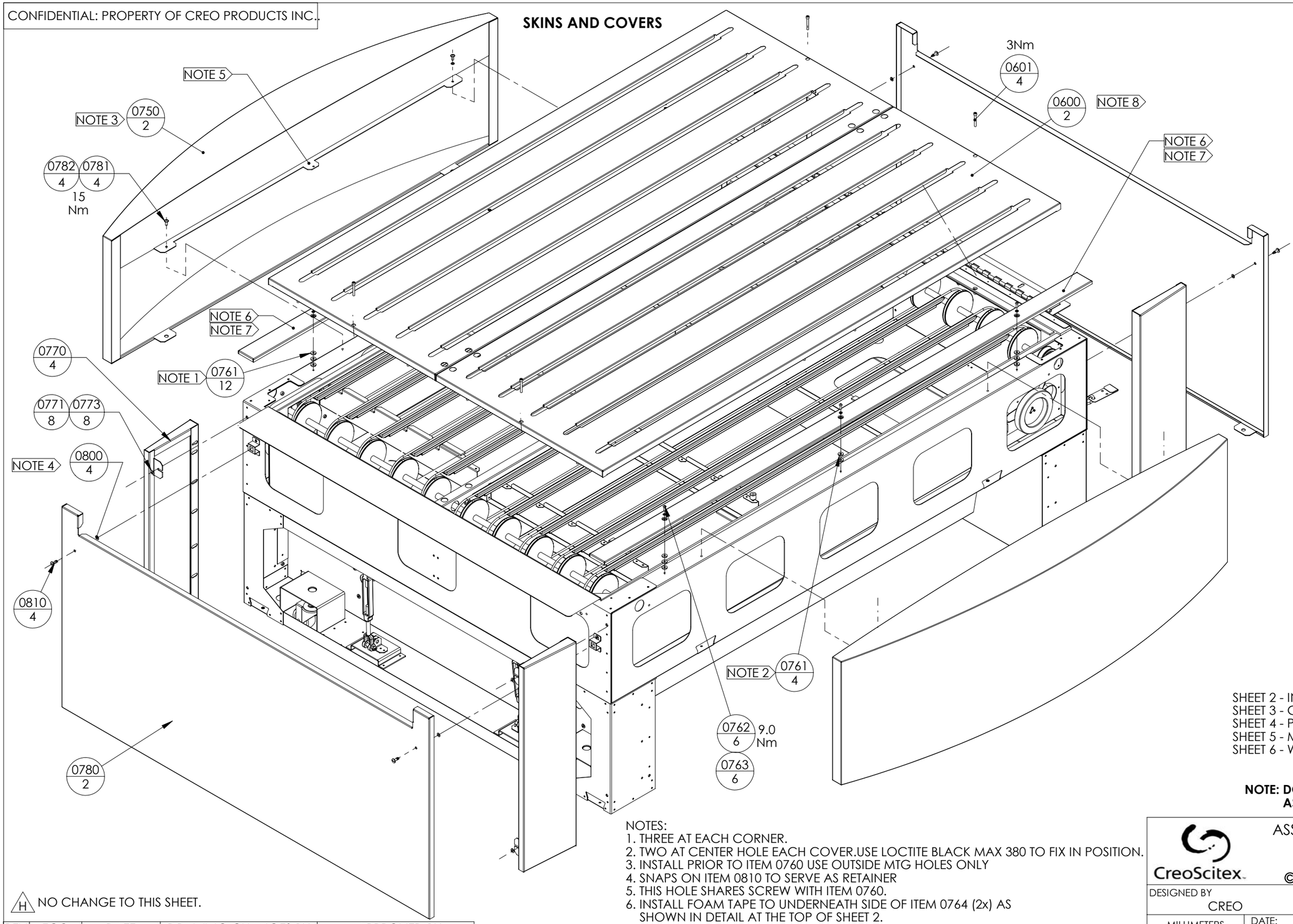
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SKINS AND COVERS



SHEET 2 - INNER FRAME INSTALL
SHEET 3 - GLIDE RAILS AND SUPPORTS
SHEET 4 - PULLEYS, BELTS & MOTOR
SHEET 5 - MAIN FRAME ASSY
SHEET 6 - WIRING HARNESS

NOTE: DO NOT USE LOCTITE ON THIS ASSEMBLY UNLESS SPECIFIED.

NOTES:
1. THREE AT EACH CORNER.
2. TWO AT CENTER HOLE EACH COVER.USE LOCTITE BLACK MAX 380 TO FIX IN POSITION.
3. INSTALL PRIOR TO ITEM 0760 USE OUTSIDE MTG HOLES ONLY
4. SNAPS ON ITEM 0810 TO SERVE AS RETAINER
5. THIS HOLE SHARES SCREW WITH ITEM 0760.
6. INSTALL FOAM TAPE TO UNDERNEATH SIDE OF ITEM 0764 (2x) AS SHOWN IN DETAIL AT THE TOP OF SHEET 2.
7. ALIGN ITEM 0760 SUCH THAT IT DOES NOT INTERFERE WITH ITEM 0780.
8. ALIGN TWO ITEMS #0600 TOP PLATES WITH EACH OTHER AND MAKE SURE THEY HAVE EVEN GAPS WITH ITEM #0610 ITEM #0650 BEFORE ITEM #0601 TIGHTENED.

H NO CHANGE TO THIS SHEET.

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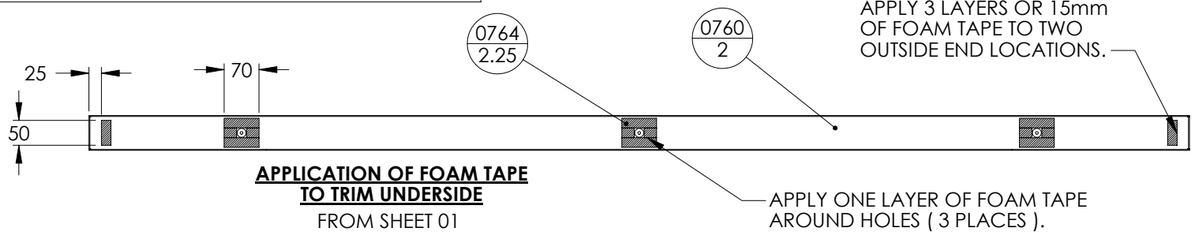
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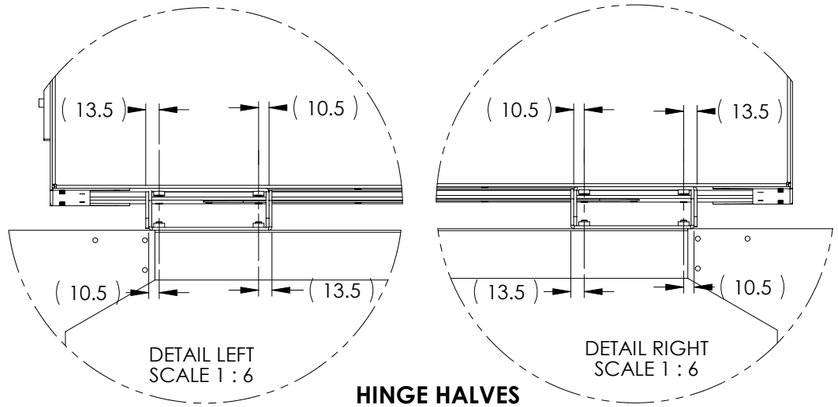
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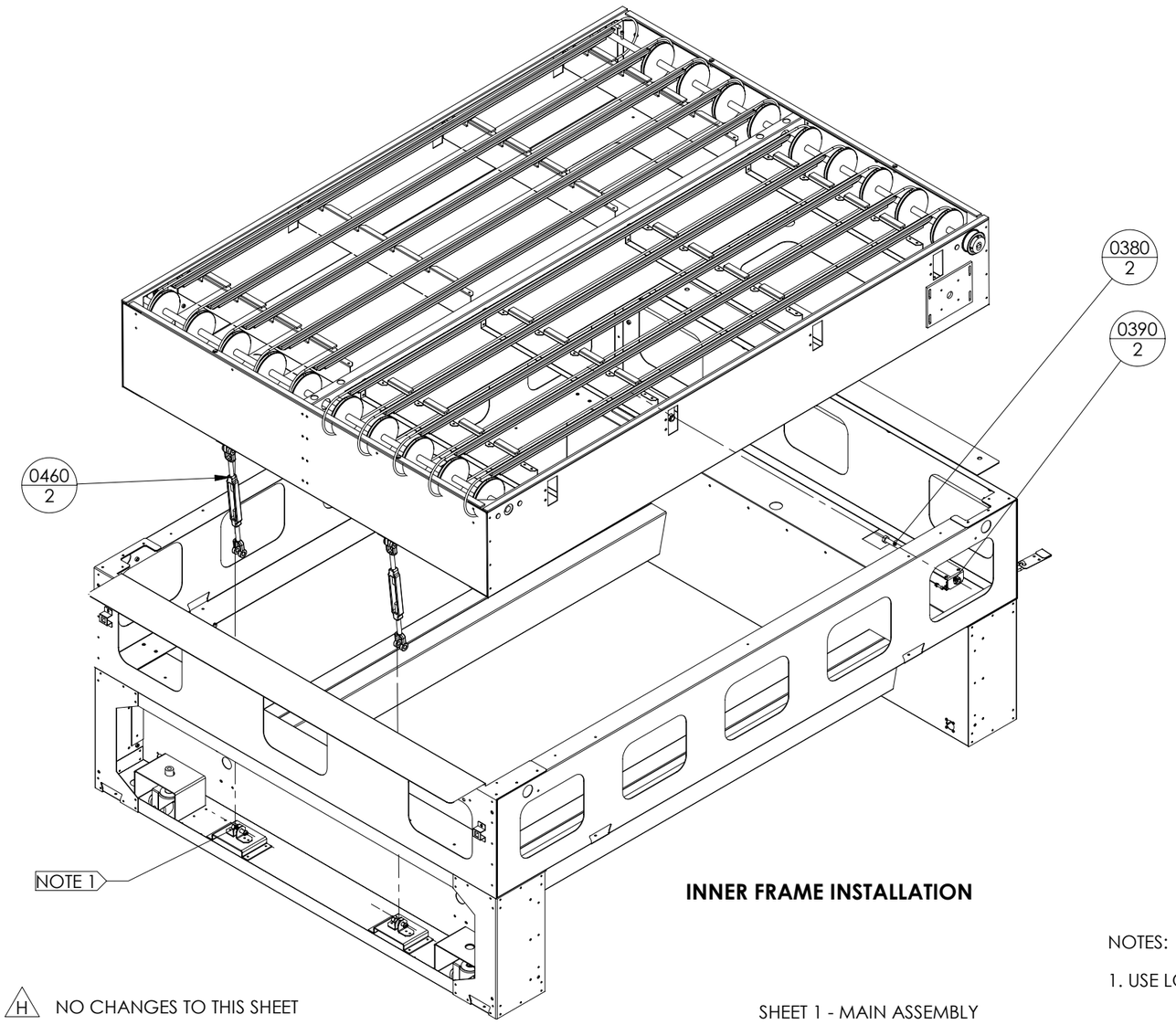
APPLICATION OF FOAM TAPE TO TRIM UNDERSIDE

FROM SHEET 01

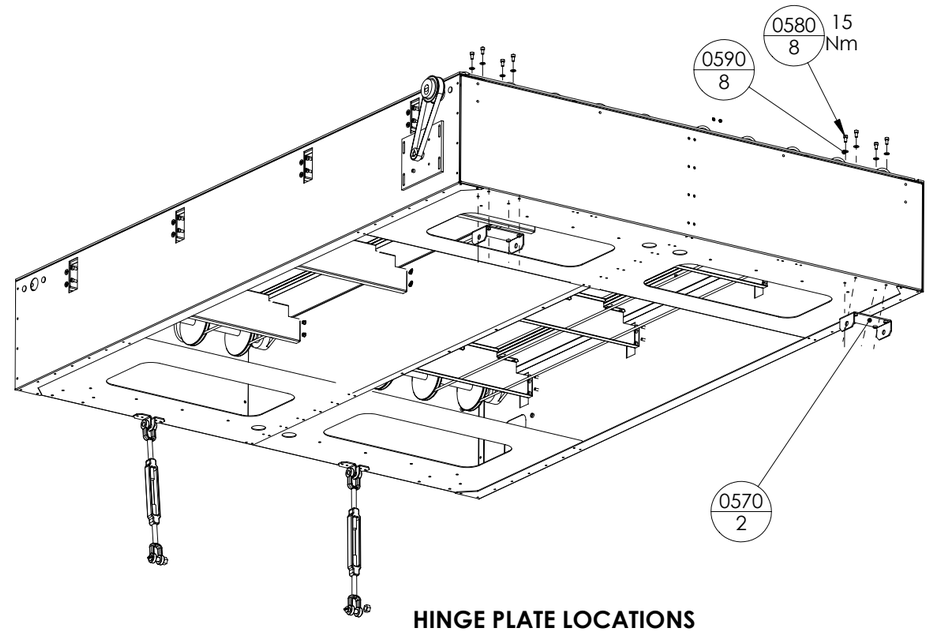
NOTE: PEMNUT PATTERNS ARE NOT SYMETRIC ON HINGE BRACKETS, INSTALL WITH OFFSETS TO OUTSIDE ON TOP FRAME AND INSIDE ON BOTTOM FRAME AS SHOWN BELOW BY REFERENCE DIMENSIONS.



HINGE HALVES ORIENTATIONS



INNER FRAME INSTALLATION



HINGE PLATE LOCATIONS

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SHEET 1 - MAIN ASSEMBLY

SHEET 3 - GLIDE RAILS AND SUPPORTS
SHEET 4 - PULLEYS, BELTS & MOTOR
SHEET 5 - MAIN FRAME ASSY
SHEET 6 - WIRING HARNESS

NOTES:

1. USE LOCTITE 242 ON SHACKLE PIN NUT

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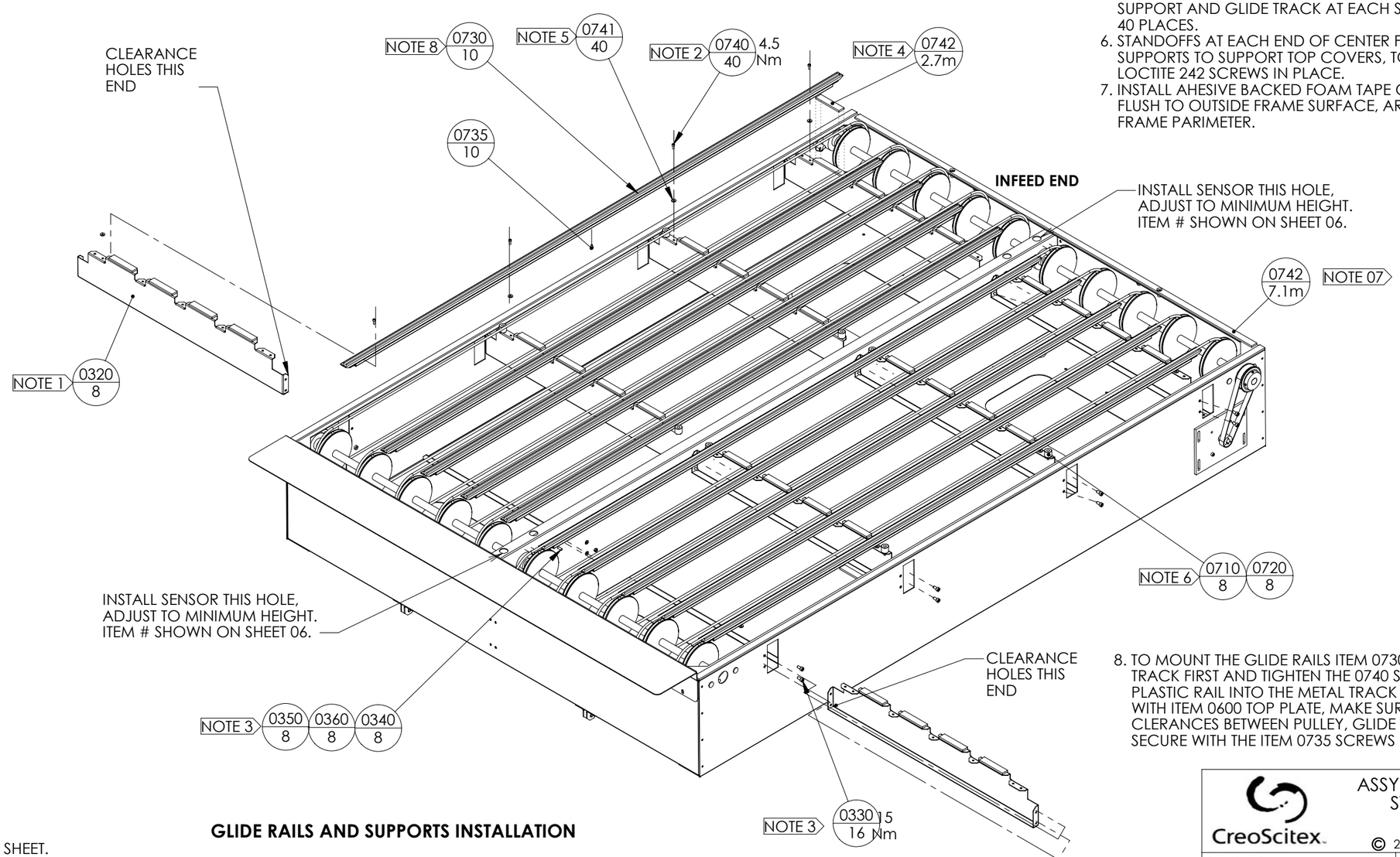
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ASSEMBLY PROCEDURE NOTES:

1. INSTALL BRACING THRU ACCESS HOLES IN FRAME AFTER PULLEYS AND BELTS HAVE BEEN INSTALLED, EIGHT PLACES.
2. INSTALL BELT GUIDES ON TOP OF BRACING AND BENEATH BELTS, TEN PLACES.
3. GLIDE SUPPORT HAVE PEM NUTS IN ONE END ONLY, LOCATE SUPPORT WITH CLEARANCE HOLES AT FRAME CENTER MEMBER. USE ITEM 0330 AT PEM NUT ENDS AND ITEM 0340,0350 AND 0360 AT CENTER.
4. INSTALL ADHESIVE BACKED FOAM TAPE ON GLIDE SUPPORTS AS SHOWN, 32 PIECES X 85 LG.
5. ONE ITEM 0741 WASHER TO BE BETWEEN GLIDE SUPPORT AND GLIDE TRACK AT EACH SCREW LOCATION 40 PLACES.
6. STANDOFFS AT EACH END OF CENTER FOUR GLIDE SUPPORTS TO SUPPORT TOP COVERS, TOTAL 8 PLACES. LOCTITE 242 SCREWS IN PLACE.
7. INSTALL AHESIVE BACKED FOAM TAPE ON TOP FLANGE, FLUSH TO OUTSIDE FRAME SURFACE, AROUND ENTIRE FRAME PARIMETER.



8. TO MOUNT THE GLIDE RAILS ITEM 0730, INSTALL THE METAL TRACK FIRST AND TIGHTEN THE 0740 SCREWS. SLIDE THE PLASTIC RAIL INTO THE METAL TRACK FROM THE END. ALIGN WITH ITEM 0600 TOP PLATE, MAKE SURE THAT THERE ARE EVEN CLERANCES BETWEEN PULLEY, GLIDE TRACK AND TOP PLATE. SECURE WITH THE ITEM 0735 SCREWS FROM UNDERNEATH.

GLIDE RAILS AND SUPPORTS INSTALLATION

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SHEET 1 - MAIN ASSEMBLY
SHEET 2 - INNER FRAME INSTALL

SHEET 4 - PULLEYS, BELTS & MOTOR
SHEET 5 - MAIN FRAME ASSY
SHEET 6 - WIRING HARNESS

NOTE: DO NOT USE LOCTITE ON THIS ASSEMBLY UNLESS SPECIFIED.

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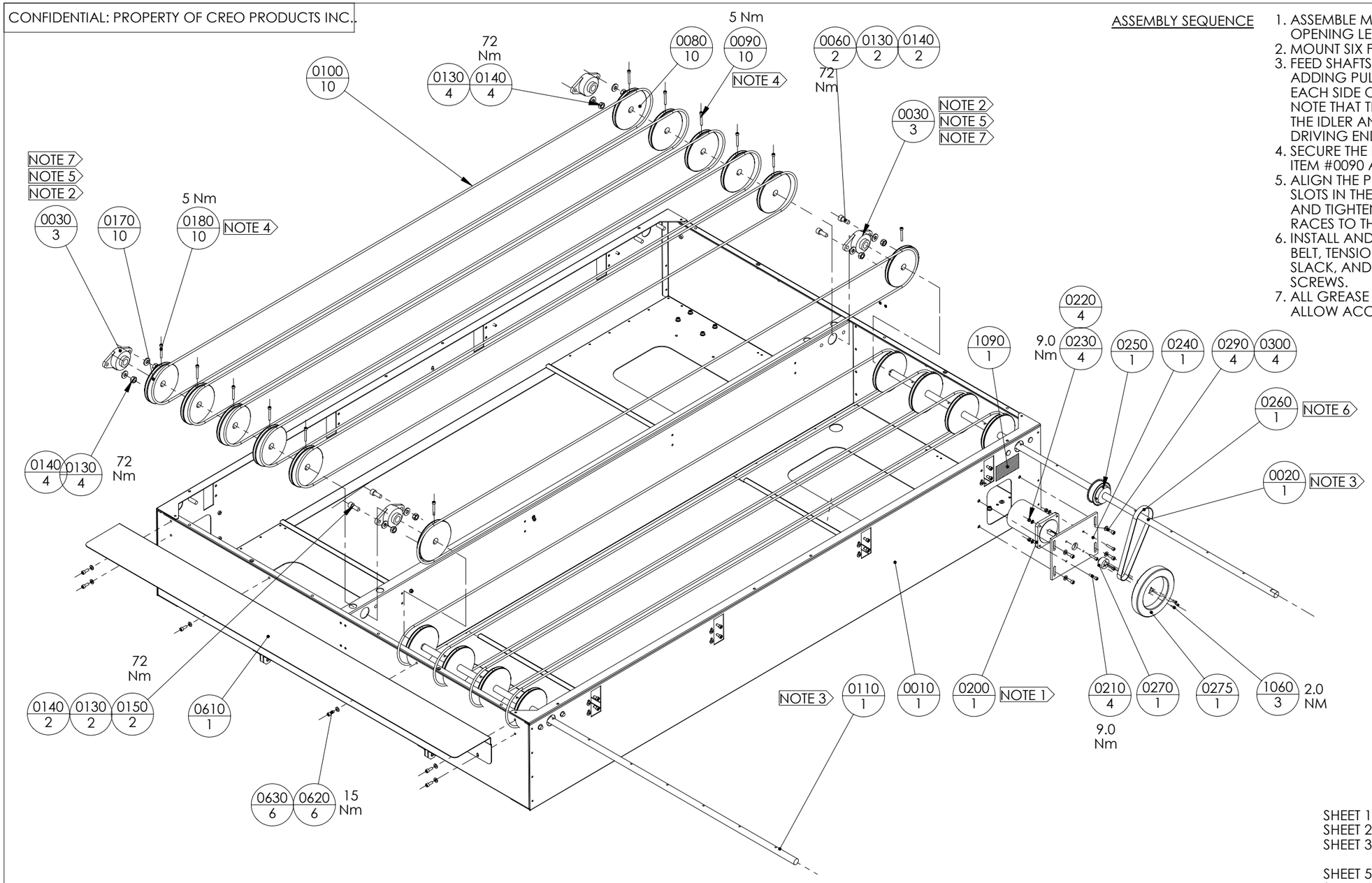
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INNER FRAME PULLEYS/BELTS ASSEMBLY

ASSEMBLY SEQUENCE

1. ASSEMBLE MOTOR AND PLATE. MOUNT IN FRAME OPENING LEAVING PLATE MNTG SCREWS LOOSE.
2. MOUNT SIX FLANGE BEARINGS
3. FEED SHAFTS THRU FRAME HOLES AND BEARINGS, ADDING PULLEYS AND BELTS AS NEEDED, FIVE EACH SIDE OF CENTER FRAME MEMBER. NOTE THAT THE DRIVING SHAFT IS LONGER THAN THE IDLER AND HAS A FLAT MACHINED AT THE DRIVING END.
4. SECURE THE PULLEYS TO THE SHAFTS WITH THE ITEM #0090 AND #0180 SCREWS.
5. ALIGN THE PULLEY/SHAFT ASSEMBLIES TO THE SLOTS IN THE TOP COVERS (ITEMS #0600 SHT 03) AND TIGHTEN THE SET SCREWS IN THE BEARING RACES TO THE SHAFTS.
6. INSTALL AND ALLIGN THE TWO DRIVE PULLEYS AND BELT, TENSION THE BELT ENOUGH TO REMOVE THE SLACK, AND TIGHTEN THE MOTOR MOUNT PLATE SCREWS.
7. ALL GREASE NIPPLES MUST FACE DOWNWARD TO ALLOW ACCESS WITH A GREASE GUN.

SHEET 1 - MAIN ASSEMBLY
SHEET 2 - INNER FRAME INSTALL
SHEET 3 - GLIDE RAILS AND SUPPORTS

SHEET 5 - MAIN FRAME ASSY
SHEET 6 - WIRING HARNESS

△H NO CHANGES TO THIS SHEET

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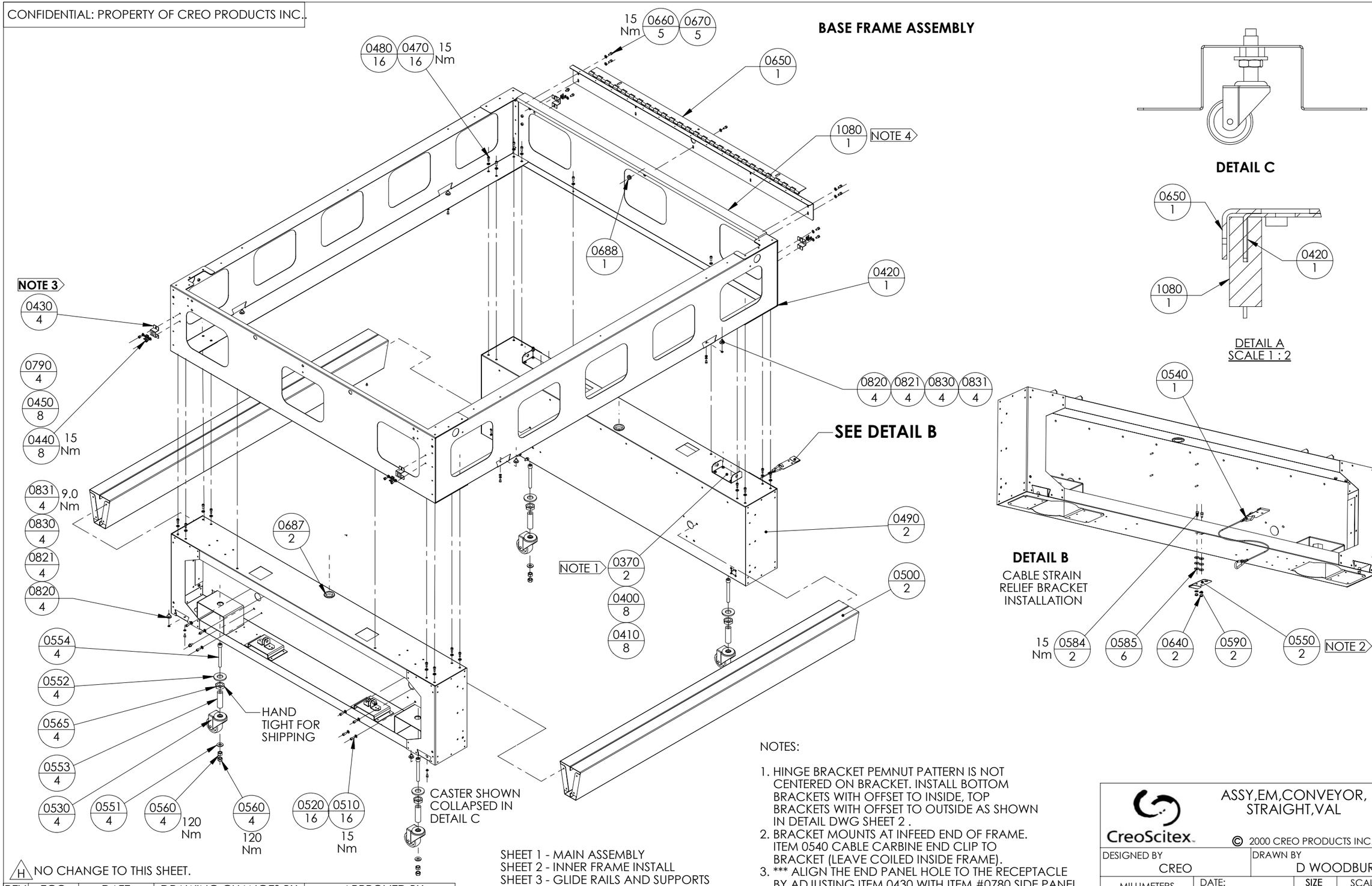
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BASE FRAME ASSEMBLY



DETAIL C

DETAIL A
SCALE 1 : 2

DETAIL B
CABLE STRAIN RELIEF BRACKET INSTALLATION

NOTES:

1. HINGE BRACKET PEMNUT PATTERN IS NOT CENTERED ON BRACKET. INSTALL BOTTOM BRACKETS WITH OFFSET TO INSIDE, TOP BRACKETS WITH OFFSET TO OUTSIDE AS SHOWN IN DETAIL DWG SHEET 2 .
2. BRACKET MOUNTS AT INFEED END OF FRAME. ITEM 0540 CABLE CARBINE END CLIP TO BRACKET (LEAVE COILED INSIDE FRAME).
3. *** ALIGN THE END PANEL HOLE TO THE RECEPTACLE BY ADJUSTING ITEM 0430 WITH ITEM #0780 SIDE PANEL BEFORE INSTALLING THE LATCH IN THE PANEL. ***
4. INSERT ITEM #1080 INTO THE SPACE BETWEEN ITEM #0420 AND ITEM #0650 ON FEED-IN SIDE. (SEE DETAIL A)

SHEET 1 - MAIN ASSEMBLY
SHEET 2 - INNER FRAME INSTALL
SHEET 3 - GLIDE RAILS AND SUPPORTS
SHEET 4 - PULLEYS, BELTS & MOTOR

SHEET 6 - WIRING HARNESS

H NO CHANGE TO THIS SHEET.

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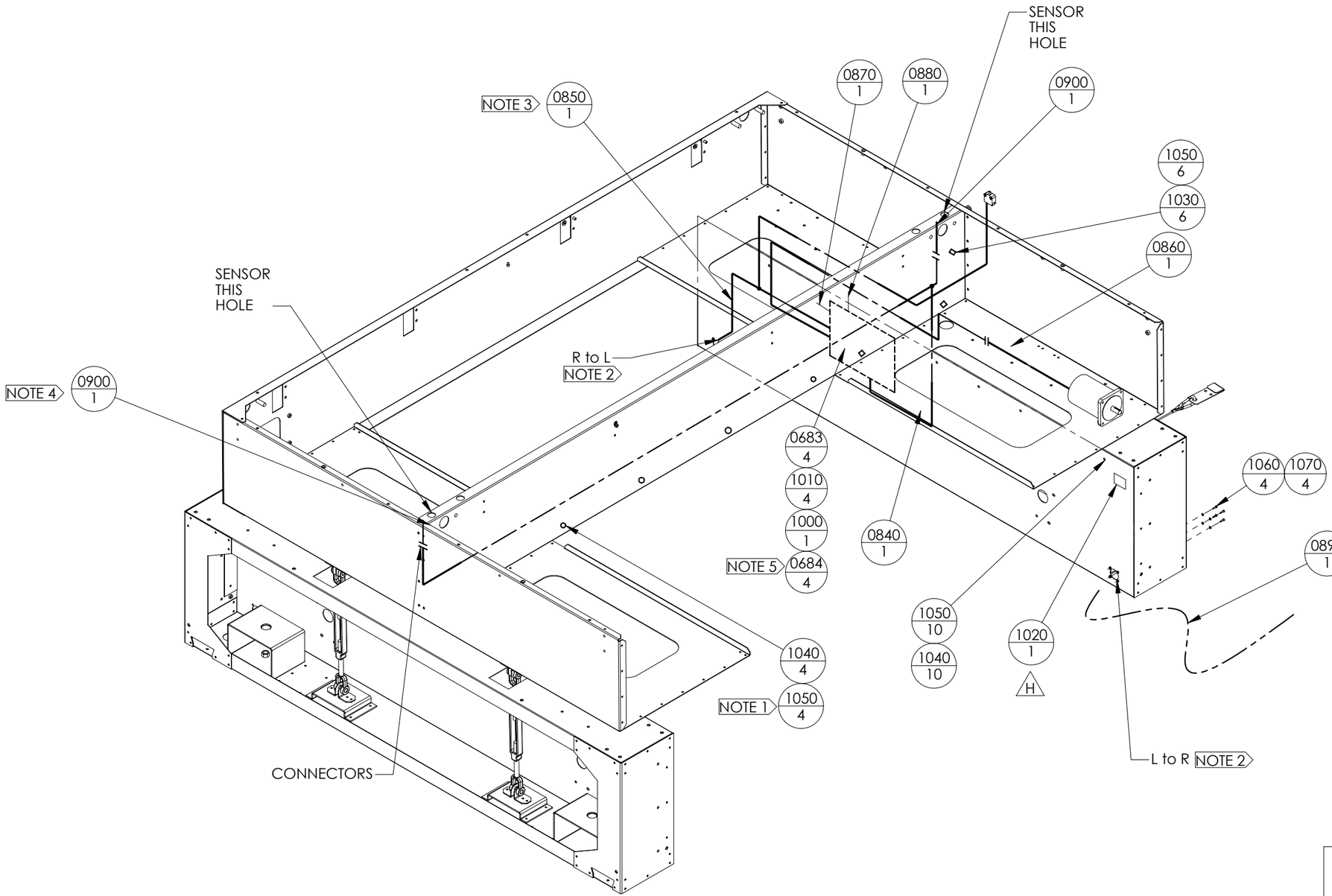
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NOTES:

1. INSERT FROM OTHER SIDE OF PANEL.
2. CONNECT ITEM #0850 TO THIS SIDE. THIS HAS BULKHEAD FITTING (L to R).
3. CABLES ITEMS #0850 & #0890 TO BE LEFT COILED UP WITH A CABLE TIE INSDE THE POD READY FOR SITE INSTALLATION.
4. ADJUST SENSORS TO MINIMUM HEIGHT.
5. LOCATE ITEM #0684 BETWEEN ITEM #1000 AND THE SIDE WALL OF ITEM #0490



NOTE: DO NOT USE LOCTITE ON THIS ASSEMBLY UNLESS SPECIFIED.

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CABLE TRACE
S-CONVEYOR
VLF AUTOLOADER

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