
Relay Retrofit Program Cutting Tool

Operating Guide SPACOM 100



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1. Preparations



You can perform the cutting from the front or the back of the door panel.

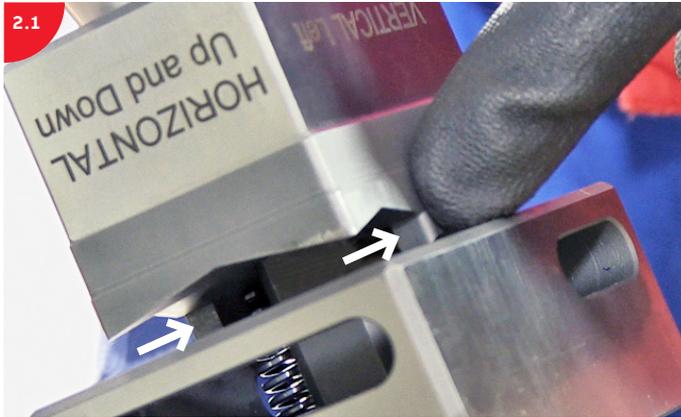
In this example cutting is done from the back, because the supporting structure of the door is close to the assembly opening.

Ensure that there is enough space to operate the cutting tool in all intended directions. Check the space required by the replacement IED and its wiring.



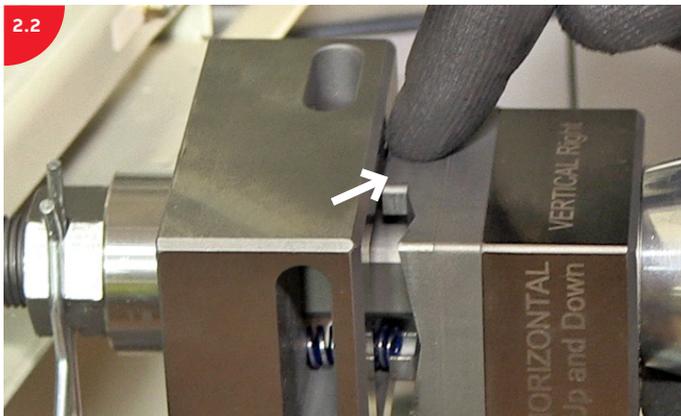
Start by removing the existing relay.

2. Setting the guiding of the cutting head



To set the cutting head for **horizontal** guiding: push the cutting head against the edges, as indicated with arrows in the image.

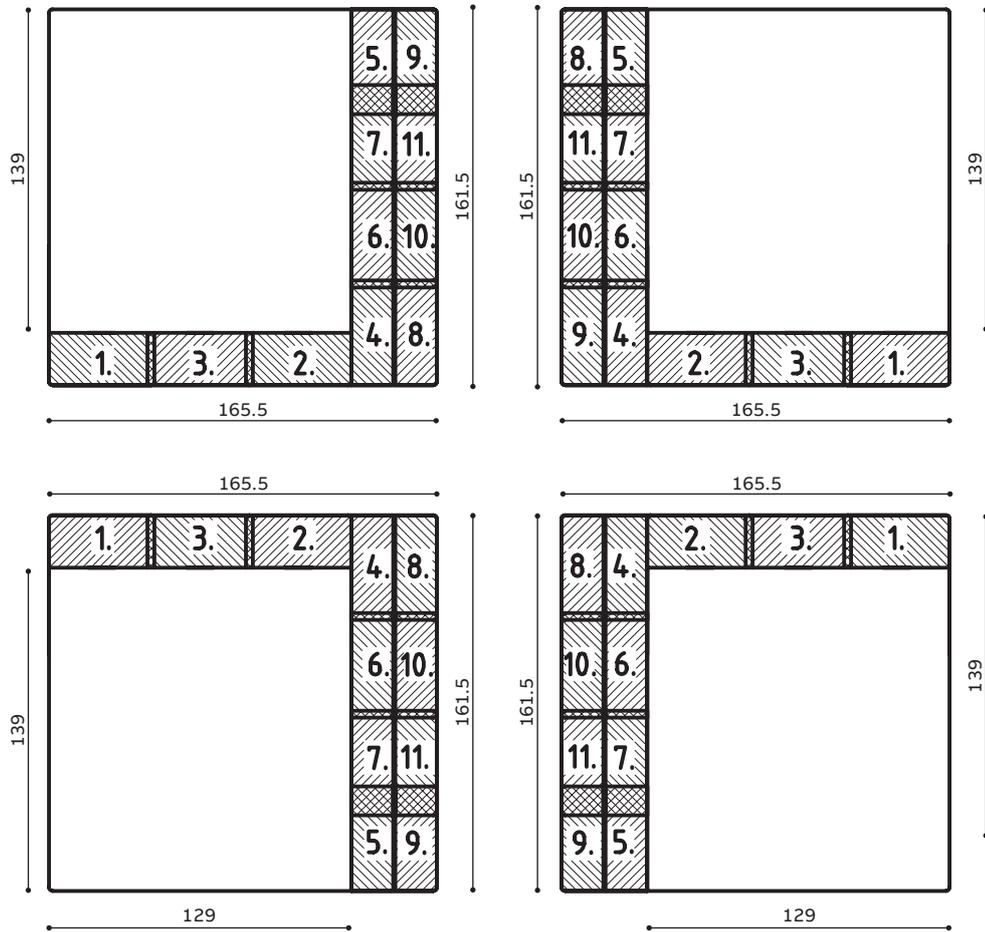
Ensure that the cutting head is set in the correct position!



To set the cutting head for **vertical** guiding: push the cutting head against the edges.

Ensure that the cutting head is set in the correct position!

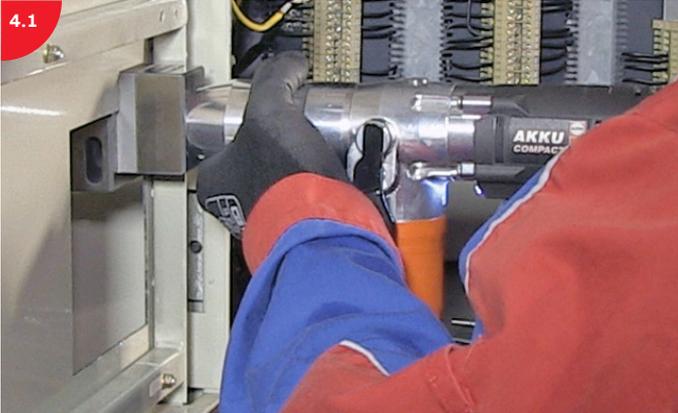
3. Cutting cycle



Perform the cutting in the order specified in the picture.

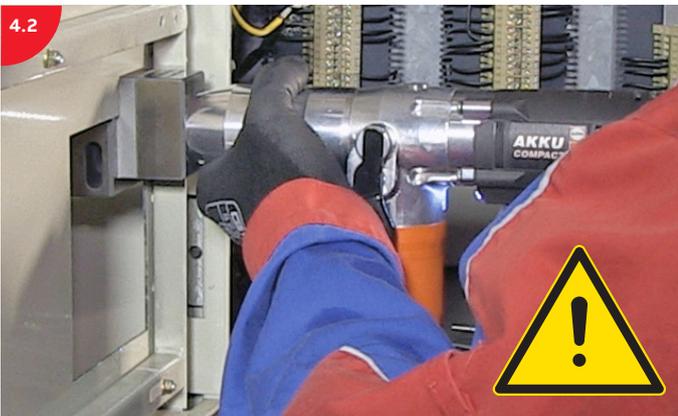
There are four options depending on which layout is wanted.

4. Operating the cutting tool on a horizontal edge (top/down)



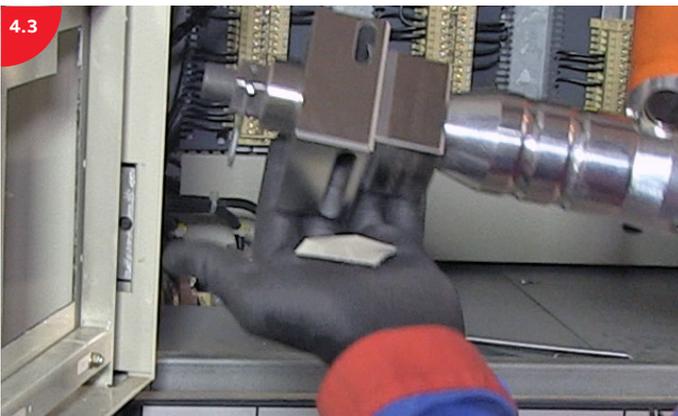
To cut horizontally, place the cutting head guiding against the top or bottom edge of the opening.

Ensure that the cutting head is set in the correct position. The text **HORIZONTAL Up and Down** must point in the direction you are cutting.



For your safety, keep your hands on the power unit, never on the cutting head.

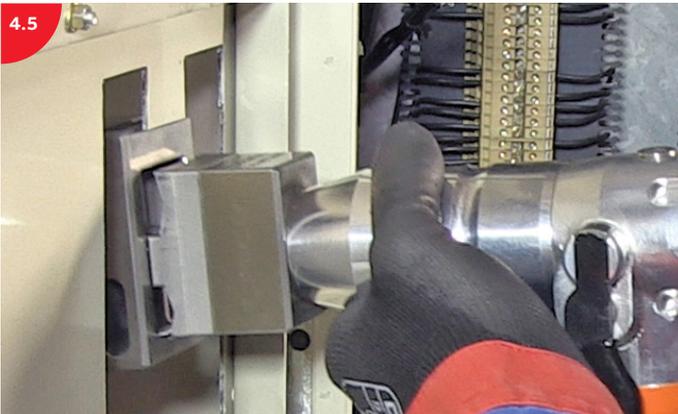
Beware of the sharp edges!



Remove the offcut from the cutting head after each cutting cycle.



Push the vent lever to ensure that the punch is released after each cutting cycle.



Make three punches, side by side.

Ensure you use the correct guiding, after each cutting cycle!



Cut the parts next to the edges first and the middle part last.

5. Changing the cutting direction



Rotate the cutting head to set the correct cutting direction.



Ensure that the text on the cutting head, indicating the desired cutting direction, is facing you!

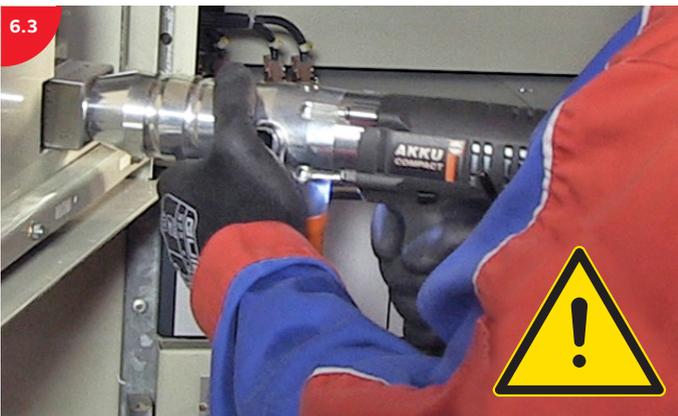
6. Operating the cutting tool on a horizontal edge (top/down)



Push the cutting head against the edges.



Make eight punches in two columns, side by side.



For your safety, keep your hands on the power unit, never on the cutting head.

Beware of the sharp edges!

6.4



When you are using vertical guiding, the offcut falls out of the cutting head immediately.

6.5



Note the cutting order. Cut the parts next to the edges first and the middle part last.

6.6



Repeat the same procedure for the second column.

7. Finishing your work

7.1



Finish your work and close the door.

7.2



Install the new IED.

Clean the offcuts from the floor.



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