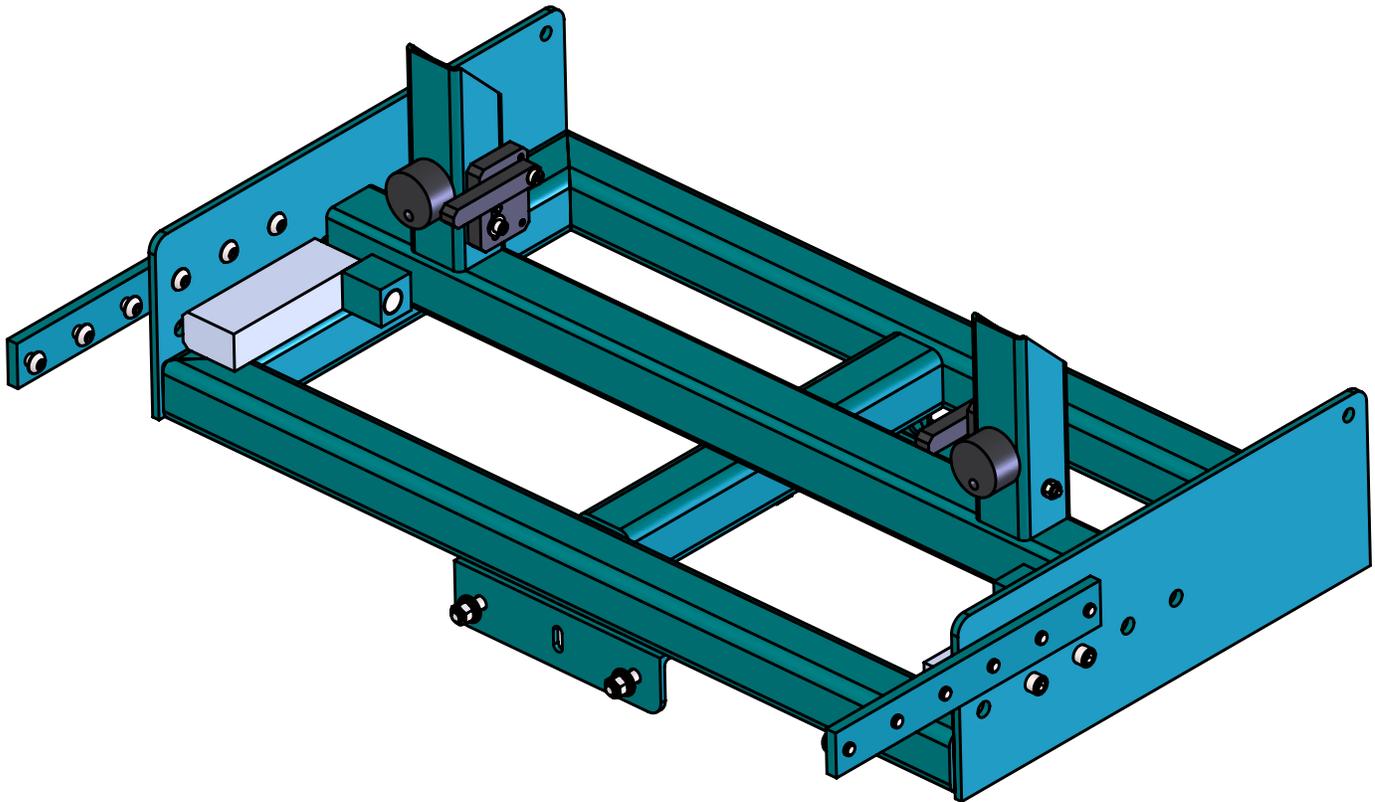


TIME FOLD SERIES

8 FT DOOR SILL CLAMP EXTENSION

ASSEMBLY INSTRUCTIONS
AND PARTS LIST
REV. 0



WORK SAFELY

OBSERVE THESE SAFETY RULES AT ALL TIMES

This machine can be hazardous in the hands of a unfamiliar, untrained or complacent operator.

DO NOT RISK INJURY

1. Disconnect the air supply to the machine before making any adjustments, repairs, cleaning, or performing maintenance.
2. **DO NOT**, under any circumstances, operate the machine without all safety guards and covers in place
3. Maintain the machine for maximum safety and performance. Make DAILY inspections
4. Never allow untrained operators to use this machine.
5. Turn the air OFF when the machine is not in use or unattended.
6. Only qualified and trained personnel should make repairs.
7. It is recommended that eye protection be worn while operating the machine
8. It is recommended that hearing protection be worn while operating this machine.

All safety and warning labels should be unobstructed and legible. Call (800) 824-6242 to order replacement labels



TIME FOLD SERIES - MODULE CONNECTOR

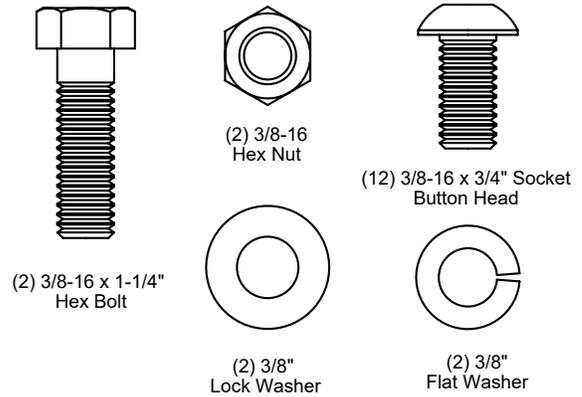
TOOLS REQUIRED:

2 - 9/16" OPEN END OR COMBINATION WRENCH*

1 - 7/32" HEX KEY

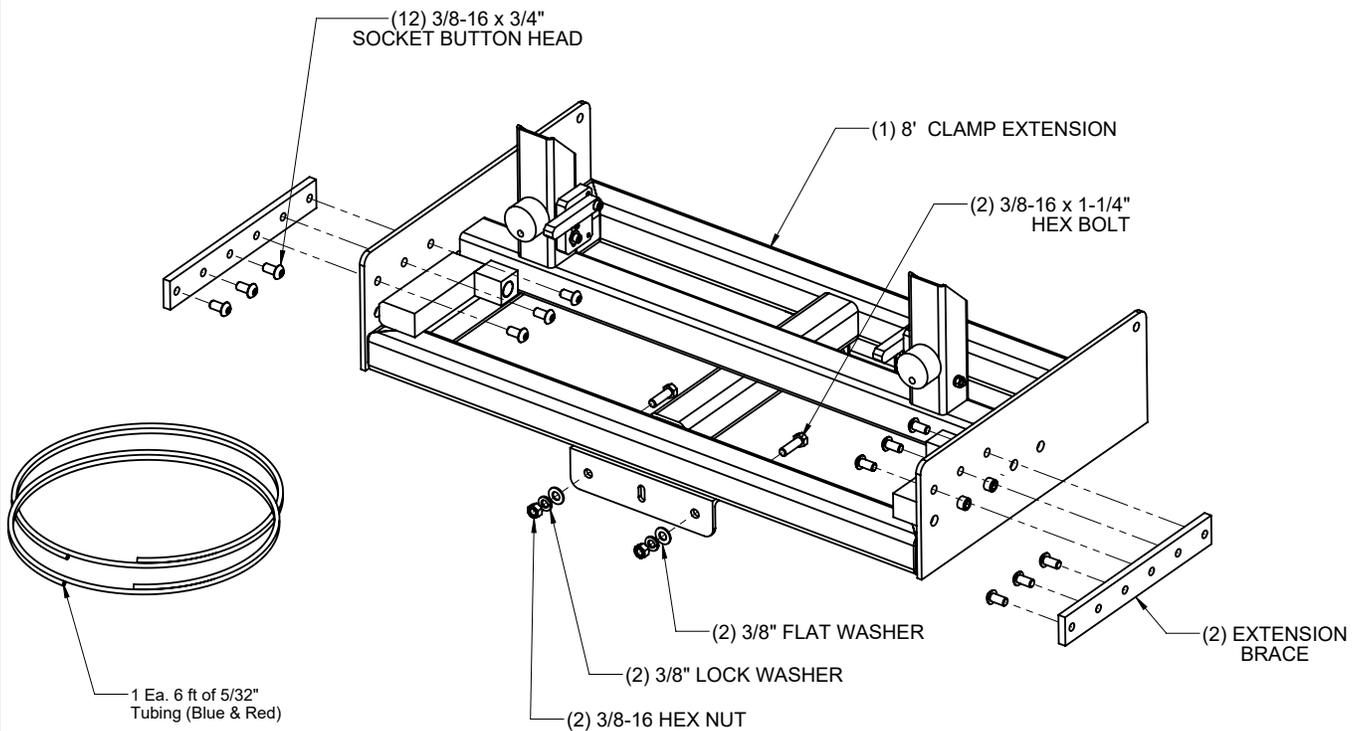
* 2 - 8" ADJUSTABLE WRENCHS MAY BE USED

FASTENERS INCLUDED



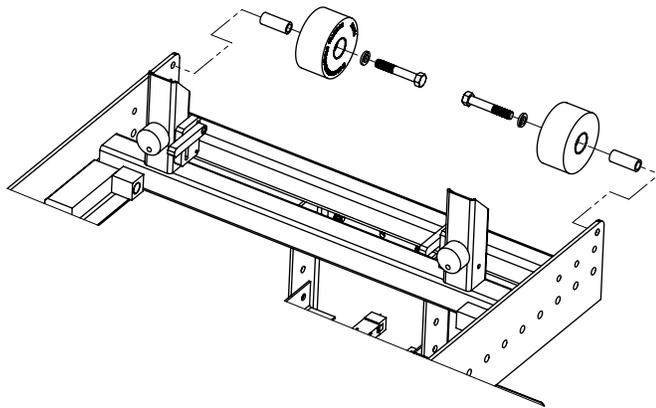
ASSEMBLY INSTRUCTIONS:

STEP 1: Remove all contents from carton and inspect for damage and shortages. The carton should include:

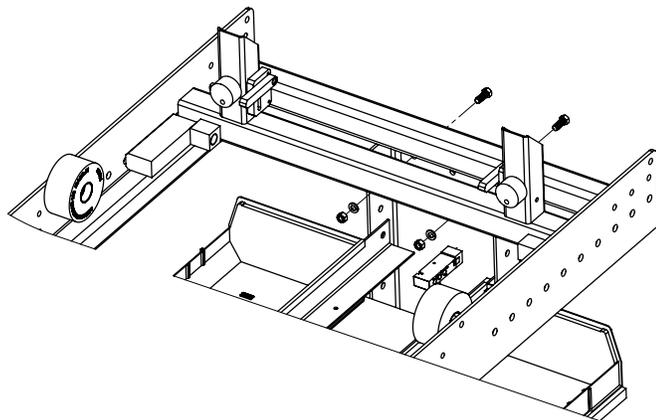


In the event there was damage in transit or if any shortages (other than backorders) are noticed, notify the freight carrier immediately to file a claim. Once you've filed the claim, please notify Norfield Customer Service by calling 1-800-624-6242 so that the replacement of lost or damaged parts can be expedited to you.

STEP 2: Support table top and Remove the two outer roller wheels from the end of the table and set aside . Next remove existing 3/8-16 fasteners that mount the table top to the legs



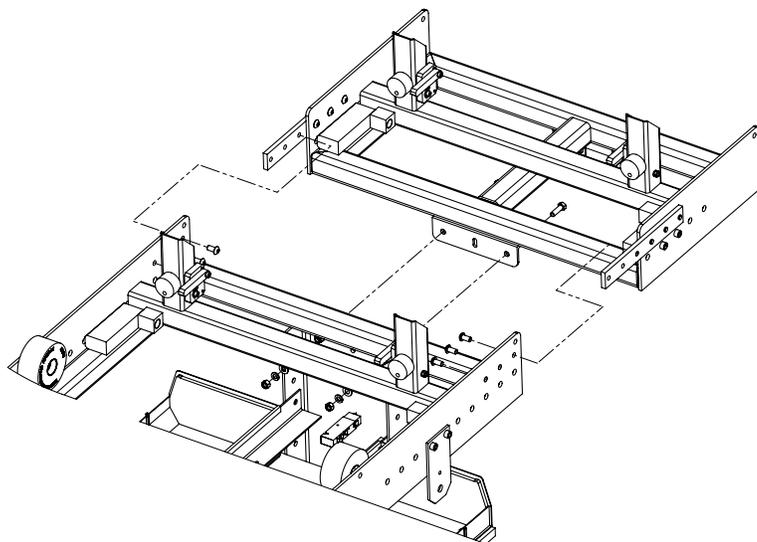
STEP 3: Remove existing 3/8-16 fasteners that mount the table top to the legs and set aside



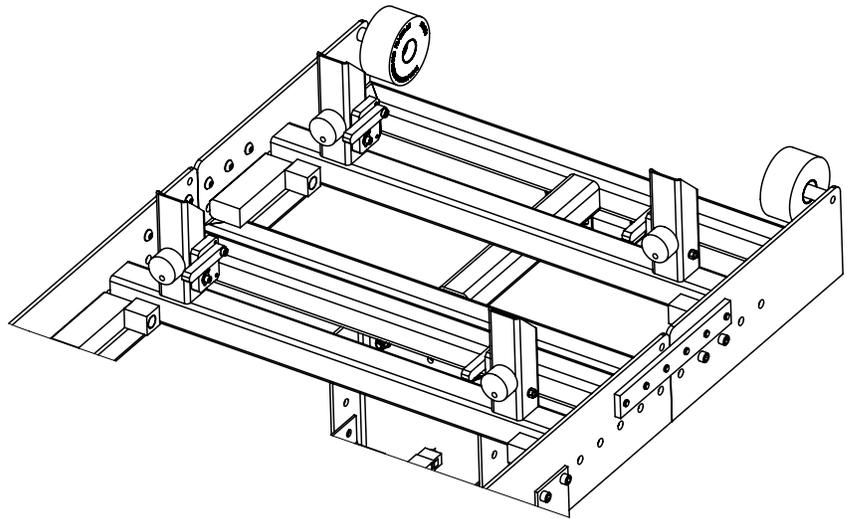
STEP 4: Loosen the six 3/8-16 x 3/4" Socket Button Head fasteners that hold the Clamp Brace to the Extension Clamp Brkt.

STEP 5: Slip the new Clamp Assembly over the Assembly Master's Side Rails. Start one 3/8-16 x 7/8" Button Head on each side of the table. Install the new longer 3/8-16 x 1-1/4" hex bolts through the new Clamp Extension into the table bracket and leg assembly and install washers and nuts (Do not tighten) Start the rest of the 3/8-16 x 7/8" Button Heads. While holding extension level tighten all fasteners

NOTE: For installation on older Assembly Masters A paper 1:1 drill location template is provided. Carefully position template and mark new hole locations, Remove template Repeat for opposite side then drill holes, Then continue with step 5

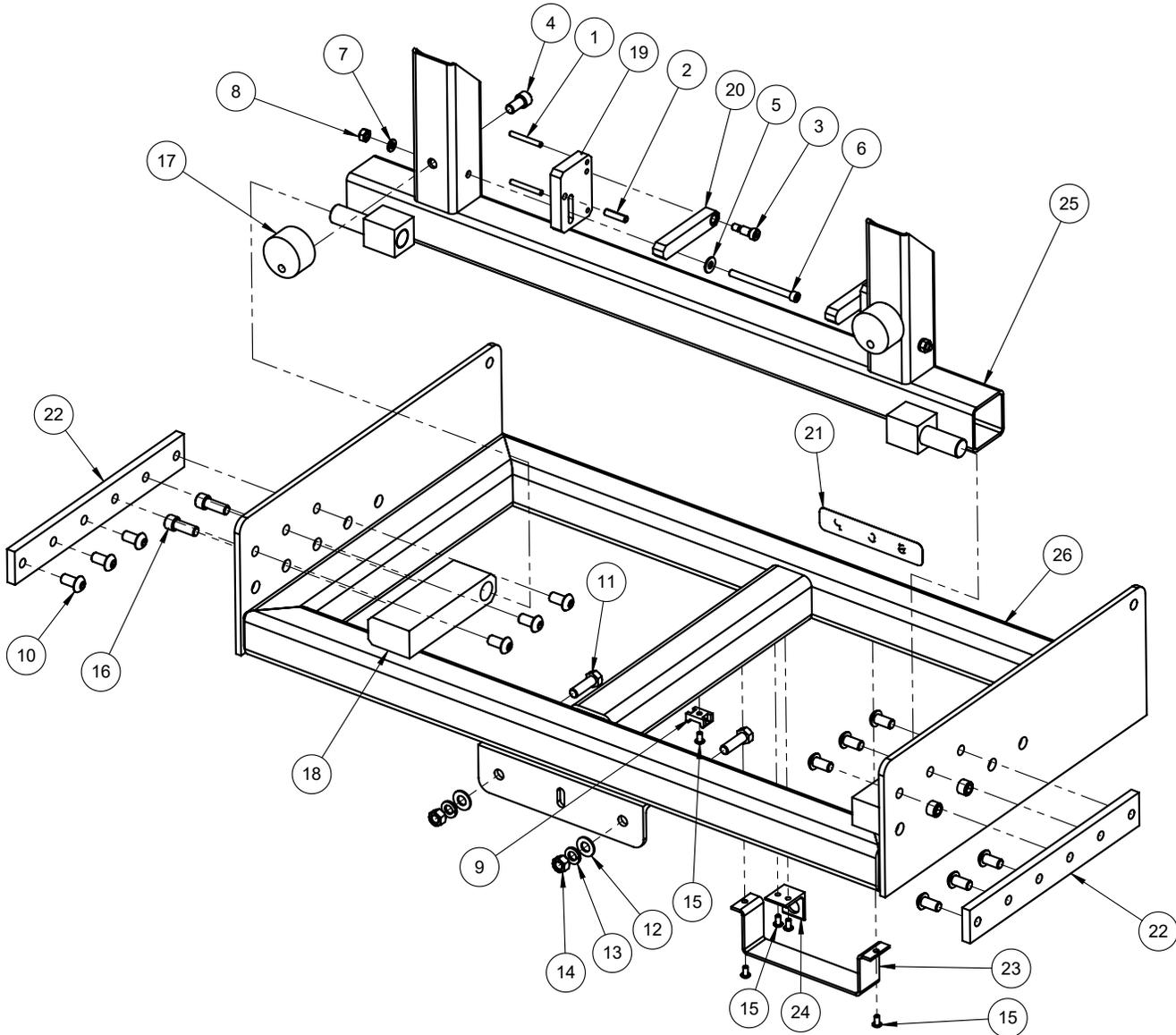


STEP 6: Re-Install the Roller Wheels
in the new location shown in the Clamp
Extension



*Sill Clamp now has range of adjustment to cover 8' doors

8Ft DOOR SILL CLAMP EXTENSION MODULE



ITEM	PART NUMBER	DESCRIPTION	QTY.
1	*****	3/16 x 1-1/2" Roll Pin	4
2	*****	1/4" x 1" Roll Pin	2
3	*****	5/16 x 1/2" Shoulder Bolt	2
4	*****	3/8-16 x 3/4" SHCS	2
5	*****	1/4" Flat Washer	2
6	*****	1/4-20 x 3-1/2" SHCS	2
7	*****	1/4" Spring Lock Washer	2
8	*****	1/4-20 Hex Nut	2
9	*****	Cable Tie Mount #10	2
10	*****	3/8-16 x 3/4" BHCS	12
11	*****	3/8-16 x 1-1/4" Hex Bolt	2
12	*****	3/8" Flat Washer	2
13	*****	3/8" Lock Washer	2

ITEM	PART NUMBER	DESCRIPTION	QTY.
14	*****	3/8-16 Hex Nut	2
15	*****	10-24 x 3/8" BHCS	6
16	*****	3/8-16 x 1" SHCS	4
17	6400-010	Sill Level Cam	2
18	6400-012	Hinge Bearing Block	2
19	6400-050	Sill Level Sub Plate	2
20	6400-051	Sill Level Flipper Block	2
21	6400-052	Sill Clamp Label	1
22	6400-067	Extension Brace	2
23	6400-079	Guard	1
24	6400-080	Valve Mount	1
25	6400-104	Sill Clamp Weldment	1
26	6400-128	8' Clamp Extension	1

6400-725

WARRANTY PARTS REPLACEMENT POLICY

The following will explain Norfield's policy for handling warranty claims. Our "Limited Warranty" is stated below for your reference.

Our warranty covers the replacement of defective parts; however, the labor to replace the parts on the machine is not included.

Upon notification of a warranty claim, Norfield will either refer the customer to a regional repair facility or replacement parts will be shipped from the factory. Parts shipped from the factory will be invoiced to the customer's account until the warranty claim is verified. To obtain verification, the defective parts must be returned to Norfield within thirty (30) days from the date of the claim for inspection. **Before returning the defective parts, please contact Norfield to obtain a "Return Material Authorization Number"**.

All parts manufactured by Norfield and found to be defective will be given appropriate credit. All parts not manufactured by Norfield are covered by their respective manufacturer's warranty and will be sent to the original manufacturer for credit. When, and if, credit is issued to Norfield, we will in turn issue credit to your account.

LIMITED WARRANTY

Norfield warrants any and all such parts manufactured by them against defects in material or workmanship for a period of two years from the date of purchase. Norfield's liability under this warranty shall be limited to replacing free of charge, F. O. B. Chico, California, any parts proved to be defective within the period of the warranty. Norfield will not be responsible for transportation charges or consequential damages.

Norfield will not in any case or under any circumstances be liable or responsible for any injuries to persons or property suffered as a result of the use or operation of the machine, or losses or costs resulting from any period of non-operation for any reason.

Parts which are claimed to be defective, but show tangible evidence of abuse or negligence will not be replaced on a no-charge basis.

Norfield reserves the right, at its own discretion without notice and without making similar changes in machinery previously manufactured, to make changes in material, design, finish and/or specifications.

Any changes, alterations or installation of additional equipment to this machine without first obtaining written consent from Norfield may void this warranty. Determination of the effect of any alteration on this warranty is left to the discretion of Norfield.

Norfield makes no written or implied warranty with respect to electrical equipment, including motors or other purchased components used in the manufacture of the machine. All such parts are covered by their respective manufacturer's warranty. We do endeavor, at all times, to purchase only those components manufactured by responsible manufacturers which we have found to be reputable in their handling of warranties.

Norfield expressly disclaims any warranty, expressed or implied, other than those which are expressly made in this limited warranty.



