

MAGNUM DOOR UNLOADER TURNTABLE UPGRADE #SK-68U06-00

PREFACE

This information refers to the installation and setup of the Norfield Magnum Door Unloader Turntable Option. Since the purchase of this upgrade does not include installation by a field technician, it will be necessary to follow these instructions as closely as possible to insure proper operation.

In the unlikely event that you have a problem during this process, you may contact the Norfield Service Department at (800) 824-6242 for technical assistance.

TOOL LIST

To complete the installation and setup of your new Magnum Door Unloader Turntable, you will need a few hand tools. The following list of tools will be necessary.

- 1 One each 1/8", 3/16", 5/16", 1/4" hex key wrenches.
- 2 One each 7/16", 1/2", 9/16 open end wrenches.
- 3 One 1/4" flat blade screw driver

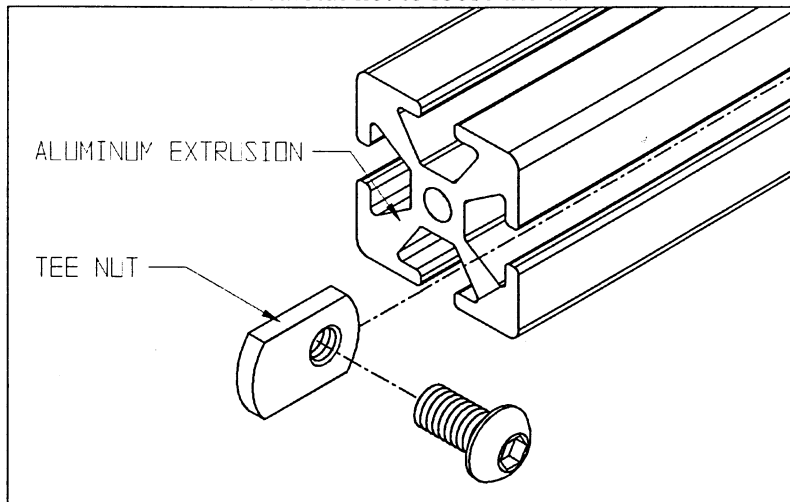
GENERAL SAFETY

DO NOT RISK INJURY

Disconnect all air pressure from the machine when performing this upgrade.

Do not attempt to do this upgrade alone. Handling large and awkward parts by yourself could result in serious back injury.

Note: All of the bolts that attach to the aluminum extrusions are threaded into tee nuts in the slots of the aluminum extrusions. Be careful not to loose them.



DISASSEMBLY

Step 1: Remove roller mount assembly.

- Tilt the unloader into the outfeed position and block it up. Disconnect the air pressure.
- Remove the 8 bolts that hold the roller mount assembly to the tilt pivot weldment. Refer to Fig. 1.
- Lift the roller mount assembly off and set it aside.

Step 2: Remove the tilt pivot weldment.

Remove the shoulder bolt from the cylinder rod end. Loosen the 1" clamp collars and slide them toward the center of the machine. Remove the bottom bolt from each of the bushed pivot blocks and loosen the top one, but do not remove it. Lift the tilt pivot weldment out of the pivot support weldment and remove the bushed pivot blocks and 1" set collars.

Note: The tilt pivot weldment is the only part that will not be reused. Save all other parts for reuse.

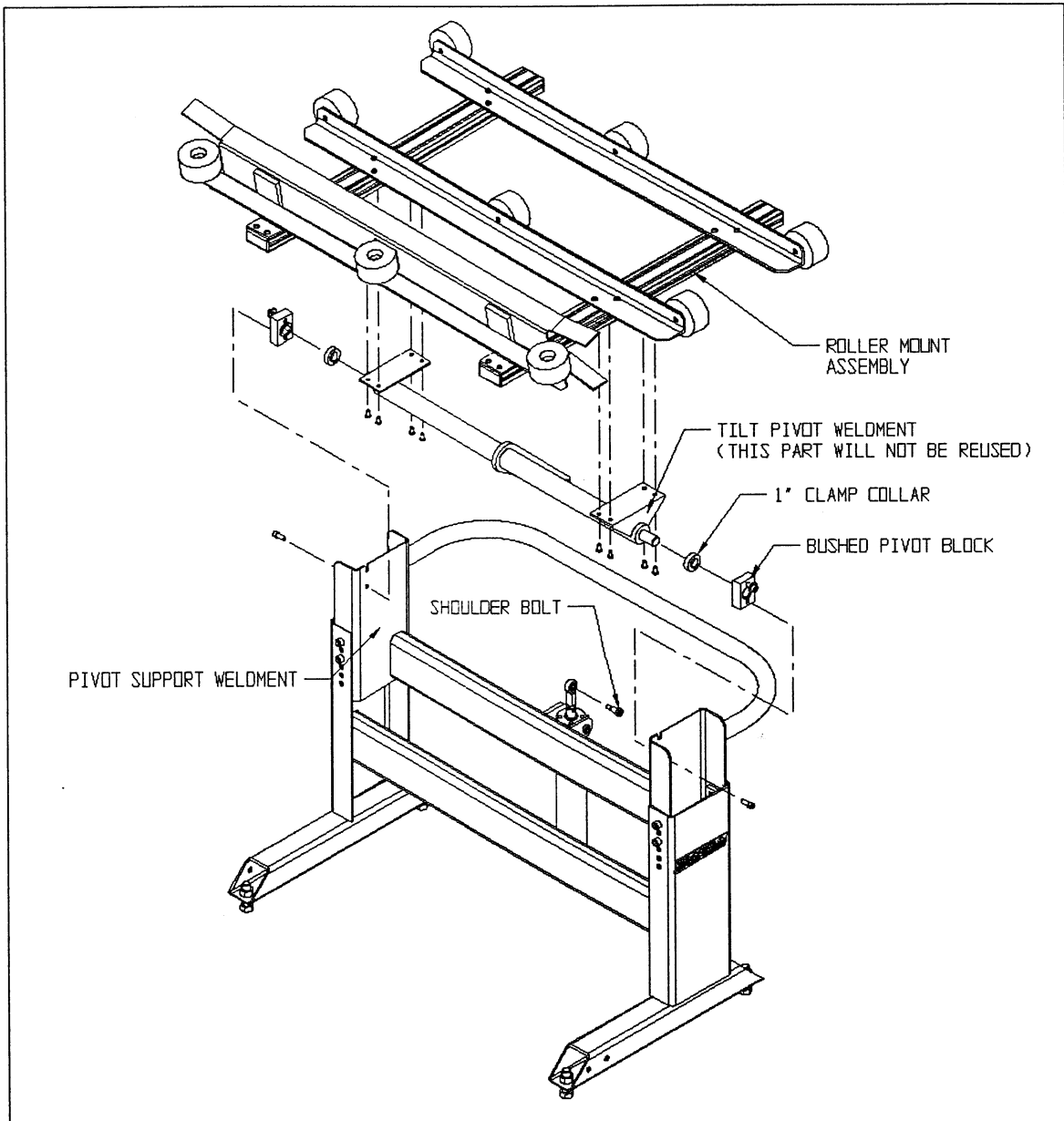


Fig. 1

ASSEMBLY INSTRUCTIONS

Step 1: Install new tilt pivot weldment.

Locate the new tilt pivot weldment and install the 1" clamp collars and the bushed pivot blocks on to the shaft ends as shown in Fig 2.

Note: There should be one bolt with flat washer in both bushed pivot blocks.

Lower the tilt pivot weldment into the pivot support weldment sliding the bolts into the slots with the washers outside of the pivot support weldment. Install the bottom bolt in the bushed pivot blocks and tighten them. Install the shoulder bolt through the cylinder rod end into the control arm on the tilt pivot weldment.

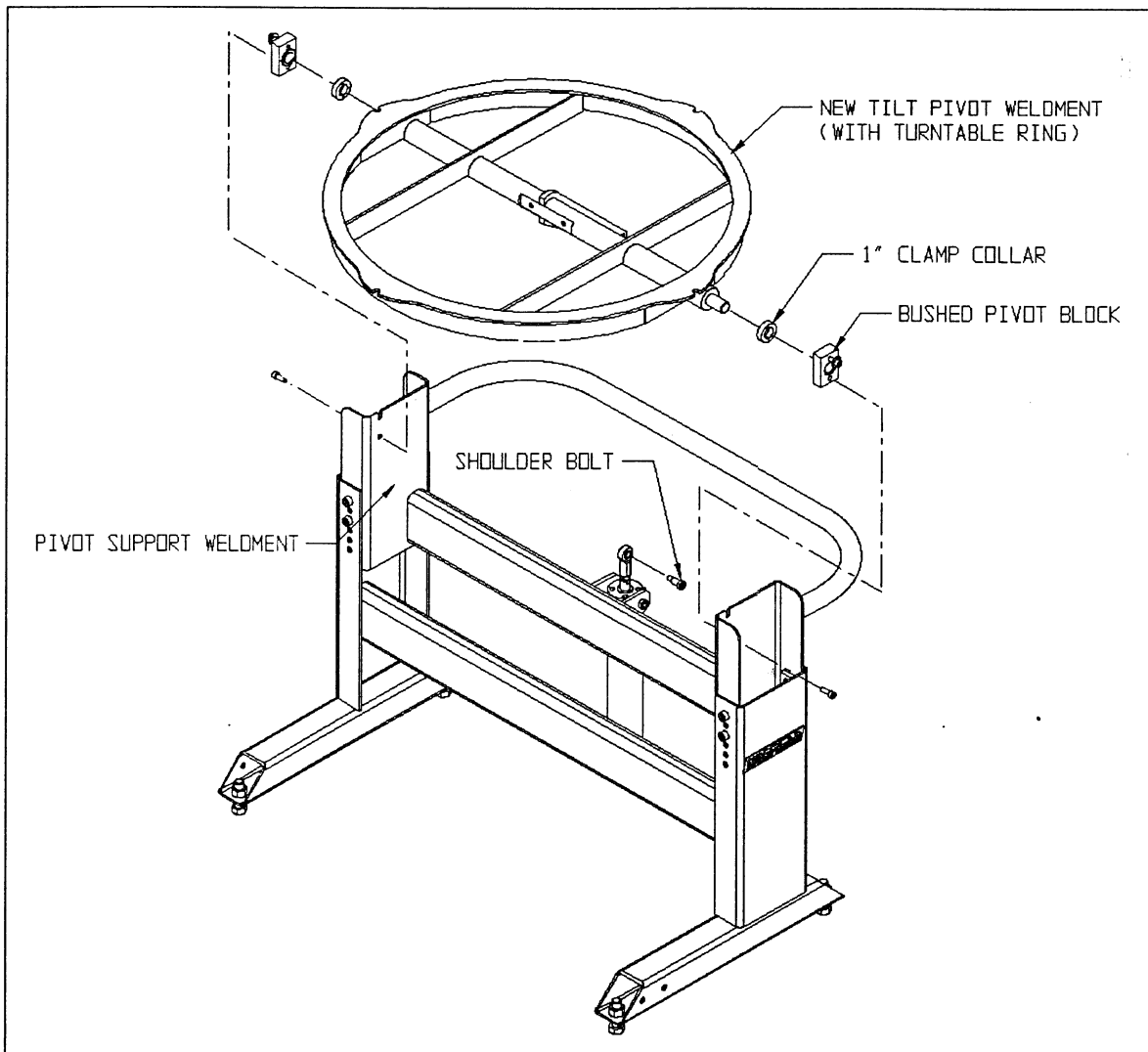


Fig. 2

Step 2: Assemble the rotator assembly.

Mount the pivot shaft support to the two aluminum extrusions as shown in Fig 3. Install the 4 corner wheel mounts positioning the edge of the angle about 1/4" to 3/16" from the end of the aluminum extrusion. Insert the wheel and one 1/4" flat washer into the slot on the corner wheel mount and insert the 1/4"x 1 1/4" shoulder bolt through the wheel, washer and wheel mount. Secure shoulder bolt with a #10 flat washer and nut.

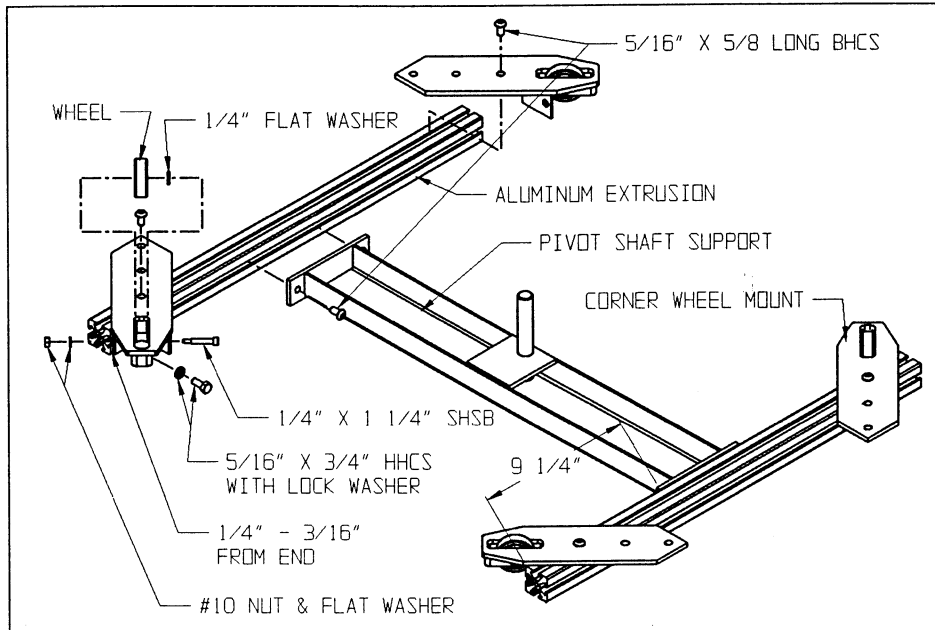


Fig. 3

Step 3: Adjust rotator assembly.

Turn on the air pressure and set the machine in the outfeed position. Place the rotator assembly on the turntable support ring as shown in Fig. 4.

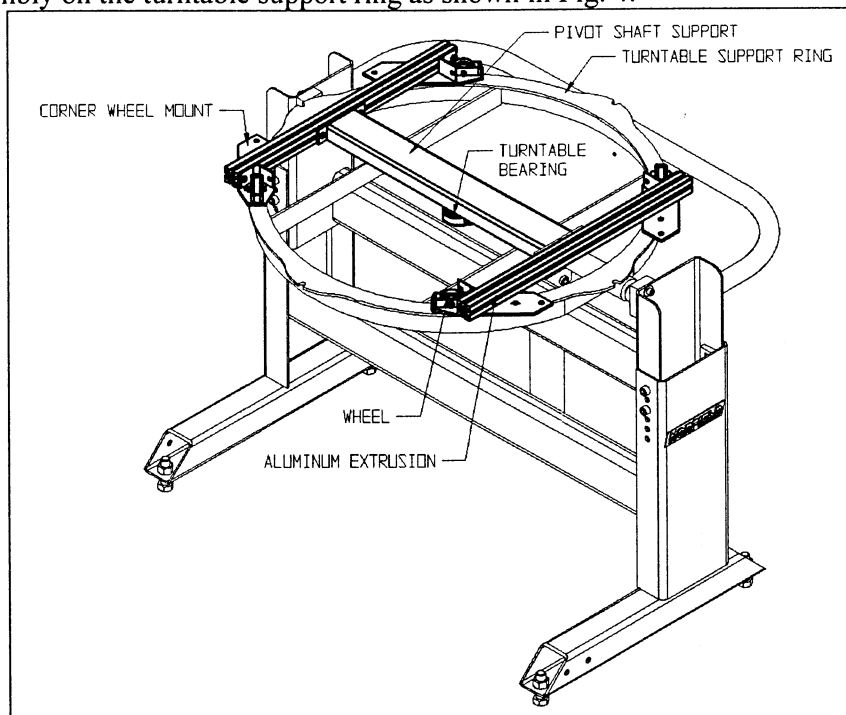


Fig. 4

Install turntable bearing as shown in Fig. 5. Rotate the rotating assembly, all 4 wheels should stay completely on the turntable support ring. If they do not, adjust the position of the turntable bearing, the aluminum extrusions, and the corner wheel mounts until the rotator assembly can be rotated all the way around with all 4 wheels completely on the turntable support ring. Install and lock the bearing lock collar.

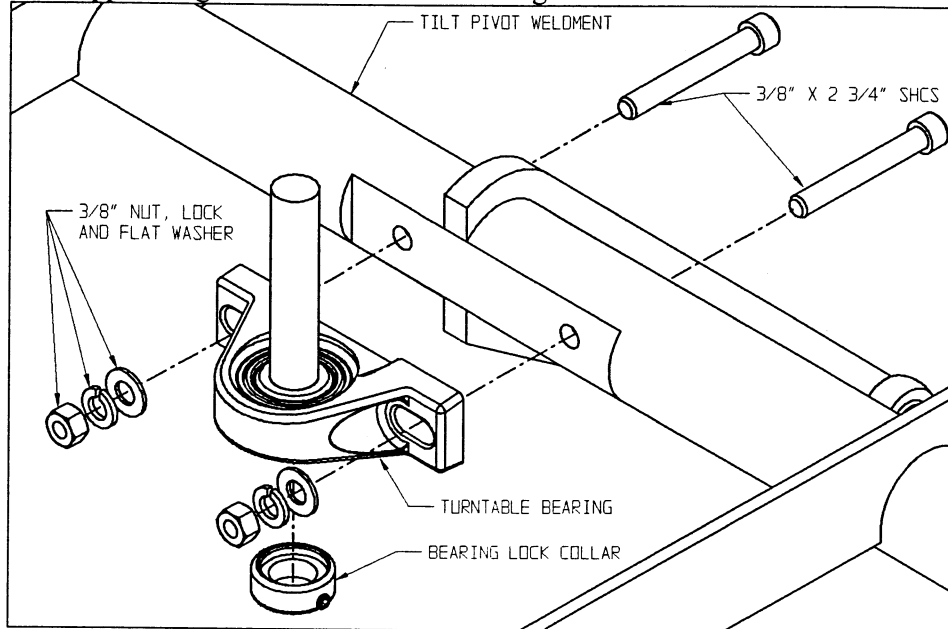


Fig. 5

Step 4: Assemble pivoting unit.

Position the roller mount assembly face down on a work surface. Remove the rotator assembly from the tilt pivot weldment and insert it into the roller mount assembly as shown in Fig 6.

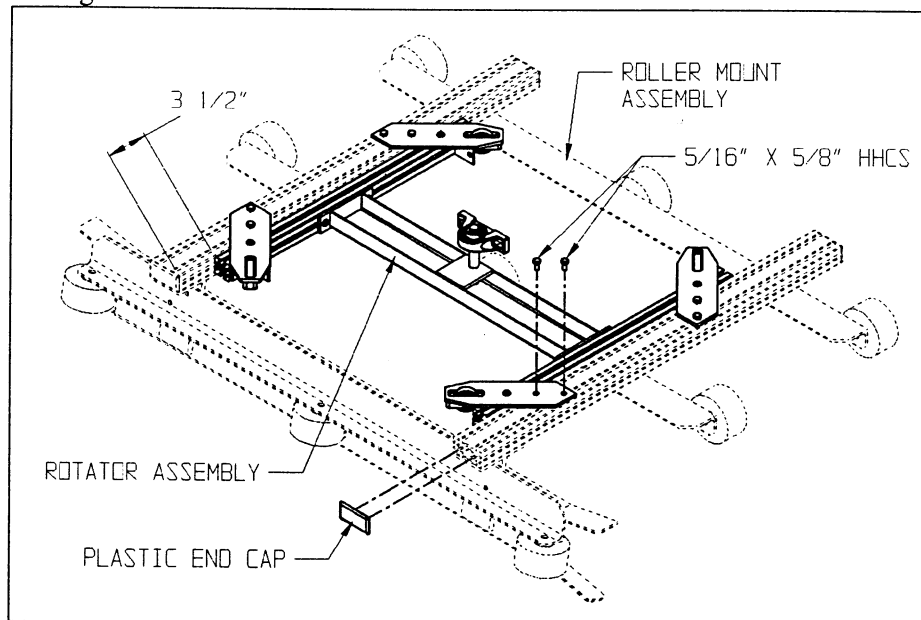


Fig. 6

Step 5: Install pivoting unit.

Turn the pivoting unit right side up and set it on the tilt pivot weldment as shown in Fig. 7.

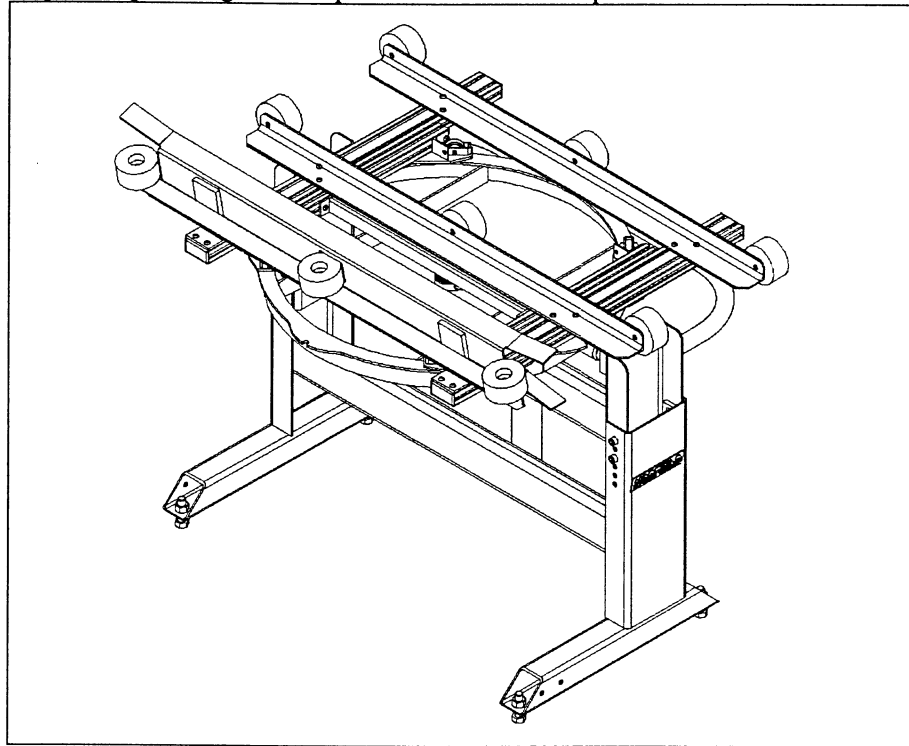


Fig. 7

Bolt the turntable bearing to the tilt pivot weldment as shown in Fig. 5. Rotate the pivoting unit to be sure the wheels stay completely on the turntable ring.

Step 6: Adjust the infeed height.

The outfeed height should be the same as before the upgrade. If it is not, adjust the 4 leg bolts accordingly. Operate the foot pedal to tilt the Unloader into the infeed position.

Caution: Stand clear of the machine as it tilts.

Move the pivoting unit so that it is level with the Magnum rollers and transfer rollers. The infeed height is adjusted by loosening the eight (8) bolts that fasten the large aluminum extrusions to the corner wheel mounts. **Helpful Hint:** Do not loosen all eight of the bolts when the machine is in the infeed position. With the machine in the infeed position measure and note the amount of adjustment needed. Rotate the tilt frame into the outfeed position, loosen all eight bolts and make the adjustment that you noted earlier. Tighten two of the bolts at each end and rotate the tilt frame back to the infeed position. Check the height. Repeat this procedure as many times as needed.

Step 7: Assemble the latch.

Locate one of the four latch brackets and install the 3/16" x 3/4" roll pin in the corner hole. **Note:** All four of the latch brackets are the same, but only one of them needs this pin. Locate the latch spring tab and mount it to the latch bracket (that has the corner pin) using the 1/4" x 1/2" shoulder bolt and nut. As shown in fig. 8.

Attach the latch link to the latch dog using the 3/16" x 3/4" dowel pin. Install the latch dog onto the latch bracket. Be sure to insert the pin on the latch link through the hole in the latch spring tab. Slide another latch bracket onto the other end of the latch dog. Install the spring over the roll pin in the corner of the latch bracket and the pin of the latch link.

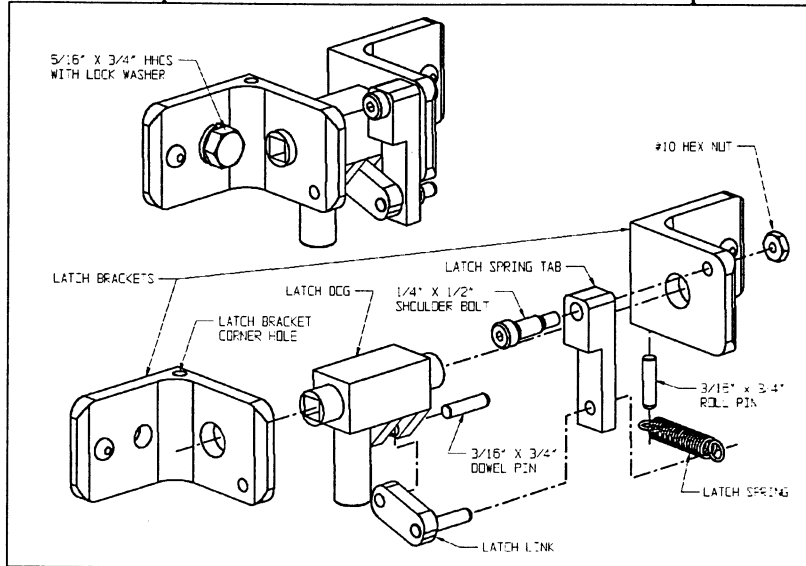


Fig. 8

Step 8: Install the latch assembly.

Mount the latch assembly, from step 7, to the side of the large aluminum extrusion. Use two 5/16" hex head bolts and lock washers. Refer to fig 9. The latch dog should be in the notch on the turntable ring. Adjust the latch assembly by sliding it along the aluminum extrusion until the pivot assembly is square with the frame. Tighten the bolts and check to see that the latch dog will move freely.

Note: If it will be more convenient for the operator, the latch assembly can be mounted on the other side of the machine.

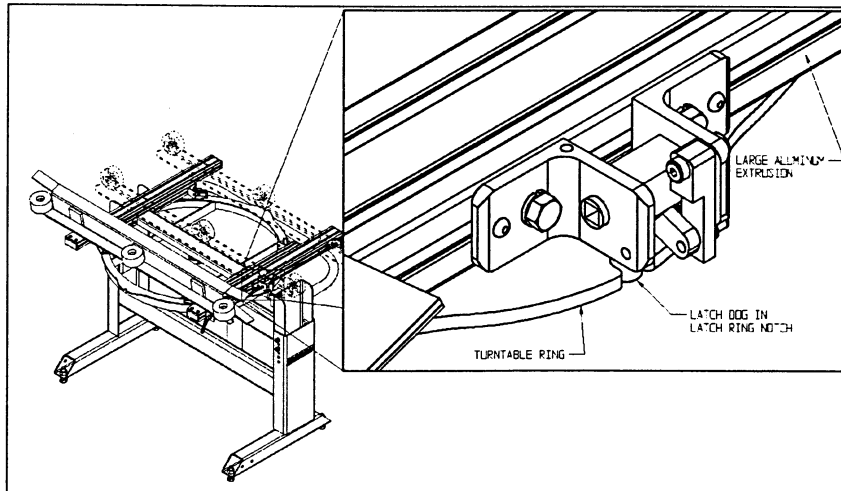


Fig. 9

Step 9: Assemble the latch handle.

Install the 5/16" hex bolt through the hole in the latch bracket and thread it into the tee nut. Do not tighten it at this time. Thread a 5/16" nut onto one end of the square rod as far as it will go. Slip the spacer over the threads on the square rod and insert it into the large hole in the latch bracket, as shown in Fig. 10. Install the 5/16" flat washer over the threads and thread the handle on as far as it will go. Hold the handle with a flat blade screwdriver and tighten the nut.

Note: The rotational relationship of the handle and the square rod can be changed by pushing on the screwdriver slot with your thumb while pulling on the handle. This will disengage the handle and allow it to be repositioned.

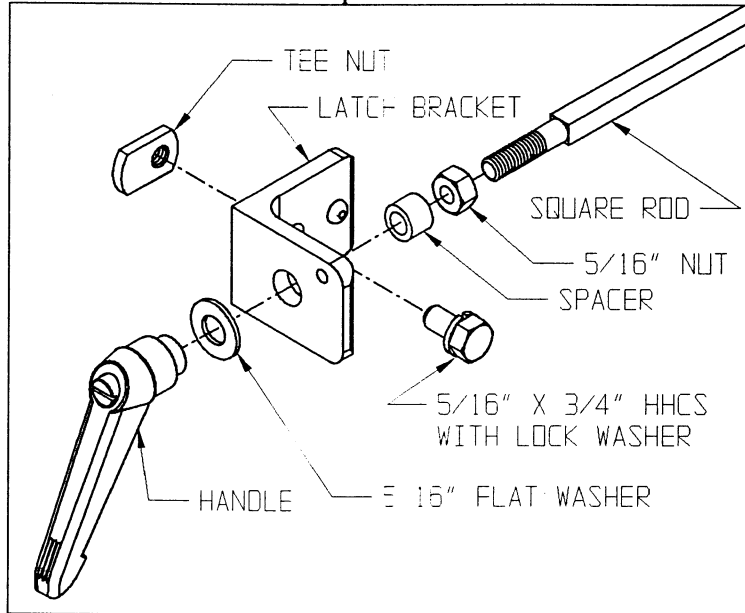


Fig. 10

Step 10: Install the handle assembly.

Insert the square rod into the square hole in the latch dog, as shown in Fig. 11. Carefully push the square rod through the latch dog and slide the tee nut into the slot on the side of the large aluminum extrusion. Continue to slide the handle assembly through until the other end of the square rod extends past the end of the aluminum extrusion.

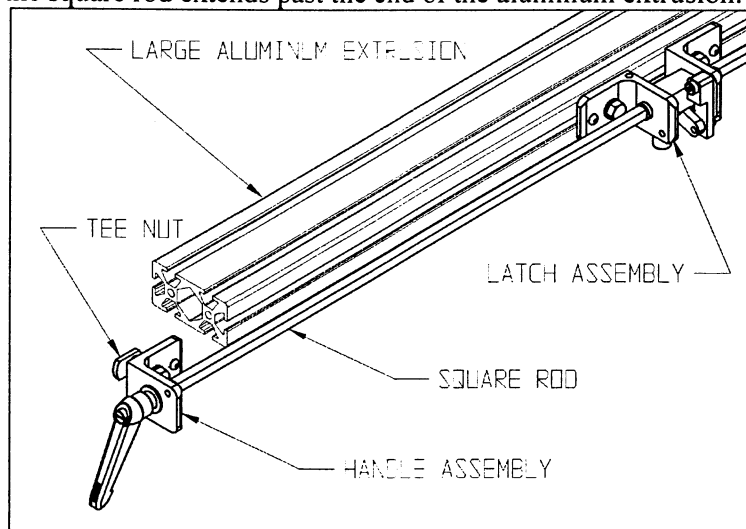


Fig. 11

Assemble the other handle assembly, using the instructions in step 9.
Slide the completed handle assembly back until the tee nut is in the slot on the large aluminum extrusion and the handle assembly is centered on the aluminum extrusion.
Refer to Fig. 12.

Note: The handle assemble can be closer to one end of the aluminum extrusion if it is more convenient for the operator.

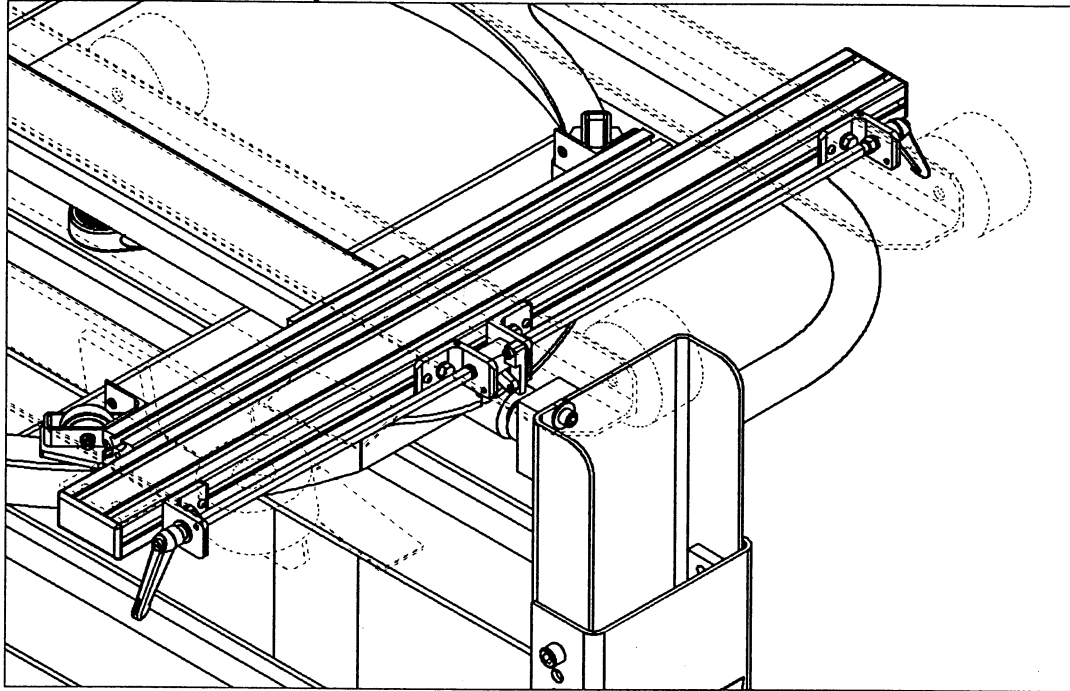


Fig. 12

FASTENER DESCRIPTIONS

<u>ABBREVIATION</u>	<u>DESCRIPTION</u>		<u>DIMENSION</u>
SHCS	SOCKET HEAD CAP SCREW		DIA. x L
BHCS	BUTTON HEAD CAP SCREW		DIA. x L
SHSB	SOCKET HEAD SHOULDER BOLT		DIA. x L
FHCS	FLAT HEAD CAP SCREW		DIA. x L
HHCS	HEX HEAD CAP SCREW		DIA. x L
SS	SET SCREW		DIA. x L SET

FASTENER.PRT

OPERATING INSTRUCTIONS

The foot pedal of the Magnum Door Unloader can be located anywhere it is convenient for the operator and is not a trip hazard. Turn on the main air supply.

CAUTION: Stand clear of the machine when you first turn on the air, as the tilting frame may move suddenly.

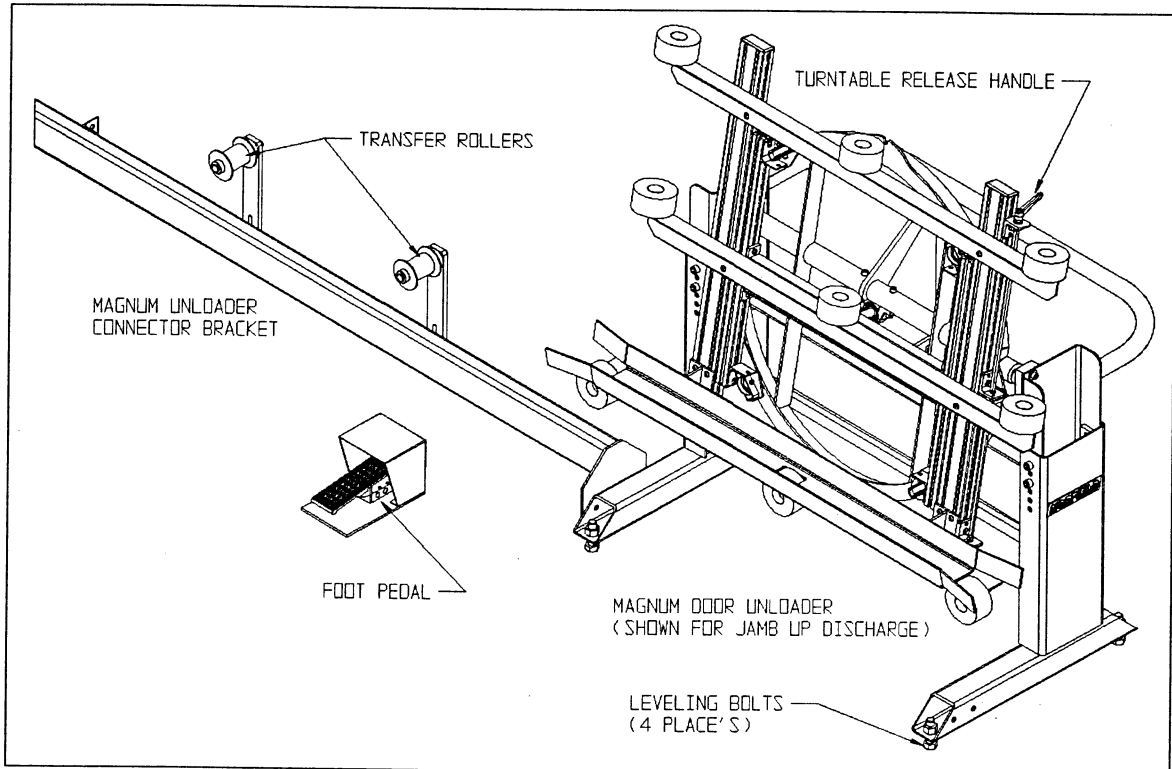


Fig. 4-1

When the treadle on the foot pedal of the Unloader is parallel with the floor, the tilt frame of the Unloader should move to a position parallel with the floor. This is the outfeed position. When the treadle is tilted down, the tilt frame of the Unloader should also tilt down. This is the infeed position.

With the Unloader in the infeed position, roll the completed door out of the Magnum, over the transfer rollers, and onto the Magnum Door Unloader. Position the door roughly centered on the Unloader tilt frame and allow it to rest on the top & center roller sets.

Stand clear of the moving parts of the Unloader and tilt the machine into the outfeed position.

With the Unloader in the outfeed position the operator may rotate either of the turntable release handles and rotate the door in either direction.

If the handle is rotated less than 50° it will spring back to the latched position when released and the turntable will latch when the turntable is rotated to the next latch position. To deactivate the latch rotate the turntable release handle until it springs up to the unlatched position. The door may then be rotated freely in either direction. To reactivate the latch rotate the turntable release handle in the opposite direction until it springs into the latch position. The turntable will latch when the turntable is rotated to the next latch position.

When the door is in the desired position roll the door out of the Unloader. Rotate the turntable back to the normal position and tilt the Unloader back to the infeed position.

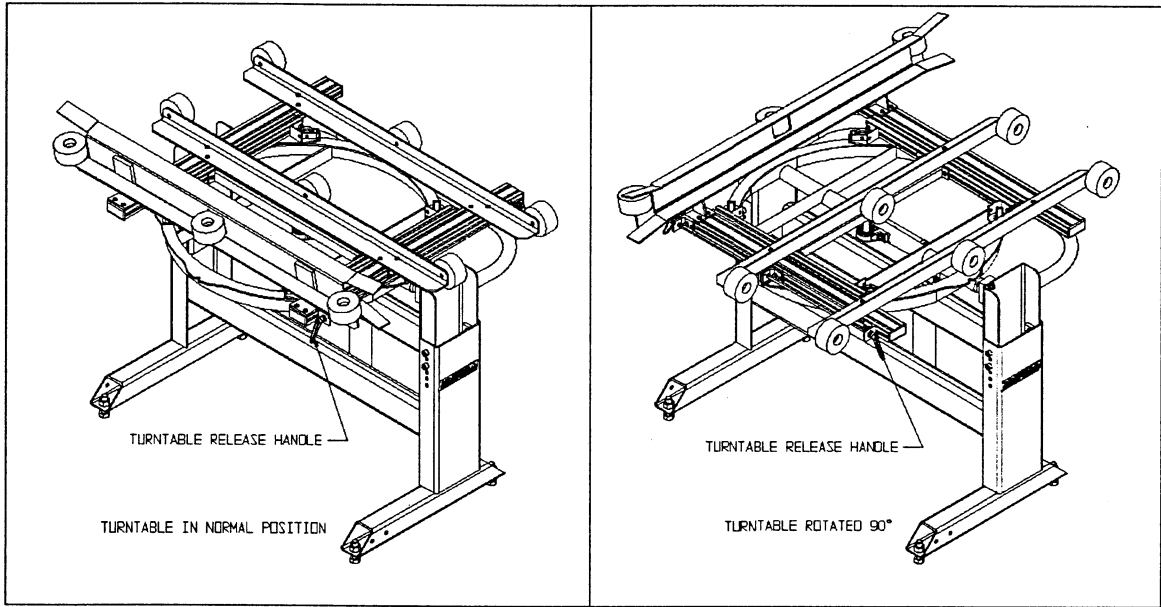


Fig. 4-2

Thank you for buying a Norfield Magnum Door Unloader. We hope that it gives you many years of trouble free service. When you do need parts or technical assistance you may call us at (800) 824-6242.