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ASSEMBLY WAS ORIGINALLY MIRRORED OR RELATED TO ASSEMBLY 500-00463A

WHEN CHANGING THIS ASSEMBLY, UPDATE MIRRORED OR RELATED ASSEMBLY IF NECESSARY

(THIS DRAWING SHOWS R-TO-L ASSEMBLY 500-00463A) FOR L-TO-R ASSEMBLY 500-00464A:

PARTS THAT MARKED AS [1] HAVE DIFFERENT PART ## (SEE BOM);

PARTS THAT MARKED AS [1] AND [2] WITH ALL PARTS MOUNTED ON THEM HAVE TO BE ASSEMBLED ON THE OPPOSITE SIDE

NOTES:

1. APPLY A 70mm LG PIECE OF UHMW TAPE TO ITEMS #0060 AND #0050 AS SHOWN.
2. SNUG BUT DO NOT CRUSH PART.
3. TO AID IN ASSEMBLY, GLUE ITEM #0052 TO #0050 AND #0062 TO #0060.
4. DO NOT USE LOCTITE ON THIS ASSY UNLESS SPECIFIED.
5. MAKE SURE THE MOVING BACKBONE FALLS DOWN FREELY BY GRAVITY.

PINCH ROLLERS PRELOAD PROCEDURE:

* FIXED BACKBONE ASSY 500-00309A(HAS TO BE ASSEMBLED AS R-TO-L FOR 500-00463A AND AS L-TO-R FOR 500-00464A):

1. WITH ROLLERS OPEN, UNSCREW CENTER BEARING SUPPORT UNTIL ROLLER IS OBVIOUSLY SLACK AND NOT CONSTRAINED BY BEARING.
2. TURN IN SET SCREW UNTIL THE ROLLER CONFORMS TO BEARING.
3. TURN SET SCREW FURTHER IN UNTIL ROLLER TOUCHES THE SHIELD FROM INSIDE.
4. TURN SET SCREW ONE FULL TURN OUT TO CREATE CLEARANCE BETWEEN ROLLER AND SHIELD. ROTATE THE ROLLER TO MAKE SURE IT DOESN'T TOUCH THE SHIELD. TURN THE SET SCREW OUT MORE IF NEEDED.
5. HOLD SET SCREW STATIONARY, TIGHTEN LOCK NUT.

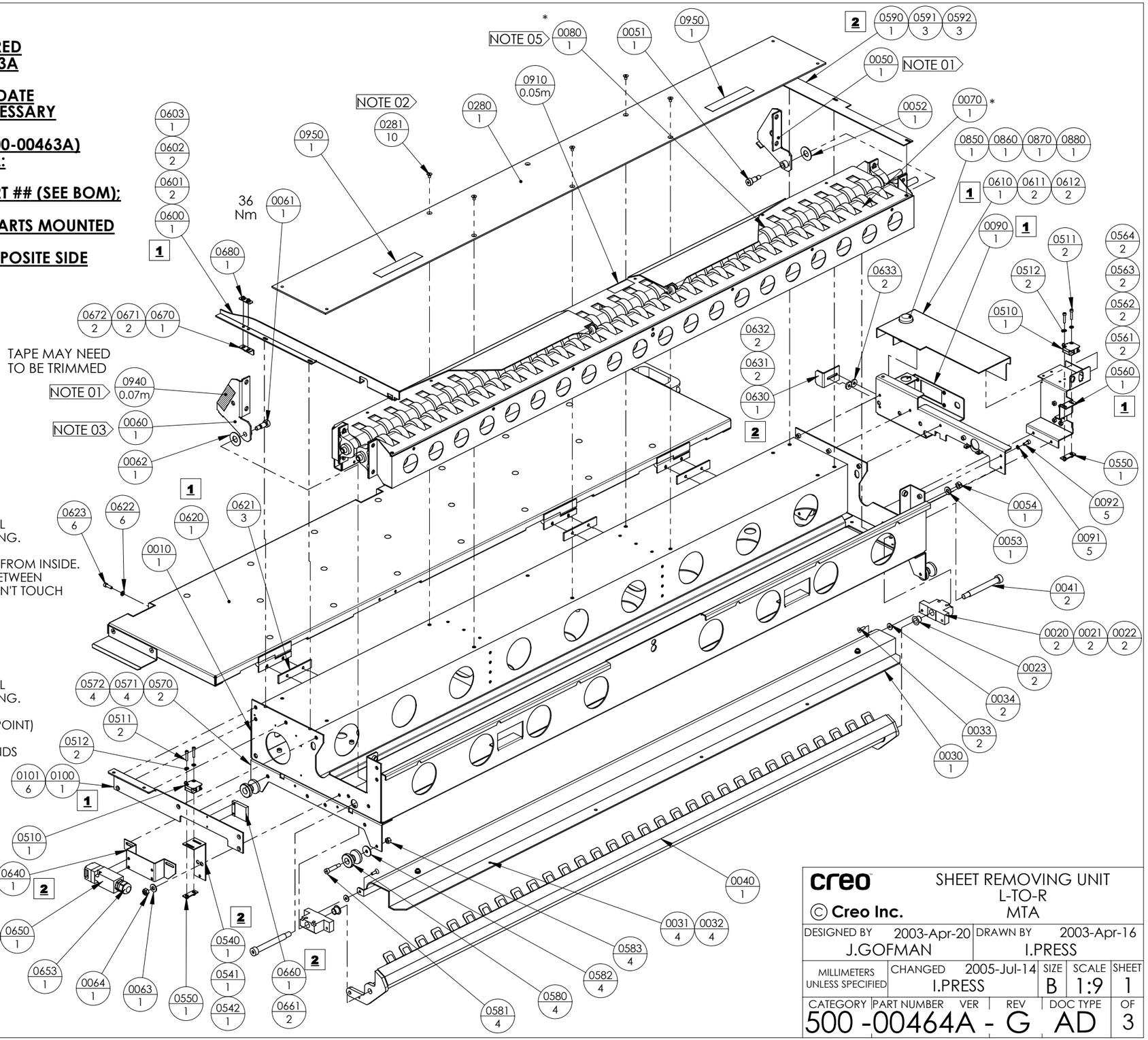
* MOVING BACKBONE ASSY 500-00310A(HAS TO BE ASSEMBLED AS R-TO-L FOR 500-00463A AND AS L-TO-R FOR 500-00464A):

1. WITH ROLLERS OPEN, UNSCREW CENTER BEARING SUPPORT UNTIL ROLLER IS OBVIOUSLY SLACK AND NOT CONSTRAINED BY BEARING.
2. TURN IN SET SCREW UNTIL THE ROLLER CONFORMS TO BEARING.
3. CLOSE MOVING BACKBONE BY HAND (NO AIR POWER AT THIS POINT) SUCH THAT ROLLERS ARE IN CONTACT AND HOLD IT.
4. SCREW IN SET SCREW UNTIL GAPS BETWEEN ROLLERS AT BOTH ENDS ARE 3.5 ±0.5mm WHILE ROLLERS IN A CONTACT IN THE MIDDLE.
5. HOLD SET SCREW STATIONARY, TIGHTEN LOCK NUT.

PRELOAD NOTES:
- THIS PROCEDURE IS DONE AFTER SSR ASSY IS COMPLETE WITH SSR NOT MOUNTED IN MACHINE.

ROLLER TRAVEL / COMPACTOR SWITCH CALIBRATION

1. ACTUATE COMPACTOR/ROLLERS TO END OF TRAVEL
2. LOOSEN SWITCH MOUNT AND SET SWITCH POSITION SUCH THAT IT IS ~0.5mm FROM BOTTOM OUT POSITION.



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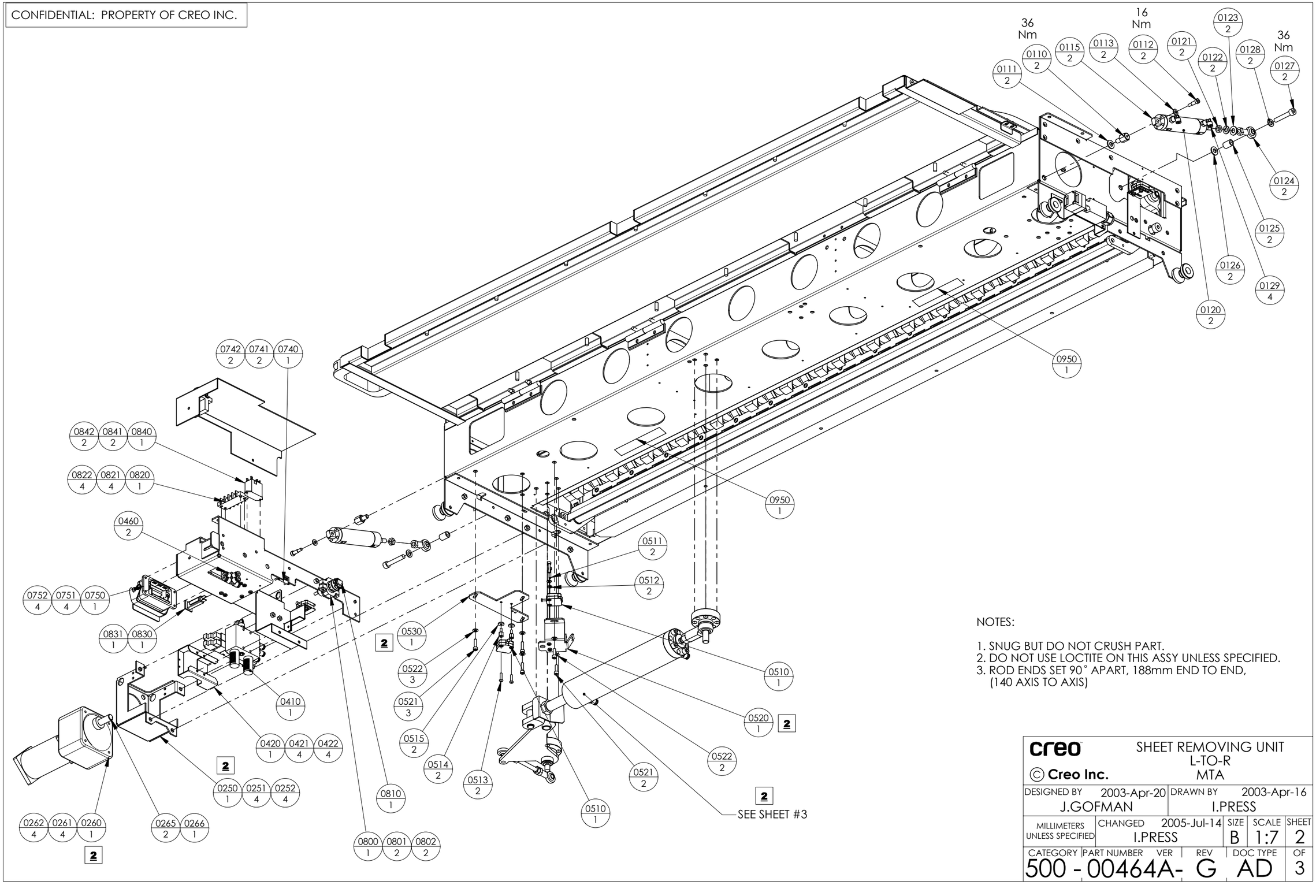
SHEET REMOVING UNIT
L-TO-R
MTA

DESIGNED BY	DRAWN BY
J.GOFMAN 2003-Apr-20	I.PRESS 2003-Apr-16

MILLIMETERS UNLESS SPECIFIED	CHANGED	SIZE	SCALE	SHEET
	I.PRESS 2005-Jul-14	B	1:9	1

CATEGORY	PART NUMBER	VER	REV	DOC TYPE	OF
500	-00464A	-	G	AD	3

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NOTES:

1. SNUG BUT DO NOT CRUSH PART.
2. DO NOT USE LOCTITE ON THIS ASSY UNLESS SPECIFIED.
3. ROD ENDS SET 90° APART, 188mm END TO END, (140 AXIS TO AXIS)

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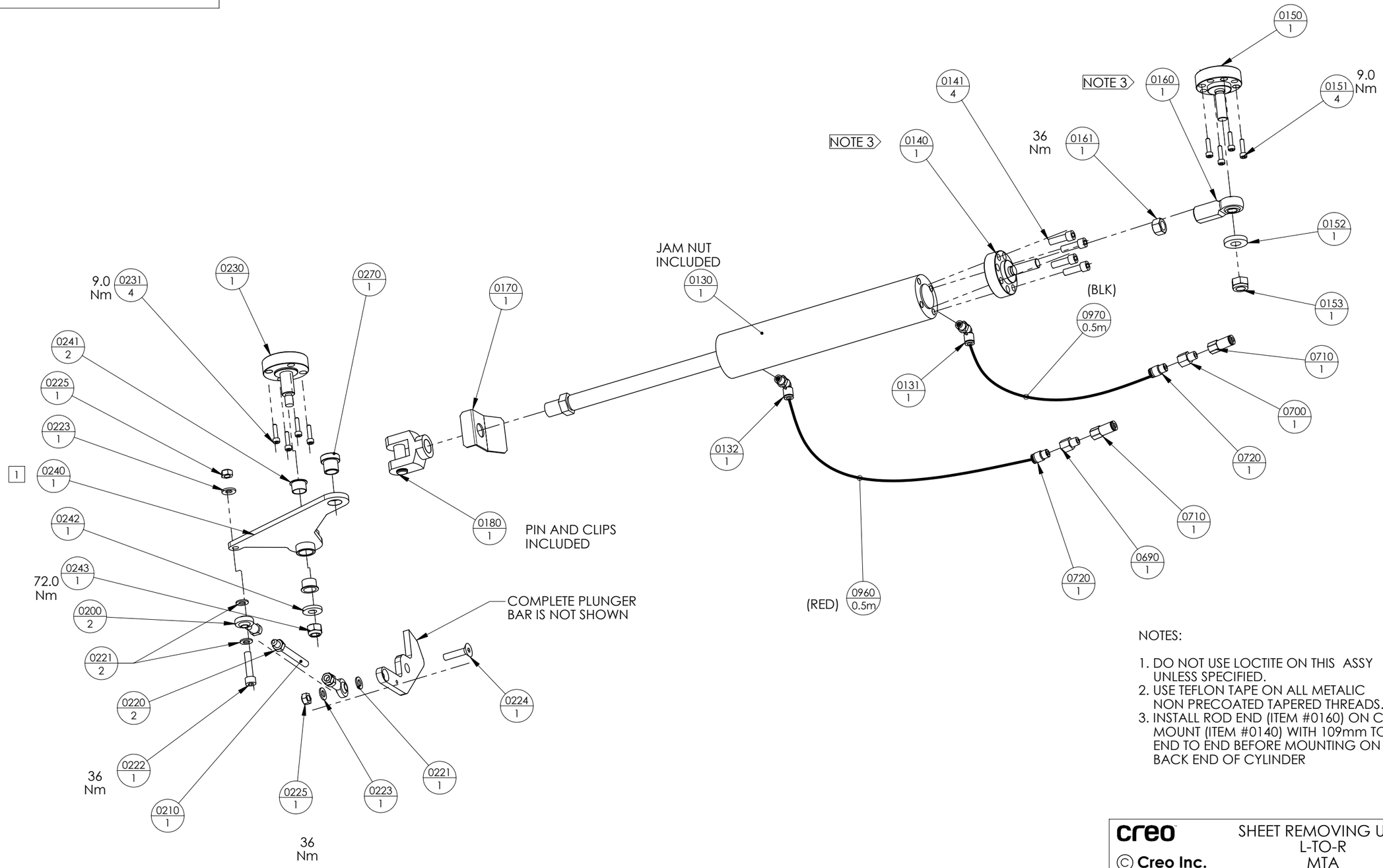
SHEET REMOVING UNIT
L-TO-R
MTA

DESIGNED BY	DRAWN BY
J.GOFMAN 2003-Apr-20	I.PRESS 2003-Apr-16

MILLIMETERS UNLESS SPECIFIED	CHANGED	SIZE	SCALE	SHEET
	I.PRESS 2005-Jul-14	B	1:7	2

CATEGORY	PART NUMBER	VER	REV	DOC TYPE	OF
500	- 00464A -		G	AD	3

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NOTES:

1. DO NOT USE LOCTITE ON THIS ASSY UNLESS SPECIFIED.
2. USE TEFLON TAPE ON ALL METALIC NON PRECOATED TAPERED THREADS.
3. INSTALL ROD END (ITEM #0160) ON CYL MOUNT (ITEM #0140) WITH 109mm TOTAL, END TO END BEFORE MOUNTING ON BACK END OF CYLINDER

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SHEET REMOVING UNIT
L-TO-R
MTA

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MILLIMETERS UNLESS SPECIFIED	CHANGED 2005-Jul-14 I.PRESS	SIZE B	SCALE 1:5	SHEET 3	
CATEGORY	PART NUMBER VER	REV	DOC TYPE	OF	
500 -	00464A- G		AD	3	