

PLASMATIC™

Bridge Squaring Procedure



Tools Needed

Metric Allen Wrench Set

13mm Socket & Wrench

13mm Box Wrench



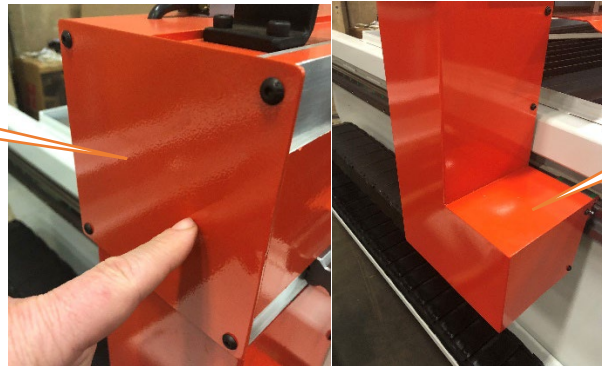
Start with moving the bridge close to the home position.

Now shut down all power to the table.



Now let's remove the housing cover and access plate from each side of the bridge.

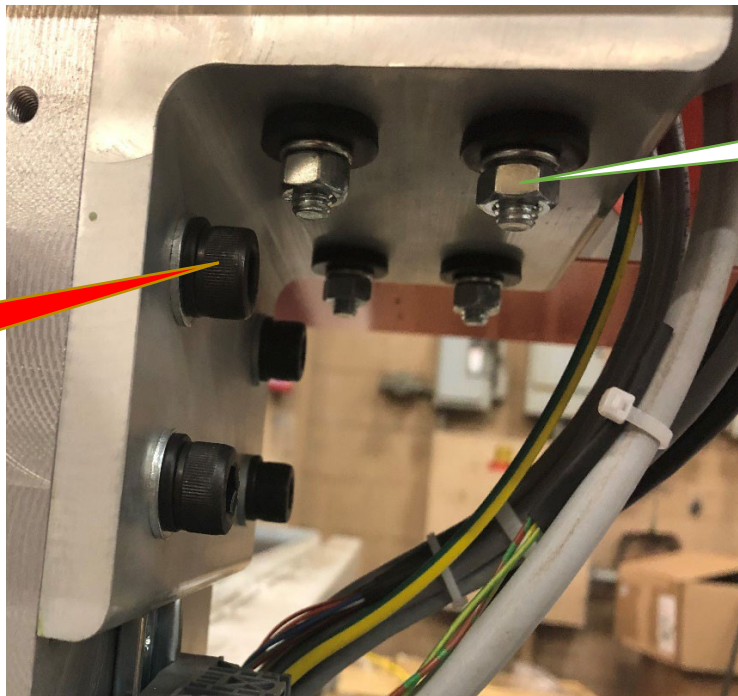
Access plate



Housing Covers

Once those have been removed find the 4- 13mm nuts and bolts that secure the bridge to L- Bracket as seen in the picture below.

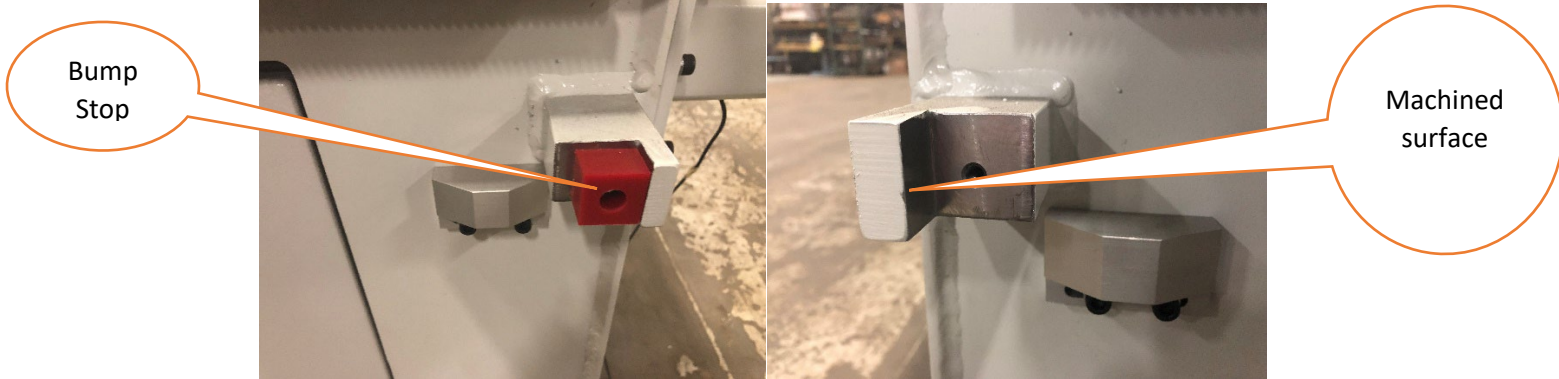
Not the Allen head bolts



13mm nuts and bolts

Using both the 13mm socket and the box wrench go ahead and **loosen** but **do not** remove the 4 bolts from each side of the table. (8 total)

Next using a 5mm allen wrench go ahead and remove the bump stops on both sides of the table. This will expose a pre-machined squaring surface.

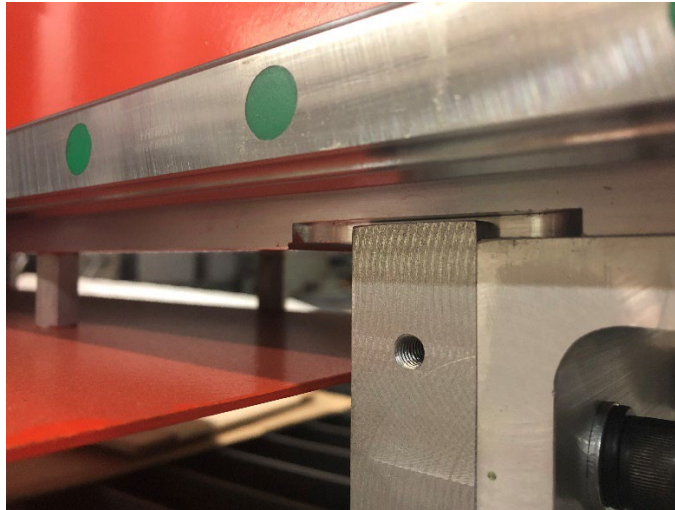


Since the powers been remove the bridge can move freely. Pull the bridge gently towards the front of the table to engage the housing surface to the squaring block. As seen in the picture below.



Ensure that both sides are touching with no gaps.

There are 2 pre-machined slots located on the front face of the bridge where the bridge meets the housing L-Bracket. These are there to square the bridge to the housings. The bottom squaring blocks square the housings to the table.



Ensure contact to all 4 machined surfaces.

Once established tighten the 13mm bolts trying hard not to move the bridge while doing so.

Once they're all tight push the bridge back off the squaring blocks and ensuring the limit switches are behind the trip dogs.

Limit
Switch



Trip dog

At this point your bridge should be square. Go ahead and put the bump stops and covers back on then power up the table. Please contact our Service Department if you have any questions (216) 267-1818 ex 213

