

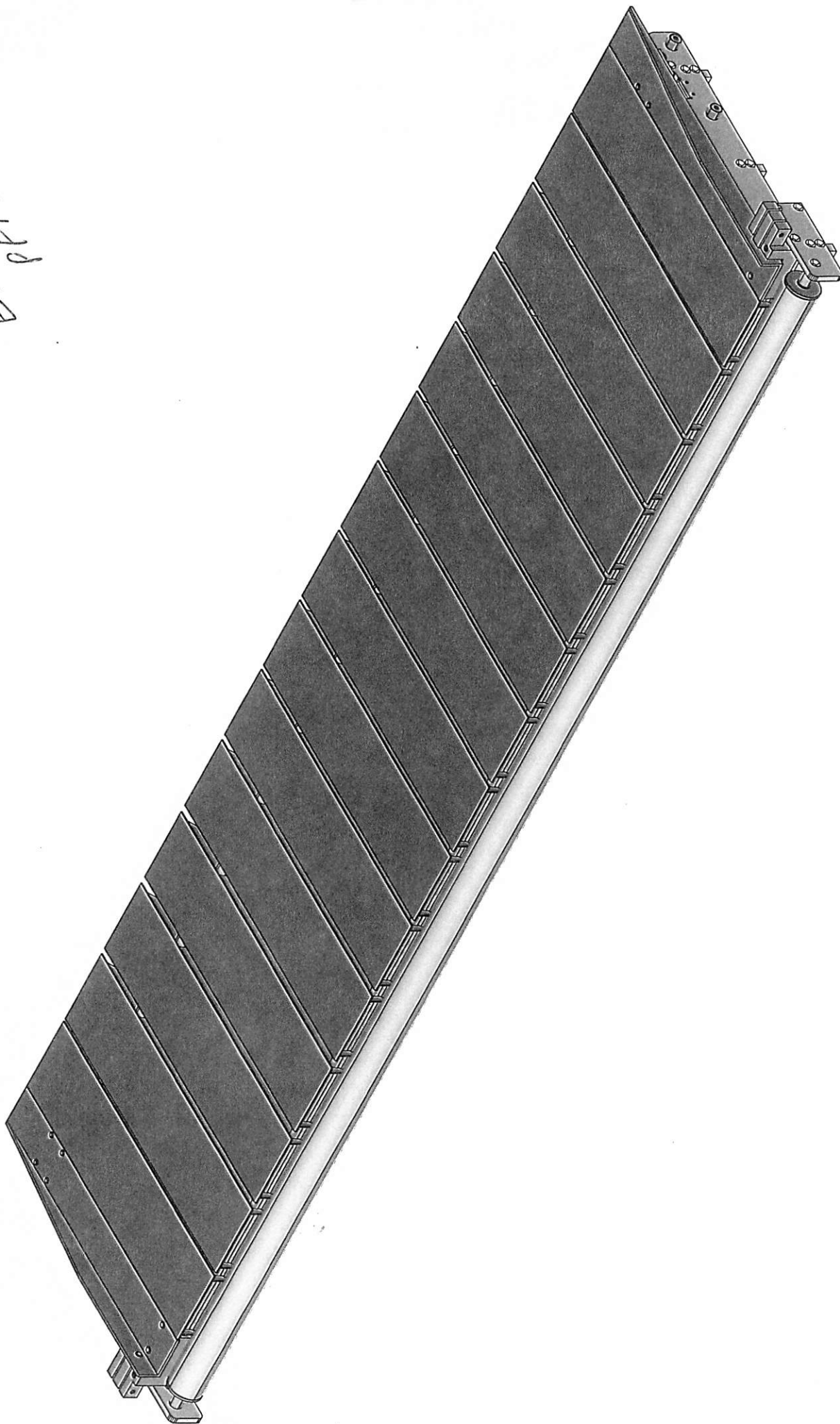
EP60

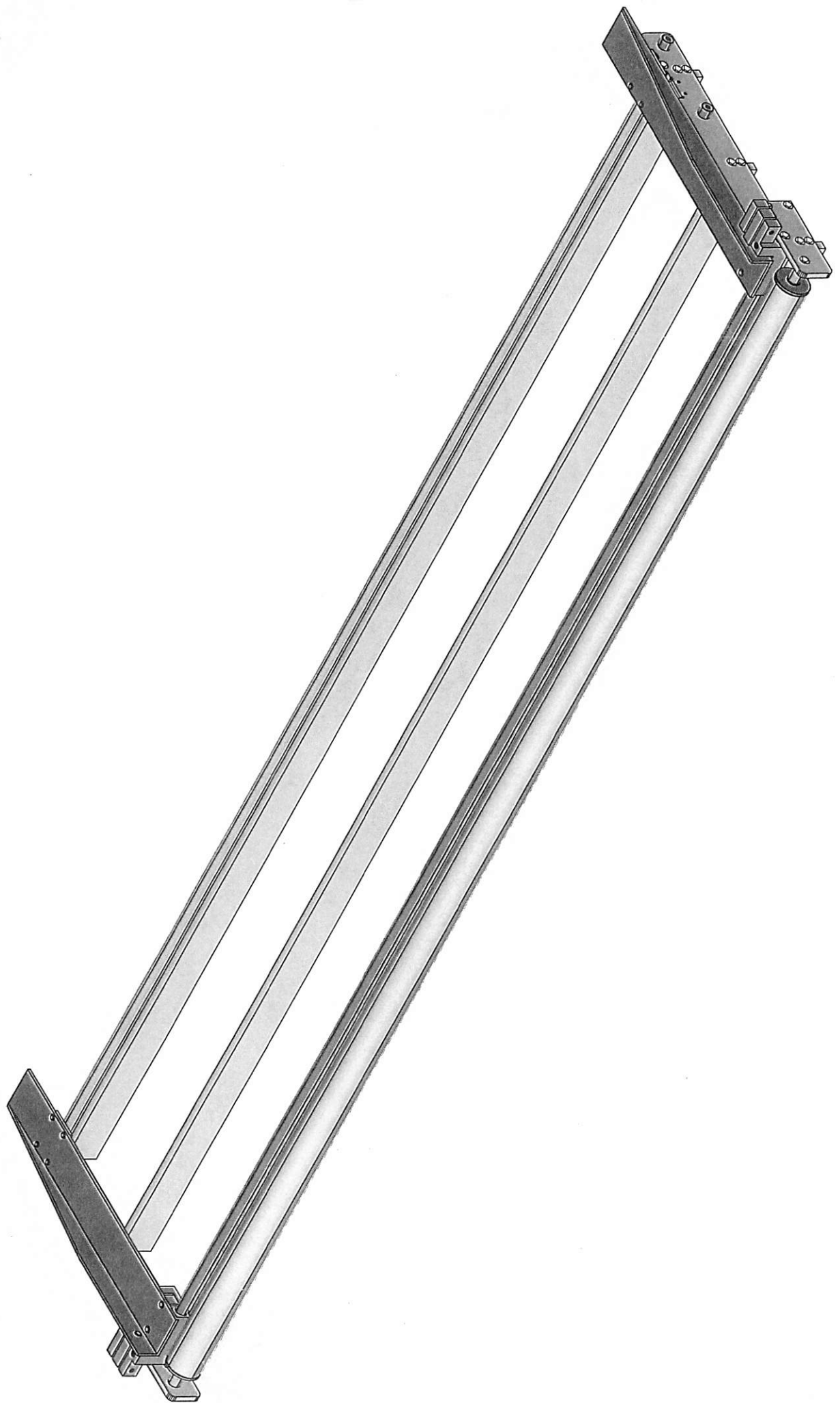
PRECISION FEED TABLE

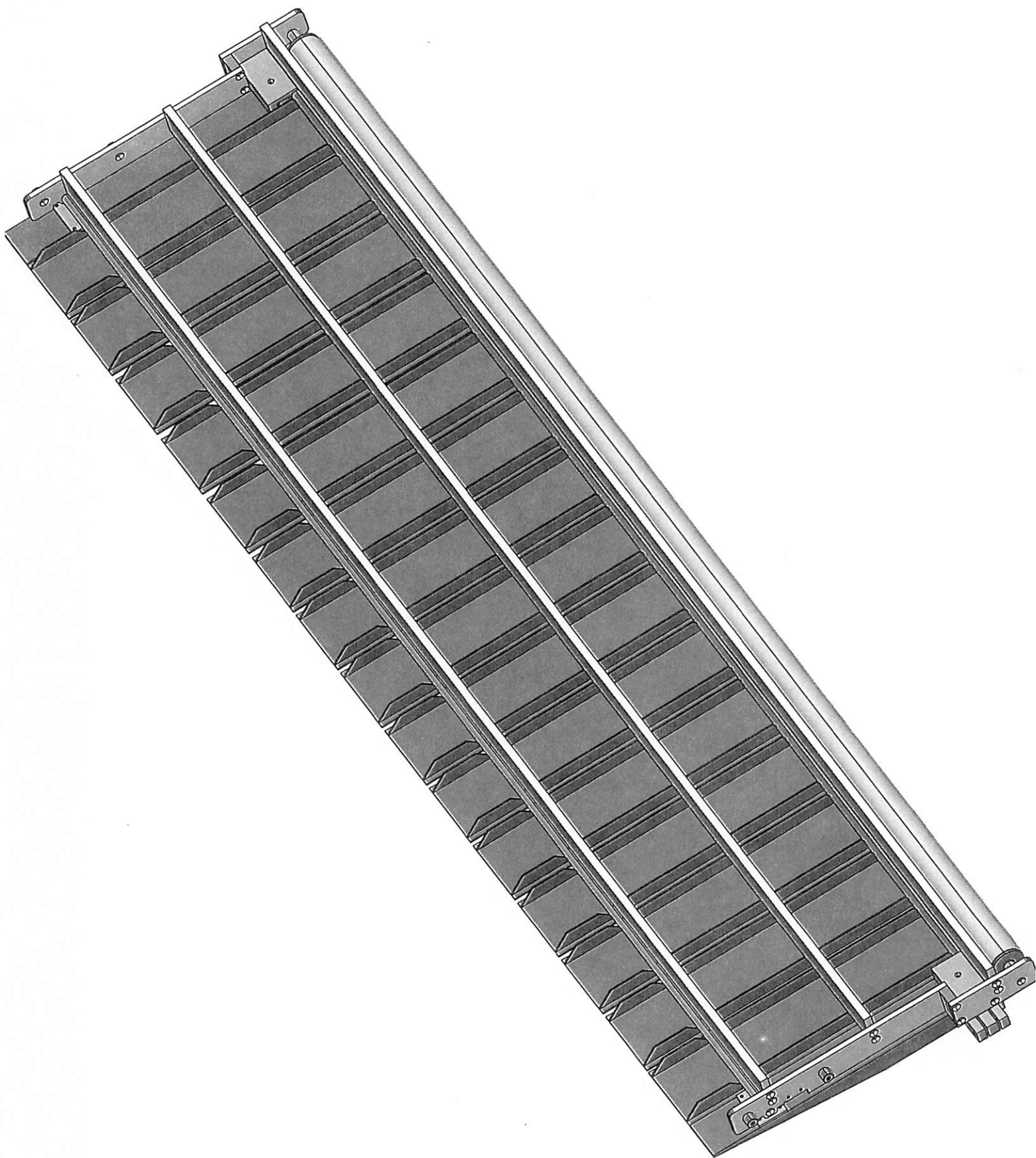
ASSEMBLY PROCEDURES

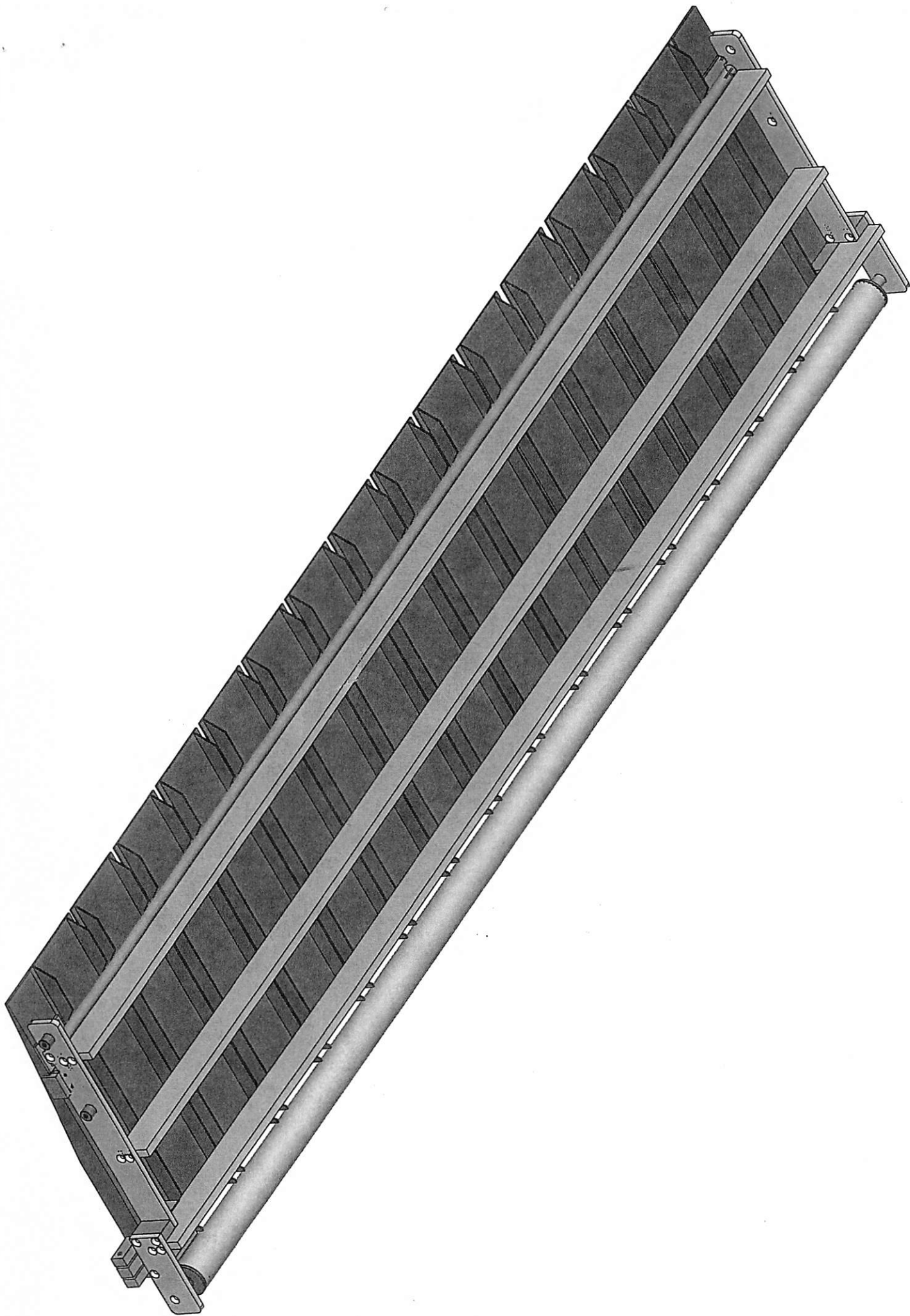
JANUARY 2010

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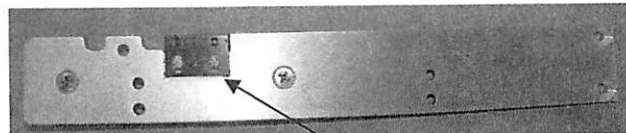


EP60 NRTL PRECISION FEED TABLE

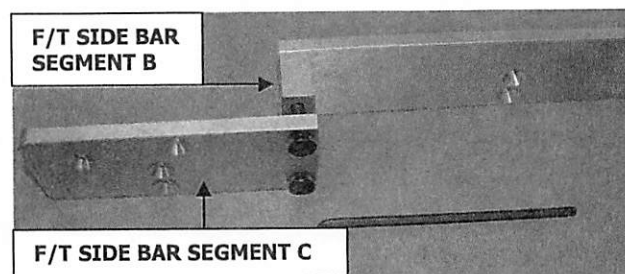
- 1) FROM RACK 10 PLACE A FEED TABLE RIGHT SIDE BAR SEGMENT A AND FEED TABLE LEFT SIDE BAR SEGMENT A (EP60 098.4RA AND EP60 098.4LA) ON A WORK TABLE. PLACE THE NOTCHES FACING *UPWARD AND INWARD* AWAY FROM YOU. THE COUNTERSINKS AT BOTH ENDS OF THE SIDE BARS FACE *INWARD*. SECURE (2) FEED TABLE MOUNTING STUB SHAFT (D105 101.4) AS13 TO BOTH OUTER SIDE BARS THROUGH INNER COUNTERSINKS. USE 10-32 BY $\frac{1}{2}$ FHMS WITH LOCTITE ON THREADS.
- 2) FROM RACK 1 SET THE PROXIMITY SWITCH MAGNET (PRS352) INTO *INNER* RIGHT SIDE BAR DEPRESSION, AND THREAD THROUGH MAGNET CHANNELS INTO SIDE BAR WITH (2) 4-40 X $\frac{1}{4}$ PH.
- 3) SECURE (2) FEED TABLE SIDE BAR SEGMENT B (EP60 098.4B) RACK 10 TO THE RIGHT AND LEFT *OUTER* FRONT END OF THE SIDE BARS. INSERT (2) 10-32 X $\frac{3}{4}$ FHSH EACH THROUGH BOTH INNER END COUNTERSINKS.
- 4) SECURE A RIGHT AND LEFT FEED TABLE SIDE BAR SEGMENT C (EP60 098.4RC AND EP60 098.4LC) RACK 10 TO THE FEED TABLE SIDE BAR SEGMENT B ON EACH SIDE, USING 10-32 X $\frac{1}{2}$ FHMS WITH LOCTITE ON THREADS.
- 5) SECURE THE (2) SHORTER FEED TABLE REAR STIFFENERS (EP60 104.4) LOFT 2 BETWEEN THE SIDE BARS, TIGHTEN ON ONE SIDE ONLY. USE 10-32 X $\frac{3}{4}$ FHSH THROUGH THE CLOSER COUNTERSUNK HOLES, WITH THE EXCESS STIFFENER *DOWNWARD*.
- 6) SECURE THE LONGER FEED TABLE FRONT STIFFENER (EP60 105.4) LOFT 2 BETWEEN FRONT SIDE BAR COUNTERSINKS, TIGHT ON ONE SIDE ONLY. USE 10-32 X $\frac{3}{4}$ FHSH. THE EXCESS STIFFENER IS DOWNWARD.



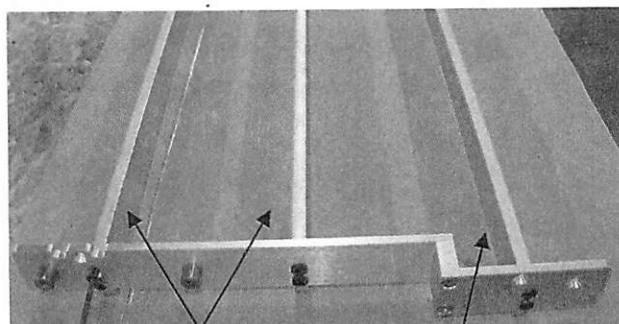
OUTER RIGHT SIDE BAR SEGMENT & STUB SHAFTS



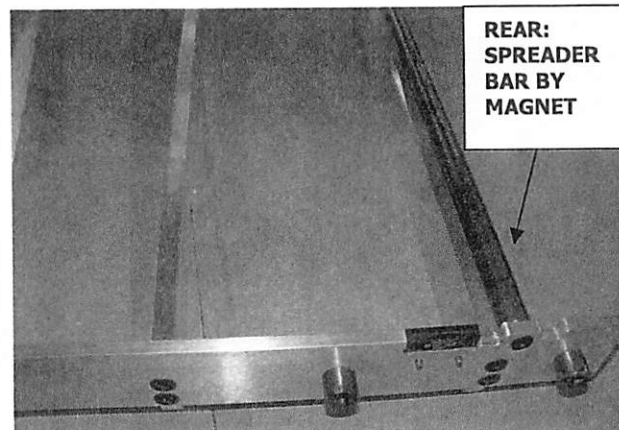
INNER RIGHT SIDE BAR & PROXIMITY MAGNET



F/T SIDE BAR SEGMENT C



SHORT REAR STIFFENERS & LONG FRONT STIFFENER



REAR:
SPREADER
BAR BY
MAGNET

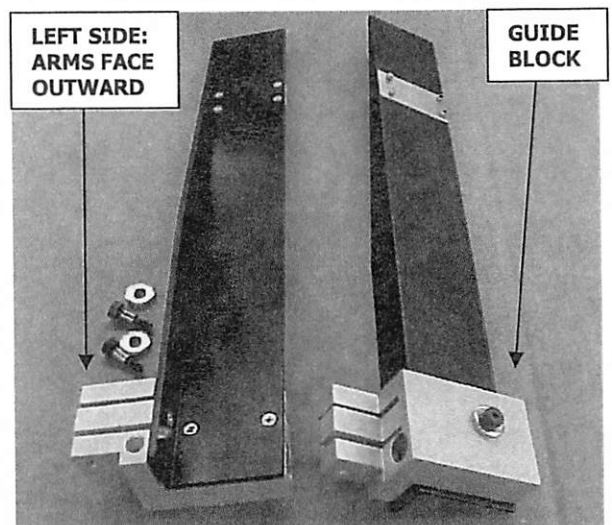
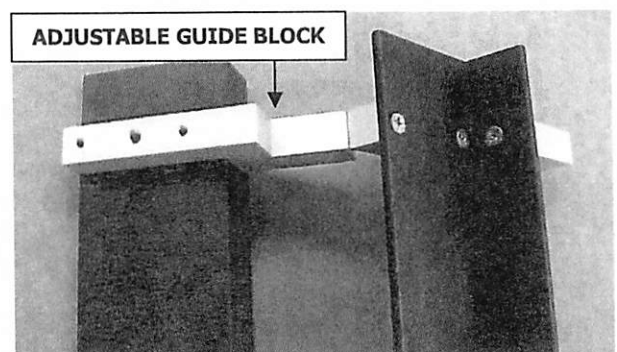
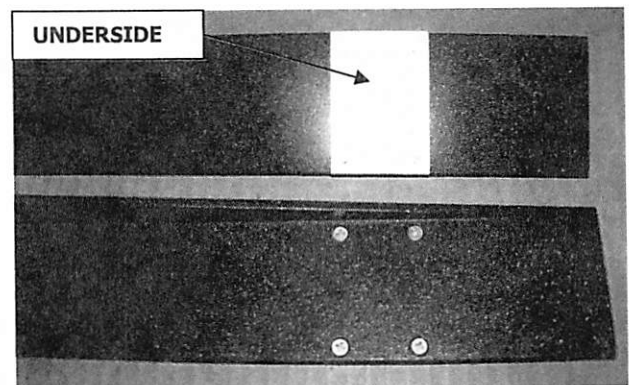
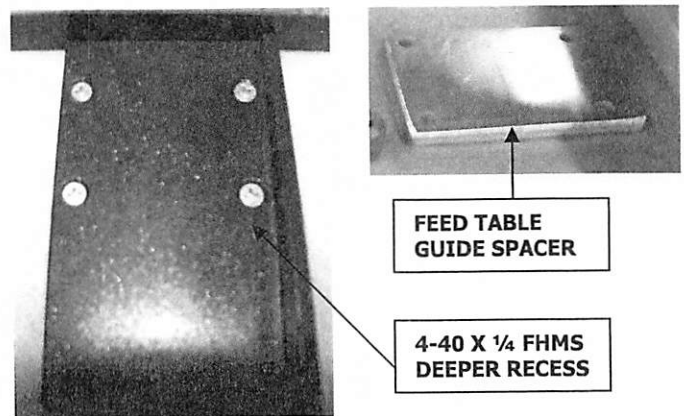
- 7) SECURE THE FEED TABLE SPREADER BAR (EP60 103.4) SHAFT RACK BETWEEN THE INNER SIDE BARS, TO THE REAR, BEHIND THE PROXIMITY MAGNET AND ABOVE THE REAR STIFFENER. TIGHTEN ONE SIDE ONLY USING 10-32 X $\frac{3}{4}$ FHS.

- 8) ALIGN THE (4) HOLES ON THE FEED TABLE GUIDE SPACER (I30 102.4) RACK 16 WITH THE HOLES ON THE UNDERSIDE OF THE FEED TABLE GUIDE RIGHT AND FEED TABLE GUIDE LEFT (I30 099.4R AND I30 099.4L) RACK 15. THE DEEPER RECESSED HOLES ON THE FEED TABLE GUIDE SPACER ALIGN UNDER THE FEED TABLE GUIDE BREAK, TO THE OUTSIDE. THE FEED TABLE GUIDE SPACERS ARE TAPPED WITH 4-40 THREADS. LOCTITE THREADS AND INSERT (4) 4-40 X $\frac{1}{4}$ FHMS INTO THE COUNTERSUNK UPPER SIDE OF THE FEED TABLE GUIDES. SNUG THREADS TO THE FEED TABLE GUIDE SPACERS.

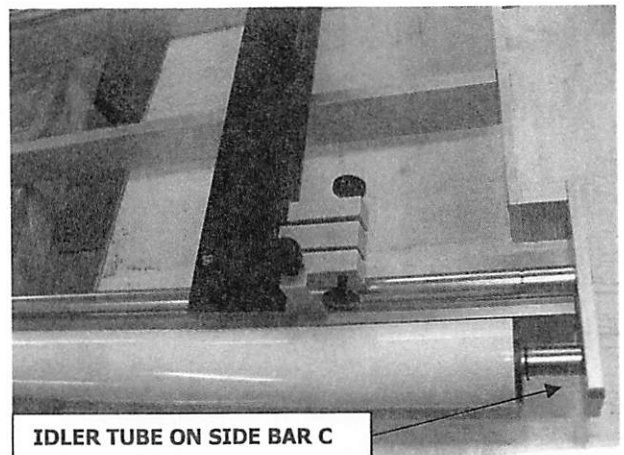
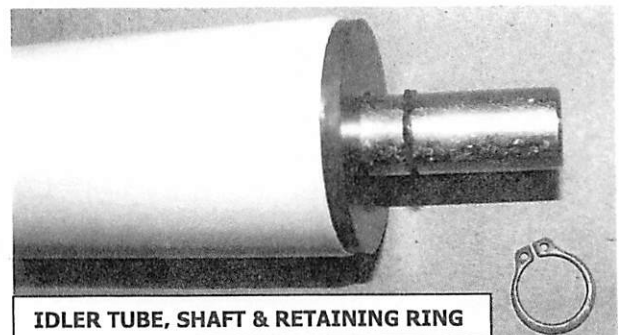
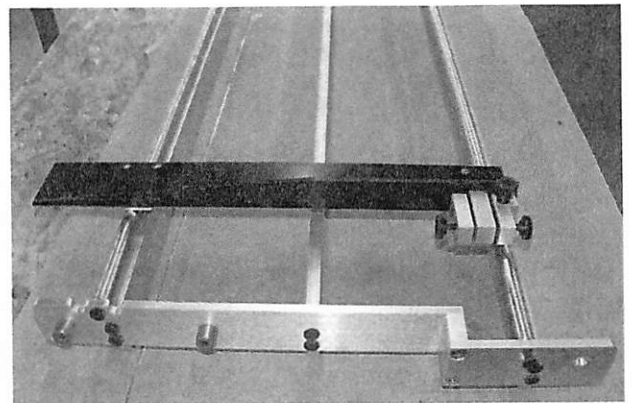
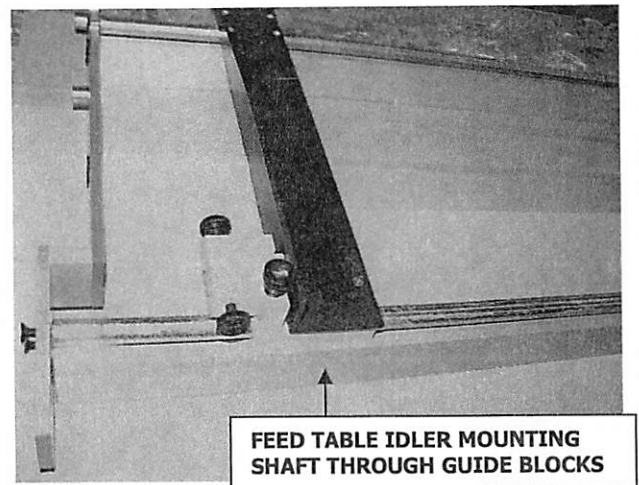
- 9) PREVIOUSLY POP RIVETS WERE USED INSTEAD OF 4-40 SCREWS. THIS METHOD IS EASIER AND THERE IS LESS RISK OF SCRATCHING THE TEFLON ON THE FEED TABLE GUIDES. DO NOT TO SCRATCH TEFLON ON GUIDES.

- 10) SECURE AN ADJUSTABLE FEED TABLE GUIDE MOUNTING BLOCK (I30 101.4) RACK 16 TO THE OUTER ENDS OF THE RIGHT AND LEFT FEED TABLE GUIDE THROUGH THE COUNTERSUNK HOLES. ROTO-BURR IF NECESSARY. USE (3) 6-32 X $\frac{3}{8}$ FHMS ON EACH. NOTE POSITIONING OF SCREWS ON PICTURE.

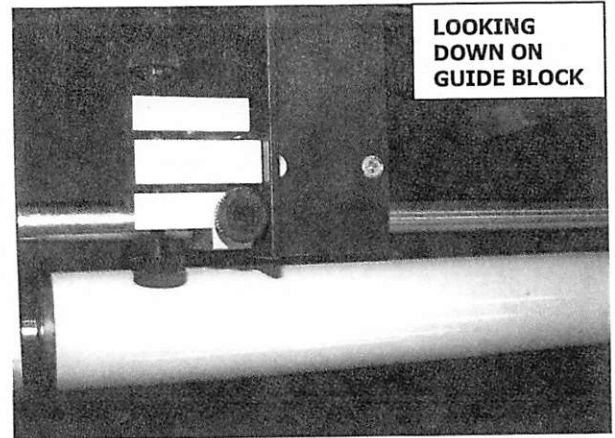
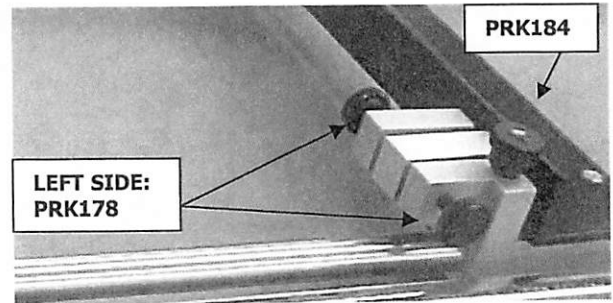
- 11) PLACE A $\frac{1}{4}$ X $\frac{5}{8}$ X $\frac{1}{8}$ FLAT WASHER ON EACH OF (2) $\frac{1}{4}$ X $\frac{3}{8}$ SHOULDER BOLTS. LOCKTITE AND THREAD THE SHOULDER BOLT THROUGH THE BOTTOM OF THE GUIDE BLOCK RIGHT AND GUIDE BLOCK LEFT (I30 100.4R AND I30 100.4L) RACK 16, AFTER THE "ARMS" OF THE ADJUSTABLE BLOCK AND THE GUIDE BLOCKS HAVE BEEN MATCHED TO FACE OUTWARD. DO NOT OVER TIGHTEN, THERE SHOULD BE EASY BACK AND FORTH MOVEMENT OF THE ADJUSTABLE FEED TABLE GUIDE BLOCK BETWEEN THE TWO STATIONARY GUIDE BLOCK ARMS.



- 12) PLACE THE ASSEMBLED FEED TABLE GUIDES TOGETHER, WITH GUIDE BLOCK ARMS FACING OUTWARD, RIGHT AND LEFT AND TO THE FRONT.
- 13) INSERT A FEED TABLE IDLER MOUNTING SHAFT (EP60 103.4I) SHAFT RACK THROUGH THE GUIDE BLOCK ASSEMBLY, WITH THE "ARMS" ON EACH FACING OUTWARD. SECURE IDLER MOUNTING SHAFT BETWEEN INNER COUNTERSUNK HOLES OF THE FEED TABLE SIDE BAR SEGMENT C. USE 10-32 X $\frac{3}{4}$ FHS WITH LOCTITE. TIGHTEN ONE SIDE ONLY. THE FEED TABLE GUIDE SPACERS WILL REST ON THE REAR SPREADER BAR.
- 14) TAP (2) NYLATRON STYLE IDLER BEARINGS (PRB086A) AS13 ONE INTO EACH END OF A FEED TABLE IDLER TUBE (D60 054.4) D60-01.
- 15) PLACE A RETAINING RING (PRR191) LD06 INTO THE GROOVE OF ONE END ON A SECOND FEED TABLE IDLER MOUNTING SHAFT AND INSERT THE SHAFT THROUGH THE IDLER TUBE NYLATRON BEARINGS. SECURE THE OTHER END OF THE SHAFT WITH ANOTHER RETAINING RING. INSERT THE IDLER TUBE ASSEMBLY BETWEEN RIGHT AND LEFT SIDE BAR C. SECURE WITH (2) 10-32 X $\frac{3}{4}$ FHS AND LOCTITE.
- 16) TIGHTEN ALL SCREWS ON BOTH SIDES.
- 17) THREAD (2) 5/16-18 X 1" PLASTIC MOLDED THUMBSCREWS (PRK184) AS09 INTO THE (2) UPPER GUIDE BLOCKS TO SECURE ON FRONT FEED TABLE GUIDES.
- 18) THREAD (2) SPI KNOBS (PRK178) AS08 INTO EACH OF THE RIGHT AND LEFT GUIDE BLOCKS.
- 19) USING A RAG, RUB A LIGHT COATING OF OIL ALONG THE IDLER MOUNTING SHAFT HOLDING THE FEED TABLE GUIDE BLOCKS. SLIDE THE GUIDE BLOCKS BACK AND FORTH TO TEST FOR EASY MOVEMENT. OIL CAN ALSO BE RUBBED ONTO THE REAR SPREADER BAR THAT THE FEED TABLE GUIDE SPACER SLIDES ALONG.



- 20) THE EP60 PRECISION FEED TABLE IS SHIPPED WITH (15) INDIVIDUALLY WRAPPED FEED TABLE BASE SECTIONS (H385 099.4) AS06. PLACE THE BASE SECTIONS WITH THE ASSEMBLY.
- 21) FILL OUT THE PAPERWORK AND NOTIFY THE SHIPPING DEPARTMENT THAT THE PRECISION FEED TABLE IS READY TO SHIP.



Legco Corporation
 Single Level Current Bill of Material

Unit Cost Effect From

Quantity per U/M U

Extended Cost

0.00000

0.00000

PRECISION FEED TABLE ASSEMBLY

10 PRECISION FEED TABLE ASSEMBLY

1/4 PH PHIL M/ (2PA54)

1/4 PH PHIL M/ S 2A484

X 3/8 SHCS

32 X 1/2 SHCS

32 X 3/4 SHCS

1/4 X 3/8 SHOULDER STUD SHAFT

FEEDTABLE IDLER TUBE

FEEDTABLE SIDE BAR SEGMENT A

FEEDTABLE LEFT SIDE BAR SEGMENT C

FEEDTABLE LEFT SIDE BAR SEGMENT A

FEEDTABLE RIGHT SIDE BAR SEGMENT C

FEEDTABLE RIGHT SIDE BAR SEGMENT A

FEEDTABLE SPREADER BAR

FEEDTABLE SPREADER MOUNTING SHAFT

FEEDTABLE IDLER STIFFENER

FEEDTABLE REAR STIFFENER

FEEDTABLE FRONT SECTION, REV. B

FEEDTABLE BASE SECTION, REV. B

FEEDTABLE GUIDE LEFT USE #130 069.4-A M

FEEDTABLE GUIDE RIGHT USE #130 100.4-L-B M

FEEDTABLE LEFT USE DWG. #130 100.4-B-B M

GUIDE BLOCK RIGHT USE DWG. #130 102.4-A M

2.00000 EA U

8.00000 EA U

6.00000 EA U

8.00000 EA U

25.00000 EA U

2.00000 EA U

4.00000 EA U

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