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NOTES:

1. APPLY A 70mm LG PIECE OF UHMW TAPE TO ITEMS 0160 AND 0170 AS SHOWN.
2. SNUG BUT DO NOT CRUSH PART.
3. TO AID IN ASSEMBLY, GLUE ITEM 0150 TO 0160.
4. DO NOT USE LOCTITE ON THIS ASSY UNLESS SPECIFIED.

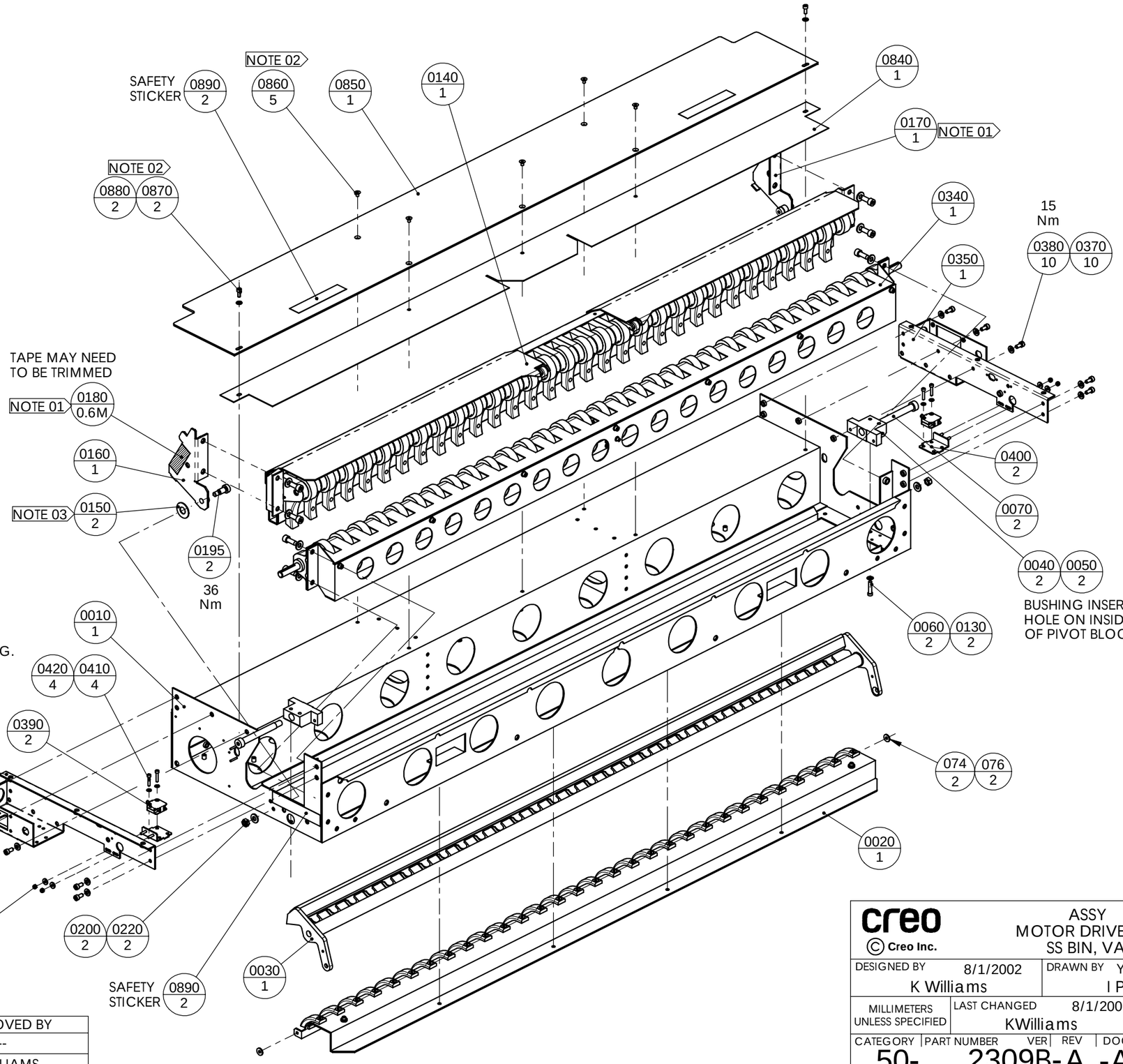
MOTOR DRIVE UNIT ASSY PROCEDURE

1. INSTALL PIVOT BLOCKS, LOWER CAVITY WALL, AND PLUNGER BAR (WITHOUT DRIVE CYLINDER, BELL CRANK, ETC.)
2. INSTALL FIXED BACKBONE WITHOUT DRIVE MOTOR, LEAVE FIXED ROLLER PRELOAD SLACK.
3. INSTALL FLOATING BACKBONE WITH BATWING AND DRIVE CYLINDERS
4. INSTALL END CONNECTOR BRACKETS WITH FITTINGS, RELAYS, SENSORS, ETC
5. LOOSELY FIT ROLLER CLOSED SAFETY SWITCHES
6. INSTALL ROLLER DRIVE MOTOR
7. INSTALL BAG RAIL HANGERS, COMPACTOR DRIVE CYLINDER, AND BAG RAILS
8. INSTALL PNEUMATICS / ELECTRONICS
9. TEST PNEUMATIC SYSTEM (ROLLERS OPEN/CLOSED, COMPACTOR ON/OFF)
10. CALIBRATE COMPACTOR END OF STROKE SENSORS
11. CALIBRATE ROLLER CLOSES SENSORS.
12. SET PRELOAD ON FIXED ROLLER
13. INSTALL SAFETY STICKERS, COVERS, AND ARBORITE WITH SAFETY STICKERS

PRELOAD PROCEDURE: (FIXED BACKBONE ASSY 50-2475A)

(DONE AFTER SSR ASSY IS COMPLETE)

1. PLUG SSR INTO MACHINE AND TURN ON ROLLERS.
2. UNSCREW CENTER BEARING SUPPORT UNTIL ROLLER IS OBVIOUSLY SLACK AND NOT CONSTRAINED BY BEARING.
3. TURN IN SET SCREW UNTIL THE ROLLER CONFORMS TO BEARING.
4. TURN SET SCREW FURTHER IN BY 1.25 TO 1.5 TURNS.
5. HOLD SET SCREW STATIONARY, TIGHTEN LOCK NUT.
6. PRELOAD SHOULD BE CORRECT.



REV	ECO	DATE	DRAWING CHANGES BY	APPROVED BY
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A	E450	8/2/2002	K WILLIAMS	K WILLIAMS

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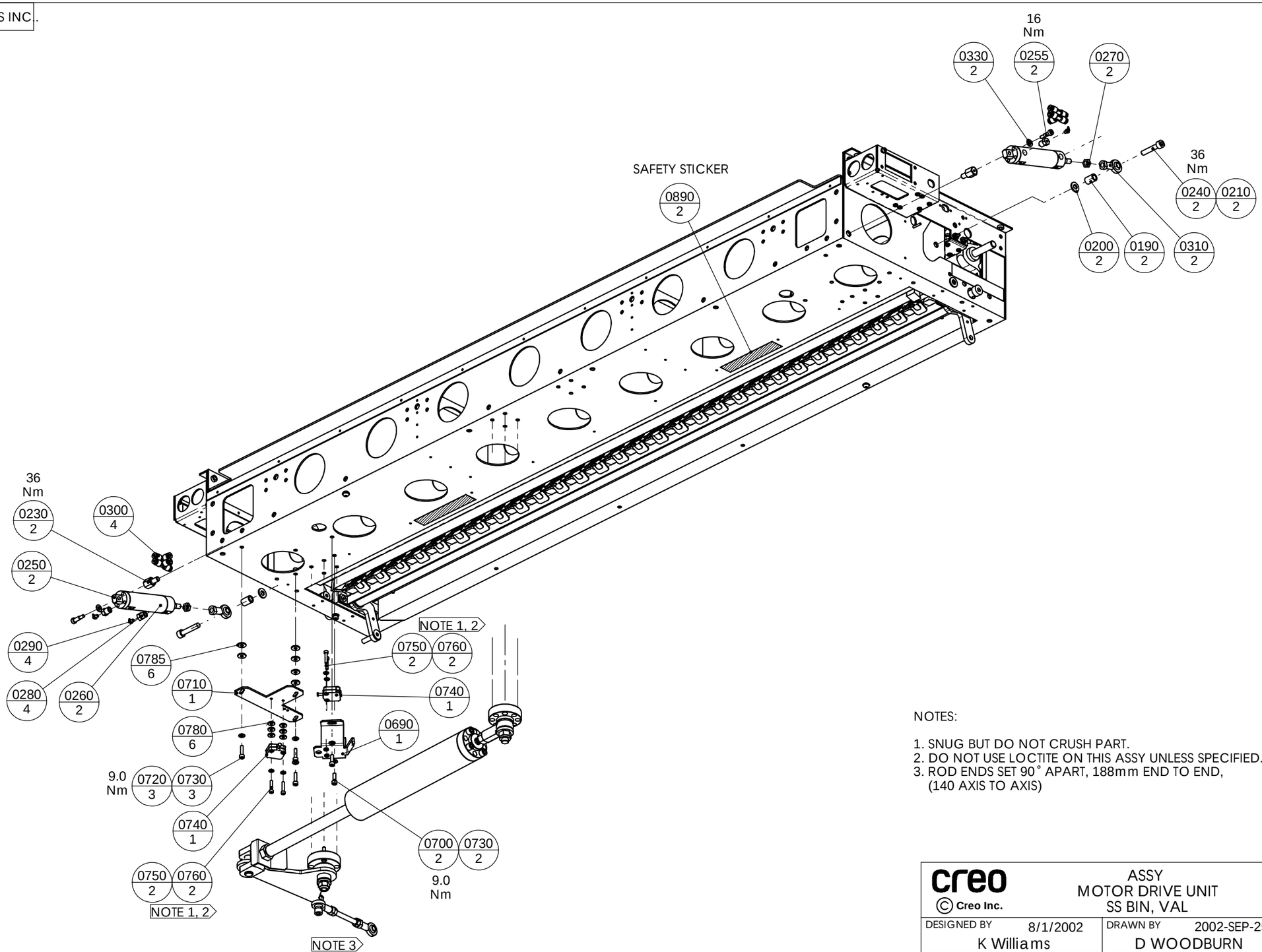
ASSY
MOTOR DRIVE UNIT
SS BIN, VAL

DESIGNED BY	DRAWN BY
8/1/2002 K Williams	YYYY-MMM-DD I PRESS

MILLIMETERS UNLESS SPECIFIED	LAST CHANGED	SIZE	SCALE
	8/1/2002 KWilliams	B	1:8

CATEGORY	PART NUMBER	VER	REV	DOC TYPE	SHEET	OF
50-	2309B	-	A	-AD	1	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)

REV	ECO	DATE	DRAWING CHANGES BY	APPROVED BY
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A	E450	8/2/2002	K WILLIAMS	K WILLIAMS

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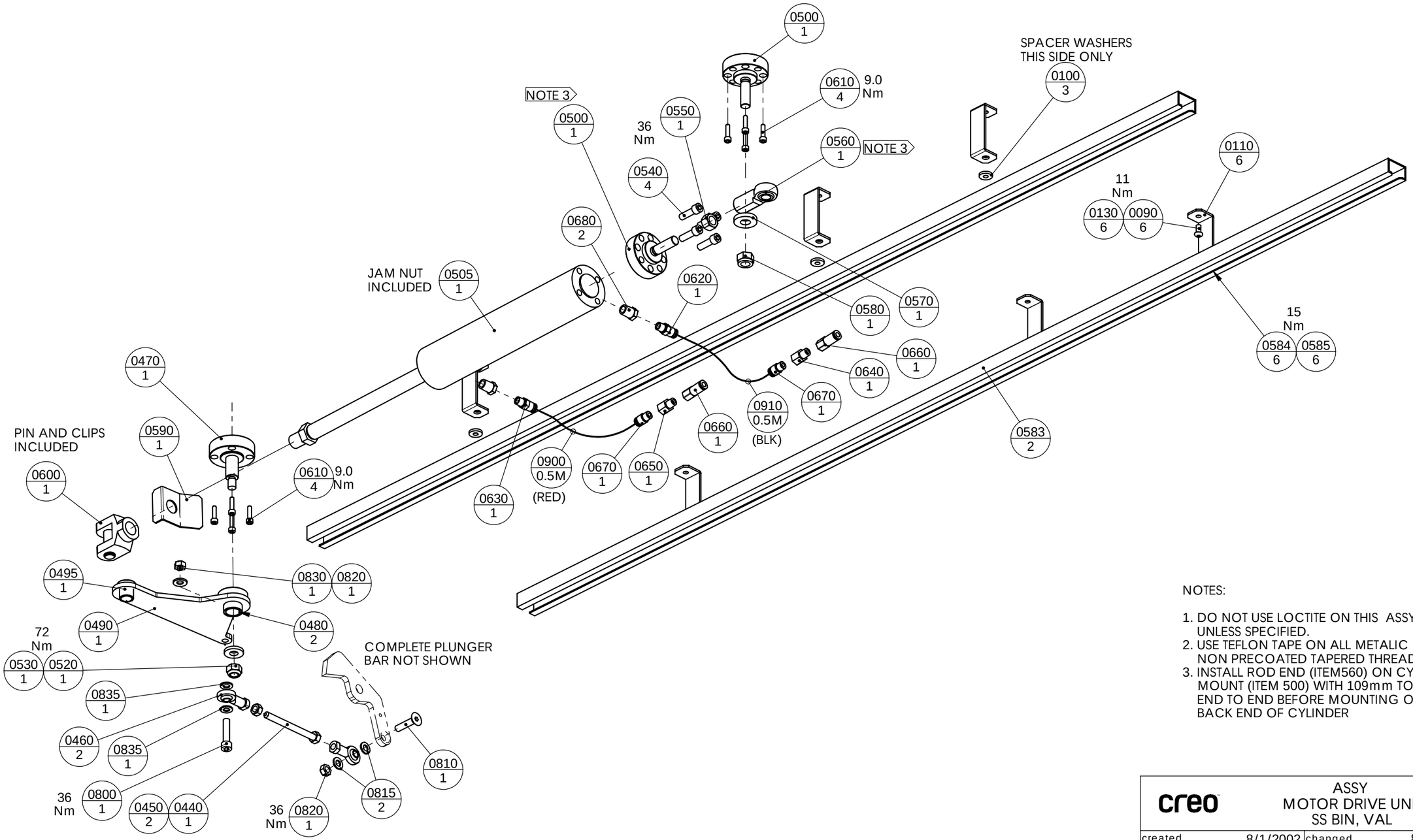
ASSY
MOTOR DRIVE UNIT
SS BIN, VAL

DESIGNED BY	DRAWN BY
8/1/2002 K Williams	2002-SEP-25 D WOODBURN

MILLIMETERS UNLESS SPECIFIED	LAST CHANGED	SIZE	SCALE
	8/1/2002 KWilliams	B	1:7

CATEGORY	PART NUMBER	VER	REV	DOC TYPE	SHEET	OF
50-	2309B-A		-AD	2		3

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REV	ECO	DATE	DRAWING CHANGES BY	APPROVED BY
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A	E450	8/2/2002	K WILLIAMS	K WILLIAMS

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 (ITEM560) ON CYL MOUNT (ITEM 500) WITH 109mm TOTAL, END TO END BEFORE MOUNTING ON BACK END OF CYLINDER

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ASSY
MOTOR DRIVE UNIT
SS BIN, VAL

created	changed
8/1/2002 K Williams	8/1/2002 KWilliams

MILLIMETERS UNLESS SPECIFIED	© Creo Inc.	size	scale	pages
		B	1:5	3

category	part number	version	revision	doc type	sheet
50 -	2309B - A - AD				-3

DWG BY: D WOODBURN