

Step	Description	Notes
1.	Attach the <i>fixed rack wall</i> (2) to the <i>ground plate</i> (1) using two phillips head screws M5 x 16 from below, (bolting torque 5 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 phillips head screws M5 x 16 from below, (bolting torque 5 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 phillips head screws M5 x 16.	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 screw 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 screw 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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