

# Final Assembly PCB Magazine 701 - 703

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.
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 side wall.	<i>Width adjustment lock</i> (9) shows to the <i>fixed side wall</i> (2)
5.	Attach the <i>top plate</i> (4) to the aluminum profiles using four phillips head screws M5 x 16, (bolting torque 5 Nm).	Position see picture 2. For reversible use don't mount the plastic plate top
6.	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 shows up.
7.	Push the four <i>gear wheels</i> (7) to the four spindles.	Flat front side of the <i>gear wheels</i> (7) up to limited stop
8.	Put the gear belt over the four <i>gear wheels</i> (7) and the <i>tightener pulley</i> (8) and also under the <i>width adjustment lock</i> (9).	
9.	Tighten the gear belt with <i>tightener pulley</i> (8). Tighten also the phillips head screw M4 x 12.	
10.	Fix the gear belt with the knurled head screw of the <i>width adjustment lock</i> (9).	
11.	Put the four clamp hoops on the <i>gear wheels</i> (7) and tighten them up.	
12.	Take off the fixing of the four <i>rack wall holders</i> (6)	Take off screws and washers (picture 3)
13.	Losen the knurled head screw of the <i>width adjustment lock</i> (9).	
14.	By pulling the gear belt make shure the magazine moves freely.	If it moves hardly - losen the gear belt (Step 9)
15.	Check the parallelism.	

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