WARNING: This is a controlled document. It is your responsibility to deliver this information to the end user of the Destaco Robohand product. Failure to deliver this could result in your liability for injury to the user or damage to the machine. For copies of this manual, call your Customer Service Representative at 1.248.836.6700
**Parallel Grippers | Maintenance and Assembly Procedure**

### Assembly Procedure

1. Lubricate and install seal #55 into the body #1
2. Install #59 screw with thread locker into the body #1
3. Sub assemble the sensing nuts #9 into the jaws #6
4. Sub assemble the jaws #6 on either side of the double wedge #3 with lubrication
5. Insert the jaws and double wedge sub assembly into the body
6. Install seal #58 into the bottom case #5
7. Insert the screws #7 into the bottom case #5
8. Install bottom case #5 with pressed-in pins #63 onto the body and fasten with #64 screws with thread locker
9. Lubricate and install seal #54 into the piston #2
10. Mount magnets #56 to piston #2 with thread locker

11. For –C option, insert the springs #65 into the body #1 counterbore holes
12. Insert the piston #2 with pressed-in pin #57 onto the double wedge #3 and fasten with screw #61 with thread locker and washer #62. Face mount the piston counterbore holes to the body counterbore holes for –C option. Opposite mount for –O option.
13. For –O option, insert the springs #65 into the piston #2 counterbore holes
14. Install the screws #52 with thread locker onto the cap #4
15. Install seals #50 and #51 into the cap #4
16. Insert the cap #4 into the body #1 and locate it using cap dowel pins #60
17. Fasten the cap #4 with #53 screws with thread locker
18. Install the sensor holders #71 onto the body and fasten with screws #72
19. Insert screws #73 into the sensing nuts #9 from the body holes
20. Insert locating sleeves #8 into the jaws

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**Item Qty Name**

| Item | Qty | Name
|------|-----|----------------|
| 01   | 1   | Body
| 02   | 1   | Piston
| 03   | 1   | Double wedge
| 04   | 1   | Cap
| 05   | 1   | Bottom Case
| 06   | 2   | Jaws
| 07   | 2   | Bottom Case, SS Screw
| 08   | 4   | Locating sleeve
| 09   | 2   | Sensing nut
| 50   | 1   | Cap, O-ring
| 51   | 2   | Cap, O-ring
| 52   | 3   | Cap, SS screw
| 53   | 4   | Cap, SHC screw
| 54   | 1   | Piston, O-ring
| 55   | 1   | Body, O-ring
| 56   | 4   | Piston, Magnet
| 57   | 1   | Piston, Pin
| 58   | 1   | Bottom case, O-ring
| 59   | 1   | Body, SS screw
| 60   | 2   | Cap, Pin
| 61   | 1   | Double wedge, HH screw
| 62   | 1   | Double wedge, Seal
| 63   | 2   | Bottom case, Pin
| 64   | 6   | Bottom case, SHC Screw
| 65   | 4 or 8 | Spring
| 71   | 2   | Sensor holder
| 72   | 4   | Sensor holder, SHC screw
| 73   | 2   | Sensing nut, SHC screw

**Seal Repair Kit Order #'s**

- SK

See Product Data Sheets

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**NOTE:** Contact the Destaco-Robohand Sales Department for a complete spare parts list with order numbers and prices.
**Accessory Installation & Adjustment Instructions**

**Magneto Resistive Sensor #90**
1) Insert sensor #90 from either end of the profile slot
2) Adjust the sensor #90 into the profile slot, depending on the position to sense
3) Set the sensor with the integrated screw

**Inductive Sensor #91**
1) Insert sensor #91 into the sensor holder #71
2) Tighten the sensor using the SHC screw onto the sensor holder #71
3) Insert the SHC screw #73 into the sensing nut #9. The SHC screws are the targets to be adjusted in front of the sensor. The SHC screws #73 are supplied with 2 different lengths: depending on the position to sense, use the shortest for open position, or the longest for close position. The sensing nut #9 has a thread insert that prevents the target from loosening (this may make the target harder to tighten into the nut).
# GLOBAL LOCATIONS

## NORTH AMERICA

**Corporate Headquarters**  
Auburn Hills, Michigan  
Toll Free: 1.888.DESTACO  
Marketing: marketing@destaco.com

**Global Technology Center**  
Auburn Hills, Michigan  
Tel: 1.248.836.6700  
Customer Service: customerservice@destaco.com

**Mt. Juliet, Tennessee**  
Tel: 1.888.DESTACO  
Customer Service: customerservice@destaco.com

**Wheeling, Illinois**  
Tel: 1.800.645.5207  
Customer Service: camco@destaco.com

**Red Wing, Minnesota (Central Research Laboratories)**  
Tel: 651.385.2142  
Customer Service: sales@centres.com

## ASIA

**Bangkok, Thailand**  
Tel: +66-2-326-0812  
Customer Service: info@destaco.com

**Shanghai, China**  
Tel: +86-21-6081-2888  
Customer Service: china@destaco.com

**Bangalore, India**  
Tel: +91-80-41123421-426  
Customer Service: india@destaco.com

## EUROPE

**Oberursel, Germany**  
Tel: +49-6171-705-0  
Customer Service: europe@destaco.com

**Sainte Florine, France**  
Tel: +33-4-73545001  
Customer Service: france@destaco.com

**Wolverhampton, United Kingdom**  
Tel: +44-1902-797980  
Customer Service: uk@destaco.com

**Sant Boi de Llobregat, Spain**  
Tel: +34-936361680  
Customer Service: spain@destaco.com

**Uithoorn, Netherlands**  
Tel: +31-297285332  
Customer Service: benelux@destaco.com