

SEPTEMBER 2005
Alignment Procedure

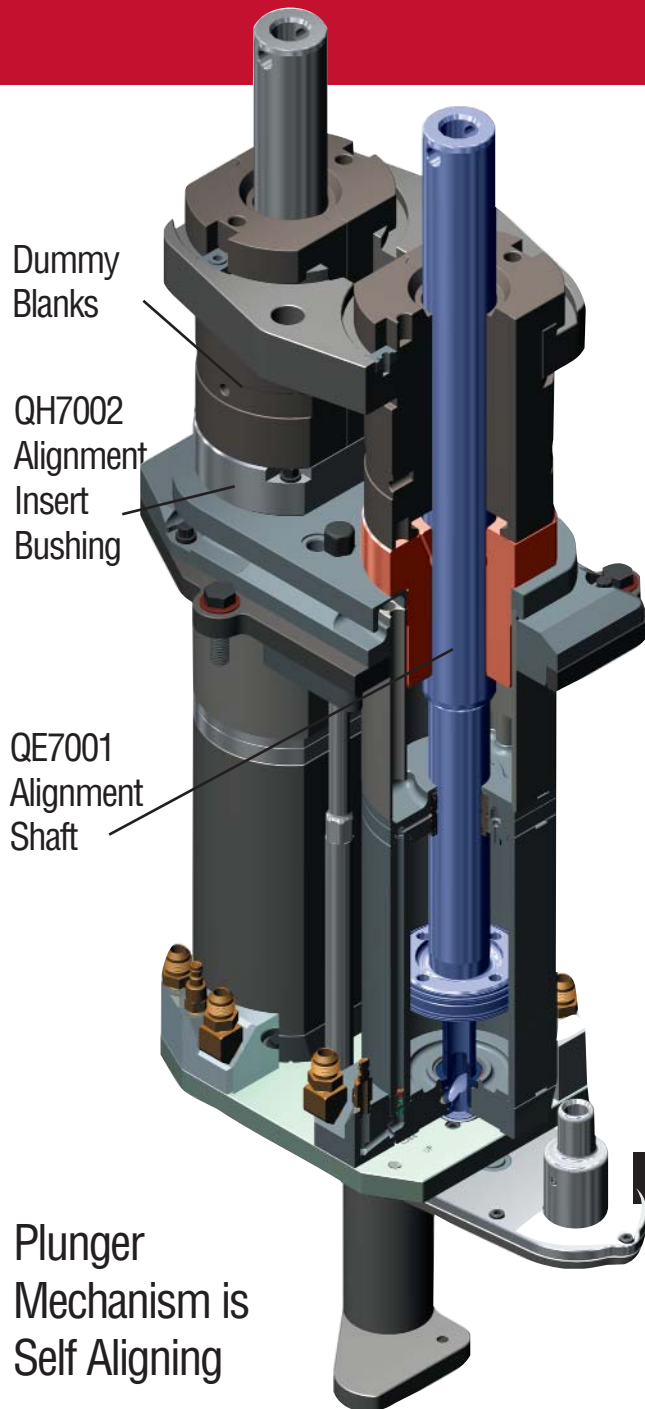


ALIGNMENT PROCEDURE



438 Saxonburg Boulevard | Saxonburg, PA 16056 USA | Tel (724) 352-5100 | Fax (724) 352-4443
quantum@quantumforming.com | www.quantumforming.com

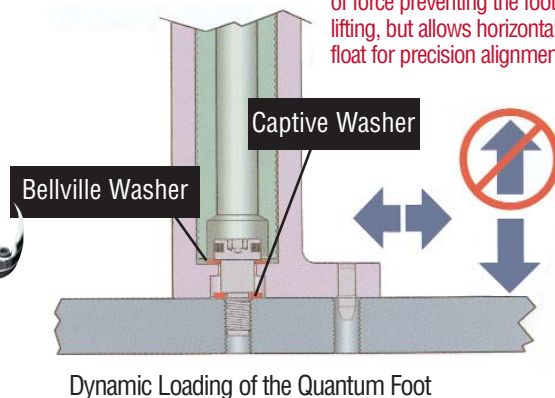
Machine Interface



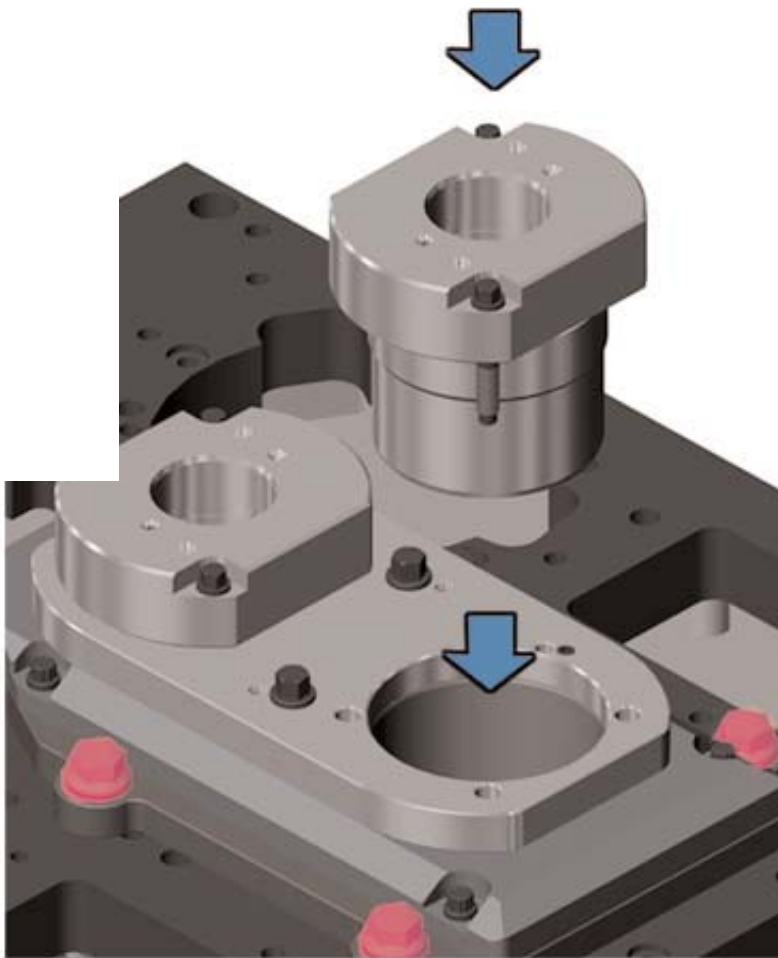
Fits any I.S. Machine maker Configuration

- Totally enclosed lift mechanisms. No wobble when changing container size.
- Pin and clevis engagement will not slip out of position during adjustment.
- Drive assembly is separate from saddle/port block assembly.
- Foot can be precision aligned or floated with dynamic loading.
- All gears are protected from glass contamination. Frequent job changes are easy and precise.
- Gear train prelubed for life of machine.
- No exhaust gases to “cook” the gears.
- Anti-friction coating on all working pieces.

The captive bolt and Belleville washer provide over 790# (359kg) of force preventing the foot from lifting, but allows horizontal float for precision alignment.



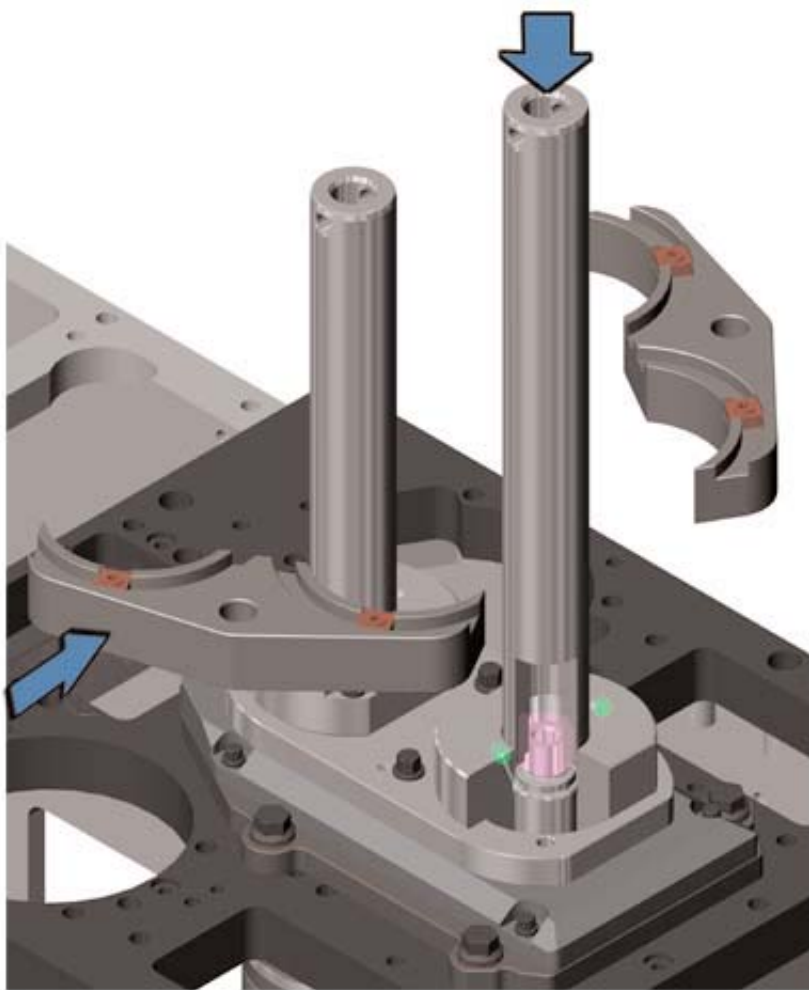
Step 1:



1. Remove the standard blank, neckring, plunger, and plunger adapter.
2. Loosen the four permanent alignment plate screws which bolt directly to the machine top (**highlighted**)
3. Install the special dummy alignment plate bushing.
4. Bring Plunger to Full up.



Step 2:

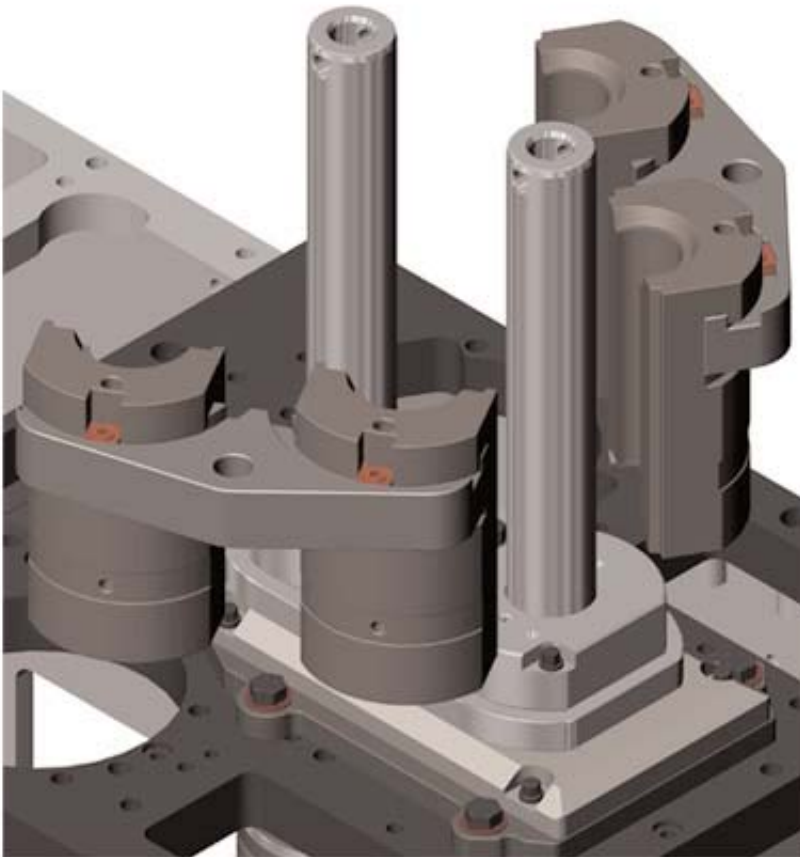


1. Place the alignment shaft through the bushing.
2. Thread the shaft onto the plunger cylinder piston rod. **(highlighted)**
3. Add lubrication through holes in alignment bushing. **(highlighted)**

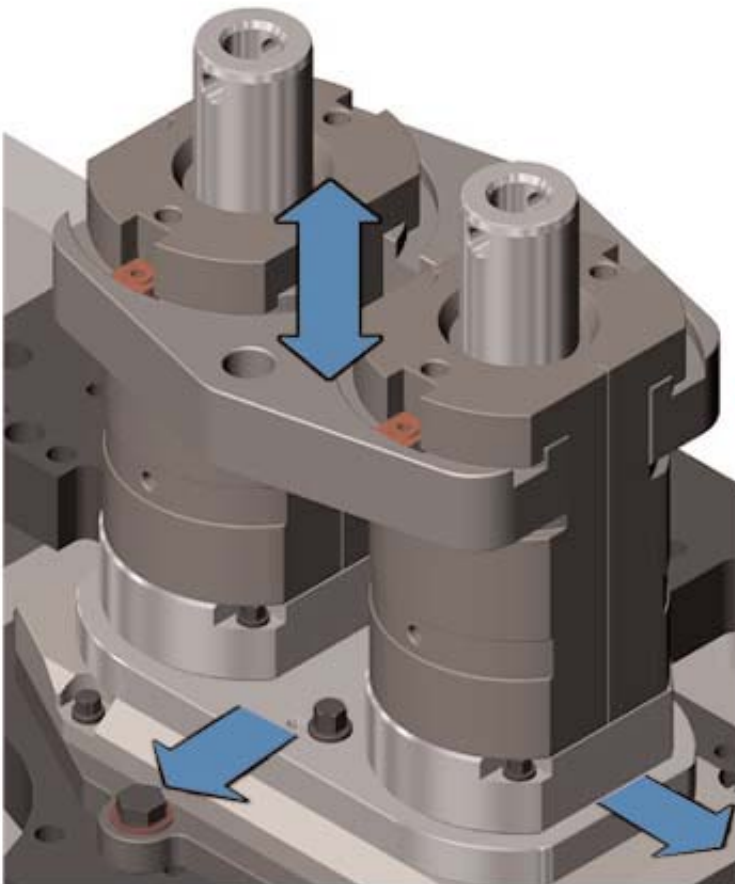


Step 3:

1. Hang special Dummy Blanks on to Blank Inserts.
2. Close the Blank



Step 4:



1. Using manual override, operate the plunger cylinder up and down several times.
2. Take the piston rod to its full down position. Snug the permanent alignment plate screws and repeat step one.
3. In an alternate fashion, secure the 4 permanent alignment plate screws.
4. Bring the piston rod to full up and turn off plunger up air. The alignment shaft should move smoothly to the down position with slight hand pressure. If not, repeat previous steps to find the source of the interference.

