



745-35-10

Additional Instructions

Assembling the long
transport clamp

IMPORTANT
READ CAREFULLY BEFORE USE
KEEP FOR FUTURE REFERENCE

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1 General information

Class 745-35-10 can be retrofitted with a long transport clamp.

Components of the kit

Check whether the scope of delivery for kit 0745 417754 is correct prior to installation.

| Part number | Quantity | Description |
|----------------|----------|---|
| 0745 417824 | 1 | Set of clamps, right, consisting of: <ul style="list-style-type: none">• 0745 417744, clamp, quantity:1• 0745 417764, flap clamp, quantity:1 |
| 0745 417834 | 1 | Set of clamps, left, consisting of: <ul style="list-style-type: none">• 0745 417734, clamp, quantity:1• 0745 417774, flap clamp, quantity:1 |
| 0791 745790 EN | 1 | Additional Instructions |

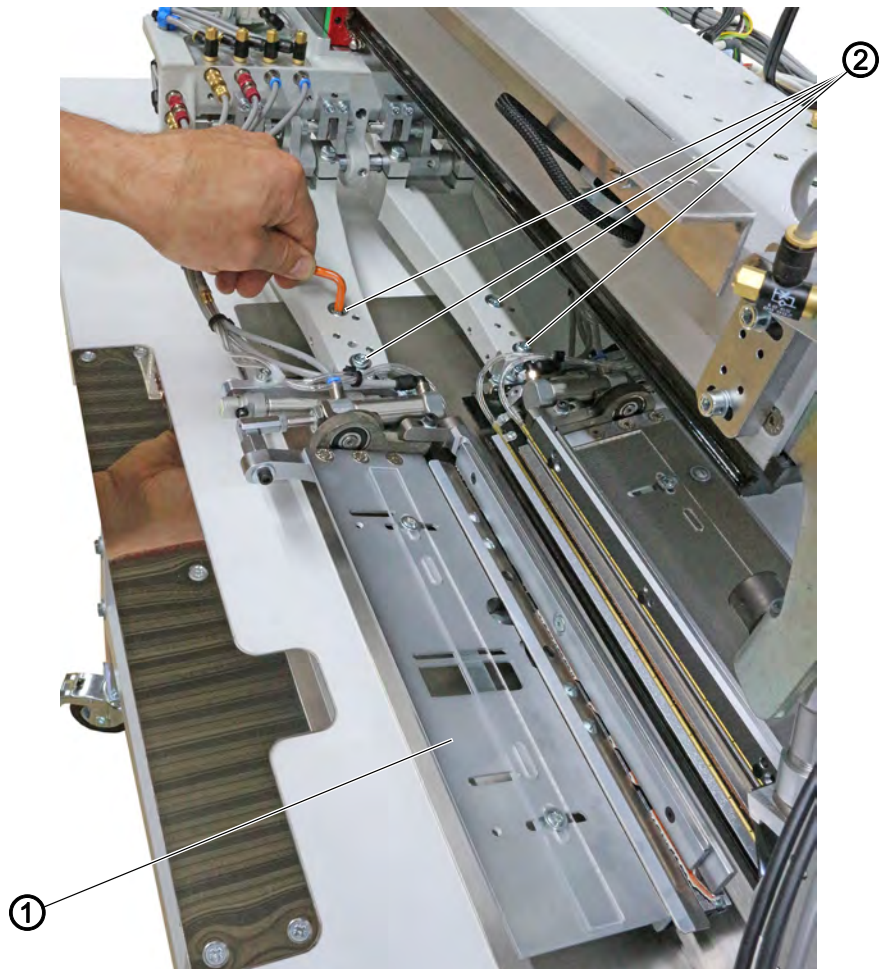
2 Assembling the long transport clamp



To assemble the long transport clamp:

1. Disassemble the old transport clamp:
 - Pull the cables off the throttle valves.
 - Unscrew the transport clamp

Fig. 1: Assembling the long transport clamp (1)

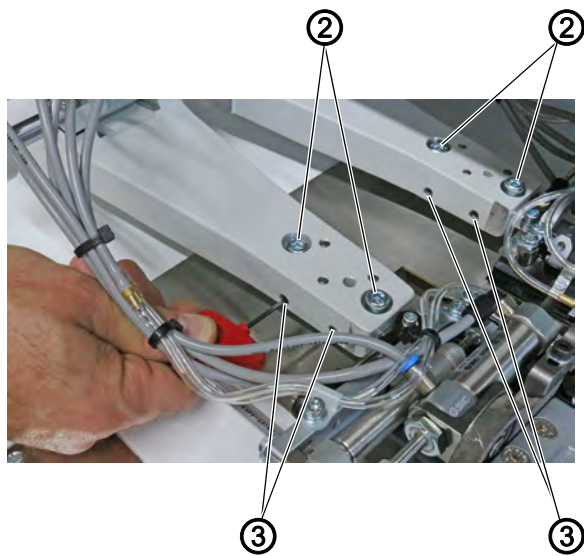


(1) - Long transport clamp

(2) - Screws

2. Insert the long transport clamp (1) and slightly tighten the screws (2).
3. Connect the cables on both sides of the corresponding throttle valves.

Fig. 2: Assembling the long transport clamp (3)



(2) - Screws

(3) - Screws

4. Set the long transport clamp including the screws (3) parallel to the folder.
5. Tighten the screws (2).

3 Adjusting the software settings



Information

The long transport clamp requires a software version A02.XX.

If the machine has a software version A01.XX a software update must be performed (*Operating Instructions*).

Following the installation of the long transport clamp, the software setting for the seam length must be set to a greater value. The greater seam length must be set both in the service menu and in the program parameters.

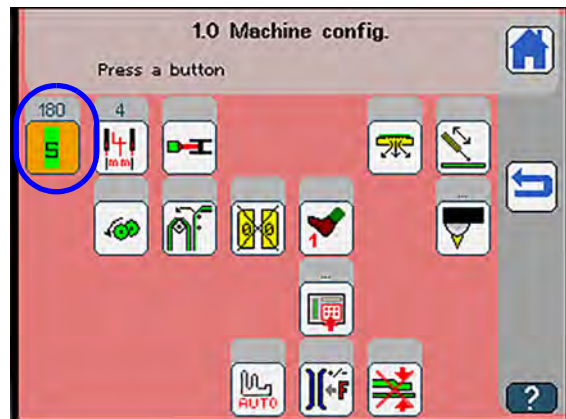
Adjusting the setting in the service menu



To set the seam length in the service menu:

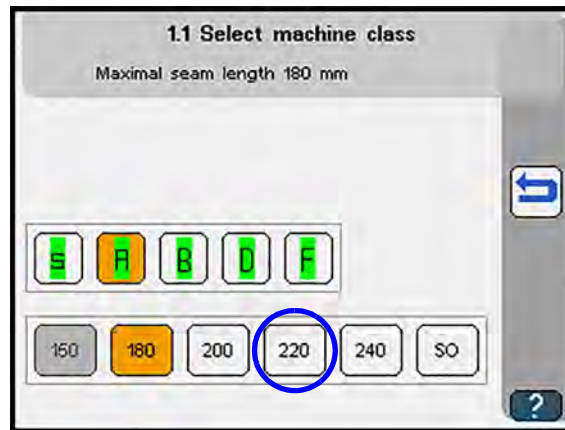
1. Select the subitem *Machine configuration* in the service menu .

Fig. 3: Adjusting the setting in the service menu (1)



2. Select the subitem *Subclass* and set the seam clearance to **220 mm**:

Fig. 4: Adjusting the setting in the service menu (2)



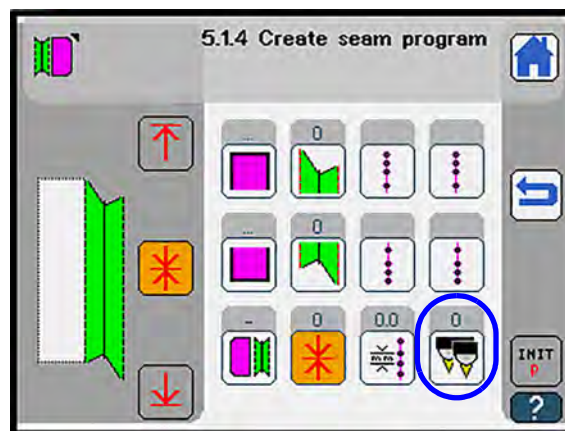
Adjusting the setting in the program parameters






To set the seam length in the program parameters:

1. Select the item *Create seam program* in the program parameters **PP**.

Fig. 5: Adjusting the setting in the program parameters






2. Select the subitem *Flap scan* and set the flap length to **220 mm**.
3. Adjust or correct the positioning points    of the seam programs that have already been created.

4 Additional settings

4.1 Selecting the positioning points

Following the installation for the long transport clamp, you need to select new positioning points.

To do so, refer to chapter **Aligning the laser modules** ( *Service Instructions*) and **Select positioning points** ( *Service Instructions*,  *Operating Instructions*).

4.2 Changing the folder

The folder for class745-35-10 A must be changed to a folder with a length of 220 mm.

To do so, refer to chapter **Folder** ( *Service Instructions*).



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