
7. Pull run on the press, and turn the operator speed control potentiometer to the maximum speed position.
8. Adjust the new potentiometer to the desired speed of the press. The new pot will limit the input voltage to the AC motor controller, thus limiting the speed of the press.
9. If everything checks out, turn off the power to the press and re-install the power box front cover.
10. The installation is complete.