



Door Pro



Model: #713A- Door Pro

Serial Number: DP-

130 Salt Point Turnpike
Poughkeepsie, NY 12603

Tel: (845)-452-3780

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Web: <http://www.jamestaylor.com>

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INTRODUCTION

Company Introduction

We at James L. Taylor would like to thank you and your company for selecting the James L. Taylor Pneumatic Miter Door Pro. With proper care, your Pneumatic Miter Door Pro will provide you with many years of reliable service.

This manual contains important information about the installation, operation and maintenance of your machine. We urge you to read it carefully, become familiar with the components and features it describes. Following these recommendations will make your door pro as trouble free and productive as possible.

This manual is intended for use by anyone working with our product. It should be kept available for immediate reference so that operations can be performed with maximum efficiency and safety. Do not attempt to perform maintenance or operate this machine until you have read and understand the information contained in this manual.

Limited Warranty

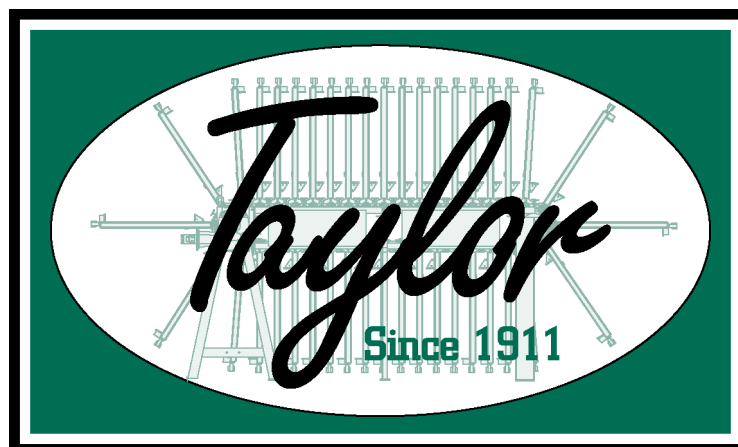
(This supersedes all previous warranties)

James L. Taylor Manufacturing guarantees all products of its manufacture to be free of defects in workmanship or material when properly installed, serviced and maintained under normal conditions. **James L. Taylor Manufacturing's** obligation under this warranty is limited to repairing or replacing any part or parts thereof which shall within one (1) year after shipment to the original user, be returned to its factory, transportation charges prepaid, and which **James L. Taylor Manufacturing's** examination shall disclose to be defective.

James L. Taylor Manufacturing assumes no liability for labor charges incidental to the adjustment, service, repairing, or removal or replacement of parts or other losses, or for expense of repairs made outside of its factory, except when made pursuant to **James L. Taylor Manufacturing's** PRIOR written consent.

James L. Taylor Manufacturing does not guarantee equipment furnished by us, but manufactured by others, such as belts, electric motors, starters, controls or other electrical equipment or accessories, as they are guaranteed separately by their respective manufacturers. **James L. Taylor Manufacturing** assumes no liability whatever for any of these parts claimed to be defective or for damages or delays caused by defects beyond making such repair or furnishing duplicate parts within the manufacturer's warranty, nor shall we be liable for any defective material repaired or replaced without our consent.

The foregoing shall constitute the fulfillment of all of our obligations under this warranty and there are no other warranties or guarantees, expressed or implied except as stated herein.



RULES FOR SAFE OPERATION

RULES FOR SAFE OPERATION

Types of Warnings

This is the safety alert symbol. It is used to alert you to potential injury hazards.



Obey all safety messages that follow this symbol to avoid possible injury.

DANGER in white letters on a safety red background with a safety red exclamation point.



This indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.

WARNING in black letters on a safety orange background with a safety orange exclamation point.



This indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.

CAUTION in black letters on a safety yellow background with a safety yellow exclamation point.



This indicates a potentially hazardous situation which, if not avoided, COULD result in minor or moderate injury.

RULES FOR SAFE OPERATION

General Safety Rules

- Follow lockout procedure before servicing.
- Read and understand manual before operating machine.
- Wear eye protection.
- See the plant supervisor to determine what protective equipment each job requires.
- Follow electrical and fire codes.
- Do not wear loose clothing, jewelry or long hair around operating equipment.
- Keep guards in protective position when machine is operating.
- Keep clear of belts chains and moving parts.



! **DANGER**

**Lockout ALL
energy sources
before servicing.**

RULES FOR SAFE OPERATION

Machine Safety Decals

The following warning stickers are some that are used on your machine. Over time, these stickers can become worn and illegible. New stickers can be obtained from:

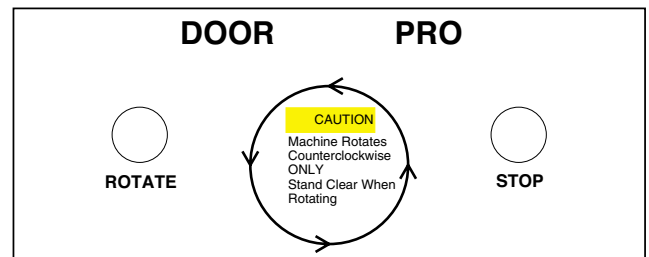
James L. Taylor Mfg.
130 Salt Point Turnpike
Poughkeepsie, NY 12603
Tel: (845)-452-3780
<http://www.jamestaylor.com/>

RULES FOR SAFE
OPERATION

Part Number: PLA.190
Description: Crush Hazard Sticker



Part Number: PLA79.1449
Description: Control Box Sticker



RULES FOR SAFE OPERATION

Safety Decal Location

These are the locations on the machine where the Safety Decals should be placed:

You will find the Crush Hazard Decal on the Movable Square Bar and on the control box-side of the Squaring Frame.

RULES FOR SAFE
OPERATION



INSTALLATION

Receiving & Unpacking

Inspect the shipping crates and skids for shipping damage.

If any shipping damage has occurred, notify the shipping company immediately.

The Door pro has been pre-assembled at our factory, then disassembled into major components.

Unpacking Instructions

- 1.) Position the skid close to the area of installation.
- 2.) Remove the stretch wrap, door clamp sections and items from under the machine. Set these aside for further installation.
- 3.) Remove the lag bolts from the machine frame and remove it from the skid. Take care when picking up the machine. **DO NOT** pick up from the installed door clamp sections or the shafts. Pick up from the **SIDE FRAMES ONLY.**

INSTALLATION

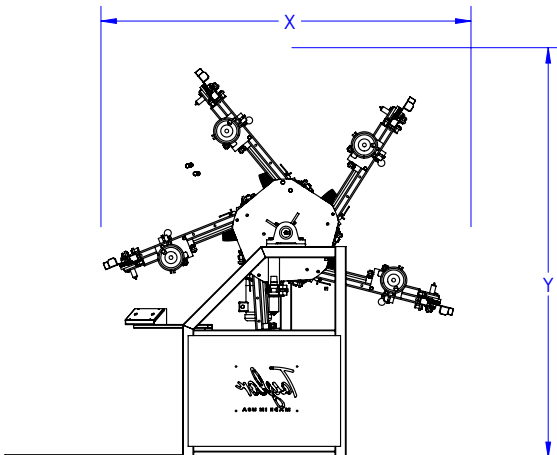
Layout & Power Requirements

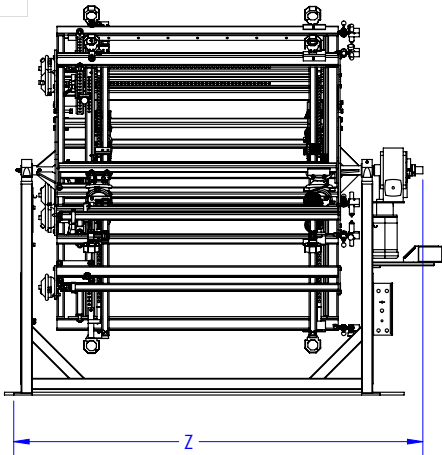
The Door Pro requires a 110V plug connected to its OWN 20 Amp circuit breaker. DO NOT use extension cords of lesser gauge than the existing power cord. It also requires a 3/8" air line at 2 CFM.

The final set up dimensions of the Door Pro are:


#713A-

#713A										
#717A-					#79K-					
Size	# of Sections	X	Y	Z	Size	# of Sections	X	Y	Z	
26 x 62	5	100	110 1/4	112 3/4	26 x 62	5	96	108 1/4	114 3/4	
26 x 62	8	104	121 1/4	112 3/4	26 x 62	8	104	121 1/4	114 3/4	
26x 96	5	93	98 3/4	146 3/4	38 x 96	5	137	139 3/4	150 3/4	
38 x 96	5	128	135 1/4	146 3/4	38 x 96	8	137	139 3/4	150 3/4	
38 x 96	8	128	135 1/4	146 3/4						





Door Pro v.5

MATERIAL NAME:		James L. Taylor Mfg. Co. Poughkeepsie, NY, USA
Description:	DWG. NO. #713A-	REV
Created: 5/4/2012 by: Jacob D. Greenfield Modified: 10/1/2018 by: Jacob Greenfield		
SCALE: 1:24	WEIGHT: 6073.7132	SHEET 1 OF 2

INSTALLATION

Installing the Door Clamp Sections

Some sections may have been installed onto the machine. Using it as a guide, the rest will need to be installed.

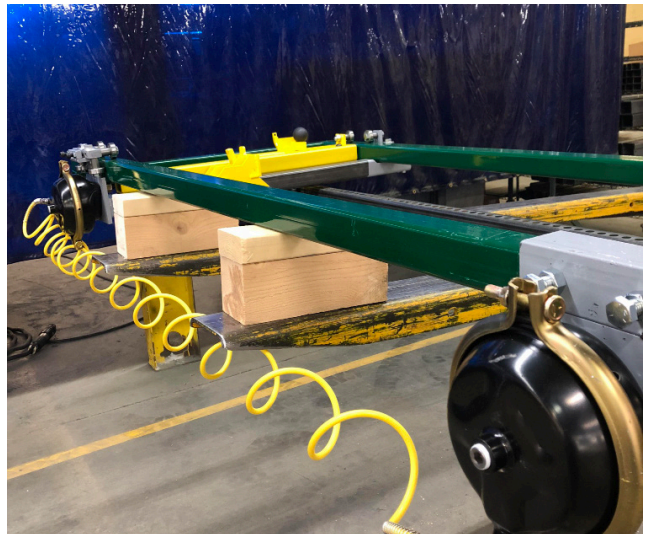
1.) Connect the 110V Power Cord, located near the back of the machine on the operator's left side to its own 20 Amp Circuit. Do not use an extension cord of lesser than 12 gauge as it will limit the power to the motor.

2.) Loosen, but do not remove the attachment bolts for the installed door clamp sections. This will make the rest of the sections fit into place easily.

3.) On the Control Box, flip the turn switch to "On" and then press the Rotate button to rotate the machine to an empty section. The motor is designed to continue rotating until reaching a certain position. Use the stop button to fine tune the position for now. Until the machine is balanced, you will need to help the motor by pulling up on the sections as it rotates. If the machine does not turn on, make sure the disconnect is switched on.

4.) Using the installed sections as a guide, install the door clamp section with the nuts and bolts provided. It is suggested to use a forklift or hoist to help support the section during install. Put in the rear bolts in first then swing the door clamp section into position to put in the front bolts.(leave bolts loose for now.)

5.) Repeat the process for the rest of the door clamp sections, using the control box buttons to rotate the machine.



INSTALLATION

6.) Tighten all door clamp section bolts and make sure set screws on all bearings are tight.



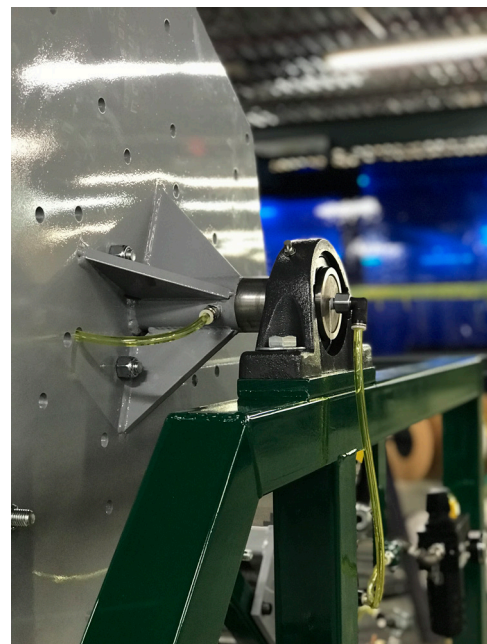
INSTALLATION

Air Hose & Fitting Installation

Fittings and 3/8" tubing have been supplied with the machine. Follow these instructions for the cutting and routing of the airlines. **Do not add lubricant to the air system.** Damage to your dial regulators will result and your warranty will be voided.

Some or all of the following may have been completed at the factory:

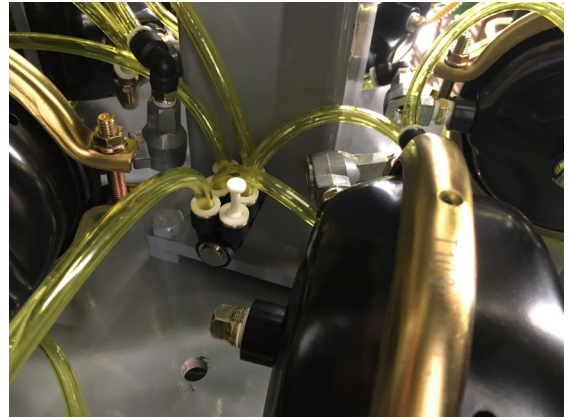
- 1.) Install the main filter/regulator unit on the tab on the right side of the machine. Do not remove the plug in the tee.
- 2.) Insert a supplied 3/8" Tube x 1/4" NPT swivel elbow fitting into the tapped hole on the end of the right side of the center shaft. Cut a piece of 3/8" tubing to run between this fitting and the fitting on the tee of the regulator. Route the tubing through the hose clamps on the side of the machine.
- 3.) Insert a supplied 3/8" Tube x 1/4" NPT straight fitting into the tapped hole on the right side of the center shaft, just to the left of the bearing. Insert a second fitting in the tapped hole on the right side of the center tube (air tank). Cut a piece of tubing to run between these fittings and through the hole in the disk.



INSTALLATION

4.) For 5 Section machines, insert the supplied 6 port 3/8" Tube x 1/4" NPT swivel fitting into the tapped hole on left side of the center air tank. Make sure that one of the ports is plugged. For 8 Section machines, these will be replaced with (2) 4 port fittings teed together. There will be no plug on 8 section machines.

5.) Review installed sections to help guide the routing of air supply from tank to valves.



INSTALLATION

INSTALLATION

Stile and Rail:

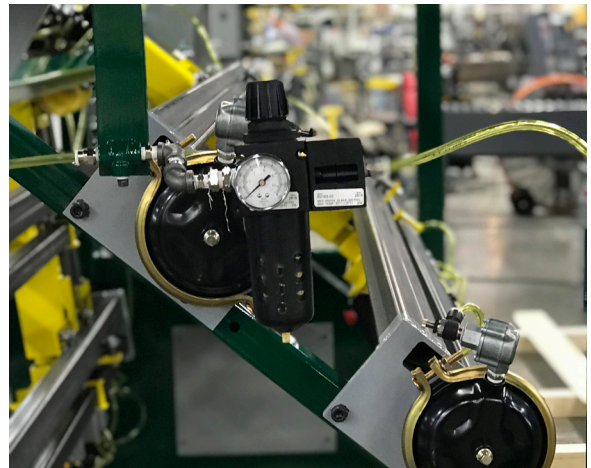
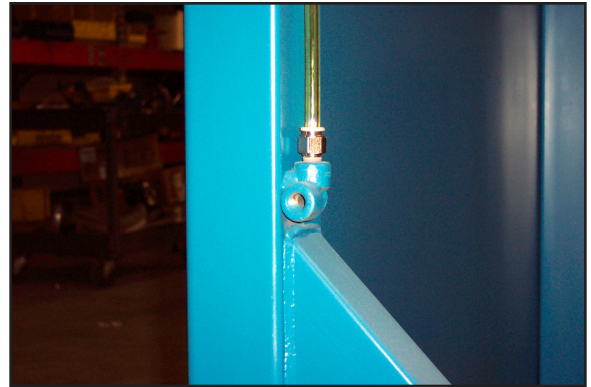
- 1.) Incoming Air will come from the multi-port manifold located on the central air drum of the Door Pro Frame.
- 2.) Using a 1/4" hose, connect one end to an open port in the manifold. Run the hose along the bottom of the left tube of the Door Clamp Frame. There are metal tabs located to help keep the hoses neat.
- 3.) Screw the lever valve into the elbow located on the underside of the left/front of the Door Clamp Frame.
- 4.) Using a 1/4" elbow fitting, run a 1/4" tube through the cross clamp tube to the cross clamp cylinder. Plug the hose into one of the ports on the "T" fitting located there.
- 5.) Using the other port on the "T" fitting in #2, run another 1/4" hose back through the cross clamp tube and up to the Stationary Clamp. Plug the hose into the Quick Exhaust valve located on a "T" fitting there.
- 6.) On the other port of the "T" Fitting mentioned in #3, screw in your 1/4" yellow Nylon Coil hose and connect it to the Nickle Elbow on the Movable Clamp Cylinder.
- 7.) Rotate the machine and repeat the process for the remaining squaring sections.



Door Pro Final Setup

Before using the machine, some final adjustments need to be made.

- 1.) The machine should be leveled and bolted to the floor.
- 2.) The machine is supplied with a trial size bottle of Bates Glue Release. Apply a very light coating of this product directly to the surfaces where glue may drip. This will enable the glue to be easily removed.
- 3.) Check the rear jaws on the four pneumatic clamps on each section. They should slide easily and lock into place of the notched bar.
- 4.) Connect a 90 PSI or higher air supply using a 3/8" air hose to the elbow on the back of the machine. Turn the air disconnect on and set the pressure on the main regulator to 30-60 psi.
- 5.) Check for any air leaks. Tighten fittings and check that air hoses are pushed in.
- 6.) The lever valve should activate and deactivate the air pressure. If the clamp operation appears slow or to not work at all, make sure that the flow controls on the bottoms of each of the pneumatic clamp cylinders are open all the way or backed all the way out. Once these are set, they should not have to be adjusted again.
- 7.) The squaring frame of the door clamp sections and the movable squares have been adjusted at the factory. Should any shipping damage occur, or wear over time,



INSTALLATION

these can both be adjusted.

8.) The Squaring frame has an adjustable shim bar down the left side of the machine. Using a precision square, check that this bar is square to the horizontal tube. Using the supplied allen wrench and shims, adjust the bar until it is square.

9.) The Movable Square should have some play in it as it rolls back and forth. While it is at rest and not under pressure, using a precision square, check that it is square to the horizontal tube. If necessary, adjust the movable square by loosening the bearings on the back angle of the clamp. The holes in the angle are oversized and will allow for adjustment. Once tightened into the proper position, be careful as to not to over tighten it, preventing the necessary play.

10.) Adjust the Cam Ring so that the the Door Clamp Sections stop in a position that is best for the operator. Rotate the ring so that the tooth trips the switch just prior to the desired position. Tighten the set screw when the ring is in the desired position.



OPERATION

Safety & Training

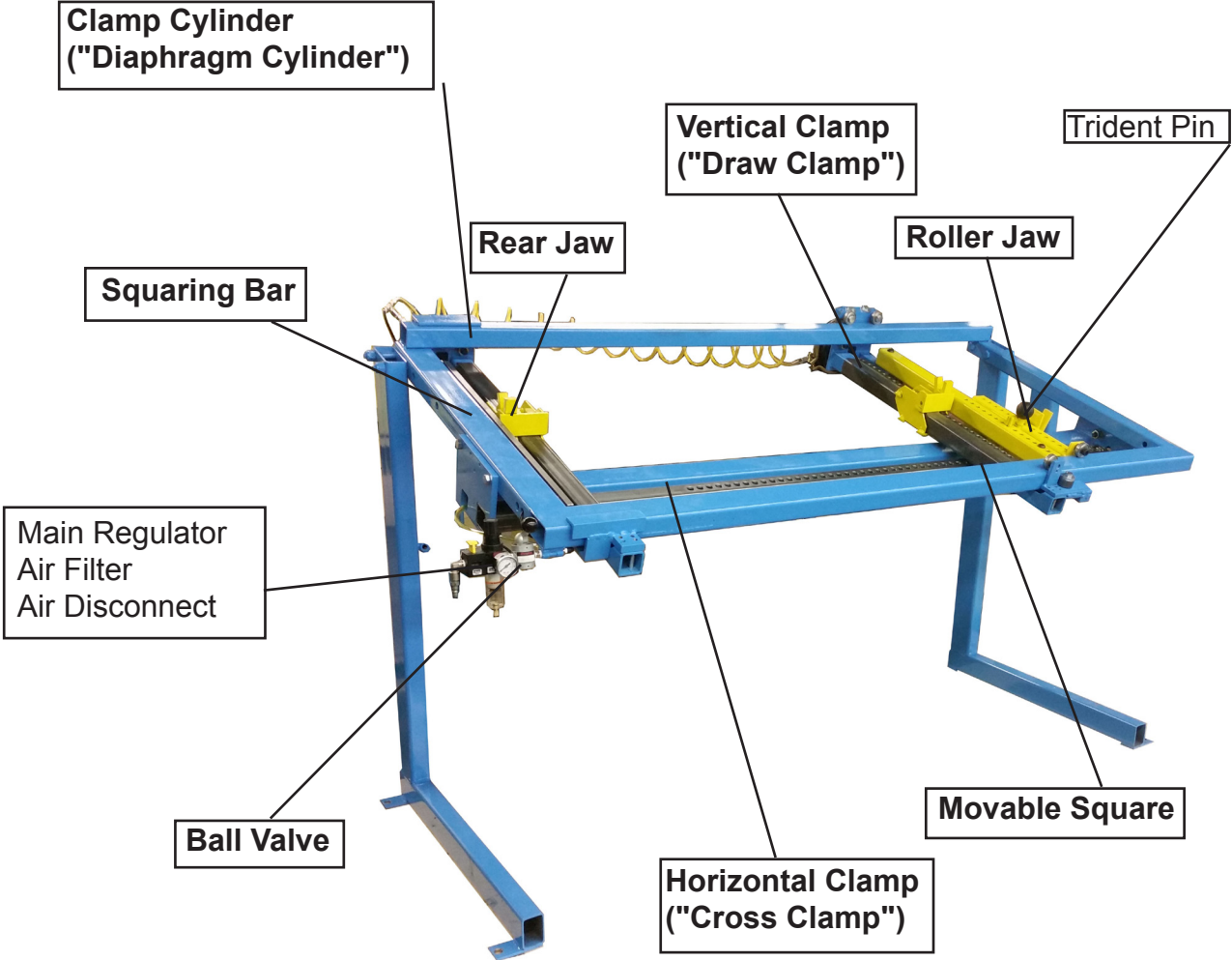
According to many OSHA, ANSI, STATE, and LOCAL CODES it is the EMPLOYER'S RESPONSIBILITY to:

- Permit only trained and authorized employees to operate equipment.
- Inspect and maintain guards, safety devices, and start/stop controls.
- Instruct, train, and supervise the safe method of work



Be sure personnel are properly trained and safety rules are clearly understood before operating or performing maintenance!

Operating Controls & Terminology



OPERATION

Door Pro Operation

1.) The Door Pro is designed for clamping "stile & rail" doors, or "miter" doors if that option was chosen. The door is placed face up in the clamp, but may be placed face down if pinning is desired. Keep in mind that for miter doors, it will be difficult to match the profile if the door is clamped face down. If the doors still do not have enough time to set, either consult a Taylor Representative, investigate some faster setting glues, or incorporate a location groove on the back of your door.



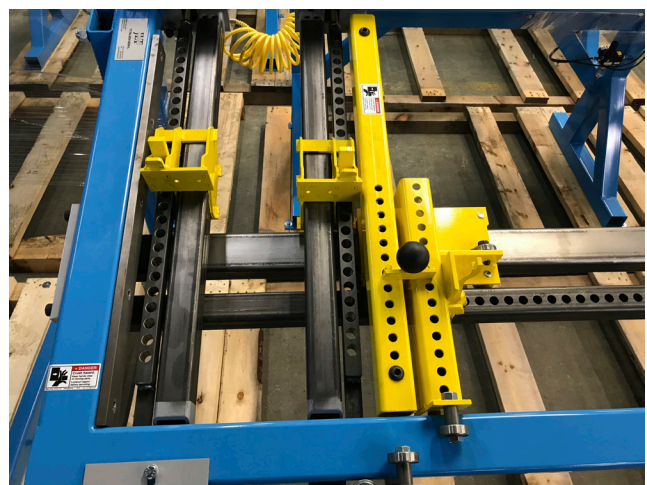
2.) Push up on the air disconnect switch on the main regulator located on the right side of the frame, this will engage the air. Set the main regulator between 30 and 60 psi. Make sure that all of the ball valves are in the off position.

3.) Turn the switch on the side of the Control Box to "On".



4.) Adjust the rear jaws of the vertical clamps as you pull on the spring loaded latch, the rear jaw can be slid back. When it is in the approximate position, let go of the latch and push the rear jaw until it locks into place of the punched draw bar.

5.) Apply glue to the joints and loosely assemble the door. It is suggested to use space balls to orient the center panel. Make sure that the top and bottom rails are just outside of the stiles, but in enough to catch the center panel. Place the door in the clamp section and adjust the vertical rear jaws to within 2" of the door.

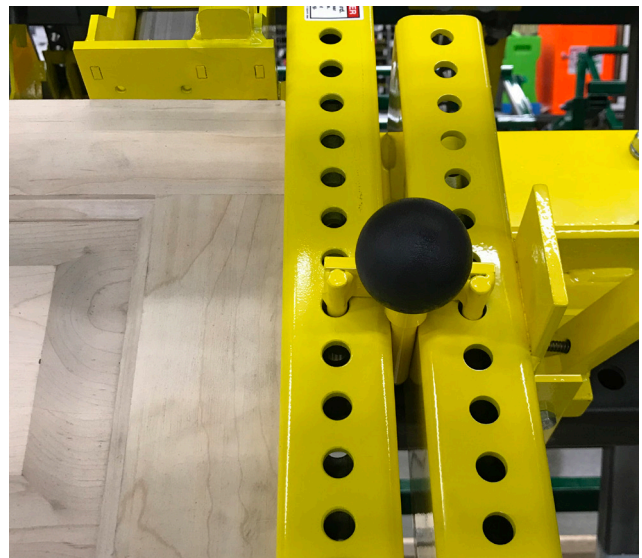
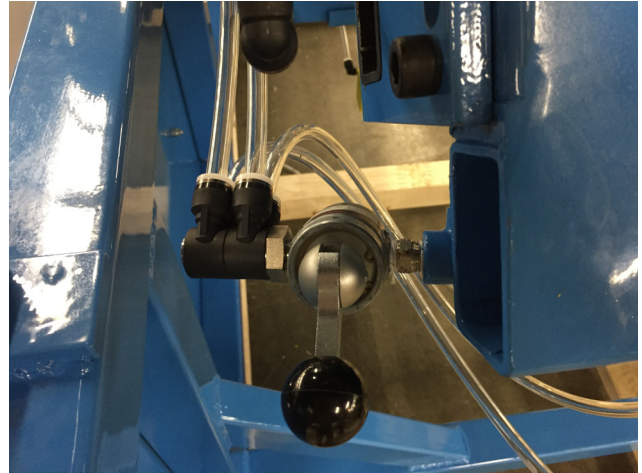


6.) Both of the horizontal jaws and the mov-

able square are adjusted in one motion. Grasp the tab on the movable square and the jaw adjustment bar, move it into position. Let go of the bar and let it lock into place.

7.) The JLT trident pin system helps for fast and easy changeover for clamping various sizes of cabinet doors. Once your door is loosely assembled in the clamp, use the pin to determine where pressure will be applied on the door. Use the two outer prongs of the pin and place them in the holes on the moving verticle clamp as close to the center of the door as possible. This will best evenly distribute pressure.

9.) Engage the clamp by flipping the ball valve on the left of the machine. Make sure that hands and other foreign material are away from the machine. The horizontal clamp should activate first, followed by the verticle.



TROUBLESHOOTING

TROUBLESHOOTING

Operational Troubleshooting

Air Leaks

- Prior to use check connection to ALL air hoses. Make sure ALL fittings are tightly fastened.
- Check for any crimped hoses that constrict air flow.

Joints are not closing completely

- Make sure air is coming to machine and the pressure setting is in the range of 30 to 60 psi
- Make sure the dial regulators are set to 10 psi at initial clamping. Adjust pressure if necessary
- Check miter joint. If the door does not go together easily outside of the clamp by hand, you may need to change or reset tooling

Will Not Rotate

- Check to see if unit is plugged in on its own circuit and there is power to the outlet.
- Turn on control box and / or reset breaker switch. Remove from any extension cords.
- Make sure there is enough space for this machine to rotate.
- Check for any obstructions such as ceiling or back wall clearance, material under the machine.
- Inspect the gear box oil level via the sight glass on the gear box. The oil level should be midway up the sight glass window. Add 90 weight extreme pressure lubricant if necessary.

TROUBLESHOOTING

Dial Valves (Regulators) are leaking or not working properly.

- Make sure air is coming to machine and the pressure setting ranges between 30 to 60 psi

- Make sure the dial regulators are set to 10 psi at initial clamping. Adjust pressure if necessary

- **Do not add lubricant to the air system.** Damage to your dial regulators will result and your warranty will be voided.

MAINTENANCE

MAINTENANCE

Maintenance Checklist

(Photocopy for monthly use)

Weekly Maintenance Checklist	Comments	Date	By
<ul style="list-style-type: none"> • Scrape and clean glue buildup. • Re-apply Bates Glue Release to surfaces which will come in contact with glue. • Check the filter on the regulator for water and foreign material. Drain as necessary. • Check for foreign material underneath the machine 			

Monthly Maintenance Checklist	Comments	Date	By
<ul style="list-style-type: none"> • Grease the Main Bearings on the shaft • Inspect the Gear Box oil level using the sight glass window. Add 90 weight extreme pressure lubricant if the level is below the midway point of the sight glass 			

MAINTENANCE

PARTS & SERVICE

Model & Serial Plate Location

You will find the Model/Serial plate on the machine on the right frame leg of the machine. You will need this information for ordering spare or replacement parts.



Motor Lubricants

Recommended Lubricants for the Motor Drive Gear Box:

Atlantic Richfield Co.	Pennant E.P. S-3150
Chevron Oil Co.	Cheveron Gear Compound 160
Cities Service Oil Co.	Citgo E.P. Compound 150 or 160
Continental Oil Co.	Conoco Milgear L-160
Gulf Oil Corp.	Gulf Transgear Lubricant E.P. 140
Humble Oil & Refining Co.	Pen-O-Led EP6
Kendall Refining Co.	Kendall NS-MP-90-140 Hypoid
Keystone Div.-Penwalt Corp.	WG-B
Mobil Oil Corp.	Mobil Compound GG
Phillips Petroleum Co.	Philube ILB Gear Oil SAE 140
Shell Oil Co.	Macoma 81
Standard Oil Co. of Br. Columbia, Ltd.	Chevron Gear Comound 160
Standard Oil Co. of Calif., W. Oper., Inc.	Cheveron Gear Compound 160
Standard Oil Co. (Kentucky)	Chevron Gear Compound 160
Standard Oil Co. (Ohio)	Factolube 6
Sun Oil Co.	Sunep 1150
Texaco, Inc.	Meropa 6
Union 76 Div. Union Oil Co. of CA	Union PB Lube 160
Warren Reining Div., Parr, Inc.	882 Gear Lube

Worm Gear Reducer Instructions & Parts

Verifying your unit:

Before installation, check to be certain that the information on this unit's name plate is correct for the application.

Check:

1. The model number.
2. Correct orientation of the worm to the right or left.
3. Speed reduction ratio and / or output speed.



FOR 5 SECTION MACHINES: RED.13 400-1 Gear Reducer
FOR 8 SECTION MACHINES: RED.11 400-1 Gear Reducer

Lubrication

Hampton Worm Gear Reducers are shipped with oil. If additional oil is needed, consult your lubricant supplier for a lubricant which suits your application and meets the standards in the table below.

Synthetic lubricants

While expensive, synthetic lubricants from Mobil Oil and others have been shown to improve efficiency and lower operating temperatures in worm gears. Caution: Consult your supplier before mixing synthetic and non-synthetic oil! Flush the reducer with a general purpose solvent such as kerosene when changing between types.

Quality essential

Do not use "all purpose" oils, automotive engine or gear oil, or any lubricant not specially formulated for worm gear service. Using them may result in severe worm wheel wear and failure.

- Before Operation:

With unit stopped, fill unit to the center of the sight gauge with the proper lubricant. If unit is incline mounted, fill with the quantity indicated in the Hampton Worm Gear Catalog. Do Not overfill!! Excessive oil levels result in higher operating temperatures. If a grease fitting is present, grease it before operation.

- After 85 hours of operation:

Drain unit and flush with light oil. Refill.

- Every 2500 hours of operation.

Drain, flush and refill.

-Regular inspection.

Check your Hampton reducer's mounting bolts for tightness regularly. Check that the unit's oil level in the sight gauge when the unit is stopped.

For oil capacity information and how to contact Hampton PT, refer to the back page.

Lubricants must meet or exceed these standards:

15° to 60° F (-9° to 16° C) AGMA 7 cSt@104° F (40° C): 414-506

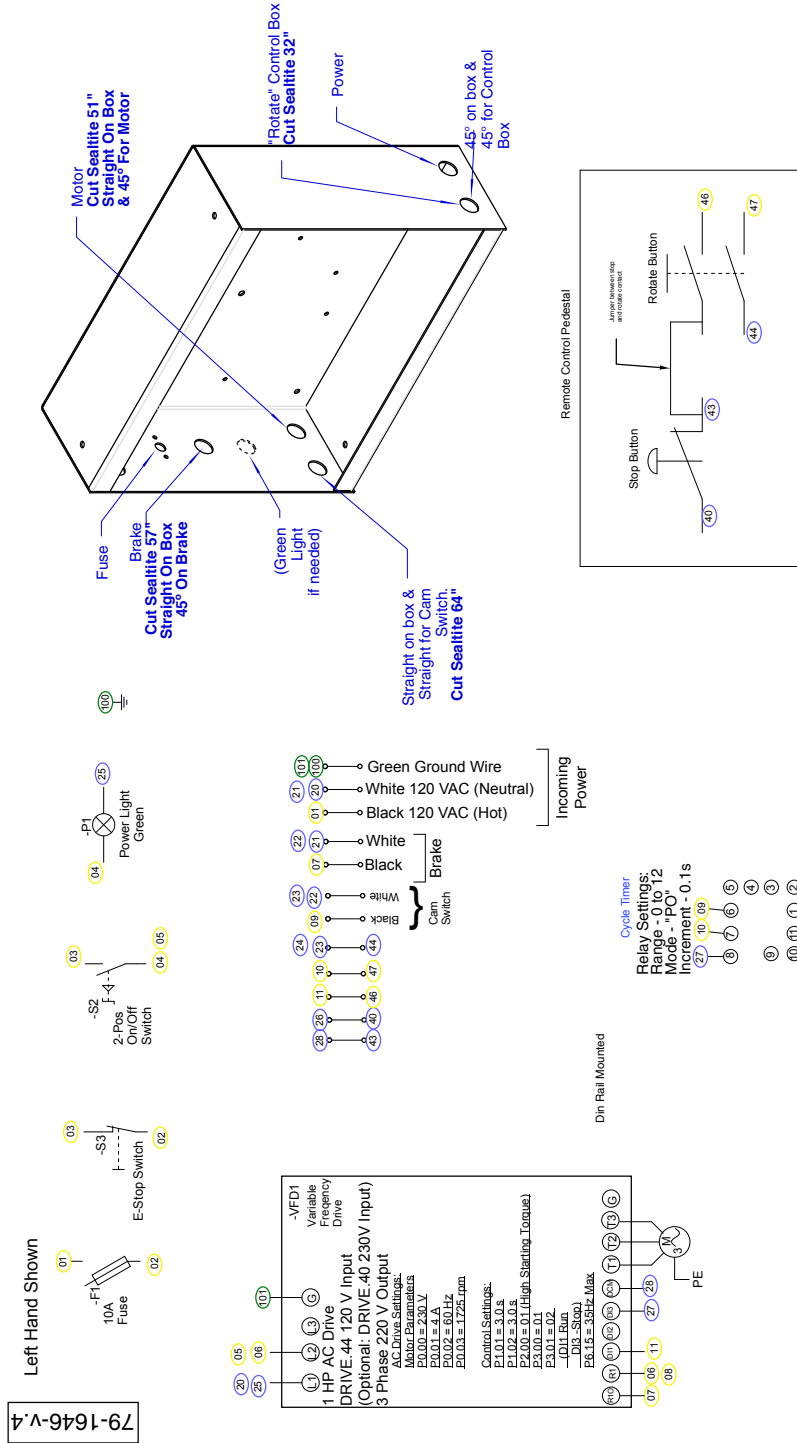
15° to 125° F (10° to 52° C) AGMA8 cSt@104° F (40° C): 612-748

Double Reduction Oil Capacities, Approximate

SIZE	DU & DUCHS		Secondary	
	Primary			
80	10 Oz.	.31 ltr	2 pt. 2 oz.	1.0 ltr.

* Note: Both primary and secondary units must be filled with oil before placing in operation.

Control Box Wiring & Parts



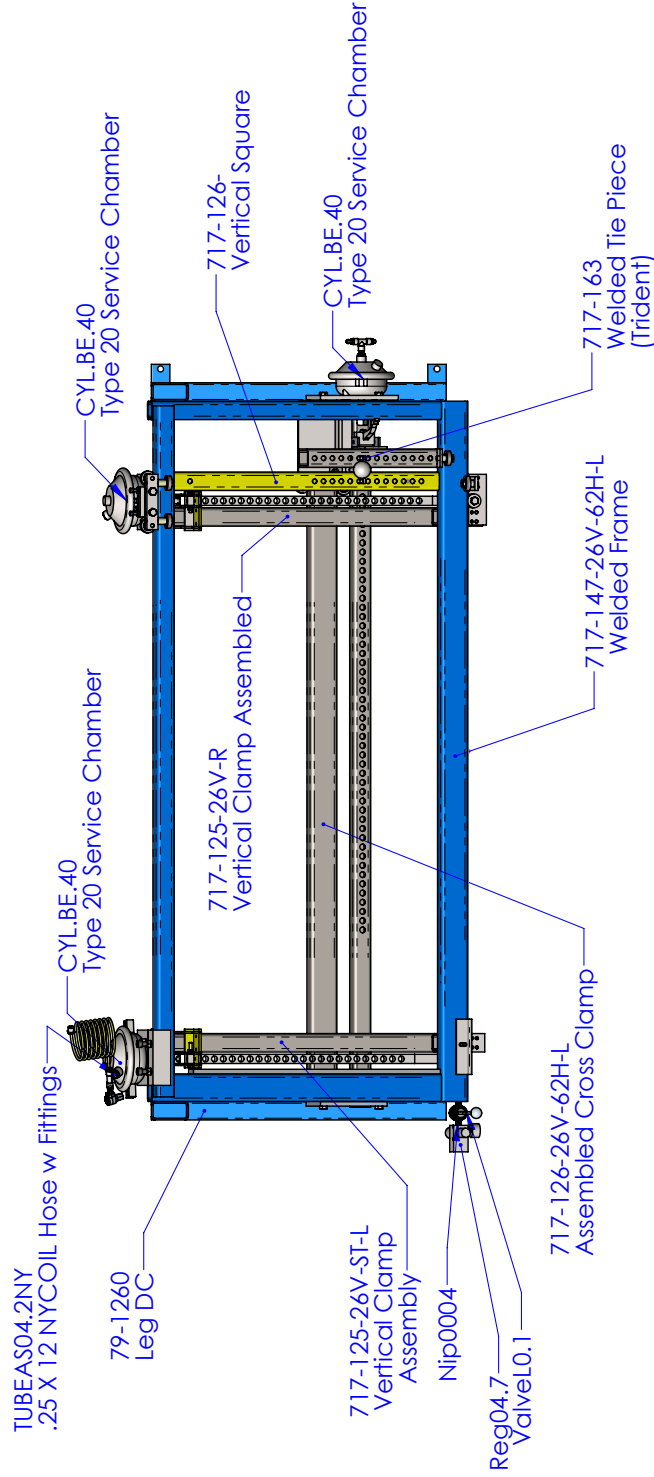
Door Pro -1 PH VSpeed Drive Control Box

Scale:	James L. Taylor Mfg. Co. Poughkeepsie, N.Y., U.S.A.
Material:	06-04-18 BW 79-1646-V.4

Cameron Automation
 100 Park Ave. Poughkeepsie, NY 12560
 Phone Number: 845.338.2200
 Email: sales@cameronautomation.com
 Website: www.cameronautomation.com
 James L. Taylor, Inc. - Poughkeepsie, NY
 Serial Number: 118888
 Date of Manufacture: 06-04-18
 Unit Number: 79-1646-V.4

- ① Wires **1-19, 46, 47** 14 ga. Black
- ② Wires **20-45** 14 ga. White
- ③ Wires **100-109** 14g . Green

#717A-



V10 Door Clamp

MATERIAL NAME:

Description:



James L. Taylor Mfg. Co.
Poughkeepsie, NY, USA

DWG. NO.

REV

#717A-

Created: 8/5/2015

by:

Modified: 9/27/2018

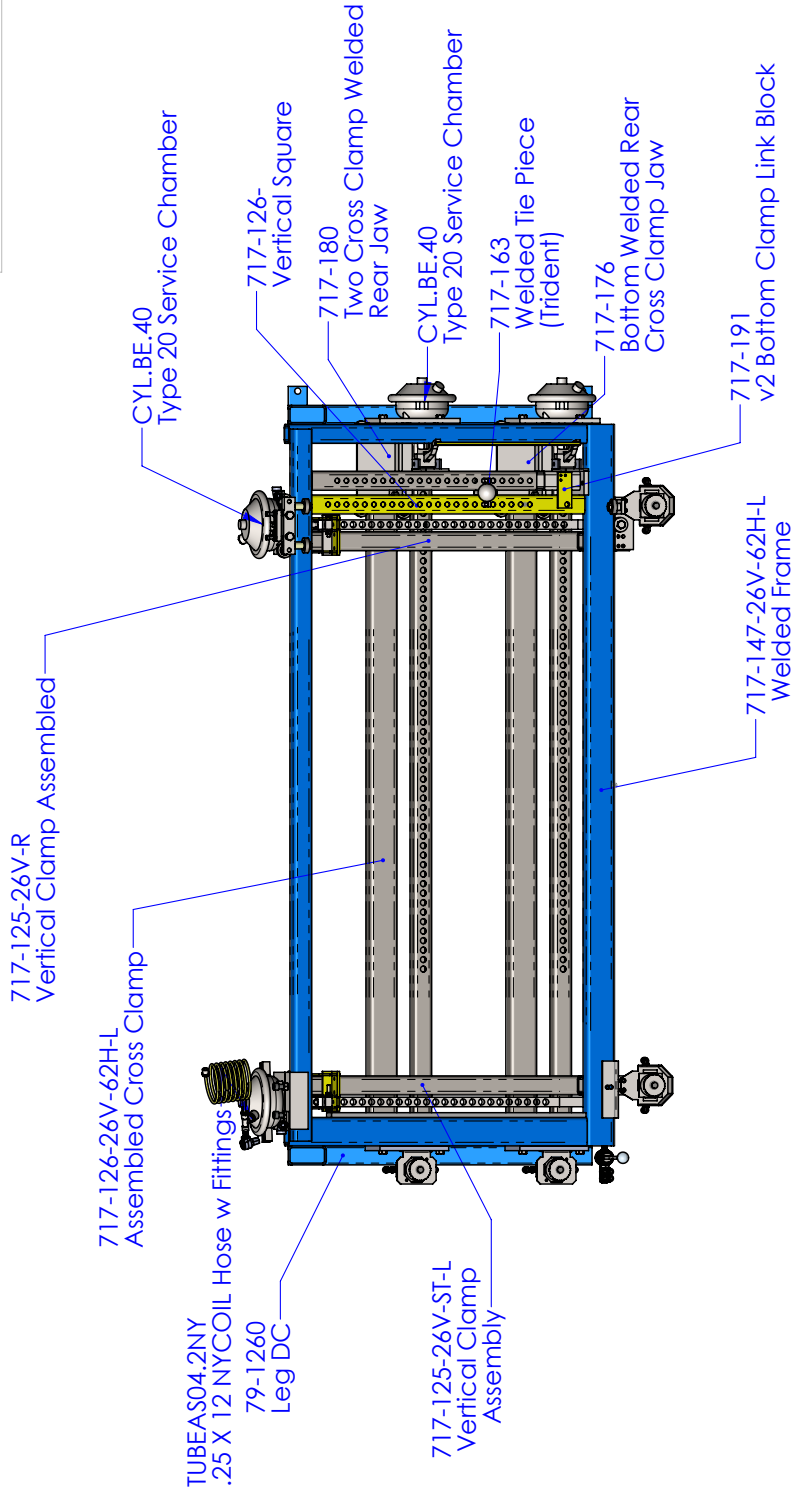
by: greg

SCALE:

WEIGHT:

SHEET 3 OF 14

#717A-



V10 Door Clamp

MATERIAL NAME:

Description:



James L. Taylor Mfg. Co.
Poughkeepsie, NY, USA

REV

DWG. NO.

#717A-

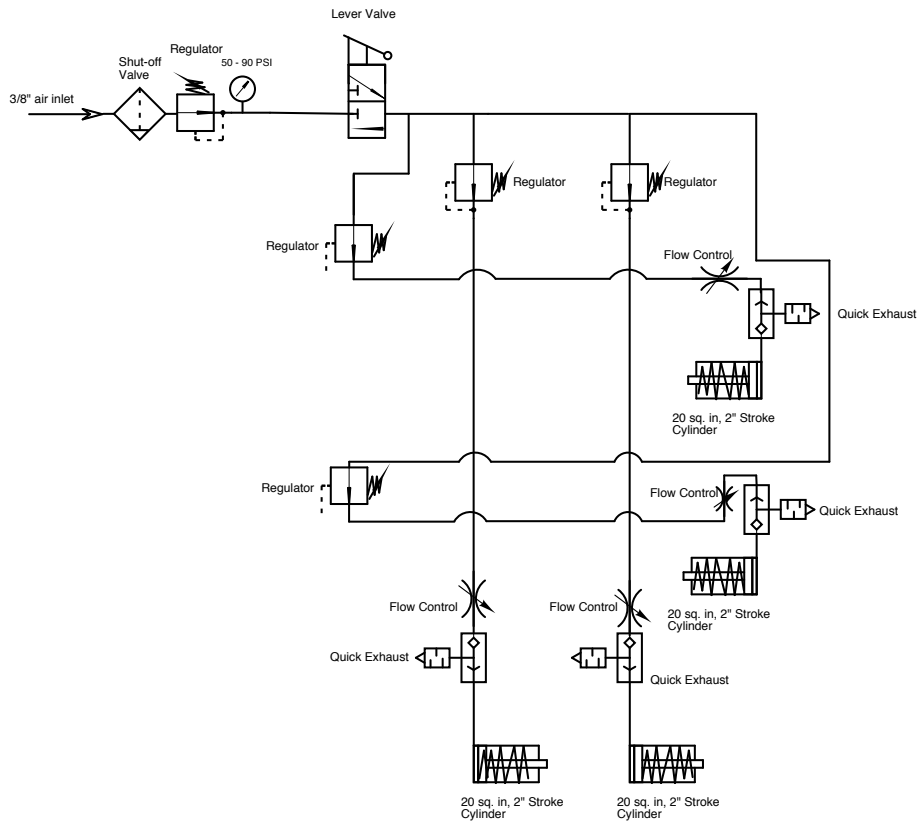
Created: 8/5/2015
by:

Modified: 9/27/2018 SCALE:
by: greg 1:16

WEIGHT:

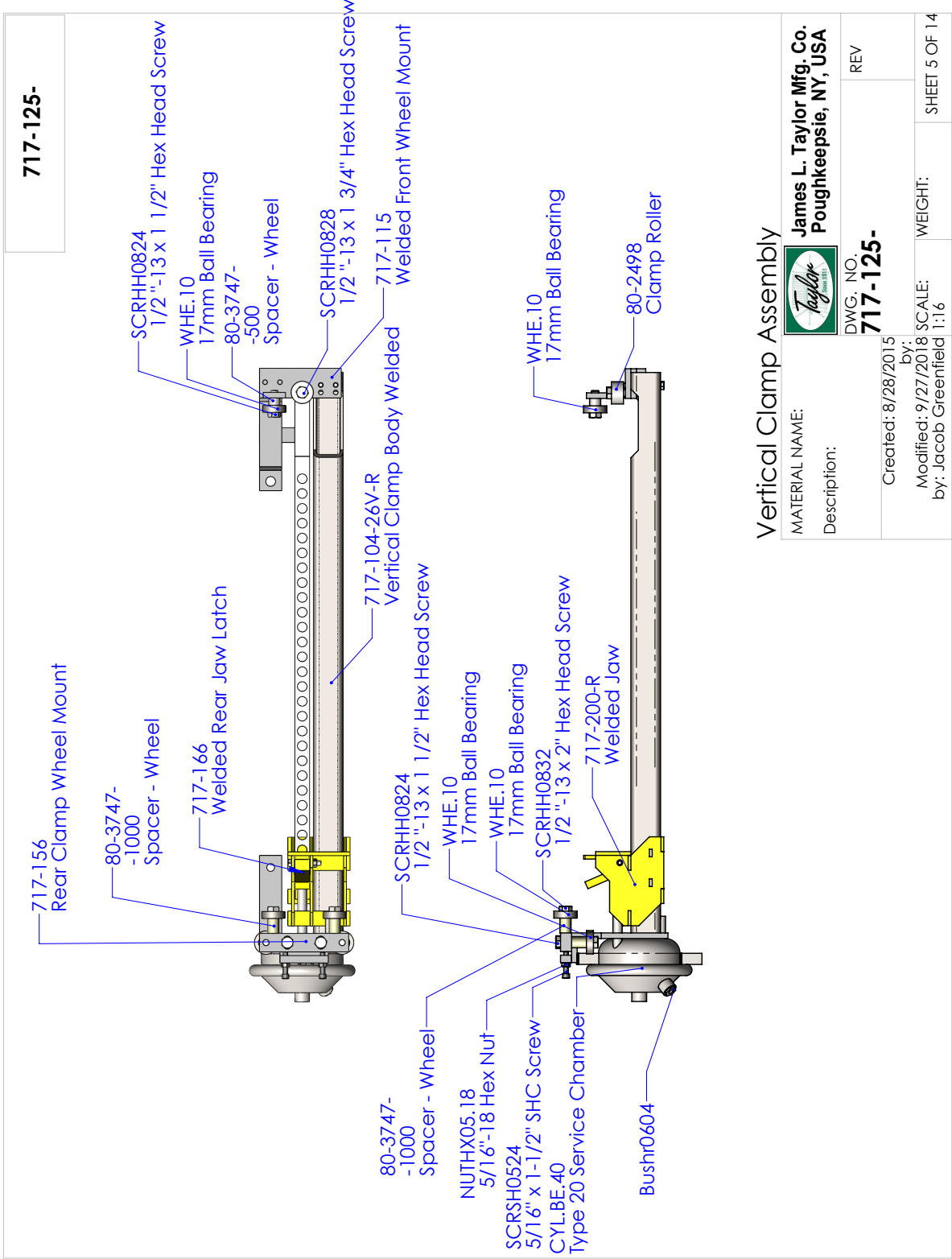
SHEET 9 OF 14

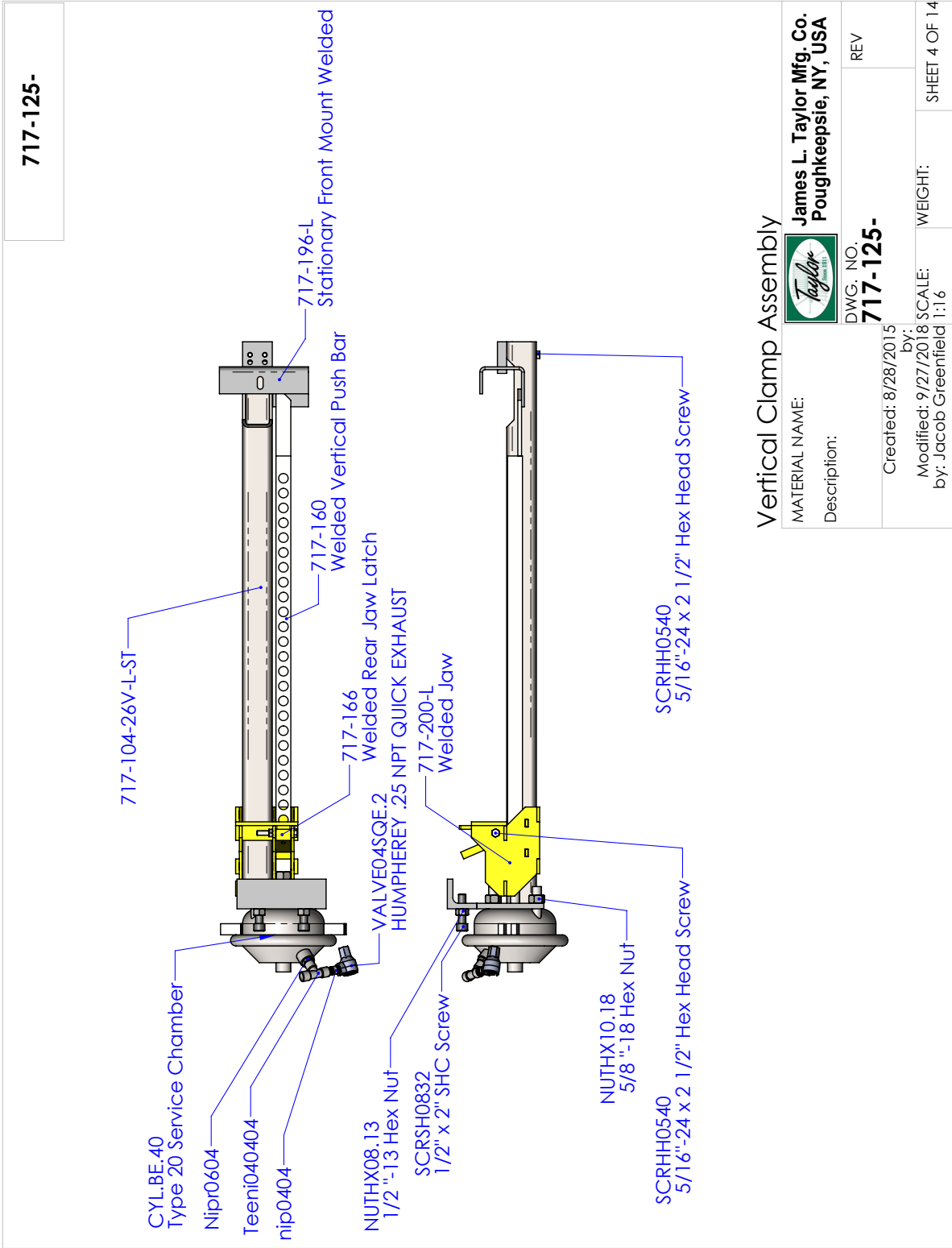
#717A-Miter



Air Schematic - HDDC #717A-Miter

Scale: None	James L. Taylor Mfg. Co. Poughkeepsie, N.Y., U.S.A.	
Material: See Picklist		
	11/3/06 cdc	#717A-Miter





Vertical Clamp Assembly

MATERIAL NAME:

Description:



James L. Taylor Mfg. Co.
Poughkeepsie, NY, USA

DWG. NO.

REV

717-125-

Created: 8/28/2015

by:

Modified: 9/27/2018

WEIGHT:

SHEET 4 OF 14

SCALE: 1:16

717-176

The diagram shows an exploded view of a v.2 Bottom Welded Cross Clamp. The main body is olive green. Components are labeled with blue text and leader lines:

- SCRHH0816 1/2"-13 x 1" Hex Head Screw
- 80-3747-063 Spacer - Wheel
- 80-3747-375 Spacer - Wheel
- SCRHH0820 1/2"-13 x 1 1/4" Hex Head Screw
- 80-3747-500 Spacer - Wheel
- SCRHH0820 1/2"-13 x 1 1/4" Hex Head Screw
- WHE.10 17mm Ball Bearing
- 80-3747-500 Spacer - Wheel
- 80-3747-375 Spacer - Wheel
- SCRHH0828 1/2"-13 x 1 3/4" Hex Head Screw

v.2 Bottom Welded Cross Clamp

MATERIAL NAME: **James L. Taylor Mfg. Co. Poughkeepsie, NY, USA**

Description:

Created: 7/19/2016
 by: Jacob D. Greenfield
 Modified: 9/27/2018
 by: greg

DWG. NO. **717-176**

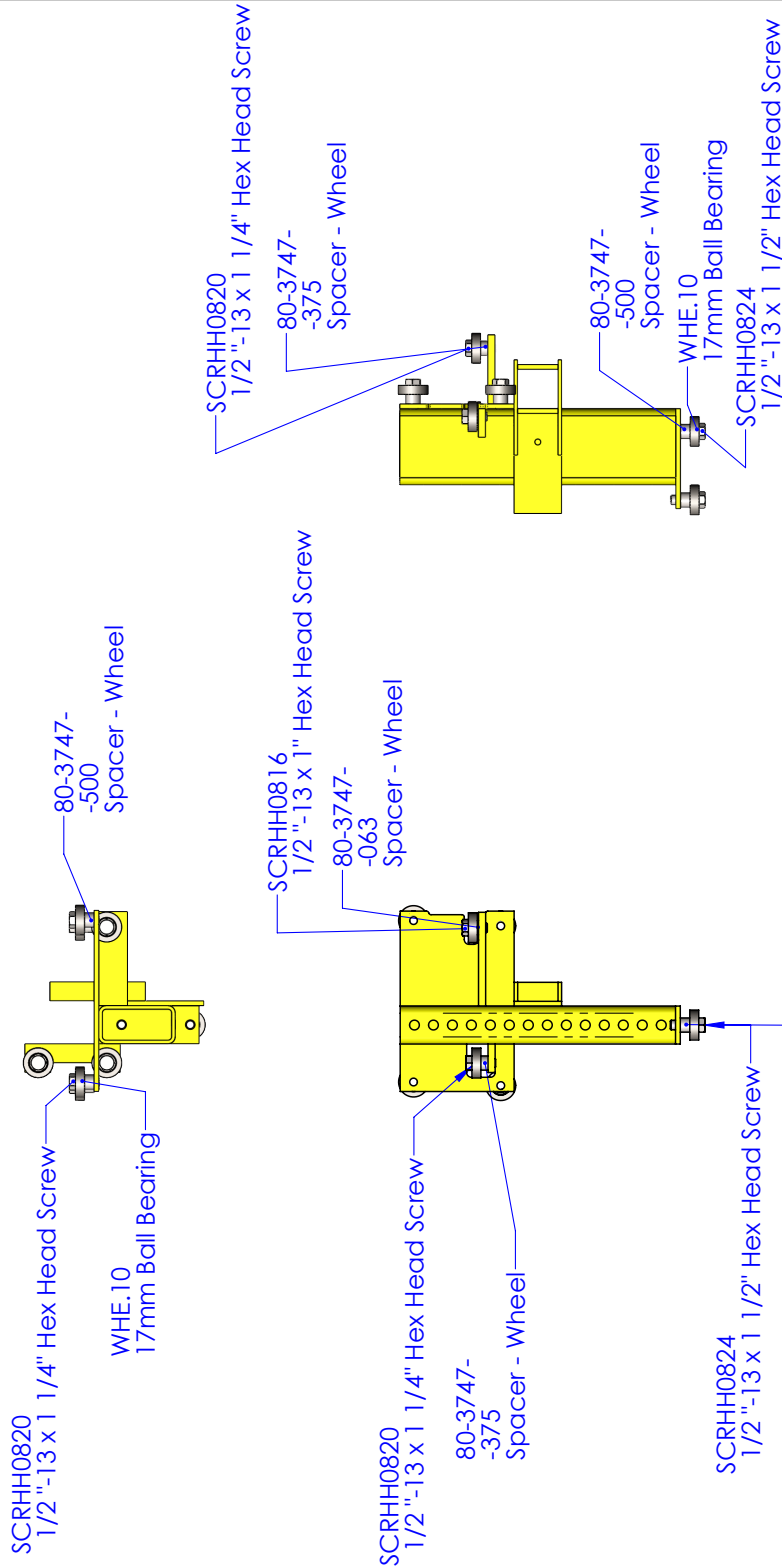
REV

SCALE: 1:16

WEIGHT: 9.6964

SHEET 11 OF 14

717-137-



Assembled Carriage

MATERIAL NAME:

Description:



James L. Taylor Mfg. Co.
Poughkeepsie, NY, USA

DWG. NO.

717-137-

REV

Created: 8/31/2015
by:

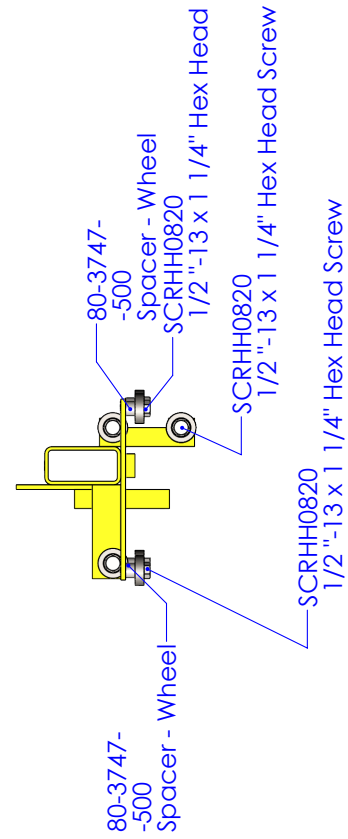
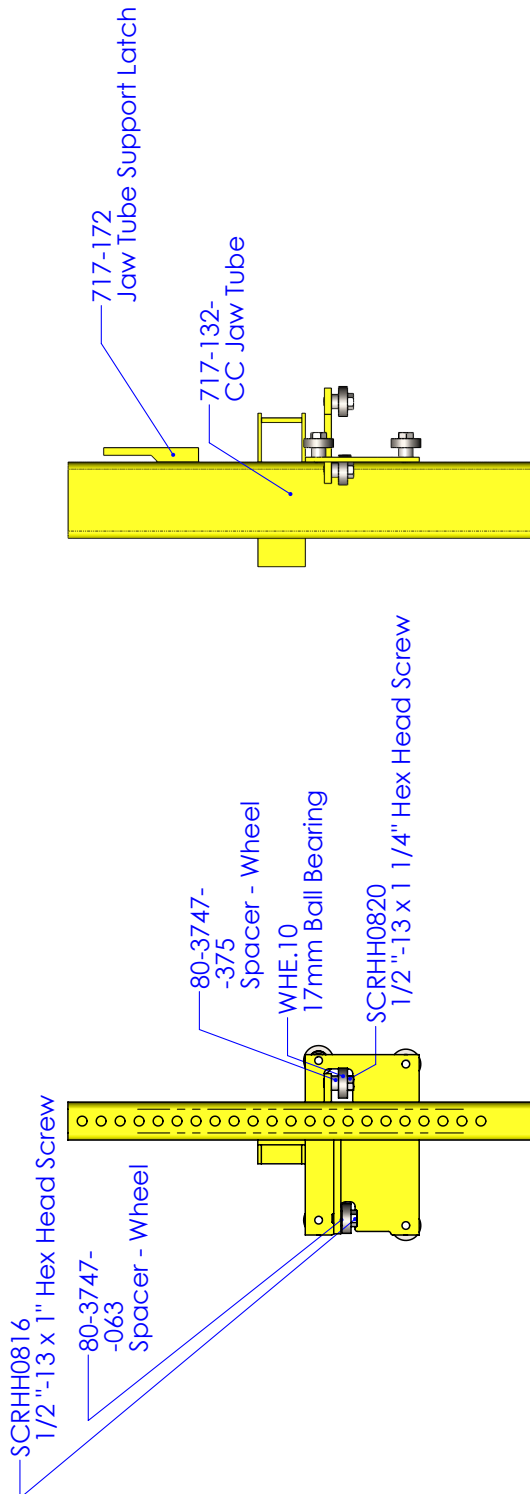
Modified: 9/27/2018
by: greg

WEIGHT:

SCALE:
1:16

SHEET 7 OF 14

717-137-



Assembled Carriage

MATERIAL NAME:

Description:



James L. Taylor Mfg. Co.
Poughkeepsie, NY, USA

DWG. NO.

717-137-

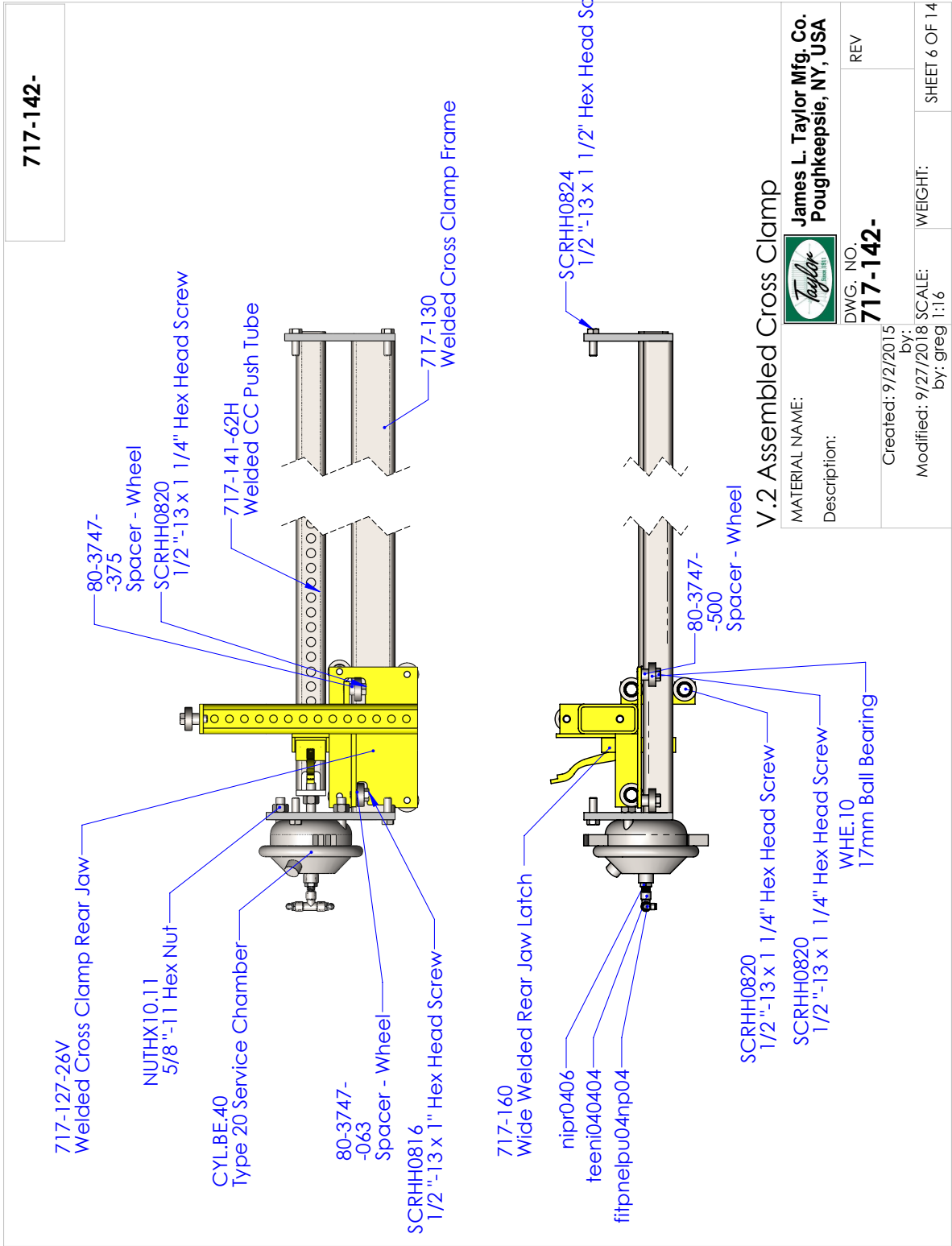
REV

Created: 8/31/2015
by:

Modified: 9/27/2018
SCALE: 1:16
by: greg

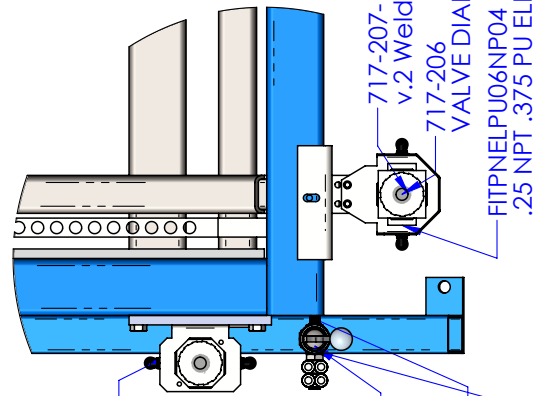
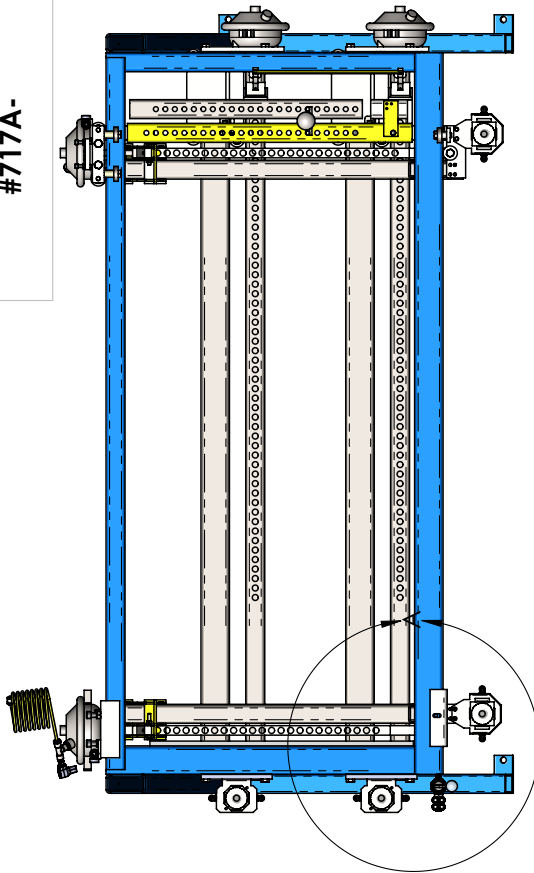
WEIGHT:

SHEET 12 OF 14



Miter Pneumatics

#717A-



FITPNELPU06NP04
.25 NPT .375 PU ELBOW

MAN06P04N04.01
4 pos .375 PU .25 NPT

NIP0004
1/4" close nipple

STANDARD_BODY

717-207-
v.2 Weldment-Vertical Clamp Guard

717-206
VALVE DIAL REGULATOR

FITPNELPU06NP04
.25 NPT .375 PU ELBOW

V10 Door Clamp

MATERIAL NAME:

Description:



James L. Taylor Mfg. Co.
Poughkeepsie, NY, USA

DWG. NO.
#717A-

REV

Created: 8/5/2015

by:

Modified: 9/27/2018

SCALE: 1:16

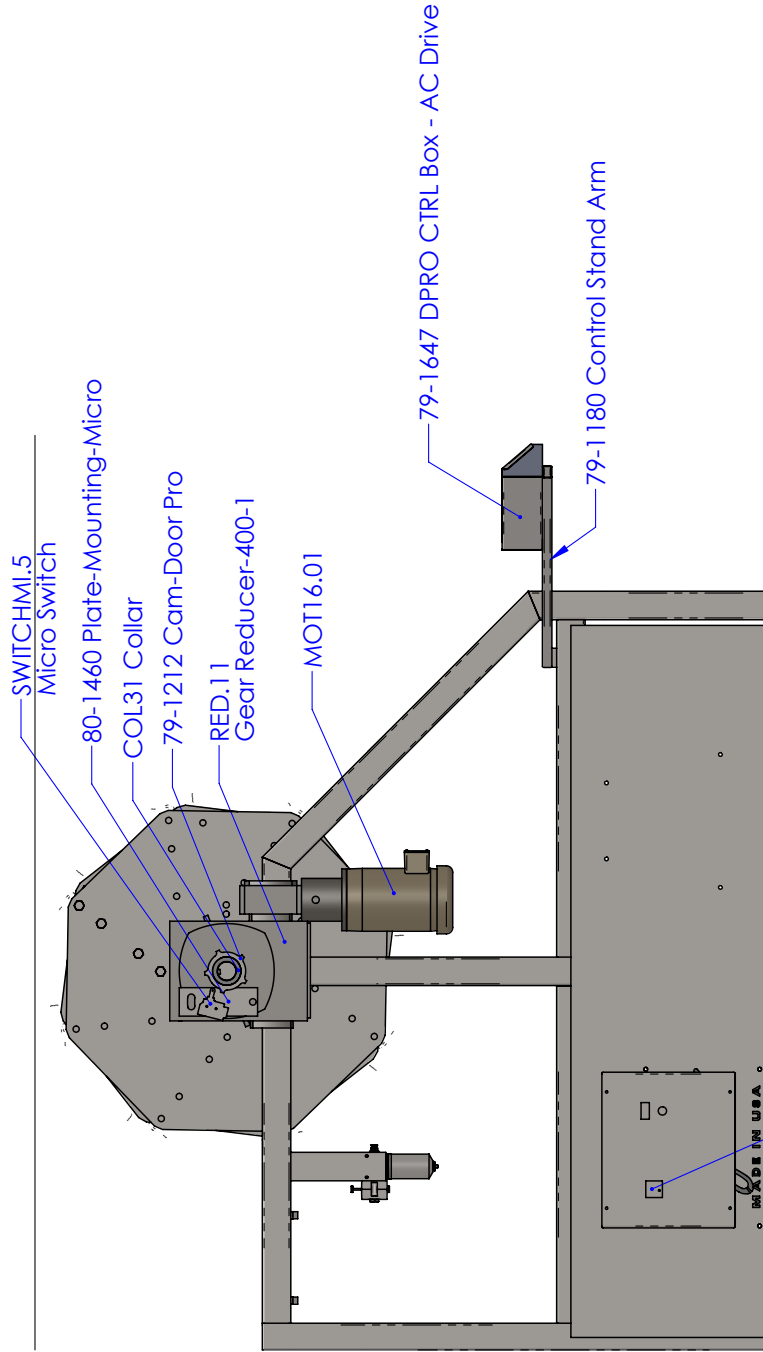
WEIGHT:

SHEET 10 OF 14

DETAIL A
SCALE 1 : 8

-For 8 Section Frames

#713A-



Door Pro v.5

MATERIAL NAME:

Description:



James L. Taylor Mfg. Co.
Poughkeepsie, NY, USA

DWG. NO.

#713A-

REV

Created: 5/4/2012
by: Jacob D. Greenfield

Modified: 10/22/2018 SCALE:

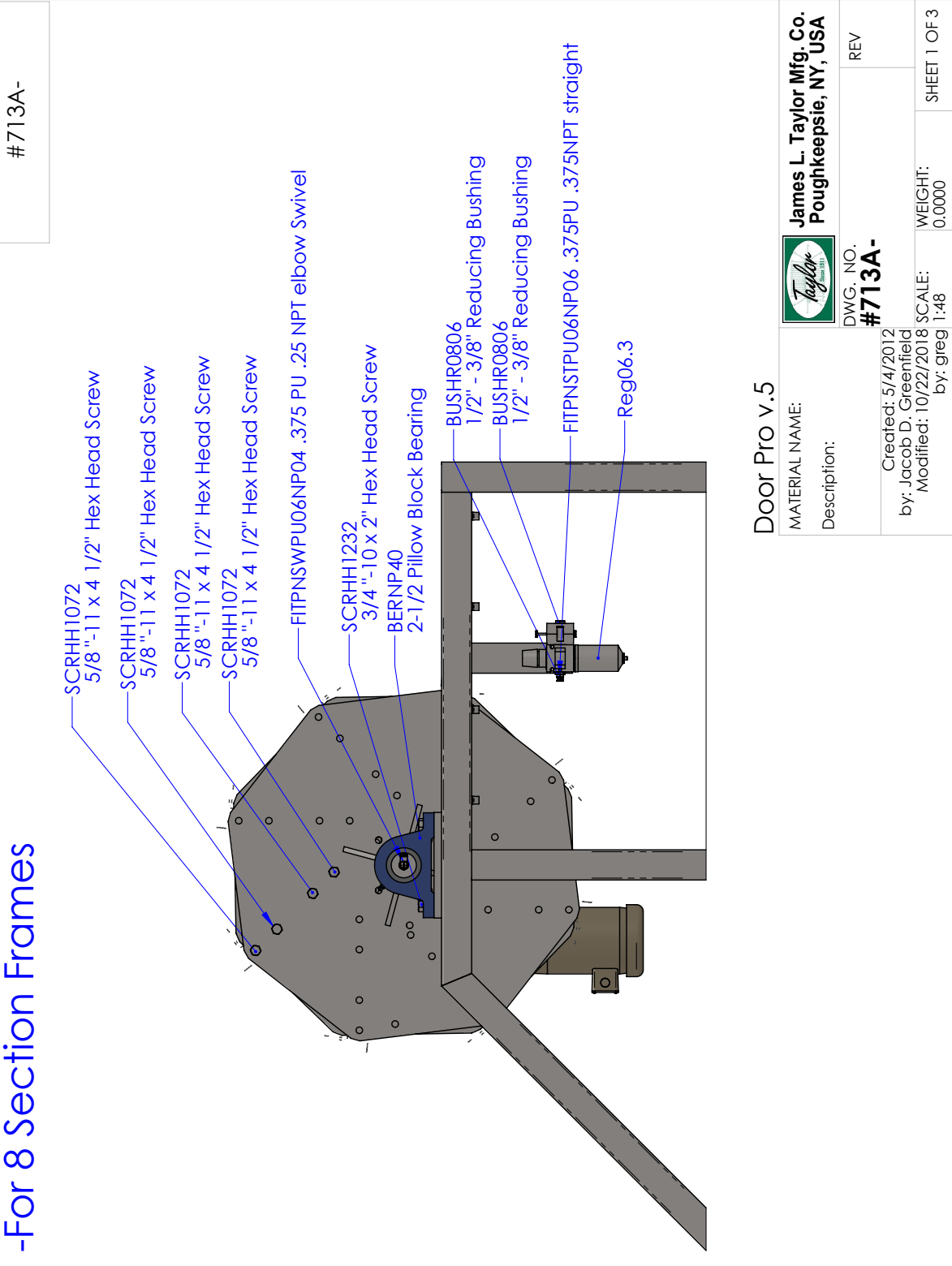
by: greg 1:48

WEIGHT:

0.0000


SHEET 3 OF 3

-For 8 Section Frames



#713A-

Door Pro v.5

		James L. Taylor Mfg. Co. Poughkeepsie, NY, USA	
MATERIAL NAME:			
Description:			
DWG. NO.	#713A-		
REV			
Created: 5/4/2012	by: Jacob D. Greenfield		
Modified: 10/22/2018	SCALE: 1:48		
	by: greg		WEIGHT: 0.0000
			SHEET 1 OF 3

-For 5 Section Frame

SCRHH1056
 SCRHH1056
 5/8"-11 x 3 1/2" Hex Head Screw
 FITPNSTPU06NP04 .375 PU straight .25 NPT
 BERNP40
 2-1/2 Pillow Block Bearing
 FITPNSWPU06NP04 .375 PU .25 NPT elbow Swivel
 SCRHH1232
 3/4"-10 x 2" Hex Head Screw
 REG06.3
 Regulator-Lockout Valve
 BUSHR0806
 1/2" - 3/8" Reducing Bushing
 FITPNSTPU06NP06 .375PU .375NPT straight

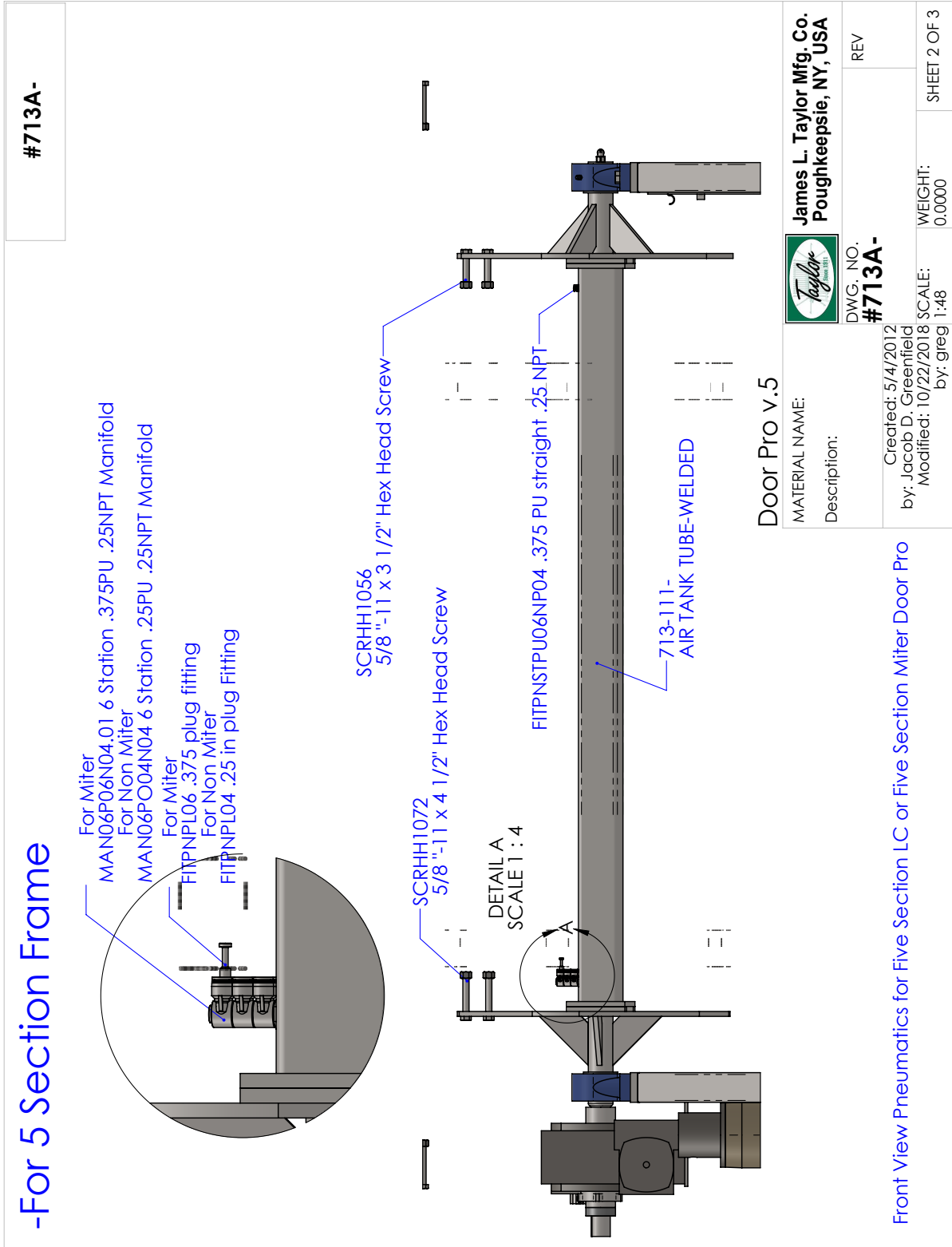
#713A-

Door Pro v.5

MATERIAL NAME: Description:	James L. Taylor Mfg. Co. Poughkeepsie, NY, USA
DWG. NO. #713A-	REV
Created: 5/4/2012 by: Jacob D. Greenfield Modified: 10/22/2018 by: greg	WEIGHT: 0.0000 SCALE: 1:48 SHEET 1 OF 3

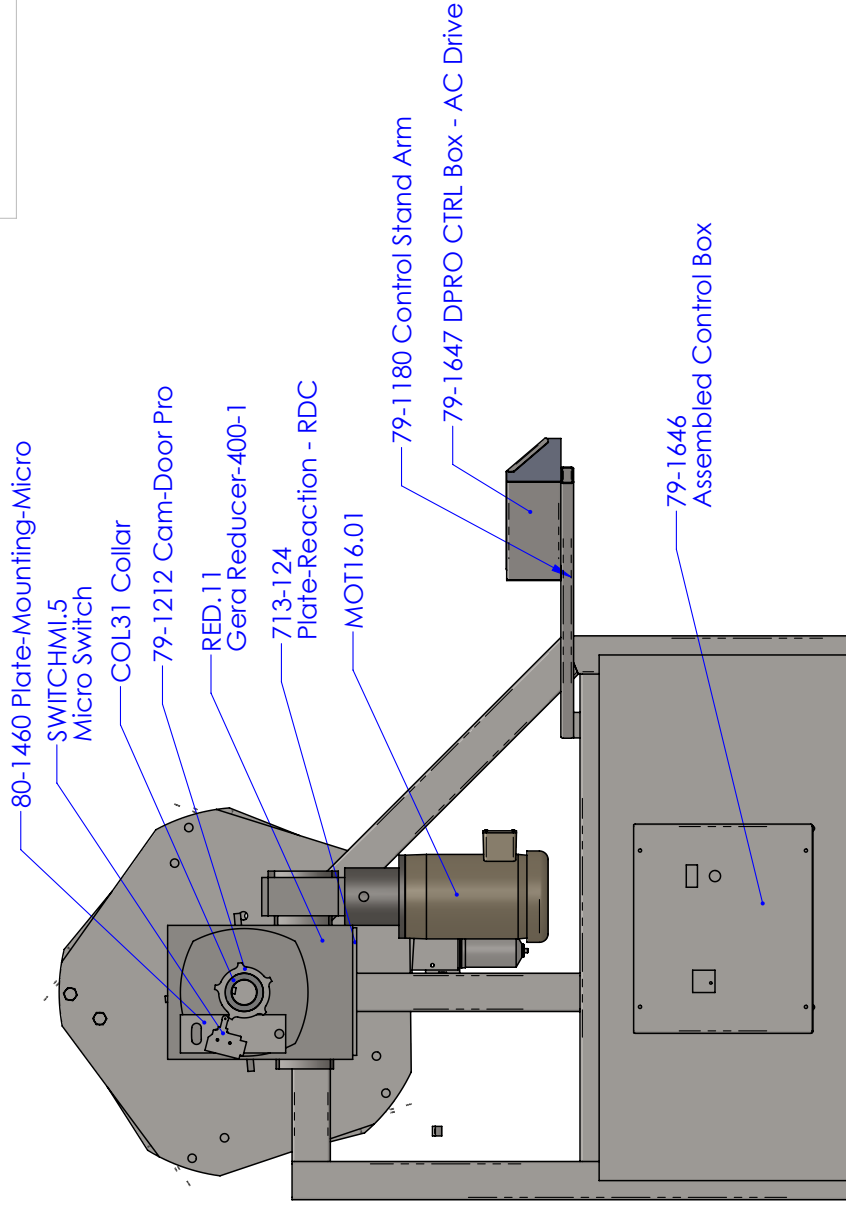
Config Shown: -5S-95W-57H-44D-NS-M-L

- Idle Side Pneumatics for Five Section LC or Five Section Miter Door Pro




-For 5 Section Frame

#713A-



Door Pro v.5

		James L. Taylor Mfg. Co. Poughkeepsie, NY, USA	
MATERIAL NAME:		DWG. NO.	REV
Description:		#713A-	
	Created: 5/4/2012		
	by: Jacob D. Greenfield	SCALE:	WEIGHT:
	Modified: 10/22/2018	by: greg	1:48
			SHEET 3 OF 3

Drive Side View Pneumatics for Five Section LC
 or Five Section Miter Door Pro

Bates Glue Release



U-C COATINGS CORPORATION

The premier manufacturer of water based coatings for the forest products industry, worldwide

BATES®

Boothcoating/Glue Release

A Silicone-Free Coating For Gluing Equipment And Paint Spray Booths

BATES is the #1 Glue Release coating in the world. A high quality, protective coating for gluing equipment and paint spray booths, BATES is ready-to-use, environmentally friendly and very cost effective.

DESCRIPTION — A water-based, wax and oil coating that makes surfaces slippery to repel glues. BATES is very effective when reapplied on a regular basis. *It is a temporary, protective film – not a cleaner.*



USES — Apply to any non-porous surface that accumulates dried glue, paint over-spray, wood resin, or other unwanted material. Use on gluing equipment, spray booths, slide ways, saw tables, etc. *Do not use on walkways; it is very slippery.*

PROVEN RESULTS — BATES Glue Release is recommended by most manufacturers of adhesives, glue clamping equipment and high-frequency electronic gluers.

BENEFITS — BATES *saves clean-up time!* Regular application prevents the harsh, difficult cleaning that abuses and deteriorates equipment. *Reduced clean-up time increases production output.*



Tel: 716-833-9366
website: www.uccoatings.com

US/CN Toll Free: 1-888-END-COAT
P. O. Box 1066 · Buffalo, NY 14215 · U.S.A.

Fax: 716-833-0120
email: info@uccoatings.com

BATES® Boothcoating/Glue Release

EASY TO APPLY — A liquid coating, BATES can be easily sprayed on, brushed on, or wiped on.

As a glue release – a light, thin coating is best

As a spray booth coating – a heavy coating is best

Apply BATES using:

A Trigger Bottle & Sponge



or a Roller



or a Spray Gun



PROPERTIES – BATES is a stable wax & oil emulsion. It contains *no silicones*.

Appearance: Viscous, white or creamy liquid that sets-up to a transparent film
Viscosity: 1900 cps. (similar to heavy weight oil)
Shipping Weight: 470 lbs./55 gallon drum; 45 lbs./5 gallon pail
(215 kg./205 liter drum; 21 kg./19 liter pail)
Specific Gravity: 0.95
Clean-up: Use hot soapy water
Coverage: 100 – 1000 sq. ft. per gallon, depending on application

STORAGE — Do not expose to freezing temperatures. Storage temperature between 50° – 90°F is suggested.

CONTAINER SIZES — 55 gallon drums / 30 gallon drums / 5 gallon pails
Smaller sizes are available upon request.

TRY IT BEFORE YOU BUY IT — All of U-C Coatings' products are available on a sample basis to allow you to test their effectiveness in your operation. Contact us for information and a sample of BATES to *start saving production time and money!*

OTHER PRODUCTS — We also produce other related coatings and sealers.

BATES HPR – high temperature glue release coating

BATES DPS – waxless sealer for dried wood parts

ANCHORSEAL – wax sealer for green lumber and logs

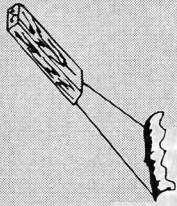
GEMPAINT – paint for dried lumber bundles and logos

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email: info@uccoatings.com



BATES

Boothcoating* / Glue Release

General Instructions

1. BATES Coating is non-flammable, non-corrosive, and gives off no toxic or irritating fumes -- very safe to use. In case of contact with skin, wash with warm water and soap. In case of contact with eyes, wash with warm water until clear. If swallowed in any appreciable quantity, obtain medical attention. Do not induce vomiting. BATES Coating contains water, petroleum oils and waxes, soap, and ethylene glycol.
2. BATES Coating will freeze after prolonged exposure to temperatures below freezing. This will cause the emulsion to break down, making it unusable. **STORE IN A HEATED AREA.**
3. Our "Freeze Stable" BATES Coating will be shipped during winter weather. If it arrives frozen, store in a warm area until thawed. It can then be used in a normal manner.
4. Cover and/or reseal containers between uses to prevent evaporation and deterioration of BATES Coating. It has an indefinite self life if kept sealed. Moderate stirring may be necessary after long periods of storage.
5. BATES Coating **DOES NOT DRY** -- it forms a waxy gel, so **DO NOT** use it on floors or other walkways. It is **VERY** slippery.
6. In addition to its primary use as a glue release coating and paint spraybooth coating, BATES Coating may also be used as a concrete mold or form release coating, and as temporary protection against fumes and spattering of most acids and alkalis. To remove the contamination and the coating, wash with a forceful stream of hot water.

Instructions for use as a Glue Release Coating

BATES Glue Release is the most widely used coating for the protection of equipment from glues of all types in the woodworking and furniture industries. It is used with excellent results on cold gluing equipment of all types: high frequency machines, clamps and clamp carriers, panel-mints, slat conveyers, set-up tables, etc. (For equipment operating above 80°C/175°F, use BATES HPR - Hot Press Release.) Except where noted in the instructions below, a thin coating of BATES Glue Release is all that is required. A thin coat will not contaminate the work. BATES Glue Release contains no silicone.

1. Surfaces of any equipment to be protected from glue accumulation must first be cleaned by conventional methods.
2. Any surface of glue equipment or equipment exposed to glue drippings can be protected by applying a thin coat of BATES Glue Release with a cloth, brush, sponge, or fine spray.
 - a. A small amount of BATES Glue Release should be applied to the cloth, brush or sponge, or sprayed onto the surface to be protected. The cloth or sponge should then be used to spread the BATES Glue Release to a thin, uniform coating in the same way that floor polish is applied in your home.
 - b. BATES Glue Release is also recommended to simplify clean-up of cold water-base glue pots, glue pans, applicator wheels and rolls, spreaders, etc. In these cases, the equipment should be cleaned at the end of every shift and a very thin new coating should be applied.
3. The BATES Glue Release should "set" for at least an hour before operation start up -- overnight is best.
4. BATES Glue Release is effective in protecting most surfaces of equipment used with hot or solvent-base glue, but it should not be used on applicator surfaces or in the glue source.
5. BATES Glue Release and accumulated glue can be removed easily with a scraper, putty knife, squeegee, cloth or sponge, depending on the application and the cleaning cycle. An efficient way to use BATES Glue Release is to make glue removal and re-application of a thin coating of BATES Glue Release a part of the operating cycle. So long as the old glue is removed, there is no need to remove remaining traces of BATES Glue Release, and no cleaning solvents are needed.
6. Use a very thin film of BATES Glue Release to protect saw table, planer tables, sander tables, etc., from rosin build-up and to keep work sliding smoothly. Dilute BATES Glue Release with a little water and spray it onto the surface with a spray bottle. Wipe off any excess with a damp cloth or sponge. Renew as needed. Scrape with a putty knife to clean.
7. Use a thick coat of BATES Glue Release for lubricating slideways and turnarounds where no one ever walks. A thick coat may also be sprayed onto non-work surfaces of clamp carriers, drive chains, and other equipment exposed to glue drippings, where the cleaning cycle is longer.

Instructions for use as a Paint Spraybooth Coating

1. Areas to be protected from paint or lacquer should be reasonably clean and smooth. The surface need not be completely clean and dry.
2. BATES Boothcoating may be applied with a brush, roller, or by spraying. Complete coverage with one heavy coat is all that is required. Application equipment can be cleaned with hot water and soap -- no solvents.
3. BATES Boothcoating **DOES NOT DRY**. It stays "wet and waxy". It should be applied and allowed to "set" for at least 4 hours before using the spraybooth. During this period, it will lose its yellowish color and become a soft, waxy gel which can be easily wiped or scraped off the wall.
4. BATES Boothcoating is most economical for spraybooths, water walls, exhaust stacks, exhaust fan blades, etc., which must be stripped and recoated on a frequent basis. IT **DOES NOT DRY** and tends to slowly evaporate.
5. A wide blade, reasonably sharp putty knife or scraper is the best tool for removal of BATES Boothcoating and the paint residue covering it. All paint or lacquer residue should be removed, but it is not necessary to remove all of the old BATES Boothcoating.
6. Where there are facilities for drainage and collection of residue, BATES Boothcoating and the paint or lacquer overspray covering it can be washed off walls, exhaust stacks, and other surfaces and equipment by hosing with a forceful stream of hot water. Surfaces do not need to be completely dry before recoating.

*BATES Boothcoating is a registered trademark of U•C Coatings Corporation.



FAX: 716-833-0120 716-833-9366
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website: www.uccoatings.com

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USA/CN Toll Free: 1-888-363-2628

SUGGESTIONS HOW TO USE *BATES Boothcoating/Glue Release* On Your Gluing Equipment

POSSIBLE USAGE AREAS	SUGGESTED PROCEDURES *
<p>A. Cleaning Up Old Glue Mess</p> <p>Don't let equipment go unprotected after this! <i>BATES Glue Release</i> is a protective coating, not normally a cleaner.</p>	<p>Hammer & chisel, power sander, or...</p> <p>To penetrate and soften dried glue build-up (water-based adhesives only), this sometimes works:</p> <p>(a) Paint on a heavy coating of <i>BATES Glue Release</i> at the end of the day Friday. Let sit over the weekend. On Monday, pry up with a scraper or blade. (Glue build-up may become pliable, like plastic.) Or,</p> <p>(b) Cover the glue build-up with wet cloths on Friday. Scrape on Monday. Or,</p> <p>(c) Do (a) and (b) together.</p>
<p>B. Applying <i>BATES Glue Release</i></p> <p>To: Clamps and Clamp Carriers High Frequency or Panel-Mint gluing machines. Set-up Tables. Any area or machinery on which glue drips or spatters.</p>	<p>Surface must be clean and free of glue</p> <p>Use a rag, sponge, roller, or dishwashing string mop lightly soaked with <i>BATES Glue Release</i> — not dripping wet — or in a spray bottle diluted 1:1 with water.</p> <p>Apply a thin coating to surfaces on which glue will drip. (Thin — like oiling machine parts for storage; thick coatings make a mess, and could be "squeegeed" into glue joints.)</p>
<p>To: Glue Pot Interior Glue Spreader Wheel Glue Pan Glue Spreader Conveyor</p>	<p>For best results, wipe on a thin coating after clean-up at the end of the work day. This allows <i>BATES Glue Release</i> to "set up" overnight. Otherwise, one hour drying time is usually sufficient.</p> <p>CAUTION: <i>BATES Glue Release</i> should be used to line glue pots, etc., only with cold, water-based glues. Use with hot or solvent based glue can result in contamination of the glue.</p>
<p>To: Saw Table Tops Any surface needing light, silicone-free lubrication.</p>	<p>Wipe on a very light film with a rag or sponge. Rub it in until it can't be seen at all — like polishing furniture.</p>
<p>NOTE: <i>BATES Glue Release</i> will remain soft and wet in appearance. It is not necessary to wait for it to "dry". However, many customers report best results when glue is scraped off at the end of a shift and <i>BATES Glue Release</i> is allowed to set up overnight.</p>	
<p>C. Periodic Clean-up</p> <ol style="list-style-type: none"> 1. A wide-blade scraper is most frequently used in areas where large amounts of hardened glue have accumulated. New <i>BATES Glue Release</i> can be applied at the same time. (See above). 2. A rag, sponge, or string mop, lightly soaked with <i>BATES Glue Release</i> is used by some to keep their work areas free of glue throughout the day, by wiping away recently accumulated glue and simultaneously applying fresh <i>BATES Glue Release</i>, for example, on a set-up table or HF bed during daily operations. <p>NOTE: As long as the glue is removed, traces of old <i>BATES Glue Release</i> do not need to be cleaned off before applying a new coating.</p>	

To clean application equipment — brushes, sprayers, sponges, or rags — simply use a solution of hot water and detergent. No cleaning solvents are needed or recommended.

*Through continued usage, each individual operation will find its own most convenient application and clean-up methods.

MATERIAL SAFETY DATA SHEET

PRODUCT NAME: BATES Boothcoating/Glue Release

DATE PREPARED: May 1, 2002

1. IDENTIFICATION

Identity (as used on label and listings): BATES Boothcoating/Glue Release

Chemical Family/Specific Type: Water-based emulsions / aqueous emulsion of wax and oil

Manufacturer:	U-C Coatings Corporation	Telephone Number:	716-833-9366
	P. O. Box 1066	Fax Number:	716-833-0120
	Buffalo, NY 14215 U.S.A.	Emergency Telephone No.:	716-833-9366

2. COMPOSITION / INFORMATION ON INGREDIENTS

<u>Ingredient</u>	<u>Approximate %</u>	<u>CAS No.</u>
Petroleum Oil	27%	64742 - 52 - 5
Petroleum Wax	17%	64742 - 61 - 6

No reportable quantities of any hazardous ingredients are present. No toxic chemical(s) subject to reporting requirements of Section 313 of Title III and of 40 CFR 372 are present.

3. HAZARDS RATINGS (HMIS) OF THE PRODUCT

HEALTH: 1 **FLAMMABILITY:** 1
REACTIVITY: 0 **PROTECTIVE EQUIPMENT:** C

Explanation of Hazards Ratings:

0 = Minimal Hazard 1 = Slight Hazard 2 = Moderate Hazard 3 = Serious Hazard 4 = Severe Hazard
 Protective Equipment: C = safety glasses + gloves + apron

General: BATES is generally harmless to handle provided that certain precautions normally taken when handling cleaning products and chemicals are observed.

Inhalation: Vapor pressure is very low, so inhalation is not normally a problem. Avoid heating the product --- heating may cause vapors causing irritation of the nose, throat and respiratory system.

Eye Contact: Causes irritation to the eyes.

Skin Contact: Repeated or prolonged skin contact may cause dermatitis or defatting.

Ingestion: Not expected to be acutely toxic. May cause irritation of digestive tract.

4. FIRST AID MEASURES

Inhalation: Remove to fresh air. Seek medical attention if symptoms continue.

Eye Contact: Flush eyes immediately with large amounts of water, using soap if possible. If irritation continues, seek medical attention.

Skin Contact: Wash skin with soap and water. Remove contaminated clothing. If irritation persists, seek medical attention.

Ingestion: Do not induce vomiting (aspiration hazard). Seek medical help immediately for ingestion of petroleum distillates.

5. FIRE FIGHTING MEASURES

Flash Point: No flash - boils at 190° - 212°F / 88° - 100°C

Extinguishing Media: Water spray, dry chemical, carbon dioxide (CO₂), foam. Do not direct solid stream of water or foam into burning pools.

Fire Fighting Instructions: Avoid breathing smoke and vapor.

Fire Fighting Equipment: Self-contained breathing apparatus and protective clothing.

Other Fire or Explosion Hazards: Incomplete combustion can produce carbon monoxide.

6. ACCIDENTAL RELEASE MEASURES

Spills or Leaks: Large spills: contain with dikes, collect, and filter for reuse. Small spills: collect or absorb with oil absorbent pads. Clean contaminated areas with soap and water. All spill response and disposal should be carried out in accordance with national and local requirements.

PRODUCT NAME: BATES Boothcoating/Glue Release

7. HANDLING AND STORAGE

Handling: Do not swallow; use normal precautions to avoid exposure to eyes and skin; use in areas with normal ventilation.

Storage: Store at temperatures above 32°F / 0°C. Avoid high heat or open flames.

General: Keep containers closed to minimize evaporation and skin formation. Store above 32°F / 0°C to prevent freezing and destruction of product.

8. EXPOSURE CONTROLS / PERSONAL PROTECTION

Exposure Limits: None established for this product.

Ventilation: Good ventilation in work area, atmospheric pressure.

Personal Protection: Eyes: safety glasses or splash goggles

Hands: rubber gloves

Other: synthetic apron for cleanliness

9. PHYSICAL & CHEMICAL CHARACTERISTICS

Appearance and Odor: Creamy colored liquid of paint-like consistency

Boiling Point: 212°F / 100°C

Specific Gravity: .94

Vapor Pressure: same as water

Melting Point: 32°F / 0°C

Vapor Density (air = 1): same as water

Evaporation Rate (butyl acetate = 1): < 1

Solubility In Water: infinitely diluteable

Flash Point: No flash - boils at 190° - 212°F / 88° - 100°C

Volatile Organic Compounds: none

Volatile Hazardous Air Pollutants: none

10. STABILITY AND REACTIVITY

Stability: Stable under normal temperatures and pressures.

Conditions to Avoid: None known.

Materials to Avoid: Strong oxidizing agents.

Hazardous Polymerization: Will not occur.

Hazardous Decomposition: Burning may produce carbon monoxide and/or carbon dioxide.

11. TOXICOLOGICAL INFORMATION

Product is practically non-toxic and non-irritating.

12. ECOLOGICAL INFORMATION

No data available.

13. DISPOSAL CONSIDERATIONS

Not a hazardous waste. Where recovery and reuse is not possible, dry water out of product and dispose of as industrial waste or by incineration where permitted under national and local regulations.

14. TRANSPORTATION INFORMATION

ADR/RID: Not regulated

IMDG: Not regulated

ICAO/IATA: Not regulated

15. REGULATORY INFORMATION

The ingredients in this product are in the TSCA, MITI, AICS, DSL inventories.

16. OTHER INFORMATION

Please consult product and application information for the proper use of this product.

BATES

Boothcoating®/ Glue Release

**A temporary protective coating
for all types of cold gluing applications and equipment**



**Regular application and use
makes glue clean-up quick and easy**

U.S. Packaging & Pricing- Effective July 12, 2004

55 Gallon Drums - 470 lbs. each

- \$5.45/gallon (\$299.75/drum), FOB Buffalo, NY
- \$5.75/gallon (\$316.25/drum), FOB Wisconsin Rapids, WI; Durham, NC; Jackson, MS; Louisville, KY; Huntington, WV.
- \$6.20/gallon (\$341.00/drum), FOB Portland, OR

30 Gallon Drums - 275 lbs. each

- \$6.75/gallon (\$102.50/drum), FOB Buffalo, NY

5 Gallon Pails - 45 lbs. each

- \$61.00/pail, including delivery by U.P.S., to Eastern U.S.A. C.O.D. charges additional.
- \$76.00/pail, including delivery by U.P.S., to Western U.S.A. C.O.D. charges additional.
- \$51.00/pail + prepaid shipping charges, to destinations outside the 48 contiguous states, payment due prior to shipment.

- **Terms are Net 30 Days from date of shipment for approved accounts.**
- **Invoices paid after due date will be assessed a late payment service charge of 1.5% per month.**

	FAX: 716-833-0120	716-833-9366
	U.C. COATINGS CORPORATION P.O. Box 1066 • Buffalo, NY 14215 • U.S.A.	

website: www.uccoatings.com

email: sales@uccoatings.com

US/CN Toll-free:

UCC704

PARTS &
SERVICE

PARTS & SERVICE

Parts Order Form

1. Sold to:

Company _____
Address _____
Address _____
City _____
State _____ Zip _____
Your Name _____
Phone # _____
Fax # _____
Purchase Order # _____

2. Ship to:

Company _____
Address _____
Address _____
City _____
State _____ Zip _____
Attention: _____
Phone # _____
Fax # _____
Purchase Order # _____

3. Parts Needed:

Quantity	Part Name	Description	Price (each)

4. Preferred Shipping Method:

(check one)

- UPS Regular Truck Customer Pickup UPS Next Day Air
 Carrier: _____ Other: _____ Air Freight

5. Fax, Mail, or Phone your Order to:

James L. Taylor Manufacturing
130 Salt Point Turnpike
Poughkeepsie, NY 12603
Phone: (845) 452-3780
Fax: (845) 452-0764