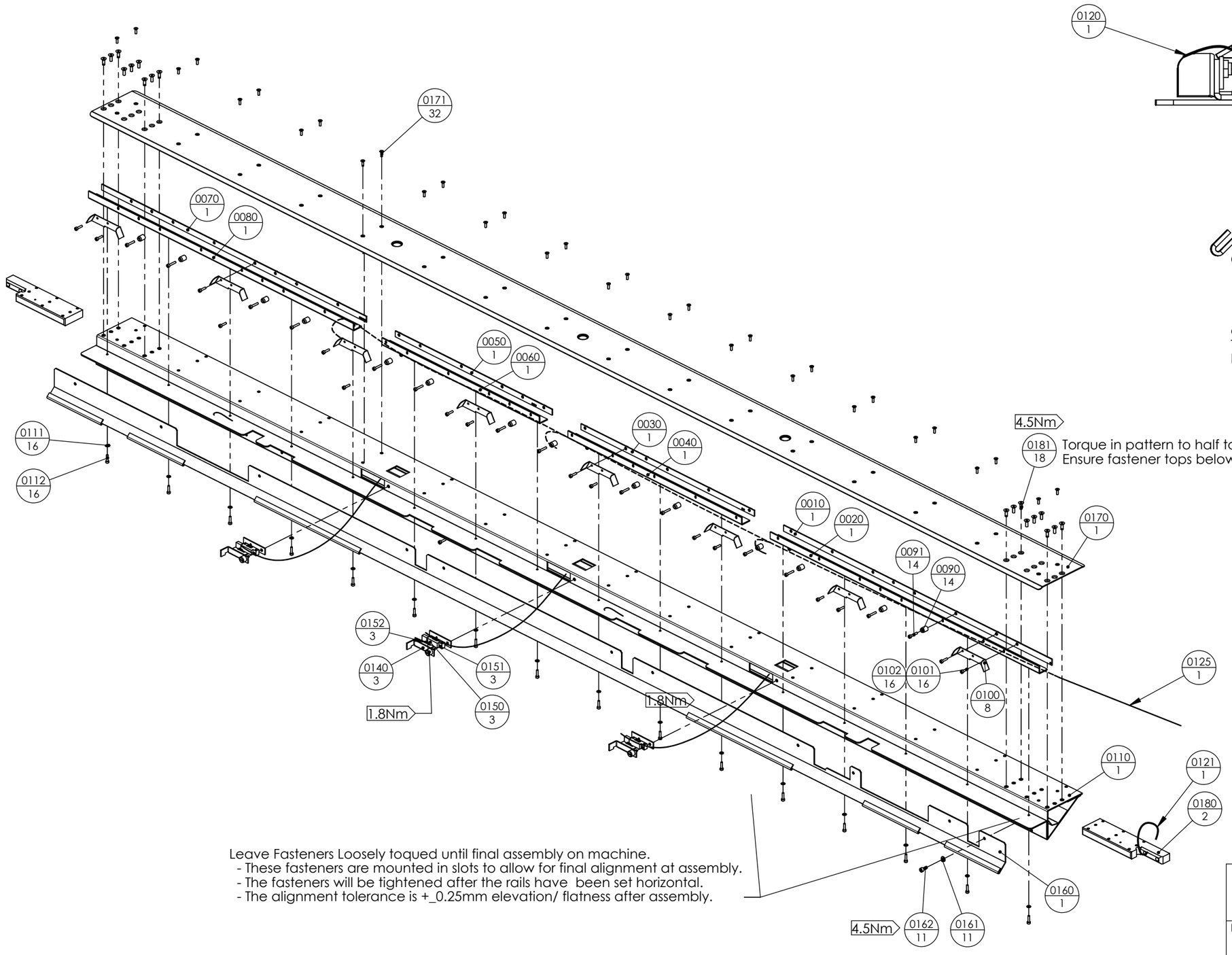
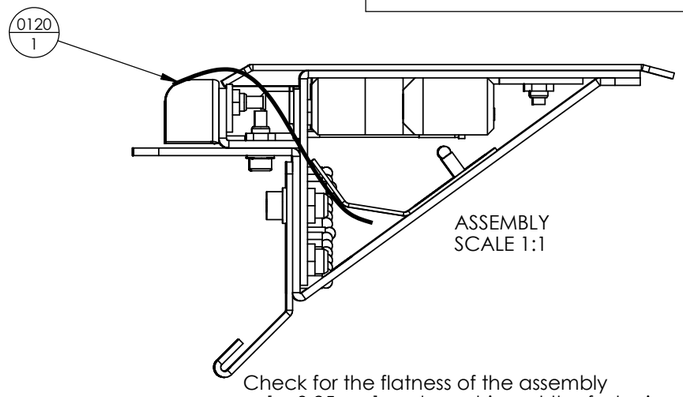
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Check for the flatness of the assembly
[+- 0.25mm] and use shims at the fastening points at screws #0171 to make the assy flat.
[i.e no vertical curve].
Shims not provided but 52-7193 M4 shim washer could be used.
Torque in a random pattern.
Ensure the screws are below the surface.

Torque in pattern to half torque then full torque.
Ensure fastener tops below the surface.

Leave Fasteners Loosely toqued until final assembly on machine.
- These fasteners are mounted in slots to allow for final alignment at assembly.
- The fasteners will be tightened after the rails have been set horizontal.
- The alignment tolerance is +_0.25mm elevation/ flatness after assembly.

F ITEM 0125 ADDED
DWG UPDATED

Torque all fasteners according to their size

creo
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ASSY,FRONT_BEAM,
MALT,MTA

DESIGNED BY	DRAWN BY			
3/5/2004 G.ANDREW	5/13/2004 G.ANDREW			
MILLIMETERS UNLESS SPECIFIED	LAST CHANGED 10/7/2004 dwoodburn	SIZE B	SCALE 1:7	

CATEGORY	PART NUMBER	VER	REV	DOC TYPE	SHEET	OF
500-	00256B-	F		-AD	1	1