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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 (ITEM 40), LOWER CAVITY WALL, AND PLUNGER BAR (ITEM 20, 30) WITHOUT DRIVE CYLINDER, BELL CRANK, ETC.)
2. INSTALL FIXED BACKBONE (ITEM 340) WITHOUT DRIVE MOTOR.
3. INSTALL FLOATING BACKBONE (ITEM140) AND DRIVE CYLINDERS
4. INSTALL END CONNECTOR BRACKETS (ITEM 350,360) WITH FITTINGS, RELAYS, SENSORS, ETC
5. LOOSELY FIT ROLLER CLOSED SAFETY SWITCHES
6. INSTALL BAG RAIL HANGERS, COMPACTOR DRIVE CYLINDER, AND BAG RAILS
7. INSTALL PNEUMATICS / ELECTRONICS
8. TEST PNEUMATIC SYSTEM (ROLLERS OPEN/CLOSED, COMPACTOR ON/OFF)
9. CALIBRATE COMPACTOR END OF STROKE SENSORS
10. CALIBRATE ROLLER CLOSED SENSORS.
11. SET ROLLER PRELOAD
12. INSTALL SAFETY STICKERS, COVERS, AND ARBORITE WITH SAFETY STICKERS

ROLLER PRELOAD PROCEDURE:

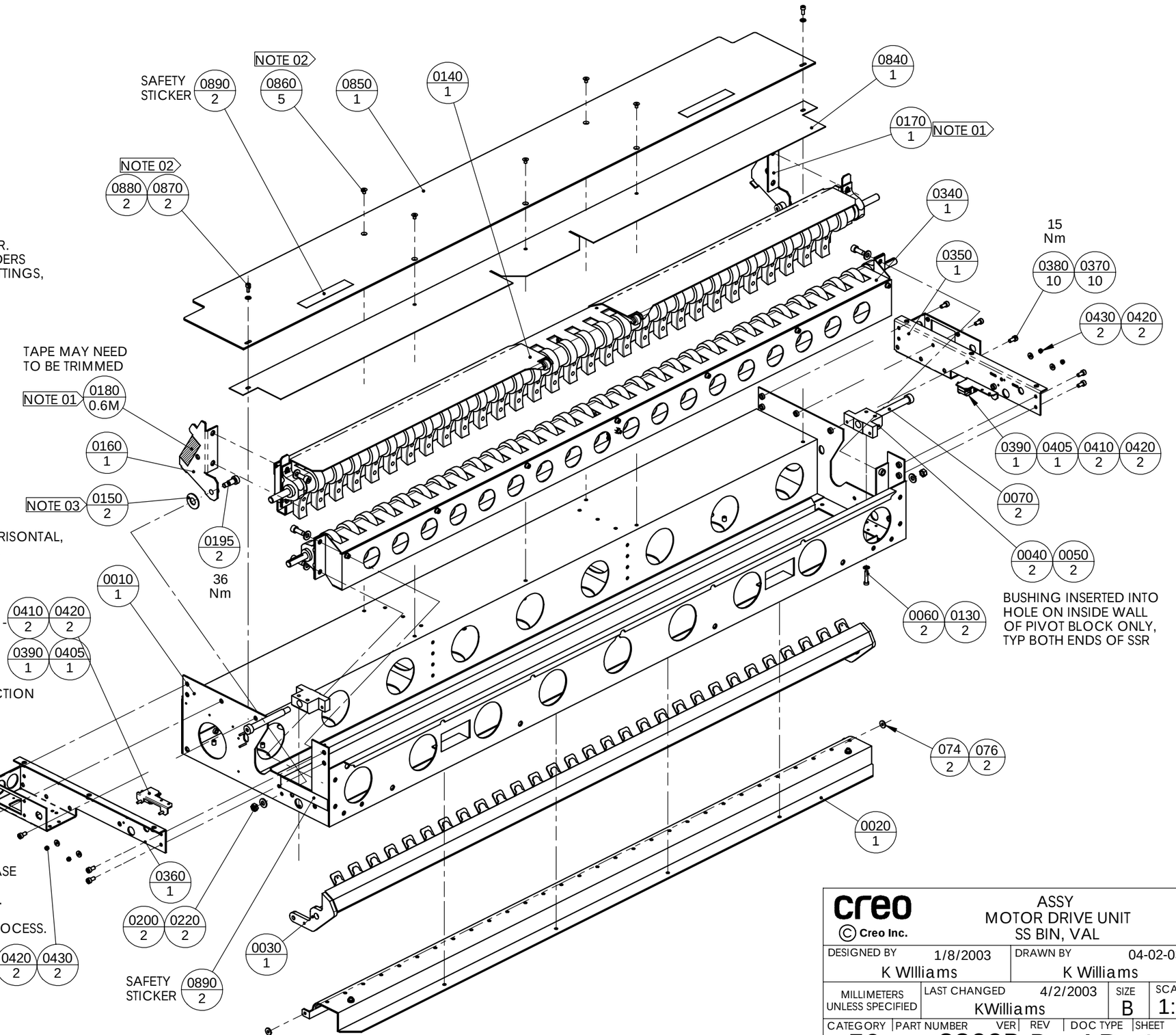
NOTE: - ENSURE SSR MOUNTING RAILS ARE PARALELL AND HORISONTAL, NON-PARALLEL RAILS CAN CAUSE UNEVEN ROLLER PRELOAD.

1. ADJUST EACH PRELOAD SCREW SUCH THAT THEY ARE IN CONTACT BUT APPLYING NO PRELOAD TO THE ROLLERS.
2. CLOSE THE ROLLERS (BY HAND, NO AIR) AND TURN IN EACH PRELOAD SCREW (EQUALLY) UNTIL A GAP OF ~1.5 - 2.0MM EXISTS AT EACH END.
3. REMOVE THE 'BATWINGS' FROM THE MOVING BACKBONE.
4. PLUG SSR CABLE INTO MACHINE AND CLOSE THE ROLLERS.
5. TURN ON THE ROLLERS. (BE CAREFUL!!!)
6. USING A ~2" WIDE PIECE OF WHITE PAPER, CHECK THE TRACTION ACROSS THE ROLLER. FEED THE STRIP INTO A PAIR OF WHEELS AND RESISTING THE TRACTION FORCE IN AN ATTEMPT TO STALL THE ROLLERS, REPEAT A FEW TIMES ALONG THE ROLLER LENGTH.
7. ADJUST PRELOAD AS NECESSARY.
6. PRELOAD SHOULD BE CORRECT, TIGHTEN THE LOCKNUTS.

PRELOAD ADJUSTMENT NOTES:

- IF THE TRACTION IS HIGHER IN THE CANTER, SLIGHTLY DECREASE THE PRELOAD ON EACH BACKBONE. INCREASE IF THE PRELOAD IF THE TRACTION IS LOWER IN THE CENTER SECTION.
- IN TRACTION IS UNEVEN FROM END TO END, THE MOVING BACKBONE MAY BE TWISTED FROM THE MANUFACTURING PROCESS. REFER TO TECH SUPPORT WEB SITE.

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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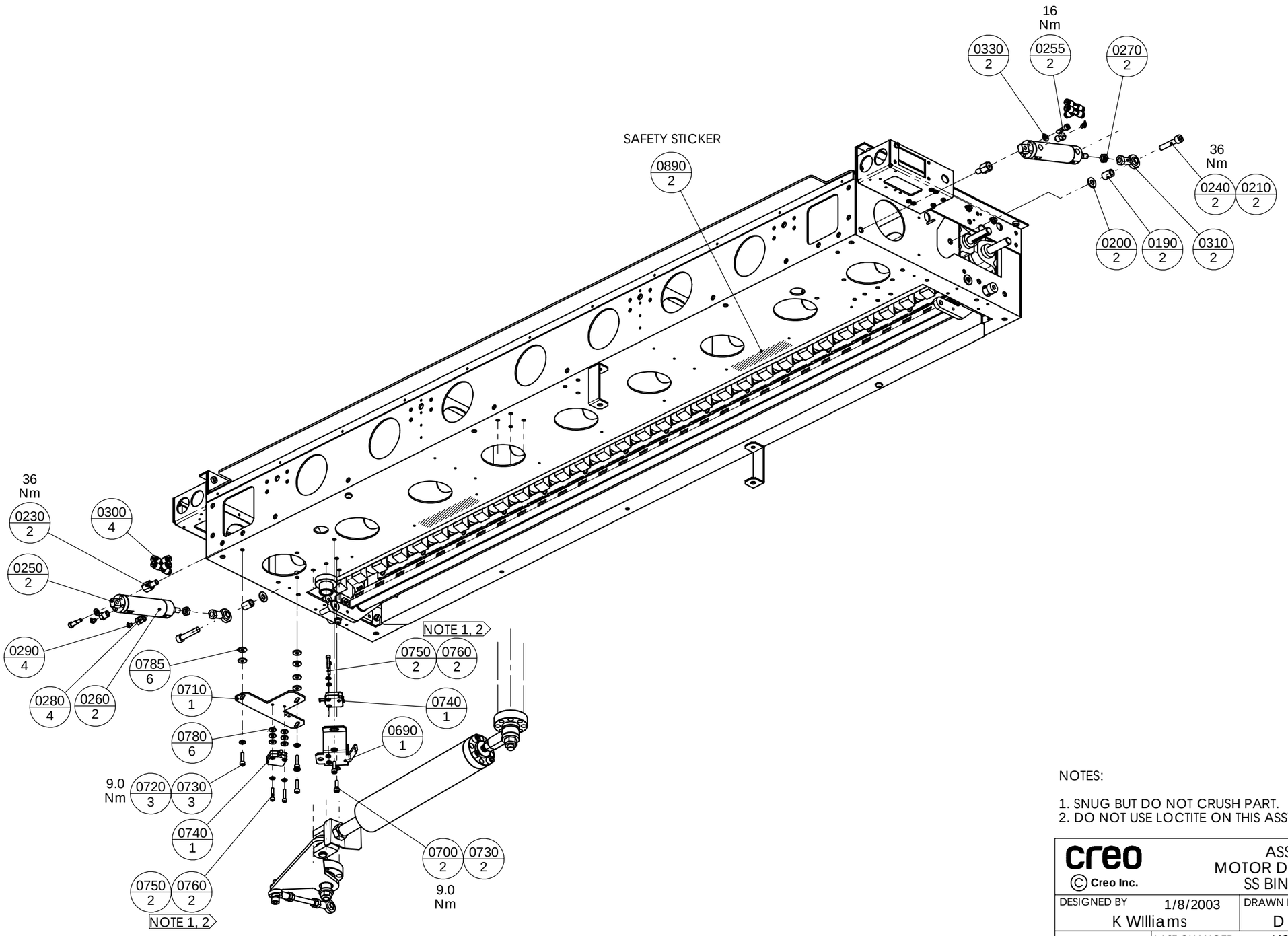
ASSY
MOTOR DRIVE UNIT
SS BIN, VAL

DESIGNED BY	DRAWN BY
1/8/2003 K WIlliams	04-02-03 K Williams

MILLIMETERS UNLESS SPECIFIED	LAST CHANGED	SIZE	SCALE
	4/2/2003 KWilliams	B	1:8

CATEGORY	PART NUMBER	VER	REV	DOC TYPE	SHEET	OF
50-	2309B-B			-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.

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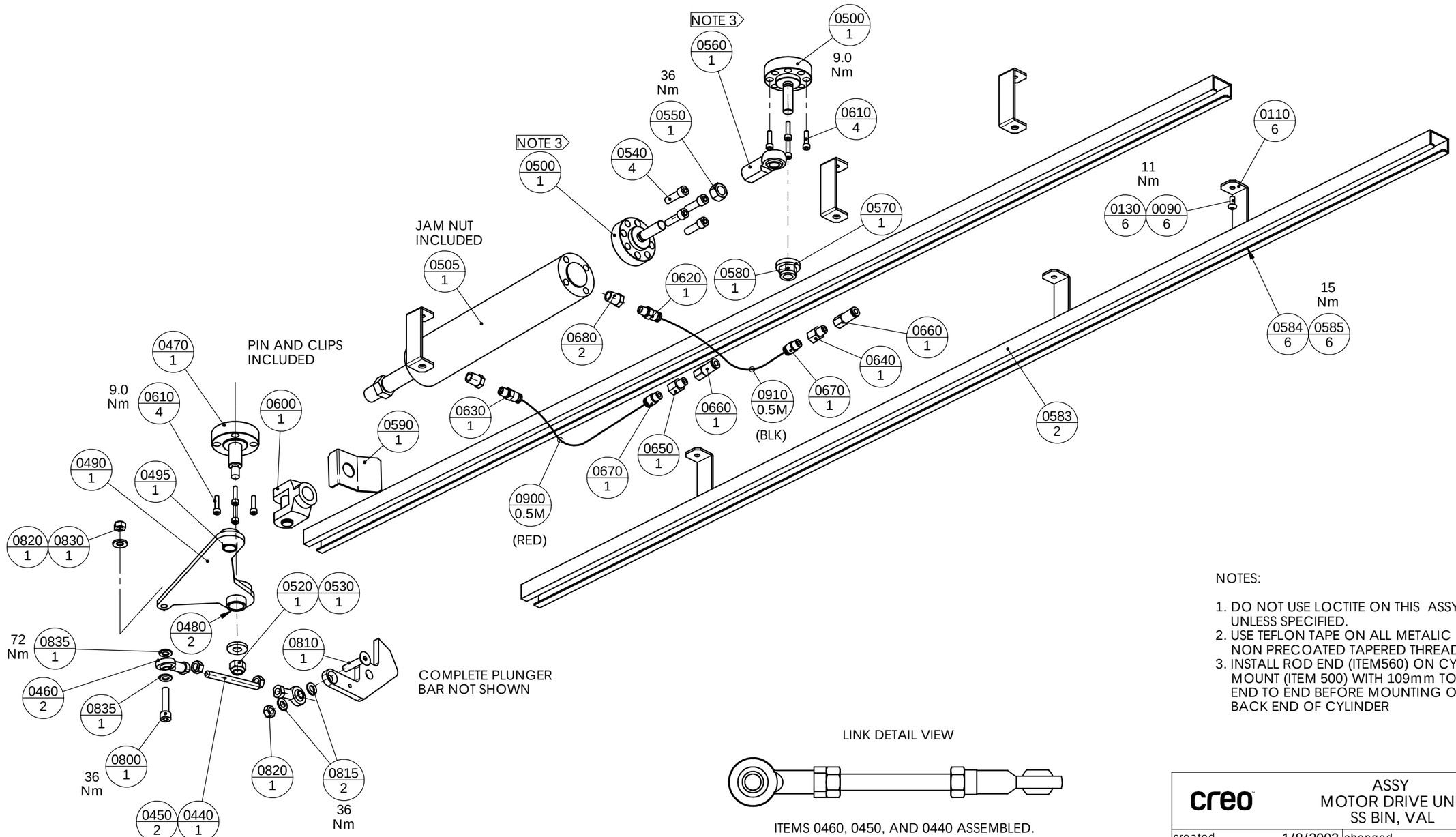
ASSY
MOTOR DRIVE UNIT
SS BIN, VAL

DESIGNED BY	DRAWN BY
1/8/2003 K Williams	2002-SEP-25 D WOODBURN

MILLIMETERS UNLESS SPECIFIED	LAST CHANGED	SIZE	SCALE
	4/2/2003 KWilliams	B	1:7

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

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COMPLETE PLUNGER BAR NOT SHOWN

LINK DETAIL VIEW

ITEMS 0460, 0450, AND 0440 ASSEMBLED.
TIP TO TIP LENGTH IS 164 mm WITH BALL LINKS OFFSET BY 90°

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	1/8/2003	changed	4/2/2003
K WIlliams		KWilliams	

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

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

DWG BY: D WOODBURN