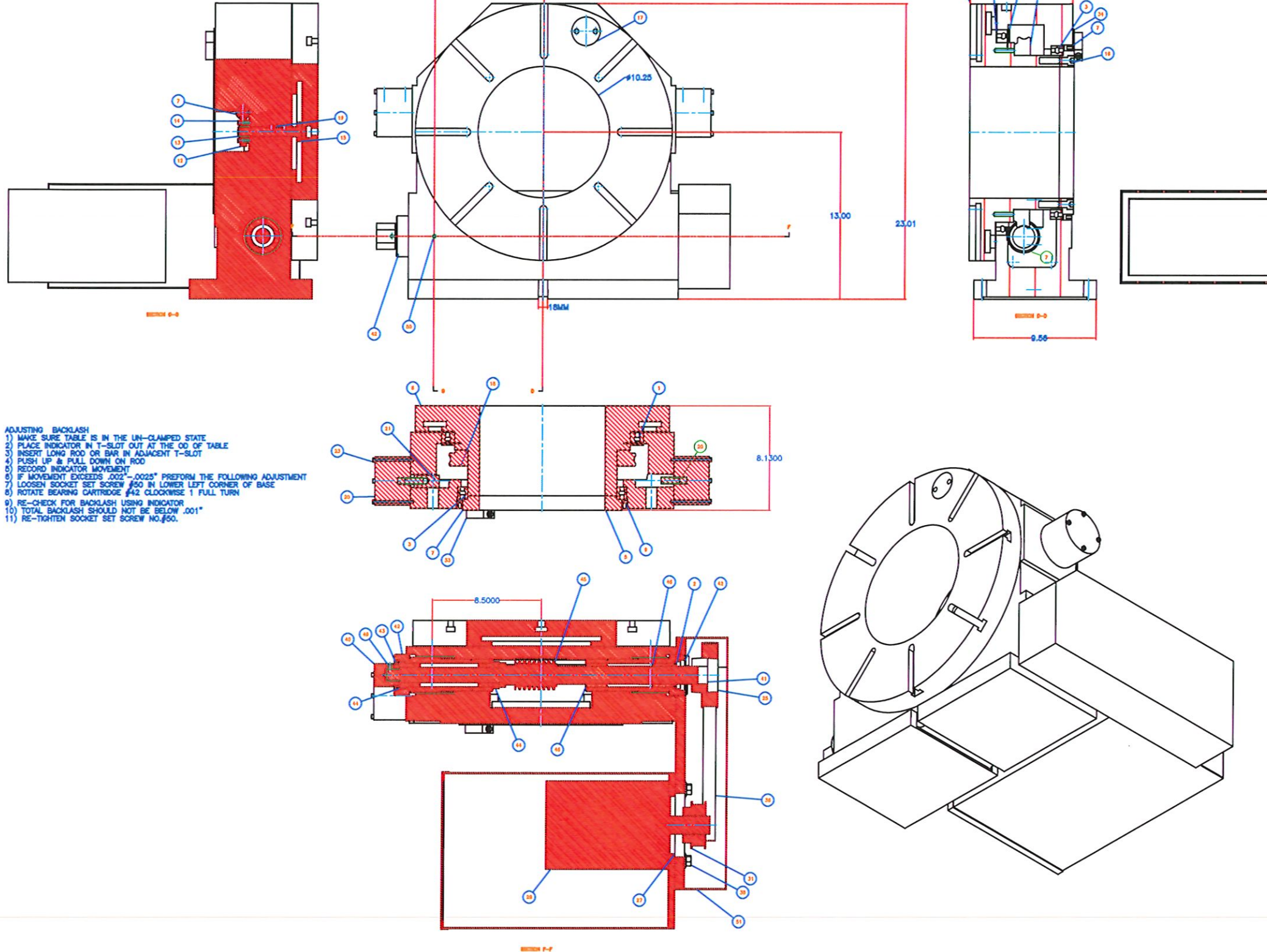


- ADJUSTING PNEUMATIC LOCKS:**
- 1) MAKE SURE TABLE IS IN THE UN-CLAMPED STATE
 - 2) REMOVE (8) BUTTON HEAD CAP SCREWS IN COVERS OVER LOCKS
 - 3) CLEAR ALL GREASE FROM BORES
 - 4) CYCLE CLAMPS AND OBSERVE THE RACK & PINION MOVING
 - 5) UN-CLAMP TABLE
 - 6) REMOVE (8) CAP SCREWS NO.14 IN LOCK GEARS NO. 12.
 - 7) ROTATE (2) LOCK GEAR HUBS NO. 13 CLOCKWISE UNTIL SHUG
 - 8) REPLACE (2) LOCK GEARS NO. 12, ROTATE LOCK GEAR HUBS NO. 13 COUNTER CLOCK WISE UNTIL TAPPED HOLES LINE UP WITH THE CLEARANCE HOLES IN LOCK GEAR
 - 9) REPLACE (8) SOCKET HEAD CAP SCRES NO. 14
 - 10) COAT LOCK RACK & GEARS WITH LIGHT GREASE
 - 11) OBSERVE CLAMPS ACTUATING AND REPLACE COVERS



- ADJUSTING BACKLASH:**
- 1) MAKE SURE TABLE IS IN THE UN-CLAMPED STATE
 - 2) PLACE INDICATOR IN T-SLOT OUT AT THE OD OF TABLE
 - 3) INSERT LONG ROD OR BAR IN ADJACENT T-SLOT
 - 4) PUSH UP & PULL DOWN ON ROD
 - 5) RECORD INDICATOR MOVEMENT
 - 6) IF MOVEMENT EXCEEDS .002"-.0025" PERFORM THE FOLLOWING ADJUSTMENT
 - 7) LOOSEN SOCKET SET SCREW #50 IN LOWER LEFT CORNER OF BASE
 - 8) ROTATE BEARING CARTRIDGE #42 CLOCKWISE 1 FULL TURN
 - 9) RE-CHECK FOR BACKLASH USING INDICATOR
 - 10) TOTAL BACKLASH SHOULD NOT BE BELOW .001"
 - 11) RE-TIGHTEN SOCKET SET SCREW NO.#50.

ITEM	QTY	DESCRIPTION	NAME
1	1	KAYDON KG140XPOM BEARING	SBO-KG140XPOM
2	1	C/R 13734 SEAL	SOS-13734
3	1	KAYDON KF120XPOL BEARING	SBO-KF120XPOL
5	1	BEARING THRUST COLLAR	PCO-1858A
6	1	TABLE	PTB-2484 Table
7	1	BASE	PBA-5888_O Base
8	1		
9	1	C/R 110303 SEAL	SOS-110303
10	1	TURCOTE BEARING RING	SBT-TN20
11	1		DL20_LOCK
12	2	PLG-2488	SGR-2488
13	2	PLH-2489 LH/ PLH-2489 RH	PGH-2489
14	8	HEXAGON SOCKET HEAD CAP SCREW	
15	2	LOCK SHAFT	PLS-2487
16	6	HEXAGON SOCKET HEAD CAP SCREW 1/2 X 2 1/4	
17	1	CLAMP CAP	PCA-4410
18	1	90 TOOTH 1/2 PITCH WORMWHEEL	SWW-2485RH
19	2		3/16 X 1/2 KEY
20	2	CLAMPING CYLINDER	SPC-C521X
21	1	LOCKING RACK	PLR-2491A
22	2	CLAMPING ROD	1/2-13X2 THREADED_ROD
23	8	HEXAGON SOCKET HEAD CAP SCREW 10 - 24 - 3	
25	1	50 TOOTH PULLEY	SPY-8M50S-21 PULLEY
27	1	SERVOMOTOR ADAPTER PLATE	PPT-4787_A12DWG
28	5		1/2-13_THREADED ROD
29	1	FANUC SERVOMOTOR (A06B-0243-#200)	
30	3	HEX NUT	HEX NUT - A 1/2 - 13
31	1	25 TOOTH PULLEY	SPY-8M25S
32	4	HEXAGON SOCKET HEAD CAP SCREW - 1/2 - 13 - 3/4	
33	1	TELEMECANIQUE XCM110 LIMIT SWITCH	ESW-XCM110
34	1		LIMIT SWITCH MOUNTING BRACKET
35	1	PULLEY PLATE	4015-DL20B180
36	1	TIMING BELT	STB-6M800-21
37	1	MOTOR ENCLOSURE	SOV-4688_ASY
38	4	LARGE HEX FLANGE NUT - UNC	- UNC - M1 - 1/2 - 13
39	6	HEXAGON SOCKET HEAD CAP SCREW -	
40	1	NUT	PNT-5493
41	1	BUSHONG	SPY-QT35MM
42	2	BEARING CARTRIDGE	PBC-5328
43	1	SEAL	SOS-18084
44	2	BEARING	SBO-N60R35
45	1	WORMSHAFT	SWS-5328
46	2	BEARING	SBO-RN908
47	1	BRASS PLUG	SPQ-217DL
48	1	HEXAGON SOCKET S5/16 - 18 X 01/2	
49	1	(GEFMSO GEFSORNT 5130) - SPLINE SOCKET SET SCREW -	
50	2	3/8-16 X 1 SOCKET SET SCREW	SSS-3816X1
51	1		SOV-4014

Part	Lot No.	REVISIONS	Part Name
		Rev. Date By	Assembly
		1	Used
		2	On
TOLERANCES			
Dim. 1st. +/- .001	4		
Dim. 2nd. +/- .001	5		
Dim. +/- 1/64	6		
TRIPLE Mfg. Co. CINCINNATI, OH 45241 Made by ENF 110307 Scale 1=4 6969			