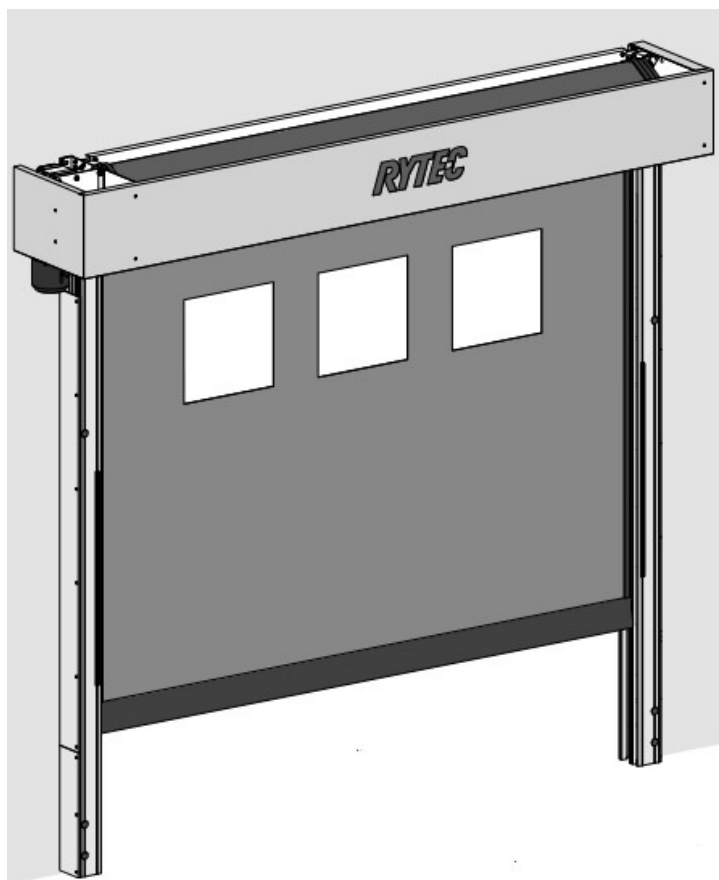


Summary	Replacing a panel on a FlexTec™				
Products Affected	FlexTec™				
Key Word Tags					
Tools/Equipment (If Required)	Allen wrenches, drill, 3/16 drill bit, rivet gun, wrenches, large zipties, rope, or strap, Forklift, scissor lift, or ladder				
Parts/Materials (If Required)	Panel, Rivets 3/16 by 1/2				
Related Media					
Author	Sam Last	Issue Date		Status	

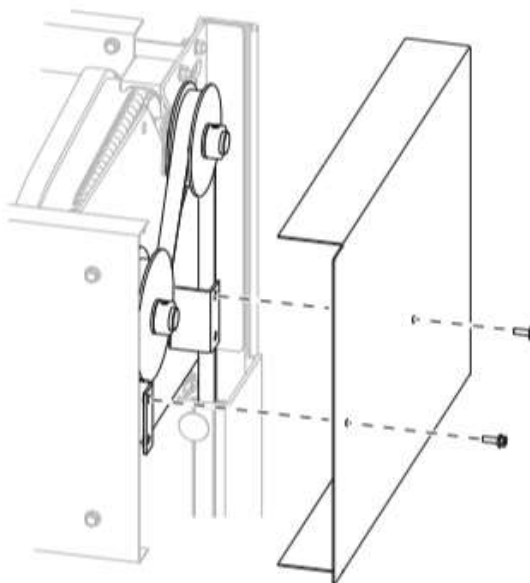
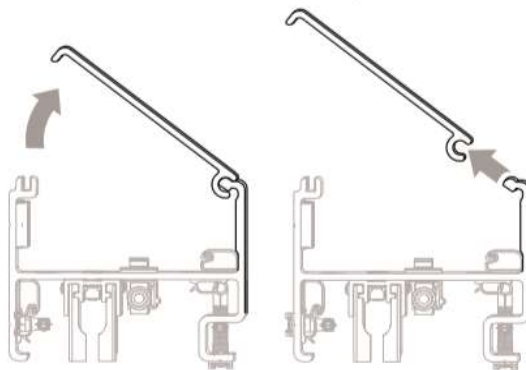
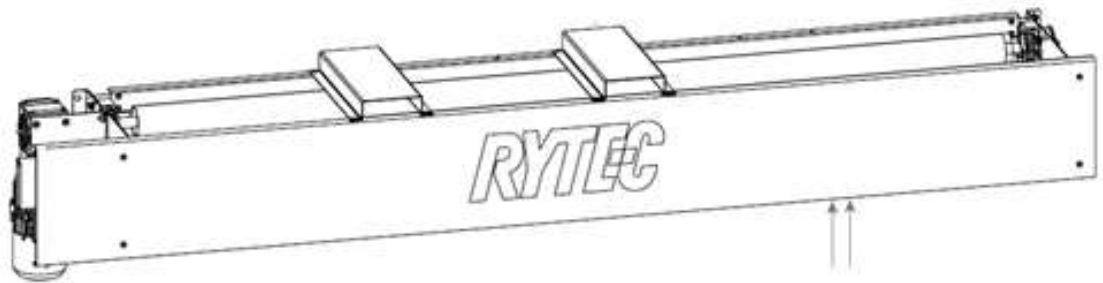
Please Read The Entire Bulletin Before Proceeding

If you have any questions please contact Rytec Customer Support at 1-800-628-1909.

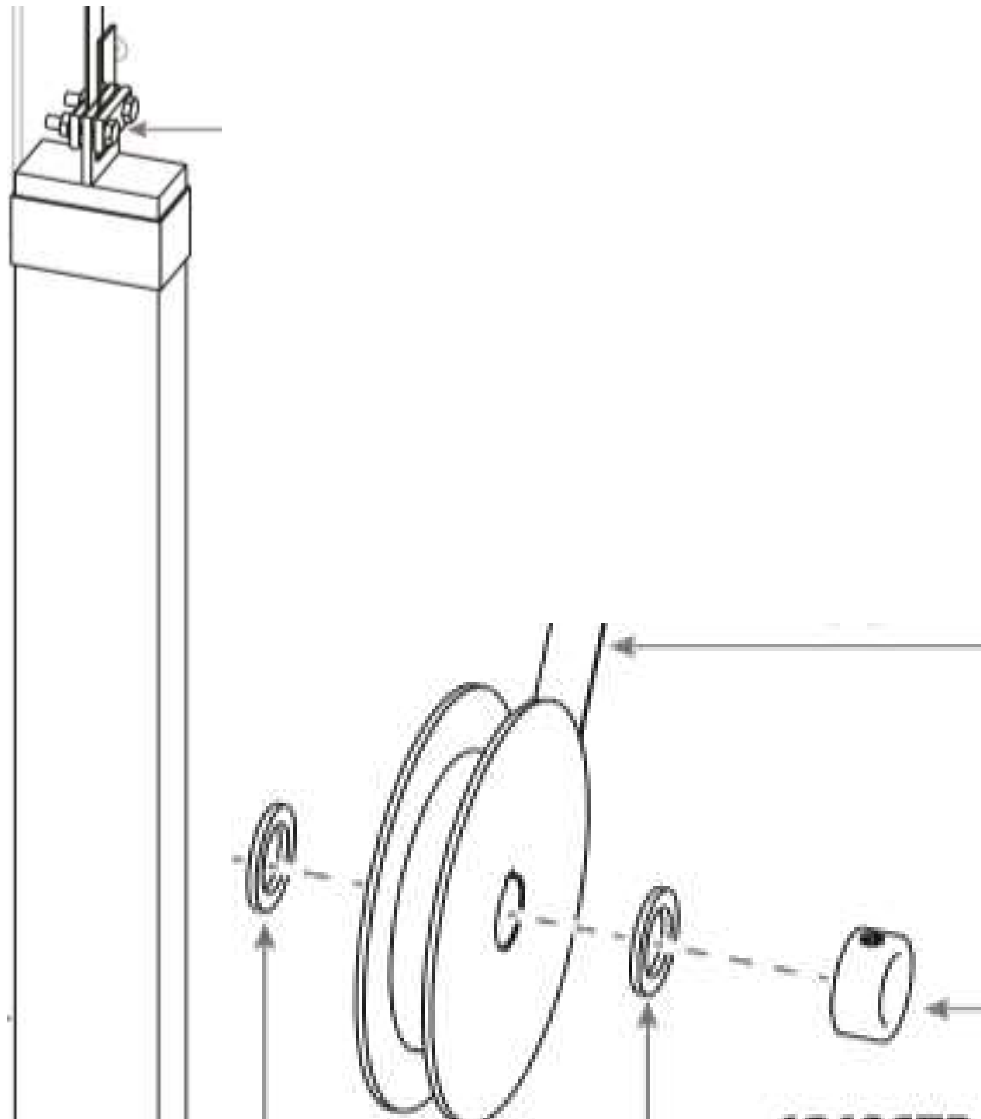
Below you will find detailed instructions necessary to replace the panel on a FlexTec™ door.



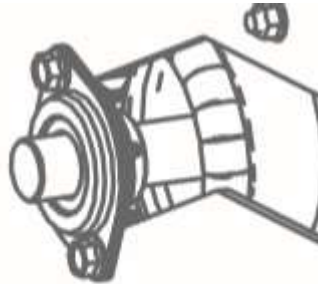
1. Place the controller in emergency jog by setting parameter 980 to the value of 3.
2. Remove the front covers from the head assembly, the side belt cover, and the non-drive side column cover.



3. Measure across the head plates so that you can verify once the new panel is installed everything is still square.
4. In emergency jog run the door panel up and out of the sprockets, once this is done zip tie, or tie the panel around the drum so that it will not unravel.
5. Remove the counterweight and the counterweight spool from the drum shaft.



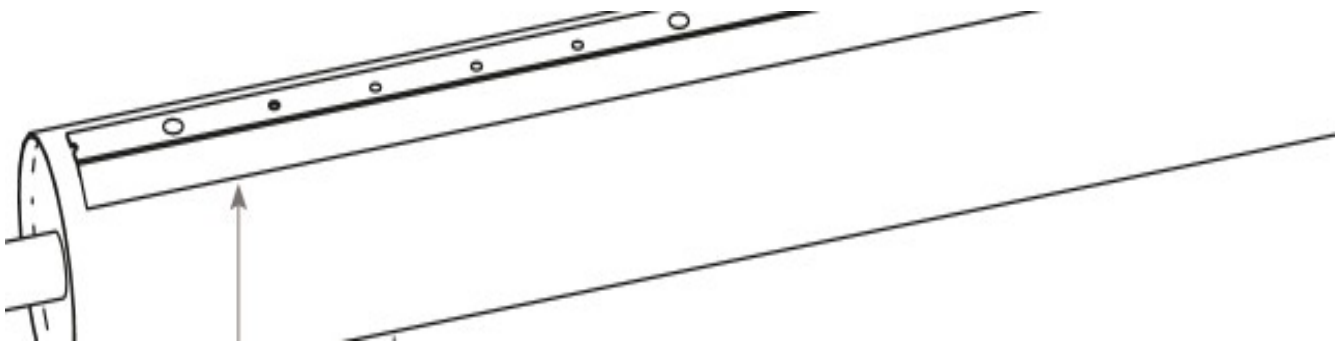
6. Position a forklift under the panel and the drum. Remove the bolts that hold the drum bearings to the head assembly.



7. Raise and back the forklift to remove the drum and panel assembly from the head of the door.

8. Find a clean area to place the drum and panel.

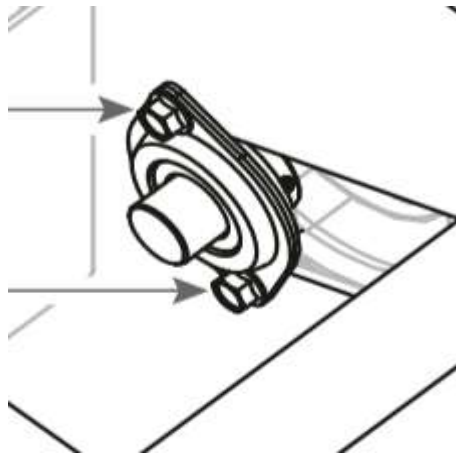
9. Remove the ties and unroll the panel assembly exposing the rivets.



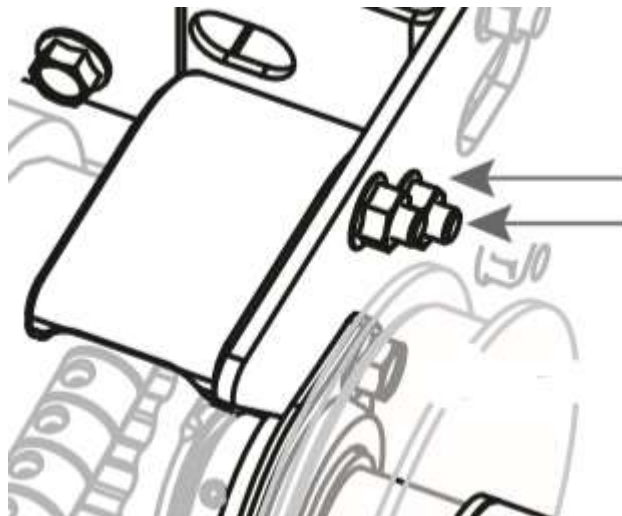
10. Drill out the rivets from the panel strap, remove the old panel.

11. Roll out the new panel on the clean surface making sure that it is laid out the same way as the old panel.

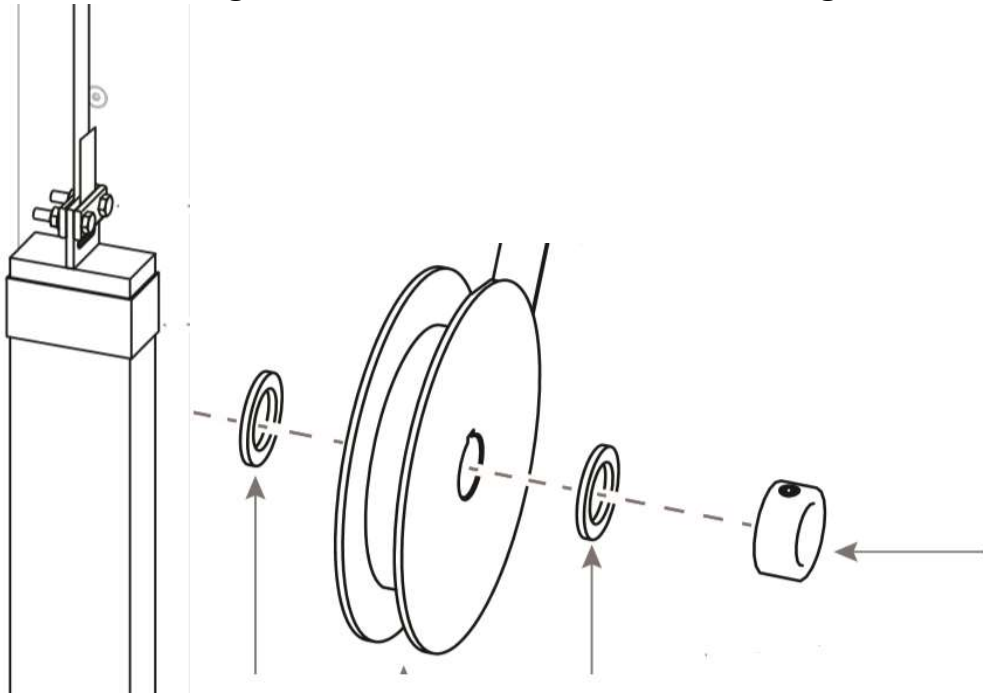
12. Using the panel strap as a template position it $\frac{3}{4}$ of an inch in from each end of the panel and mark your rivet holes and then drill them out.
13. Attach the new panel to the drum and roll it up and place a new tie around it to keep it from coming undone.
14. Raise the panel and drum into position with a forklift and replace the same way it was removed making sure the bearing flanges are on the outside of the head plates and bolt them back in. Measure between the head plates to verify that the measurements still match the originals.



15. Loosen the top blocks one side at a time and feed 4 of the panel teeth and tighten them back down.



16. Replace the counterweight spool, and replace the counterweight, the counterweight needs to be 8 inches from the ground.



17. Jog the door down in emergency jog and then back to the full open position and re-adjust the counterweight so it is 8 inches from the ground if needed.
18. Verify that the panel is still even in the guides, this can be done by counting the exposed teeth on the top of the head while the door is fully closed.
19. Replace all of the covers that were removed, set parameter 980 back to 0, set parameter 210 to 5, and reset the door limits.

