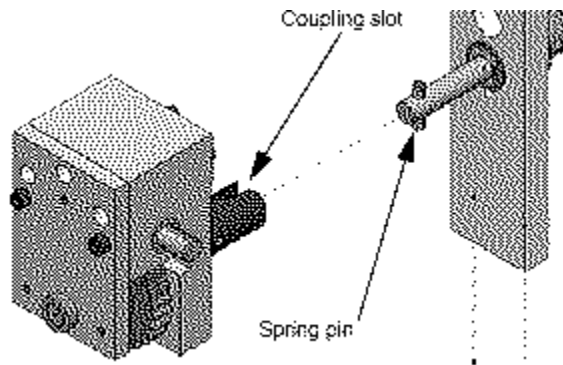
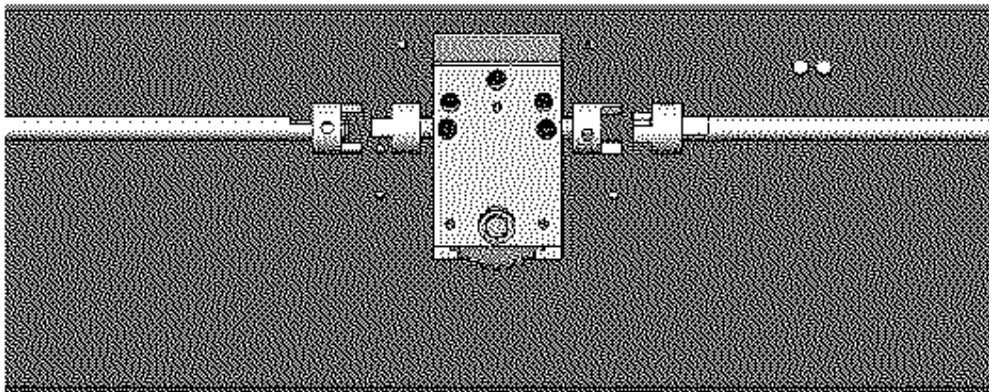


The acceptable range of the rail width parallelism is $\pm .050$ " at the gantries and $\pm .020$ " at the lead screws. This is achieved when the rail is driven all the way out to maximum width and then all the way to a determined set point approximately 1/2 the width, then at full closed, then again at full open. All of the measurements should be within the acceptable range mentioned above. Measurements should be taken at all of the points starting with onlead screw, 1st gantry, intermediate lead screw, second gantry, and finally the offload lead screw. If at any point in the measurement these are off, the rail could be out of parallel or the backlash isn't set correctly or one or more of the couplers is loose or out of adjustment.



6.23. Parallel the edge rails



Disconnect the coupling on each side and turn the worm gear shaft by hand to adjust.

Measure each assembly (end assemblies and intermediates) to find out which assemblies need adjusting so that the rails will be parallel within .040 inch. To ensure that you take up the backlash, move the conveyor width approximately two inches past the position you wish to adjust to. Then move it back in the direction you need to adjust. For example, if an assembly is too narrow, move the conveyor in two inches past the board width you are adjusting to. Then move the conveyor width in the out direction to the width of the board you are using. Disconnect the assembly that needs adjustment and continue to turn the worm gear shaft in the same direction that they were just moving until you reach your adjustment. Then just hook up the worm gear and test.