



## 12 - Lathe - Parts Catcher

# Lathe - Interactive Service Manual

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## 12.1 PARTS CATCHER SERVICE PROCEDURES

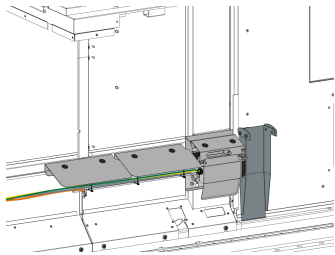
### Parts Catcher - Service Procedures

PROCEDURE	DESCRIPTION
<a href="#">Single Action Parts Catcher - Flat Door - Installation</a>	This procedure shows you how to install the Single Action Parts Catcher on Flat Door ST-10/15 machines.
<a href="#">Dual Action Parts Catcher - Flat Door - Installation</a>	This procedure shows you how to install the Dual Action Parts Catcher on Flat Door ST-10/15/20/25/30/35 machines.
<a href="#">Dual Action Parts Catcher - Actuator Replacement</a>	This procedure shows you how to replace the Dual Action Parts Catcher Actuator on ST machines.
<a href="#">Single Action Parts Catcher - Angled Door - Installation</a>	This procedure shows you how to install the Single Action Parts Catcher on Angled Door ST-20/25/30/35 and DS-30 machines.

## 12.2 PARTS CATCHER - TROUBLESHOOTING GUIDE

### PCAT - Troubleshooting Guide

#### Introduction

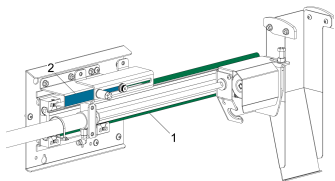


This procedure shows you how to troubleshoot the Parts Catcher system on all ST machines.

#### Symptom Table

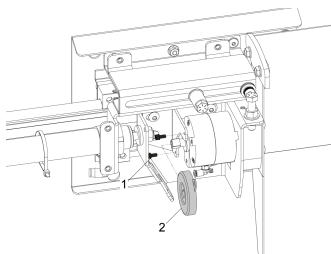
SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Slow depolyment / moving chute	Lack of lubrication / Chip build up	Refer to <b>Lubrication</b> section below
	Faulty rotary damper	Refer to <b>Actuation</b> section below
	Lack of air supply	Check all air lines are properly connected and verify solenoid functionality

#### Lubrication



Clean the highlighted surfaces [1] and [2] from any debris / metal chips / coolant residue then grease the blue surface [2].

#### Actuation



If your PCAT is experiencing slow or excessively fast deployment it may be due to a worn out damper.

Replace the rotary damper [2] by simply removing the covering sheet metal and hardware [1].

**Note :** An updated damper **P/N 59-2164** is recommended for this replacement and is included in Svc Kit **93-3771** PCAT SVC KIT 3 N.M DAMPER ST-10/20/30