

**LION PRECISION RP2 CNC RETRACTABLE PROBE HOLDER
INSTRUCTION SHEET**

M015-1001.001

Unpacking

Included in the carton should be the following items:

- This Instruction Sheet
- One fully assembled RP2 CNC Retractable Probe Holder

The RP2 CNC Retractable Probe Holder requires:

- Air supply of 50 – 100PSI
- A Programmable CNC voltage control output capable of 2W output power minimum
This output voltage must match the RP2 air solenoid voltage as labeled on the control cable. Options are:
 - 12VDC
 - 24VDC
 - 24VAC
 - 110VAC

Mounting the Probe Holder

Mount the mounting bar to the face of the coiler so the probe, when extended, will be positioned to measure the spring. Allow clearance for the clamping system around tooling etc.

Electrical Connection

There is a 10' (3m) cable that connects to CNC control terminals.

Wire Color	Connection
Red	Ground
Black	+VDC (24VDC, 12VDC) Line (110VAC, 24VAC)
White	0 VDC (24VDC, 12VDC) Neutral (110VAC, 24VAC)

Air Connection

The RP2 Retractable Probe Holder comes with a 1/4" push type fitting for air supply. Push a 1/4" piece of plastic air supply tube into the fitting, and connect to shop air supply. The RP2 Retractable Probe Holder operates on air pressures from 50-100PSI.

Operating/Programming the Retractor

When voltage is applied to the solenoid, the probe retracts. Construct the program so the probe is in the measurement location and stable before triggering the gage. Allow at least 10mS after triggering the gage before retracting the probe.