

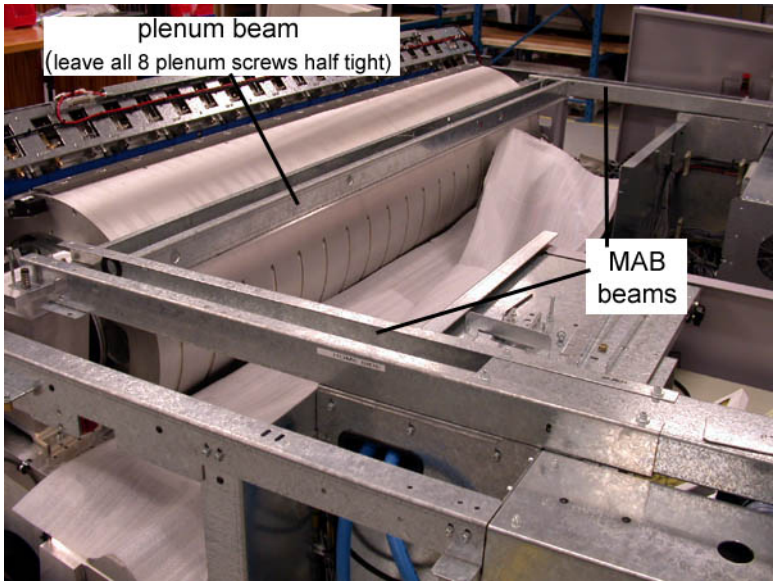
MAGNUS VLF

TABLE ASSEMBLY PROCEDURE

February 25, 2004

1

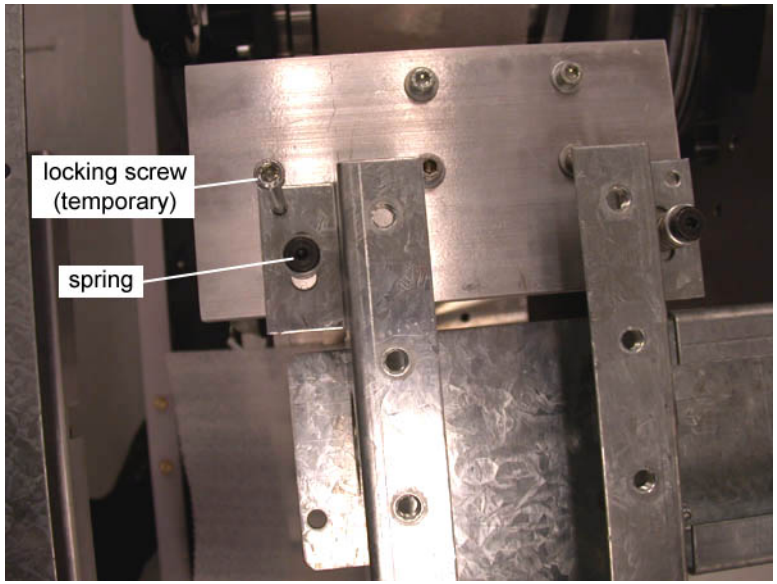
Preassemble and place the subframe on the engine frame.



The subframe has 3 pieces —:the MABs and the plenum beam. You will need a helper to lift the subframe into place. Leave the 8 plenum screws half tight (floating).

2

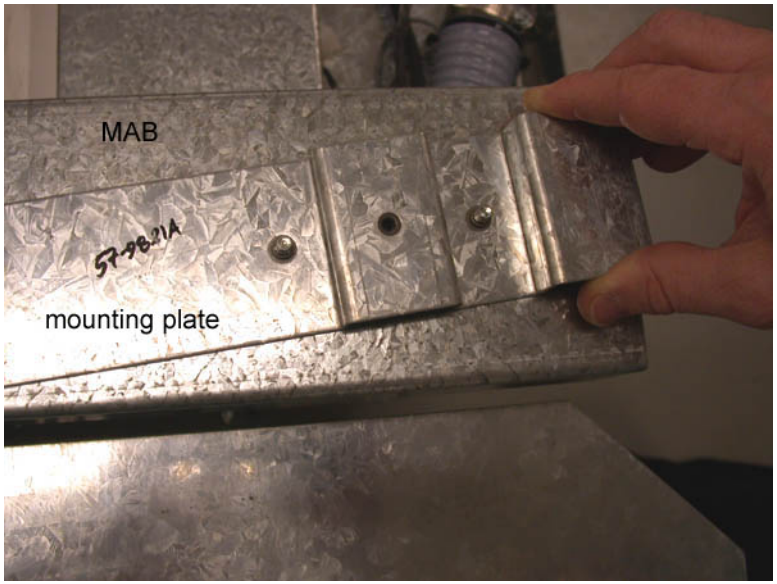
Attach the springs and locking screws to the end of the plenum beam.



Center the spring in the slot if possible. Tighten the shoulder screw on the spring fully.
Leave the locking screws half tightened.

3

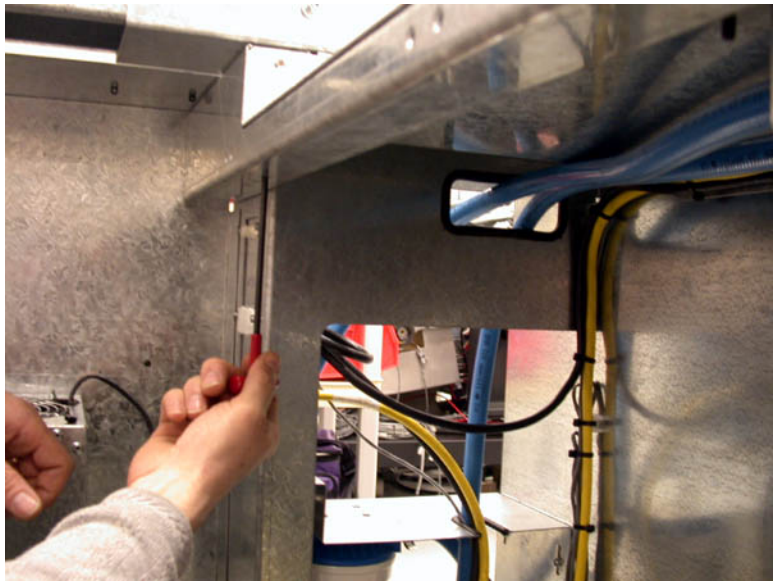
Leave the mounting plates floating on the end of the MAB beams.



Home side shown. Repeat for the away side.

4

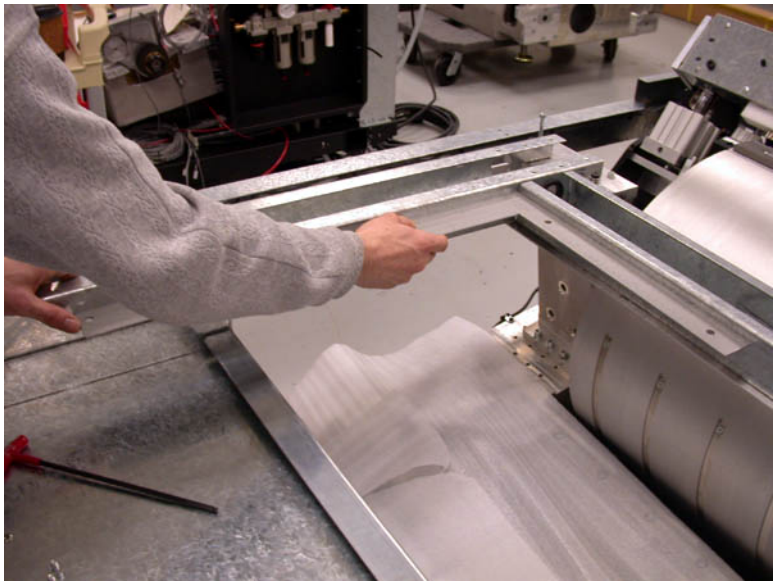
Attach the MAB beams to the chassis



Install on each side with an M5 screw.
Don't tighten - leave the MABs floating.

5

Adjust the MABs to ≤90º square to the plenum beam.



6

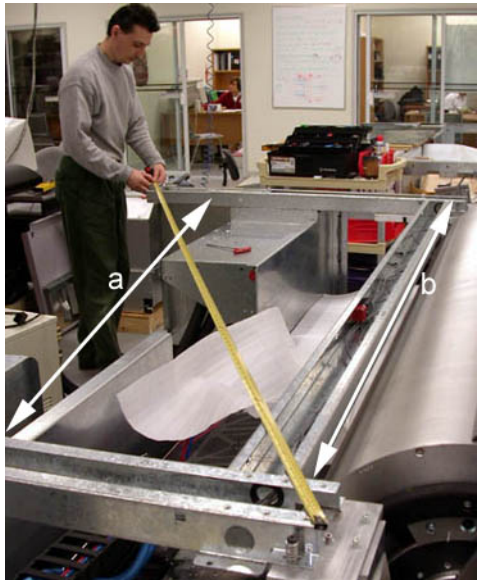
Tighten down the MABs



Tighten the chassis holding screw on each side, as shown in ④.
Tighten the plenum beam screw on each side, as shown above.

7

Check the alignment between the MABs by measuring the diagonals



The two diagonals between the beams should be equal.
Length **a** should be ≤ **b**. Length **a** may be up to 3mm less.
Place the cables for the safety switch and plate sensors inside

8

Install the subpanels on either side of the walk-in access

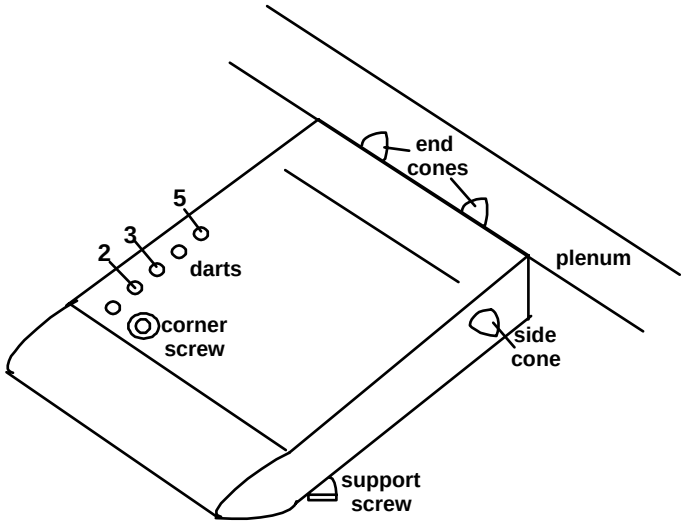


Home side shown. Repeat for the away side.

the plenum beam.

9

On the side table panels, cut darts #2,3 and 5



Home side shown. Repeat for the away side.

10

Adjust the cones on the panel so they will engage fully in the holes on the plenum beam.



A 1-2mm gap is allowed between the cone and the rim of the hole.

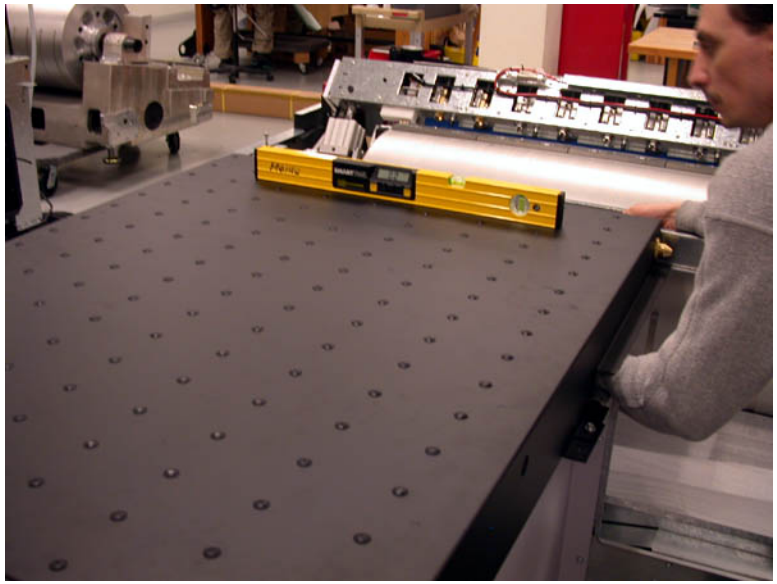
11

Install the left table panel



12

Level the panel at the engine end by adjusting the cones.



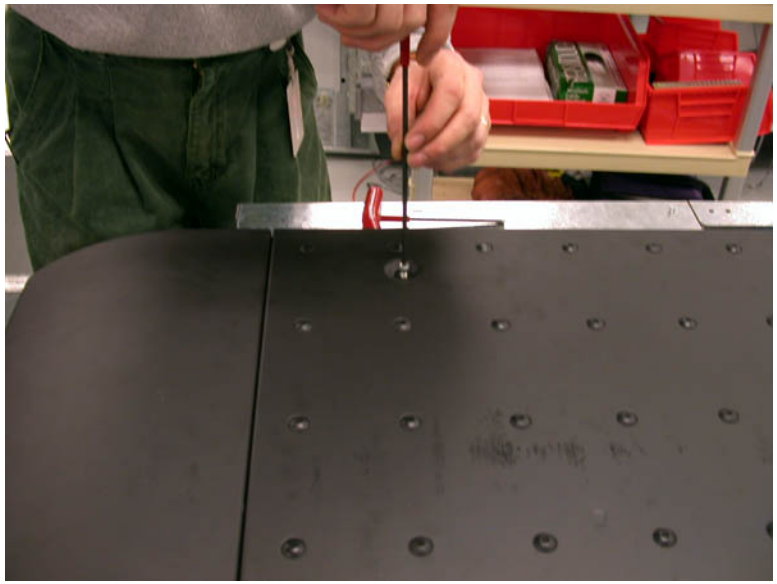
Use a digital level.
Reach under the panel to adjust the cones in the plenum holes.

13 Level the panel at the operator end by adjusting the support screw



Use a digital level.

14 Secure the panel.



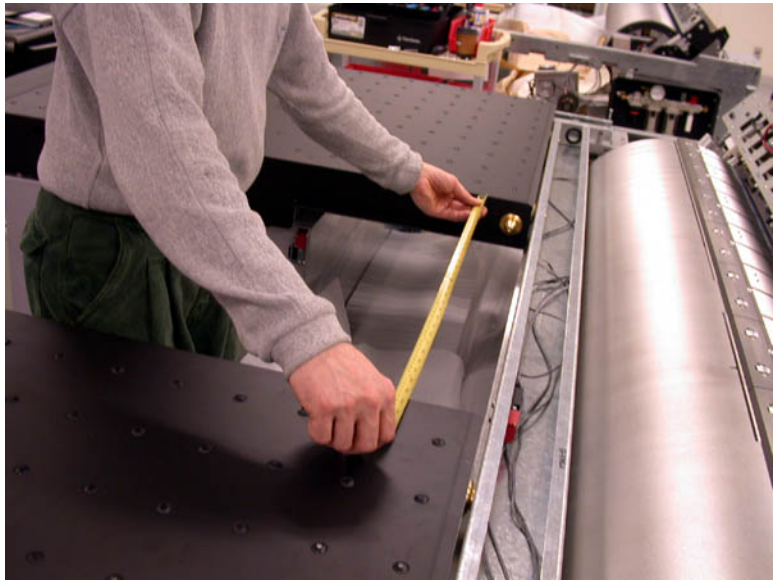
Tighten the panel corner screw.

15 Secure the mounting plate.



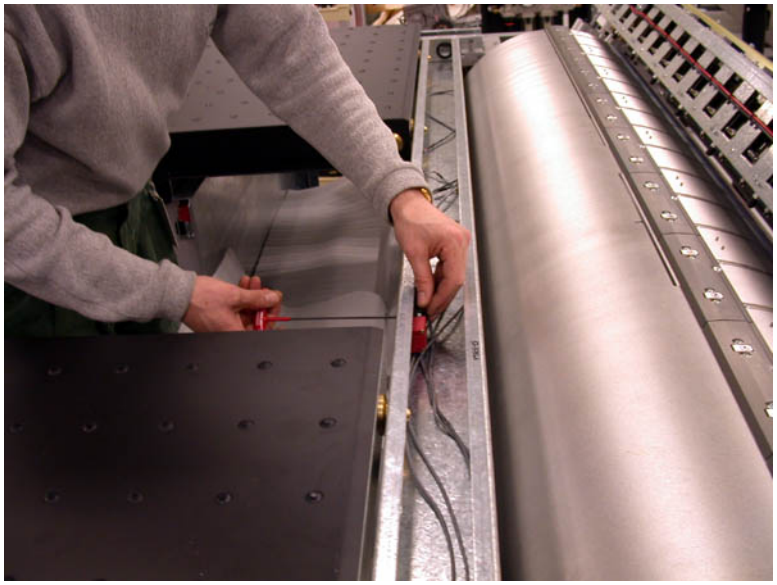
Tighten the M5 screw.

16 Install the right table panel, following Steps 11 to 15, then check the distance between the two panels.



The distance should be 750mm ± 1mm.

17 Install the safety switch and connect the cable to it.



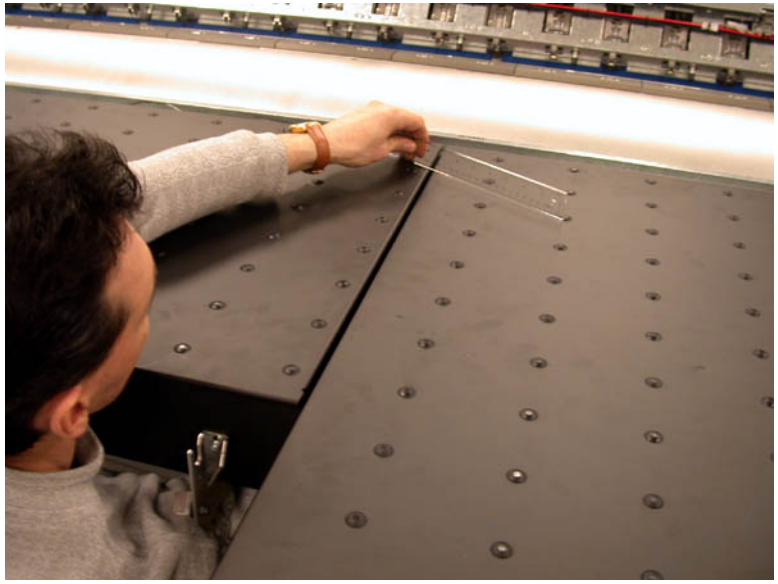
Leave the switch holding screws half tightened.

18 Install the center panel.



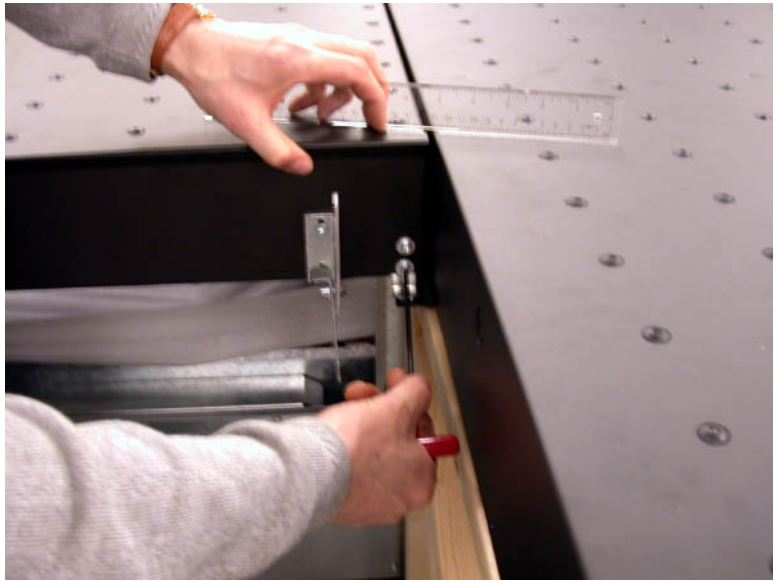
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19 Level the panels at the engine end.



Use a straight edge to check that the panels are aligned.
Adjust using the cone on the side panel
(see photo in Step #9 for location of side cone)
Away side shown. Repeat for the home side.

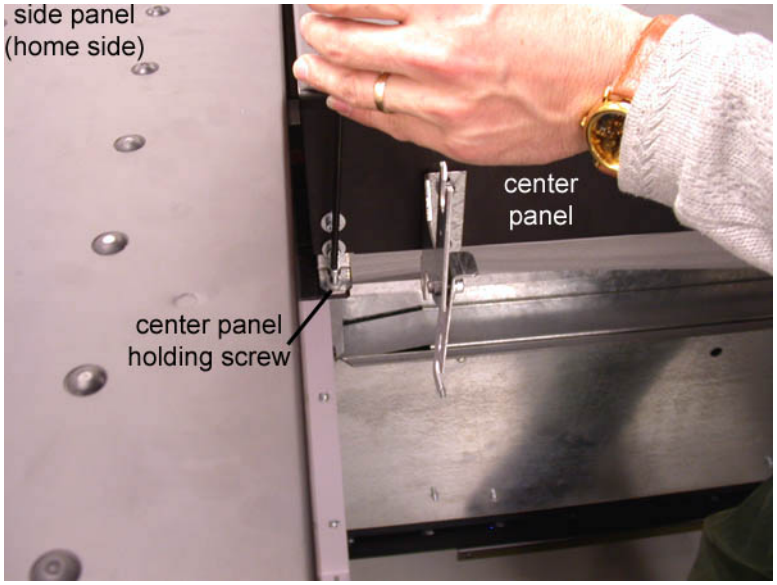
20 Level the panels at the operator end.



Adjust the center panel holding screw.
Away side shown. Repeat for the home side.
Also adjust the position of the safety switch, and then tighten the switch's holding screws.

21

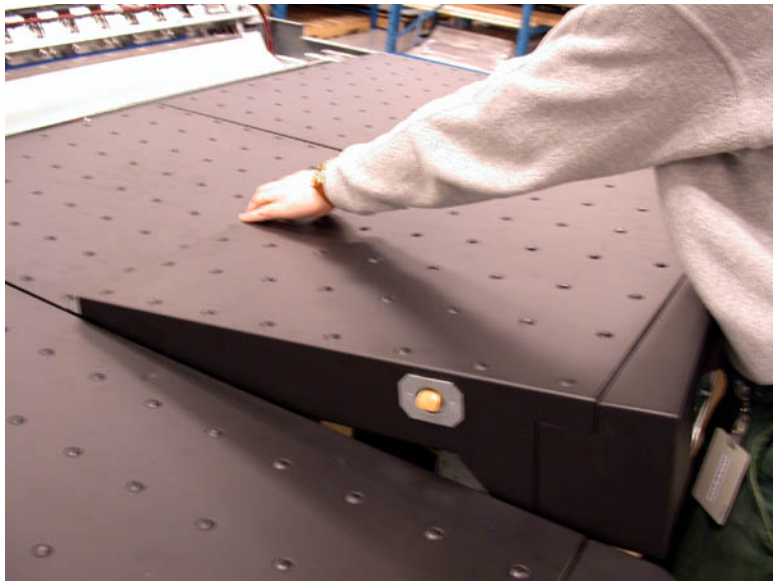
Secure the center panel



Tighten the center panel holding screw.
Home side shown. Repeat for the away side.

22

Install the dropleaf panel
.



23

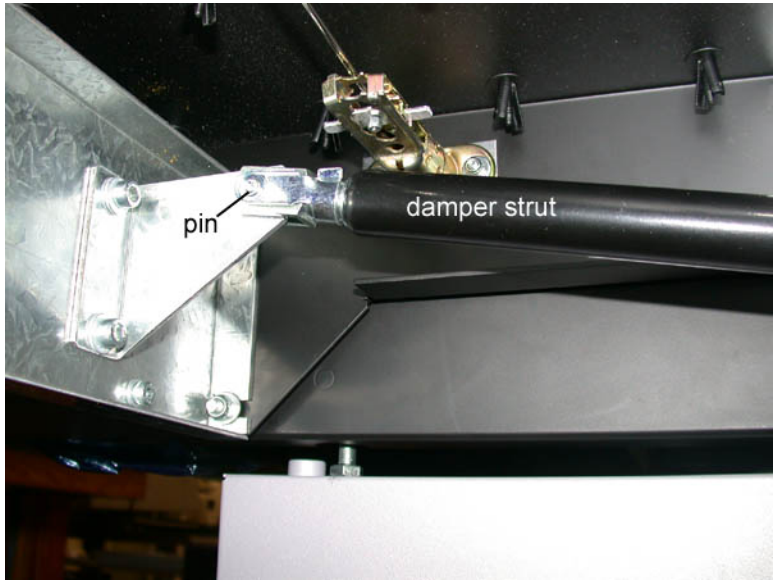
Level the panels by adjusting the hinges on the center panel



Level the dropleaf panel relative to the side panels and center panel, then tighten the screws on the hinge lock plates.
Home side shown. Repeat for the away side.

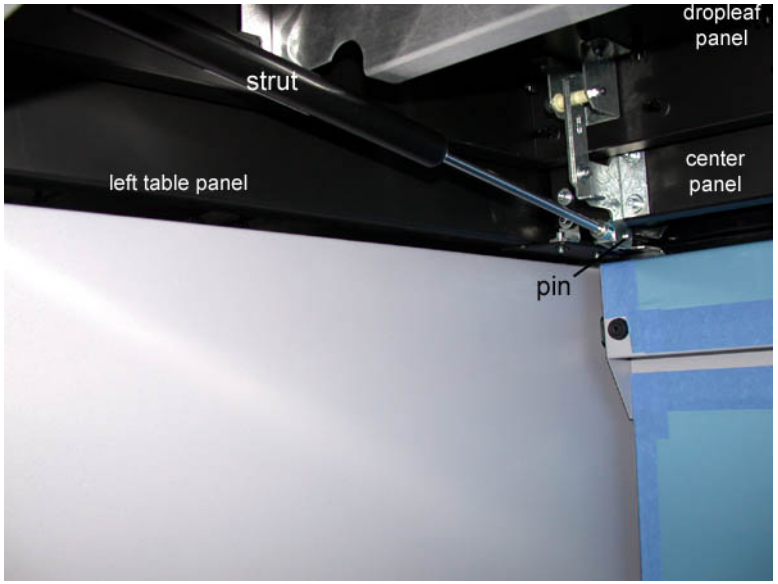
24

Install the damper strut for the dropleaf panel.



(a) Attach the cylinder to the front of the dropleaf panel.

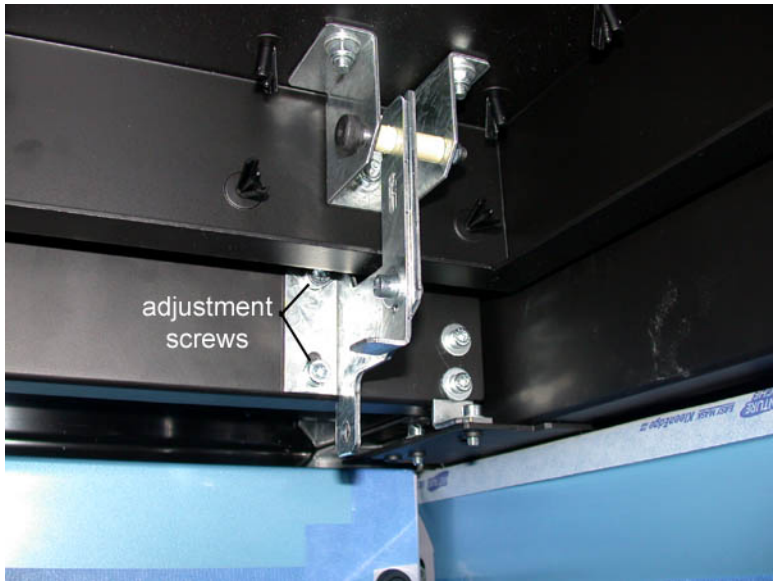
25



(b) Attach the rod end of the cylinder. It must be installed closest to the center panel.

26

Secure the locking mechanism for the dropleaf panel



Lower the locking mechanism before securing the screws.

27

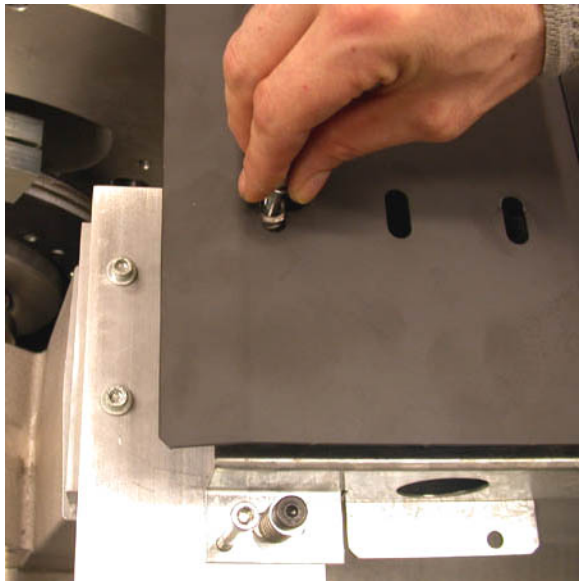
Connect the plate sensors and place the honeycomb panel in position.



Inside the plenum, connect the cables to the plate sensors. Remove the locking screws from the MAB and place the honeycomb panel on top of the plenum.

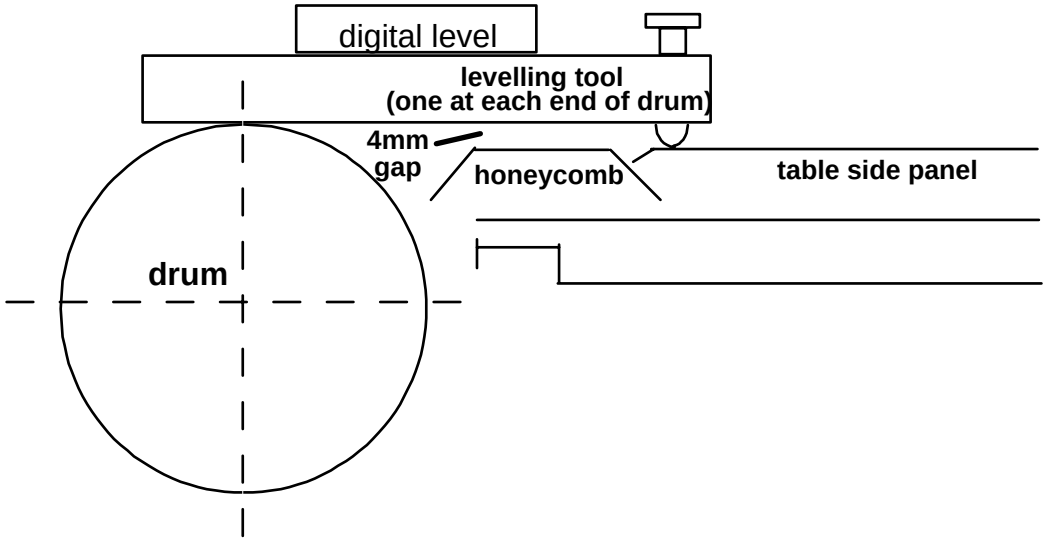
28

Attach the screws to the top of the springs, loosely.



29

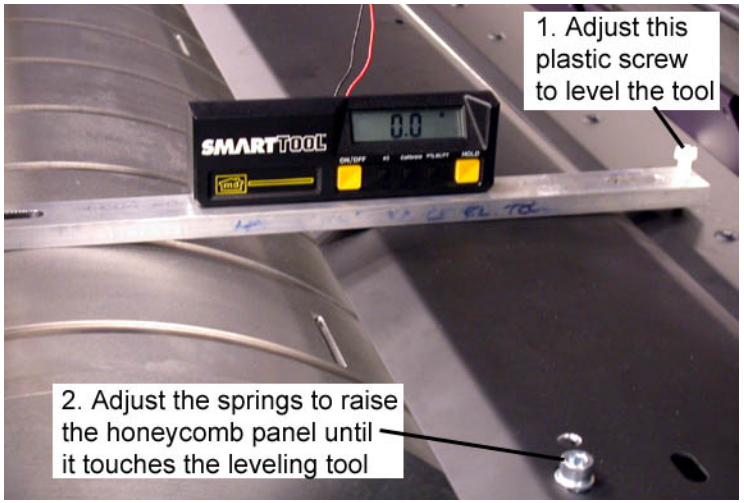
Align the honeycomb panel to the drum, using the leveling tool.



Target level of honeycomb panel, 4mm below the top of the drum.
See photos below for details of aligning the leveling tool, raising the honeycomb panel to touch it, then lowering the panel 4mm.

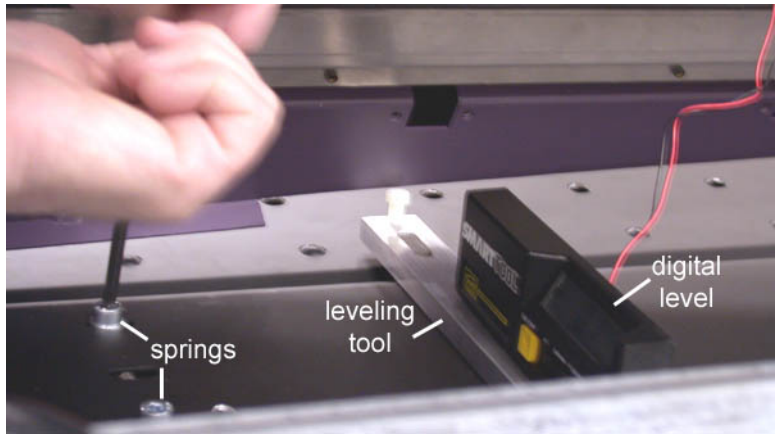
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(a)
Place the leveling tool across one end of the drum and the table.



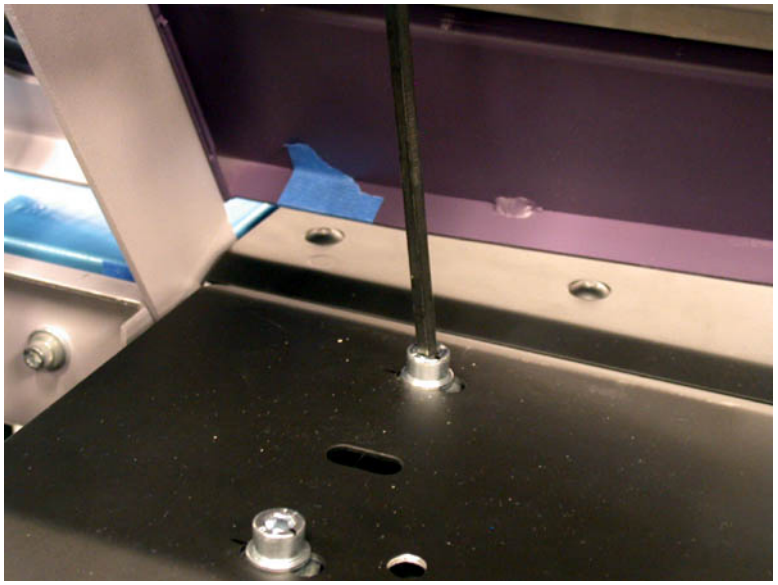
Level the tool, and then raise the honeycomb panel to touch the tool evenly.

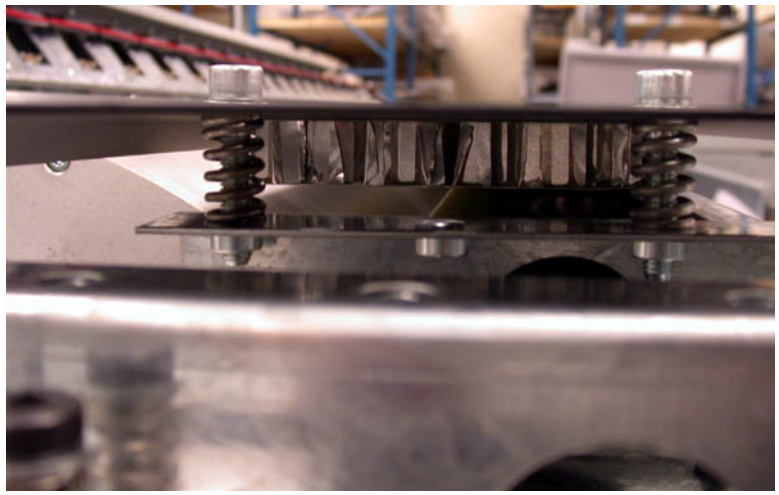
(b)
Move the leveling tool to the other end of the drum and repeat.



Level the tool, and then raise the honeycomb panel to touch the tool evenly.

(c)
Lower the honeycomb panel by 4mm.





Draw a reference line down the spring-loaded screw and washer.
Turn each screw slightly more than 3 turns clockwise (one turn = 1.25mm) to lower the honeycomb panel by 4mm.
Remove the leveling tool.