Film Table Refit Procedure

Applies to ThermoFlex

Background This document outlines the procedure for refitting the original style Flexo table with a Film loading style table.

Tools and parts

Steps

Removing Old table

1. Remove table pneumatics and cables.
2. Remove gas strut clips from struts.
3. With one person at each end of the recorder, lift and hold open the table.
4. Loosen the fasteners securing the table pivot bushing to the frame.
5. Loosen the nuts on the shoulder bolts.
6. Remove the table pivot shoulder bolts and the shim washers.
7. Remove the old table assembly.

Installing new table (part 1)

1. Begin by installing the pneumatics. Refer to Fig. 1, Fig 2. and assembly DWG 50-1630A and BOM 50-1630A.

Figure 1

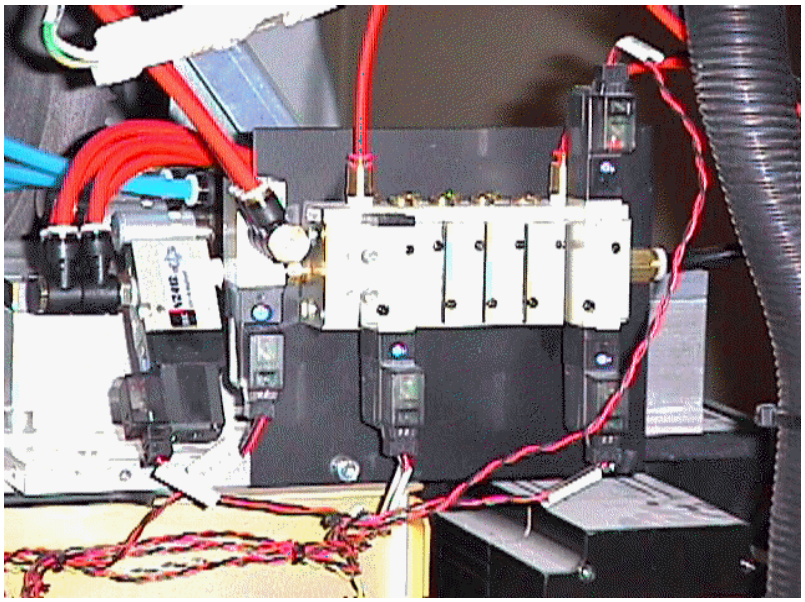
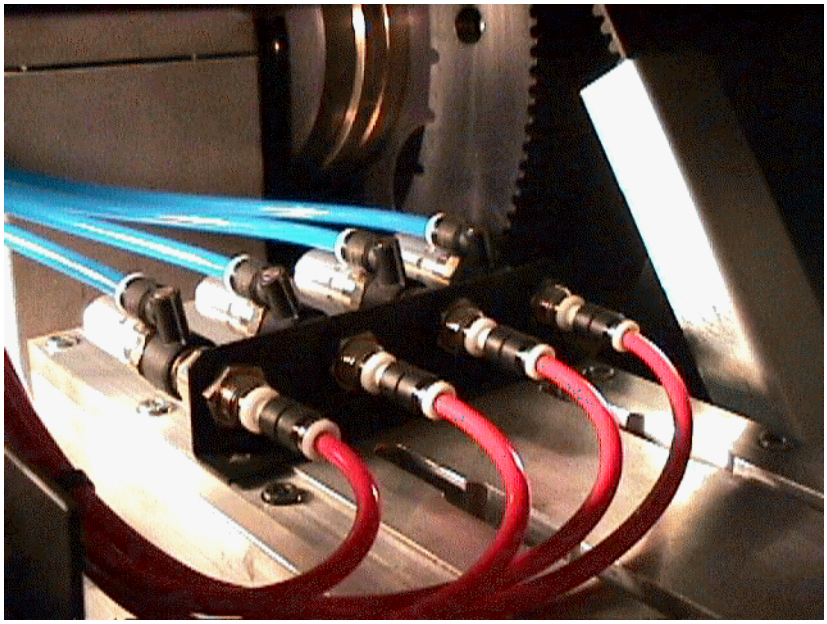


Figure 2



2. Replace manifold plate 57-5449A-A with Rev. B version.
3. Remove the “TBL VAC” solenoid valve along with the triple air fitting, and the 1/8 NPT nipple from the manifold block. Remove the 1/8NPT nipple from the solenoid valve and discard.
4. Install new pneumatic fittings; items 0020, 0160, 0170, 0180, 0190, and 0200 as per Dwg.
5. Install the vacuum generator bracket 57-6544A onto the motor mount stiffening plate using two m6 screws 52-4324, and two m6 washers 52-4186.
6. Install four vacuum generators 55-0093 using bulkheads 55-0105.
7. Insert four elbows 55-0139 into the inlets of the vacuum generators.

Installing new table (part 2)

1. Mount the table pivot bushings on the frame using m5 screws and nylock nuts. Do not tighten the fasteners.
2. Lift and carry the table with one person at each corner of the table, and approach the frame from the rear.
3. Place the assembled load/unload table in the frame.
4. Center the table between the frame top rails.
5. Measure the gap between the table pivot bushings and the table pivot mounting blocks at both ends of the table.

6. To determine the number of shim washers required at both ends of the table, divide the measured gap by the thickness of the shim washers.
7. Insert the table pivot shoulder bolts from the table pivot mounting blocks through the shim washers and the table pivot bushing.
8. Tighten the nuts on the shoulder bolts.
9. Align the table to the drum.
10. Tighten the fasteners securing the table pivot bushing to the frame.
11. With one person at each end of the recorder, lift and hold open the table.
12. Snap the gas struts onto the gas strut ball studs on the table frame at both ends of the table. The barrel end of the gas strut should be connected to the table stud.
13. Install the gas strut clips onto the struts.
14. Connect the table pneumatics and cables.

Notes

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