

Final Assembly

PCB Magazine 707, (718 Special)

| Step | Description | Notes |
|------|---|--|
| 1. | Attach the <i>fixed rack wall</i> (2) to the <i>ground plate</i> (1) using two torx screws M5 x 20 from below, (bolting torque 7 Nm). | <i>Fixed rack wall</i> (2) : Positioning stripes No. 1 is down, No. 50 is up |
| 2. | Attach the two <i>aluminum profiles</i> (5) to the <i>ground plate</i> (1) using two torx screws M5 x 20 from below, (bolting torque 7 Nm). | Position see picture 2 (top view) |
| 3. | Mount the <i>moveable rack wall</i> (3) with the aluminum U-channels to the ground plate by pushing the U-channels into the <i>spindle nuts</i> (6) until fully seated. | <i>Moveable rack wall</i> (3): Positioning stripes No. 1 is down, No. 50 is up. Take care that the softend corners of the <i>spindle nuts</i> (6) shows upwards. |
| 4. | Position the <i>top plate</i> (4) identical to the <i>ground plate</i> (1) so that the red knurled head is on the same side as the fixed rack wall. | <i>Width adjustment lock</i> (9) shows to the <i>fixed rack wall</i> (2) |
| 5. | Attach the <i>top plate</i> (4) to the aluminum profiles using four torx screws M5 x 20, (bolting torque 7 Nm). | Position see picture 2. For reversible use replace the plastic plate top (picture 3) |
| 6. | Remove the styrofoam fixing pieces under the four <i>spindle nuts</i> (6). | |
| 7. | Attach the <i>tightener pulley</i> (8) to the <i>fixed rack wall</i> (2) with a phillips head srew M4 x 12, a ratched wheel and a washer loosely. | First put the ratched wheel, than the washer on the screw. Tightener pulley shows down, long hole up. |
| 8. | Push the four <i>gear wheels</i> (7) on the four spindles. | Flat front side of the <i>gear wheels</i> (7) up to limited stop |
| 9. | Put the gear belt over the four <i>gear wheels</i> (7) and the <i>tightener pully</i> (8) and also under the <i>width adjustment lock</i> (9). | |
| 10. | Tighten the gear belt with <i>tightener pulley</i> (8). Tighten also the phillips head srew M4 x 12. | |
| 11. | Fix the gear belt with the knurled head screw of the <i>width adjustment lock</i> (9). | |
| 12. | Get the <i>moveable rack wall</i> (3) parallel to the <i>fixed rack wall</i> (2) by turning the single spindels. | |
| 13. | Put the four clamp hoops on the <i>gear wheels</i> (7) and tighten them up. | Adjust the slot of the clamp hoops horizontal and with the opening showing inwards, screw heads must be reachable. |
| 14. | Losen the the knurled head screw of the <i>width adjustment lock</i> (9). | |
| 15. | By pulling the gear belt make shure the magazine moves freely. | If it moves hardly - losen the gear belt (Step 9) |
| 16. | Check the parallelism. | If the rack walls are not parallel - lose all clamp hoops (7) and repeat step 11 to 16. |

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