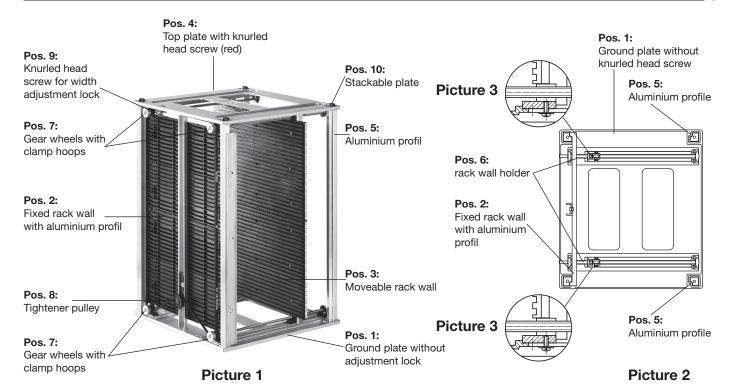
Final Assembly PCB Magazine 701 - 703



Step	Description	Notes
1.	Attach the fixed rack wall (2) to the ground plate (1) using two phillips head srews M5 x 16 from below, (bolting torque 5 Nm).	Fixed rack wall (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 srews 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.	Moveable rack wall (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.	Width adjustment lock (9) shows to the fixed side wall (2)
5.	Attach the <i>top plate</i> (4) to the aluminum profiles using four phillips head srews M5 x 16, (bolting torque 5 Nm).	Position see picture 2. For reversible use don't mount the plastic plate top
6.	Attach the tightener pulley (8) to the fixed rack wall (2) with a phillips head srew M4 x 12, a ratched wheel and a washer losely.	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 pully</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 srew M4 x 12.	
10.	Fix the gear belt with the knurled head screw of the width adjustment lock (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 rack wall holders (6)	Take off screws and washers (picture 3)
13.	Losen the knurled head screw of the width adjustment lock (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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