Trendsetter VLF

VLF Table Extension Stiffener Installation Procedure

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Revision History

Revision	Date	Author	Comments
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VLF Table Stiffener Bracket Installation

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1. SCOPE

This document describes the step-by-step procedure for installing the Stiffener Brackets to VLF tables.

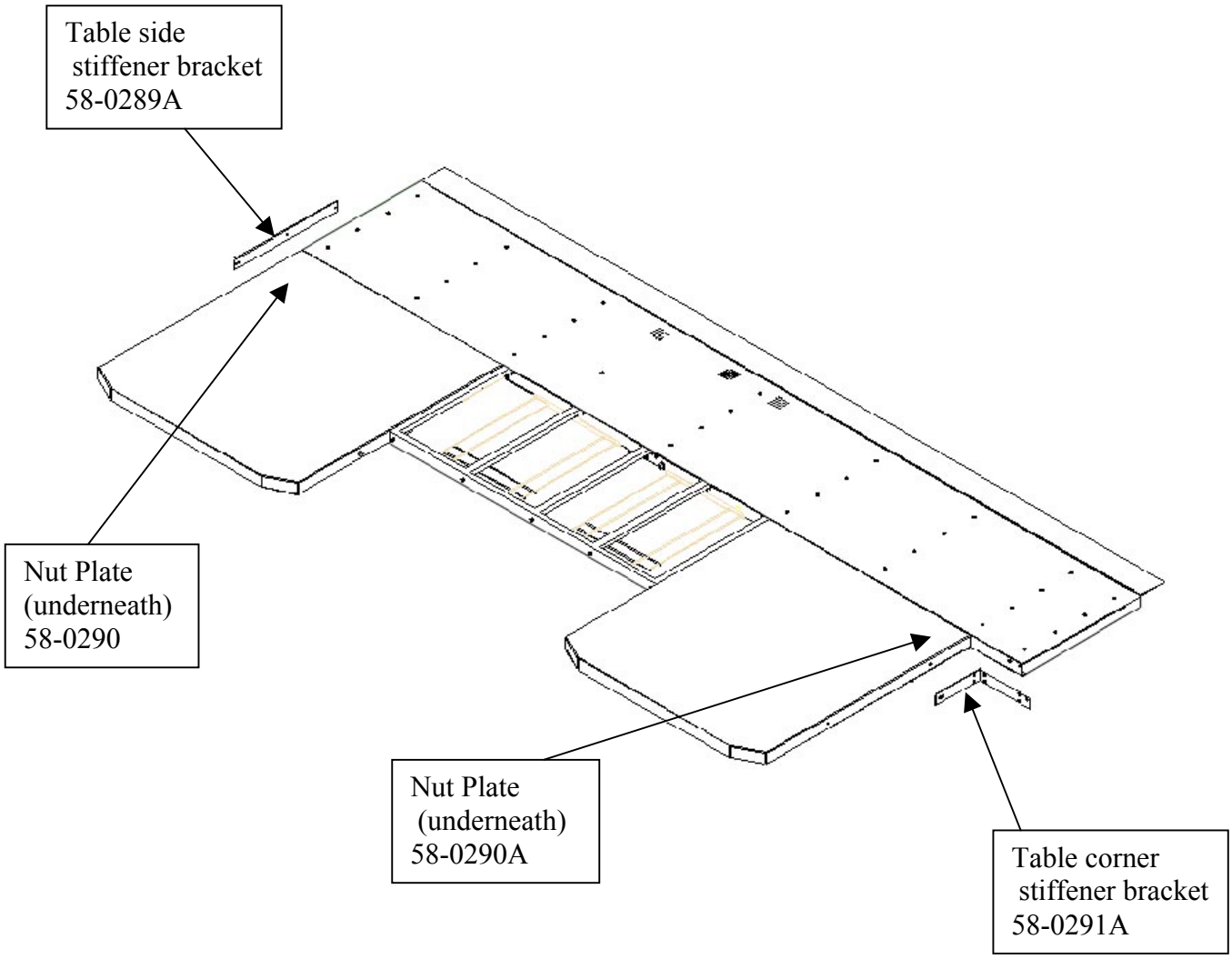


Figure 1. VLF Table showing stiffener locations

2. SAFETY PRACTICES

- Be sure to cover any areas of the machine where metal chips may enter due to drilling
- Use safety goggles whenever drilling holes.

3. TOOLS REQUIRED

- Table stiffener bracket Kit (PN 05-2047)
- Set of metric Allen keys
- Electric hand drill
- Drill bits: 4.8mm (or 3/16 dia.), 4.2mm
- M5 tap and small tap handle
- Rivet gun

4. FIELD UPGRADE PROCEDURE

4.1 Installing the Table corner stiffener bracket (58-0291A)

1. Remove the existing screws from the area to which the bracket will attach and install the corner stiffener bracket to the three existing pem holes using m4 flat head fasteners, 52-4284 (see figure 2)

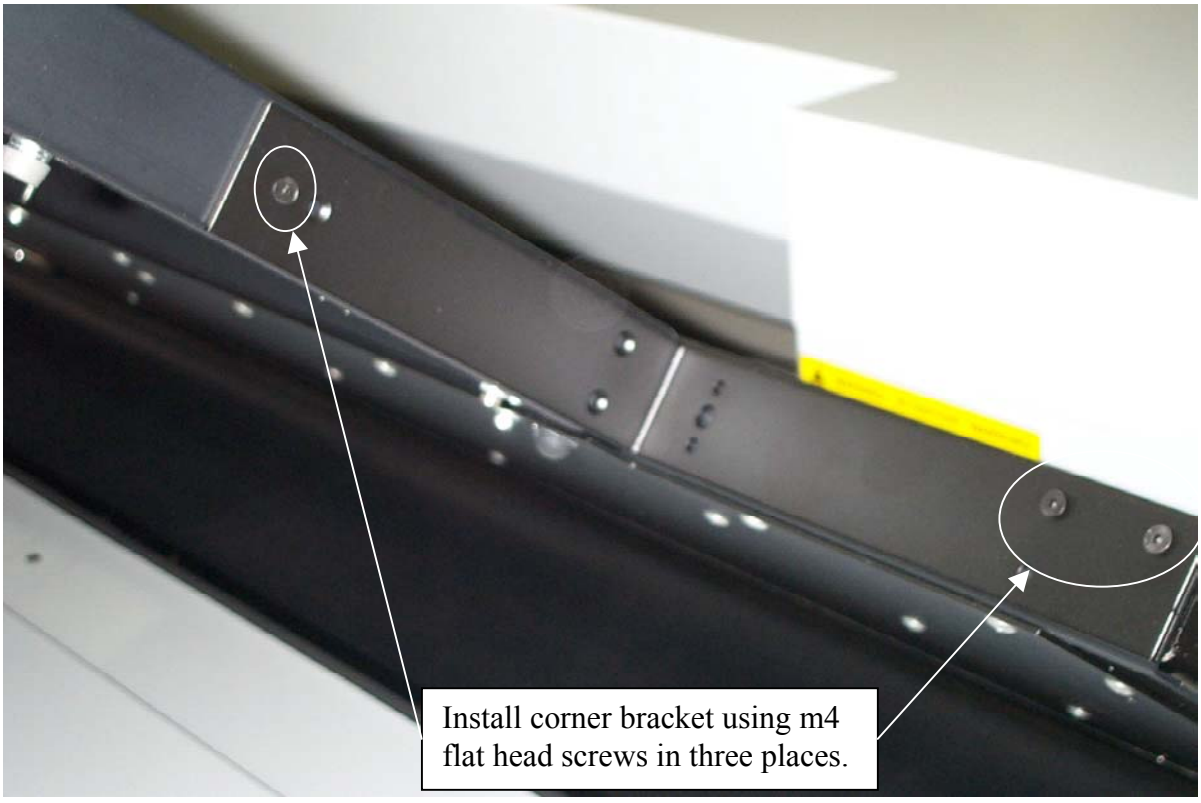


Figure 2. Install corner bracket using existing screws locations

2. Drill the remaining holes using a hand drill and a 4.8mm (or 3/16) diameter drill bit. Ensure that the machine is properly masked in order to keep any metal cuttings from entering inside. Note that one of the hole locations already has a pem nut inserted in the bracket inside the table extension. Drill through only until the pem nut is exposed in this location. If this hole is drilled to deep and the pem nut falls out, a regular nut can be used in its place.

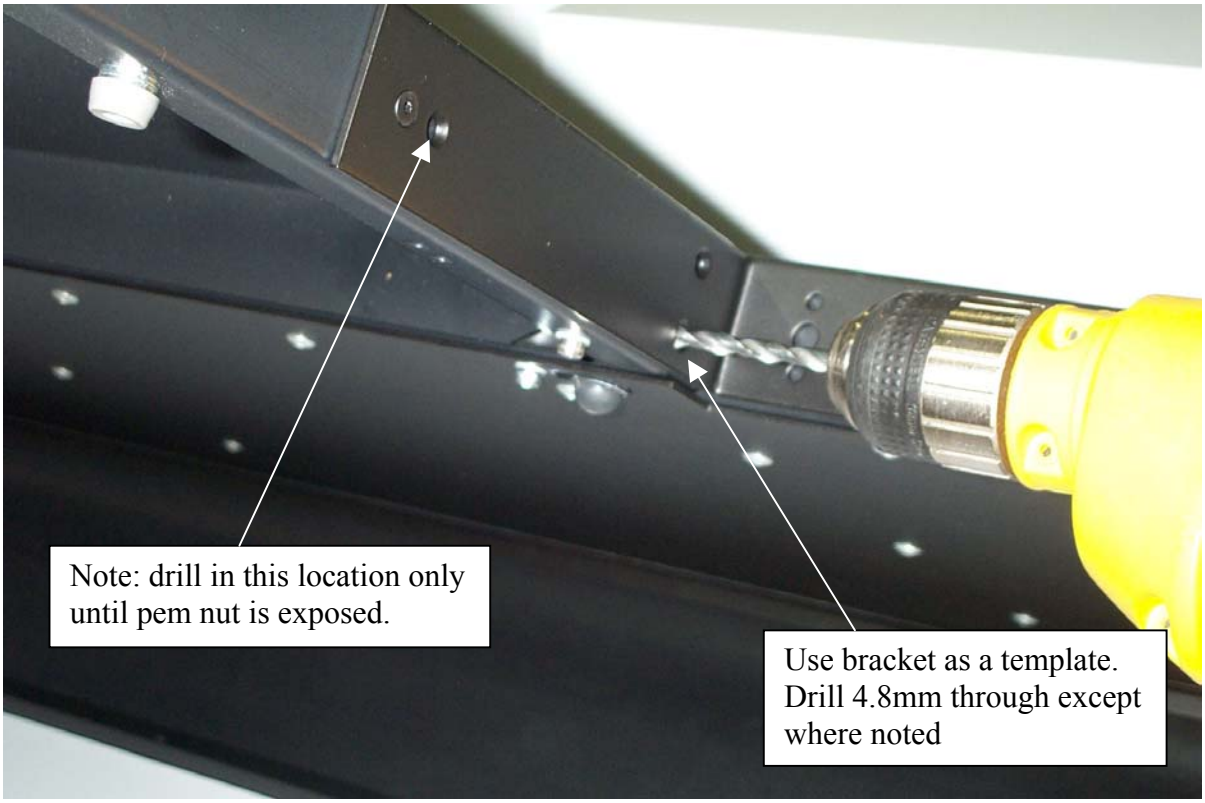


Figure 3. Use the corner stiffener bracket as a jig to drill the remaining holes

3. Secure the corner bracket using 3/16 Flat head rivets (52-4624) in 2 places, and m4 flat head screws (52-4284) in the remaining 3 holes. Use the nut plate (58-0290) behind the two screw in the table extension.

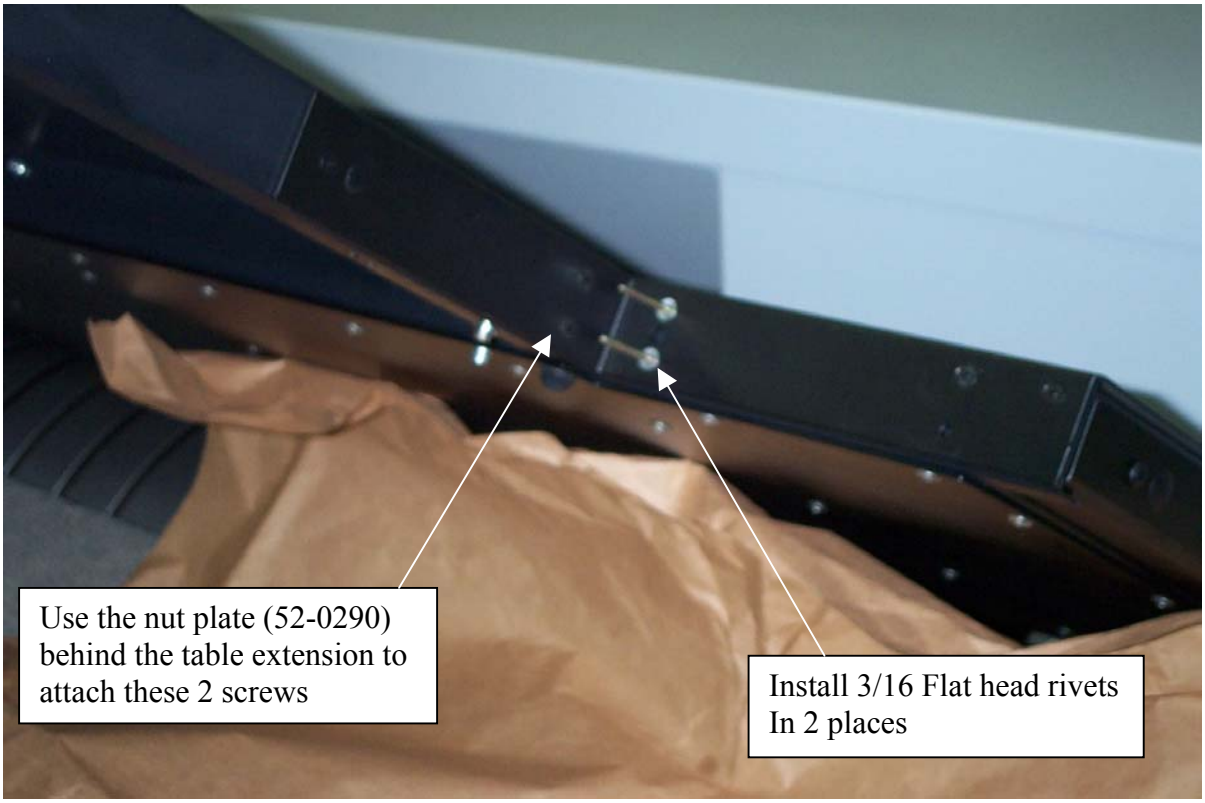


Figure 4. Install rivets and flat head screws

4.2 Installing the Table side stiffener bracket (58-0289A)

1. Install the side bracket using the existing hole in the table extension (see figure 5.)
2. On some machines, the square tubes at the side of the table may already have m5 screws installed. If not, use the side bracket as a template and drill (4.2mm) and tap m5 in two places. If the m5 button head screws were originally in place, they can be re-used in these locations. The hole plugs should be removed and discarded.
3. One of the hole locations already has a pem nut behind it (see figure 5.) Drill this hole using a 4.8mm diameter drill only until the pem nut is exposed.
4. Drill 4.8mm diameter through in 2-places and attach a nut plate inside the table extension using m4 flathead screws

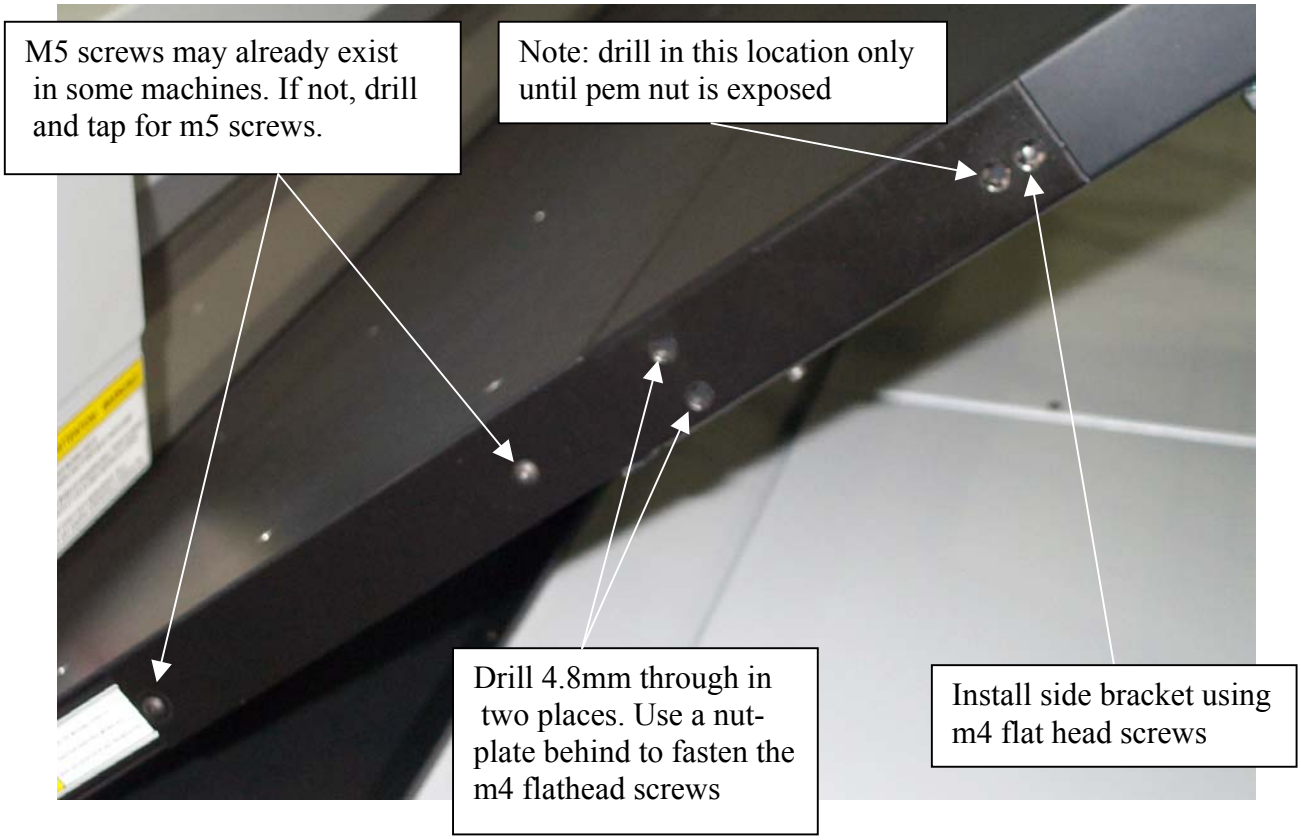


Figure 5. Side Stiffener Bracket

5. BOM FOR STIFFENER KIT (05-2047)

Item	Part No.	Part Description	Quantity
0010	77-0247A	DOC,PROC,TABLE STIFFENER INSTALL,VLF	1.000
0020	58-0289A	BRKT,TABLE STIFFENER SIDE,VLF	1.000
0030	58-0290A	FAB,TABLE STIFFENER NUT PLATE,VLF	2.000
0040	58-0291A	BRKT,TABLE STIFFENER CORNER,VLF	1.000
0050	52-4284	SCRW,M4*12,SOCK-FLT,S-BLK	10.000
0060	52-4624	RIVET,3/16"*.125-.331 CSK,STEEL UNIBOLT	2.000
0070	52-4573	SCRW,M5*12,SOCK-BUT,S-BLK	2.000