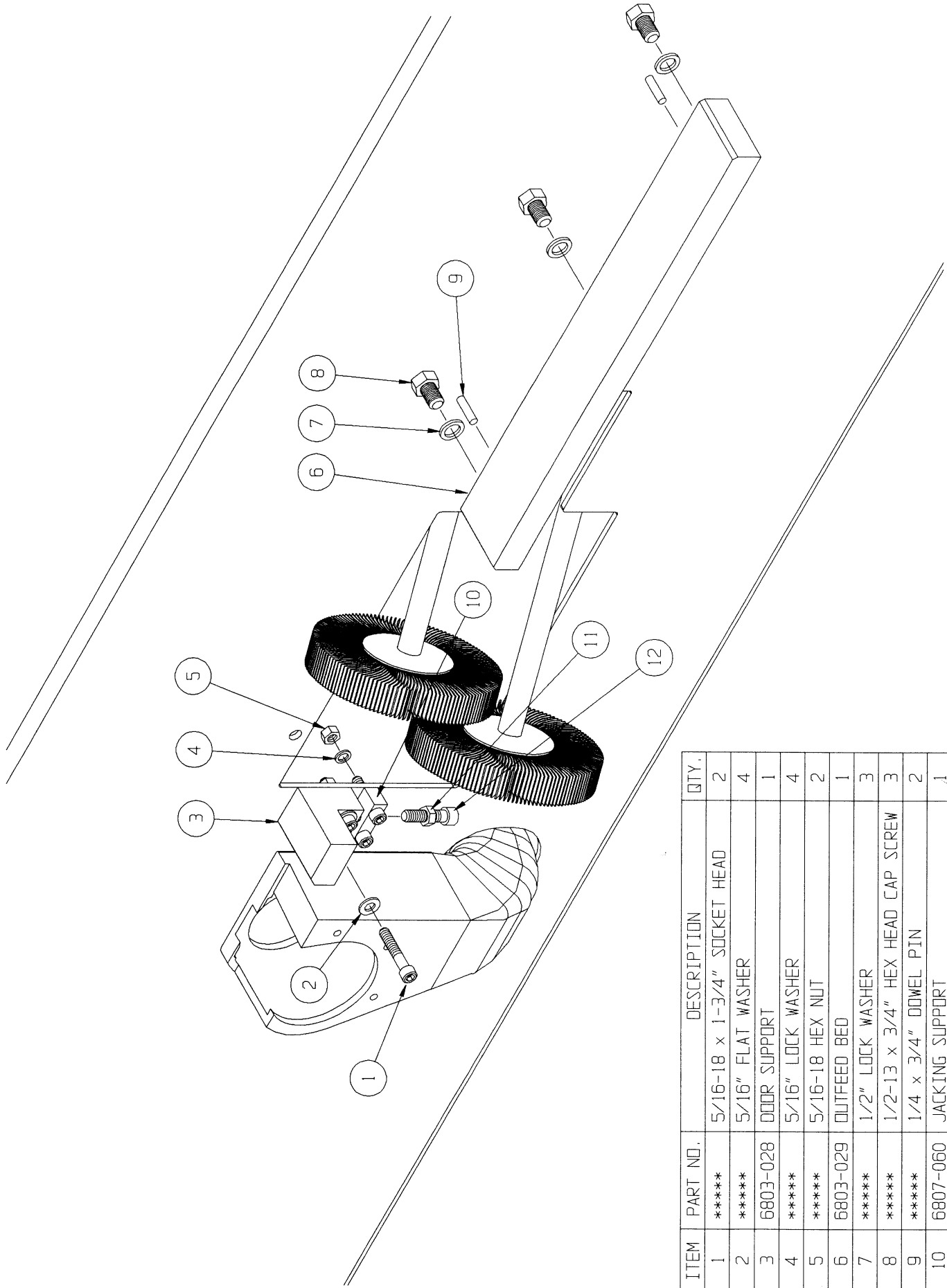


## **'95 MAGNUM SANDER ADJUSTMENT UPGRADE INSTALLATION INSTRUCTIONS**

**CAUTION – DISCONNECT AND LOCK-OUT AIR AND ELECTRICAL POWER FROM THE MACHINE BEFORE PERFORMING THESE MODIFICATIONS.**

**NOTE – DO NOT REMOVE THE OLD OUTFEED BED UNTIL STEP 8 IS ACCOMPLISHED!!!**

1. OPEN THE SIZER GUARD.
2. ON THE OUTFEED POWERFEED ASSEMBLY, REMOVE THE KEEPER AND PIN FROM THE CLEVIS AND SWING THE ASSEMBLY OUT OF THE WAY.
3. ALIGN THE PAPER DRILL TEMPLATE WITH THE CUT-OUT IN THE FRAME AND TAPE THE TEMPLATE IN POSITION. CENTERPUNCH AT THE LOCATIONS PROVIDED.
4. REMOVE THE TEMPLATE AND DRILL THROUGH THE FRAME WITH THE 1/8" DIAMETER PILOT DRILL BIT AT THE CENTERPUNCH MARKS.
5. DRILL THROUGH THE 1/8" DIAMETER PILOT HOLES WITH THE 1 1/32" DIA. BIT.
6. INSTALL THE JACKING SUPPORT ON THE FRAME AND TIGHTEN THE MOUNTING FASTENERS.
7. INSTALL THE DOOR SUPPORT ON THE FRAME BUT DO NOT TIGHTEN THE MOUNTING FASTENERS.
8. PLACE A STRAIGHT EDGE ON THE OUTFEED BED AND CAREFULLY ALIGN THE TOP OF THE DOOR SUPPORT WITH THE BOTTOM OF THE STRAIGHT EDGE BY TURNING THE JACKING BOLT IN THE JACKING SUPPORT. TIGHTEN THE MOUNTING FASTENERS FOR THE DOOR SUPPORT AND THE JACKING BOLT LOCKNUT.
9. REMOVE THE OLD OUTFEED BED.
10. INSTALL THE DOWEL PIN(S) PROVIDED IN THE BACK SIDE OF THE NEW OUTFEED BED. NOTE - MACHINES WITH SERIAL NUMBERS UP TO DJ-2083-95 REQUIRE TWO DOWEL PINS. MACHINES WITH SERIAL NUMBERS DJ-2084-95 AND AFTER REQUIRE ONLY ONE DOWEL PIN INSTALLED IN THE INFEED END (LEFT HAND).



ITEM	PART NO.	DESCRIPTION	QTY.
1	*****	5/16-18 x 1-3/4" SOCKET HEAD	2
2	*****	5/16" FLAT WASHER	4
3	6803-028	DOOR SUPPORT	1
4	*****	5/16" LOCK WASHER	4
5	*****	5/16-18 HEX NUT	2
6	6803-029	OUTFEED BED	1
7	*****	1/2" LOCK WASHER	3
8	*****	1/2-13 x 3/4" HEX HEAD CAP SCREW	3
9	*****	1/4 x 3/4" DOWEL PIN	2
10	6807-060	JACKING SUPPORT	1
11	*****	3/8-16 JAMB NUT	1
12	*****	3/8-16 x 1-1/2" SOCKET HEAD	1

11. INSTALL THE OUTFEED BED TO THE FRAME BY CAREFULLY DRIVING THE DOWEL PIN(S) IN THE OUTFEED BED INTO THE LOCATING HOLE(S) IN THE FRAME . INSTALL AND TIGHTEN THE THREE HEX BOLTS AND LOCKWASHERS. (ON MACHINES WITH SERIAL NO.'S DJ-XXXX-95 AND LATER, A JACKING BOLT SUPPORTS THE RIGHT HAND END OF THE OUTFEED BED. DO NOT RE-ADJUST THE JACKING BOLT UNTIL A TEST DOOR HAS BEEN BEVELED).

12. PLACE A STRAIGHT EDGE ACROSS TOP OF THE NEW DOOR SUPPORT, THE NEW OUTFEED BED, AND THE FIRST ROLLER AND CHECK FOR ALIGNMENT. DO NOT RE-ADJUST ANYTHING UNTIL A TEST DOOR HAS BEEN BEVELED.

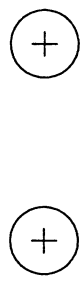
12. REPLACE THE CLEVIS PIN AND KEEPER ON THE POWERFEED ASSEMBLY AND CLOSE THE SIZER GUARD.

13. RE-ENERGIZE THE MACHINE AND BEVEL A TEST DOOR. IF THE BEVELED EDGE IS UNSATISFACTORY REFER TO YOUR OPERATOR'S MANUAL FOR ADJUSTMENTS OR CALL NORFIELD SERVICE @ 916-891-4214.

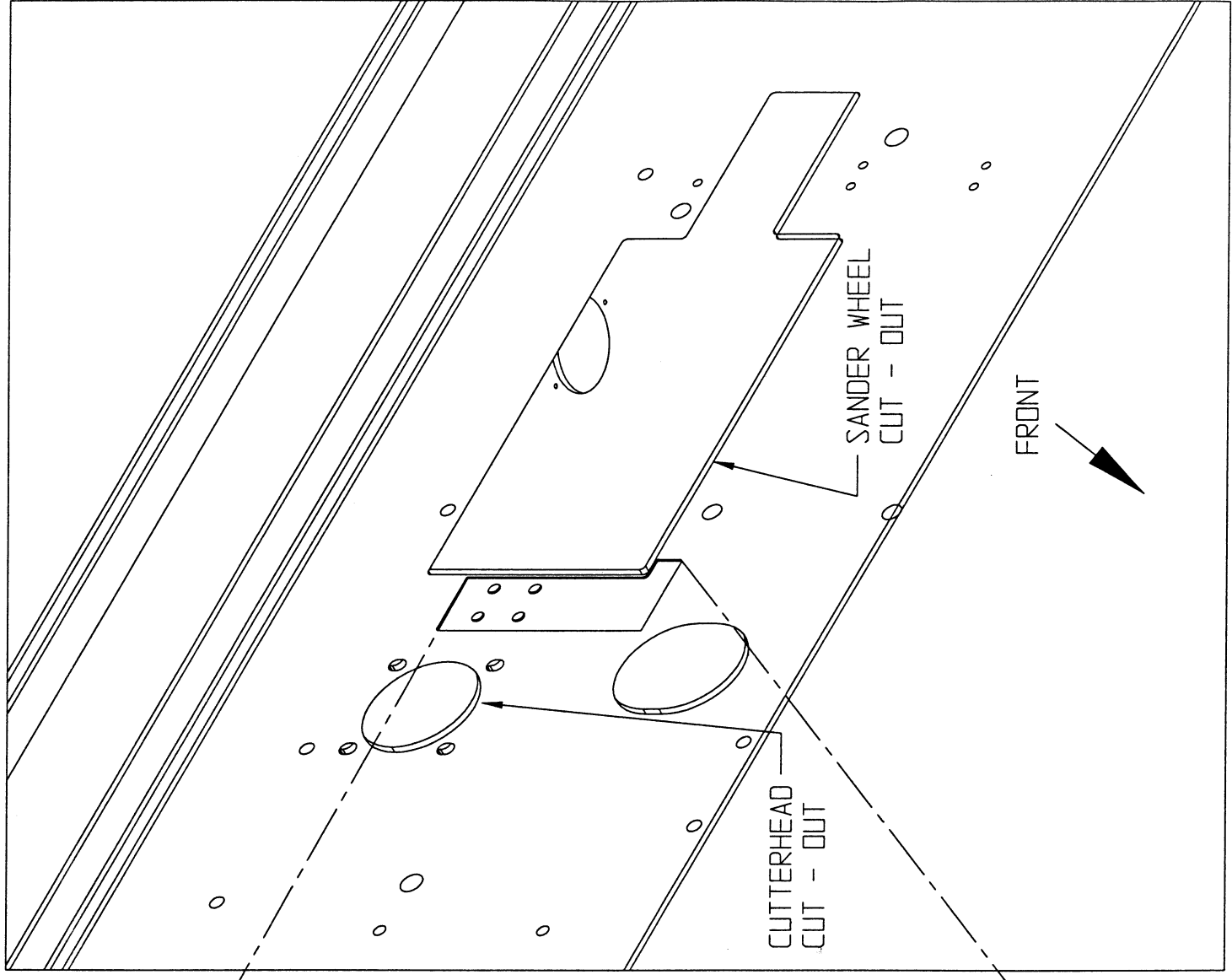
CUT ALONG  
DASHED LINE



$\varnothing$  11/32



ALIGN WITH  
CUT-OUT IN  
FRAME



DRILL TEMPLATE