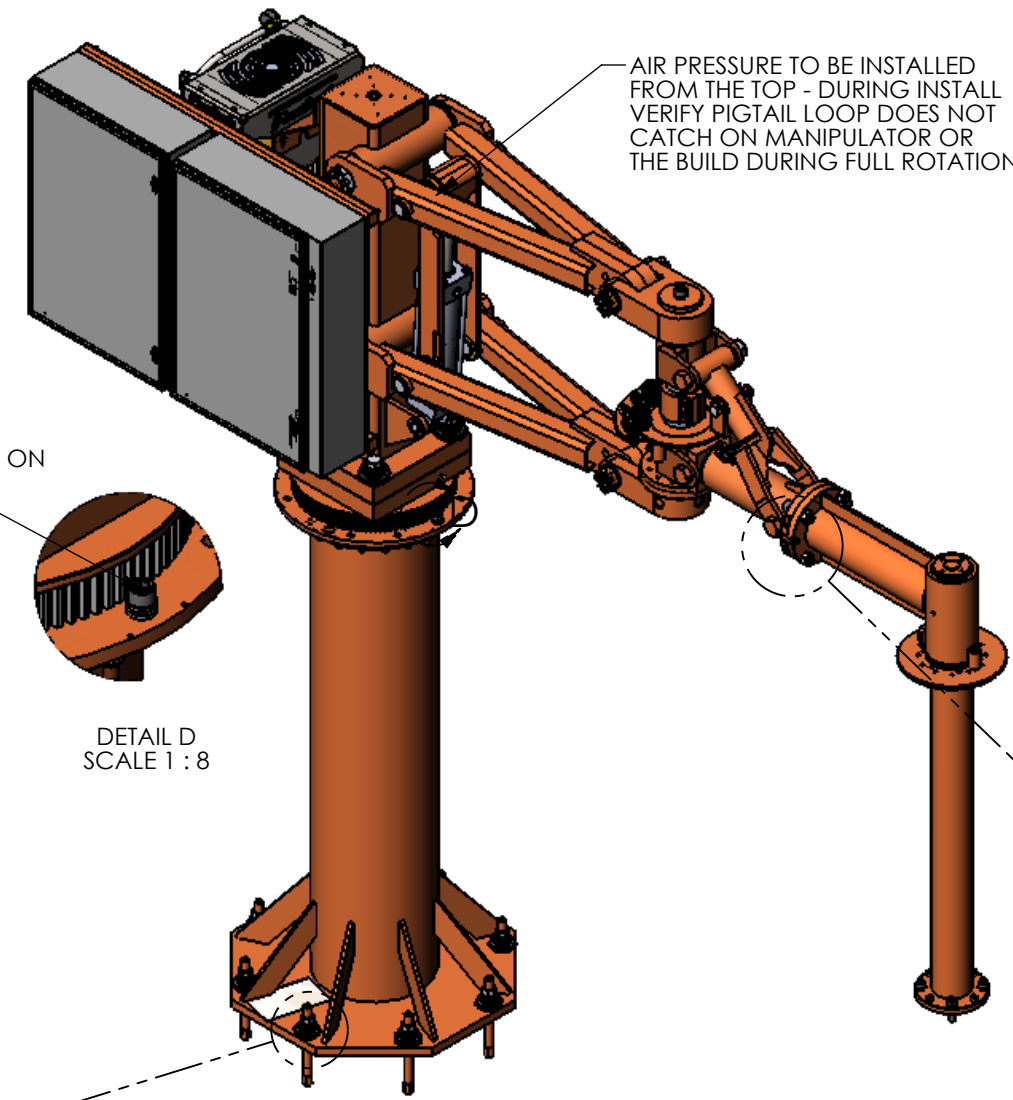


AIR PRESSURE TO BE INSTALLED FROM THE TOP - DURING INSTALL VERIFY PIGTAIL LOOP DOES NOT CATCH ON MANIPULATOR OR THE BUILD DURING FULL ROTATION

480/60/3 POWER TO BE INSTALLED FROM THE TOP - DURING INSTALL VERIFY PIGTAIL LOOP DOES NOT CATCH ON MANIPULATOR OR THE BUILD DURING FULL ROTATION

5/8 ALLEN HEX ON STOP BOLTS (3/4 SHCS)

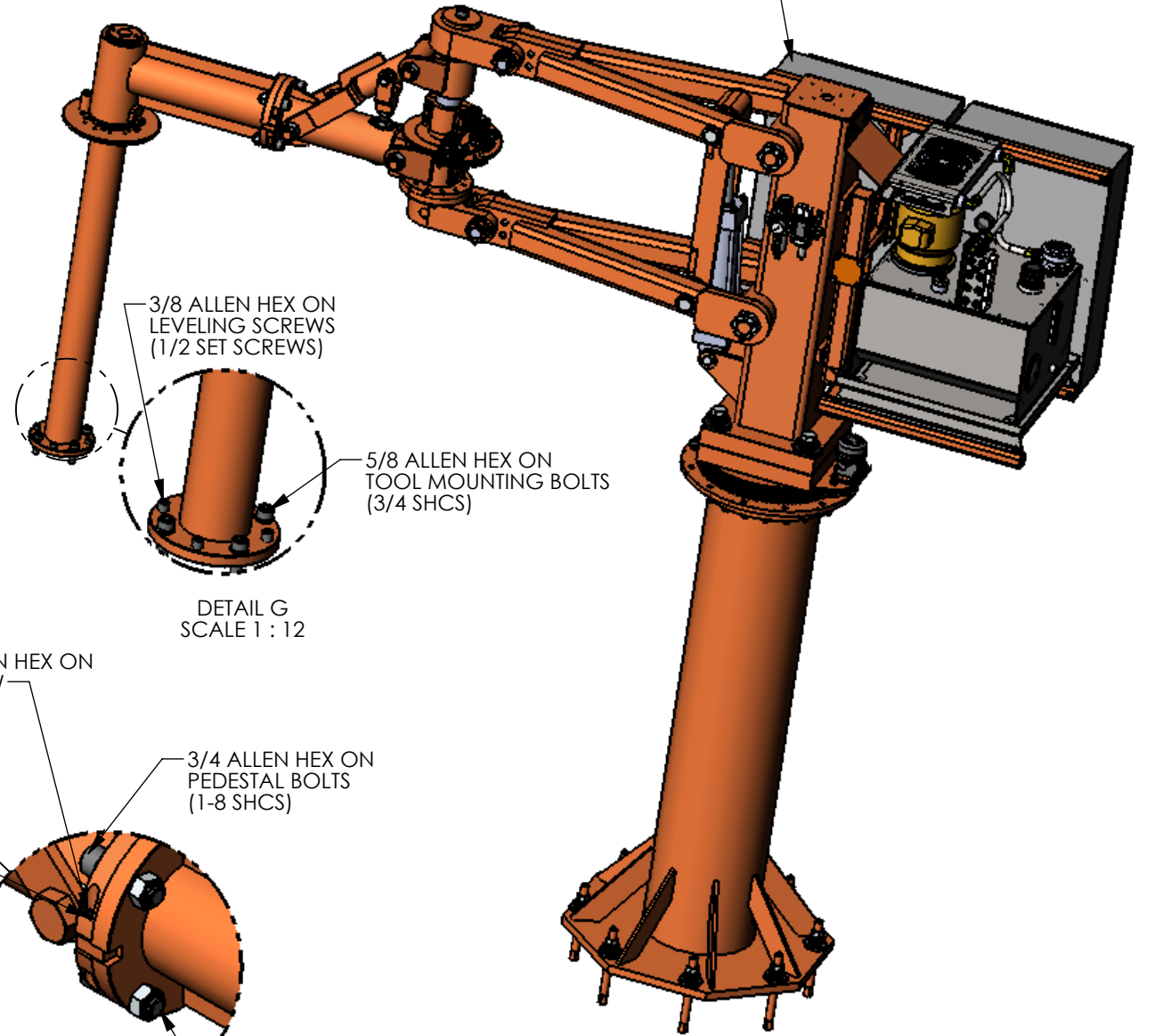
DETAIL D SCALE 1 : 8



3/8 ALLEN HEX ON LEVELING SCREWS (1/2 SET SCREWS)

5/8 ALLEN HEX ON TOOL MOUNTING BOLTS (3/4 SHCS)

DETAIL G SCALE 1 : 12



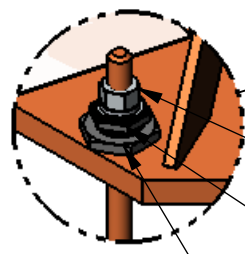
5/16 ALLEN HEX ON SET SCREW

3/4 ALLEN HEX ON PEDESTAL BOLTS (1-8 SHCS)

THESE 4 SET SCREWS WILL ADJUST THE DOWN SHAFT SIDE-TO-SIDE LEVEL
NOTE:
LOOSEN THE FOUR 1-8 BOLTS FIRST THEN RE-TIGHTEN TO CHECK LEVEL MAKE ADJUSTMENTS WITH NO LOAD AND CHECK LEVEL WITH AN AVERAGE LOAD APPLIED (DO NOT OVER TIGHTEN THE SET SCREWS SINCE THIS WILL BREAK THE KEYS)

DETAIL B SCALE 1 : 8

1 1/2 HEX ON ANCHOR BOLT NUT (1-8 THREAD)



1 1/2 HEX ON ANCHOR BOLT NUT (1-8 THREAD)

2 1/4 HEX ON LEVELING JACK (2-12 THREAD)

3 HEX ON LEVELING JACK JAM NUT (2-12 THREAD)

DETAIL A SCALE 1 : 8

THE FOLLOWING IS A NON-COMPREHENSIVE LIST OF ITEMS SUGGESTED FOR INSTALLING THE TPA 25. IT IS THE INSTALLER'S RESPONSIBILITY TO UNDERSTAND THE INSTALLATION PROCESS AND THE TOOLS REQUIRED PRIOR TO PERFORMING THE WORK.

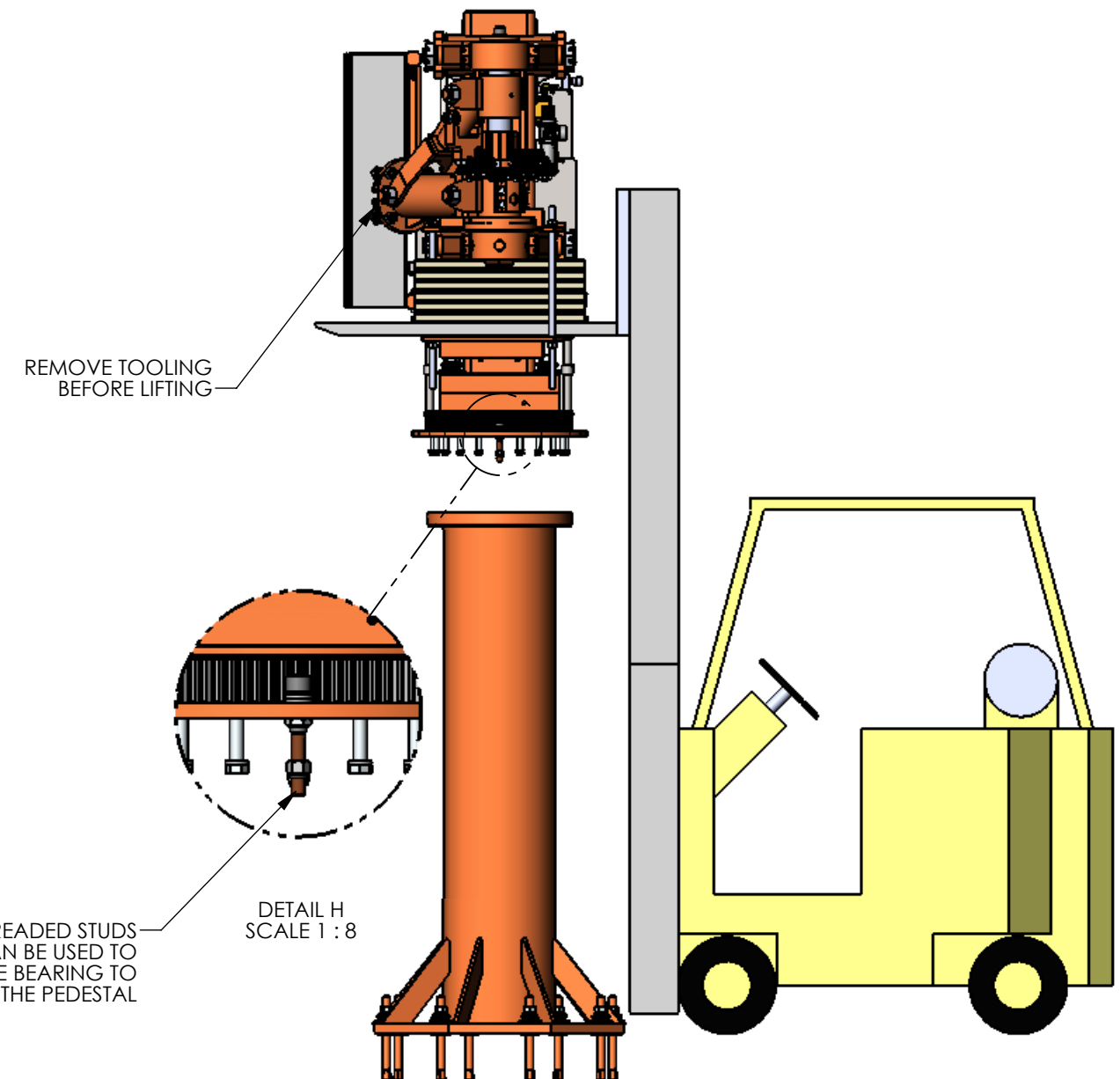
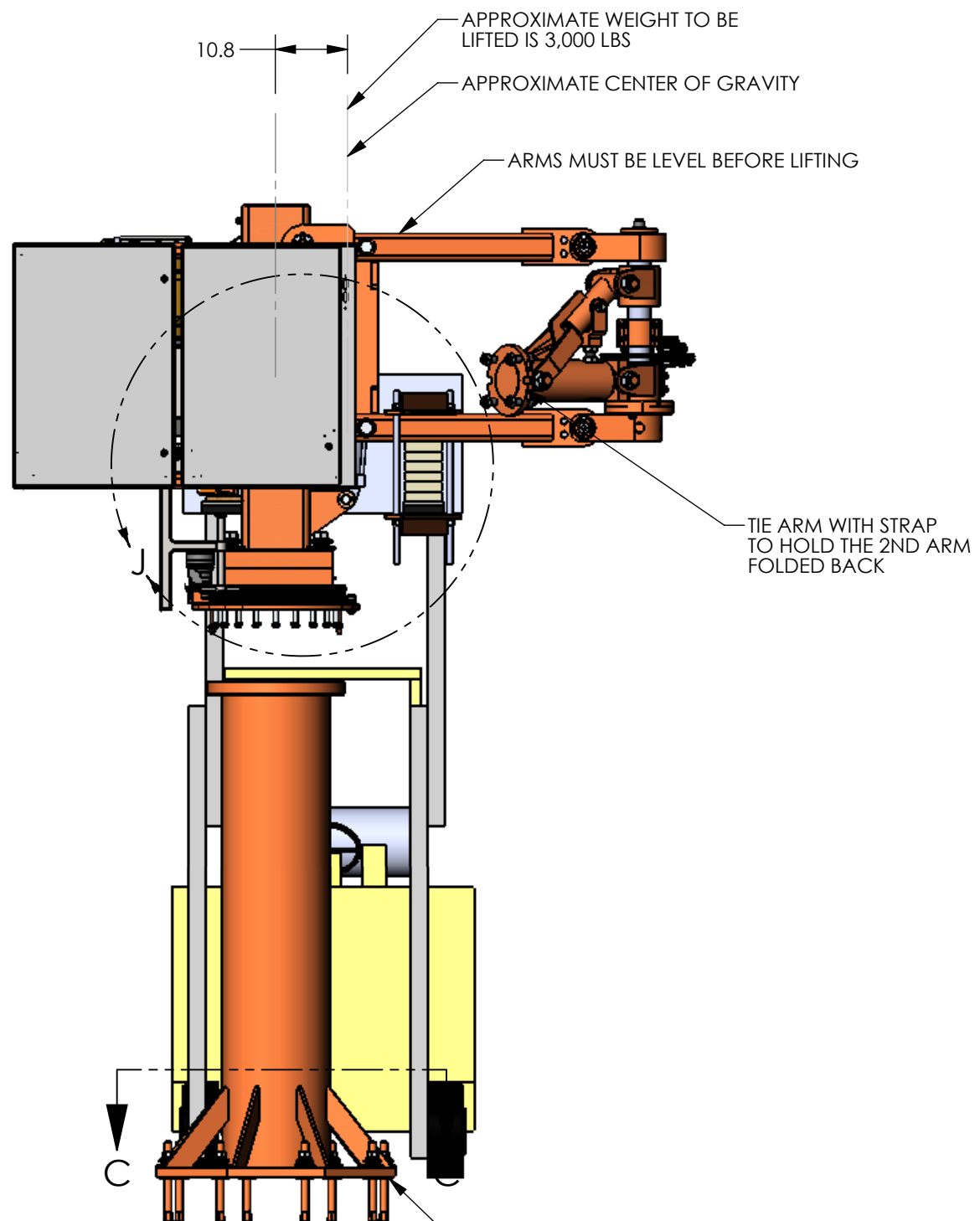
3 3/4 HEX WRENCH	MACHINIST LEVEL & BUBBLE LEVEL	CHALK TO MARK PEDESTAL LOCATION
3" HEX WRENCH	TORQUE WRENCH	DRILL
1 7/8 HEX WRENCH	HAMMER DRILL	BANDING SHEAR FOR PALLET DISASSEMBLY
2 1/4" HEX WRENCH	1" CONCRETE BIT	FISH TAPE FOR ROUTING HOSES
1 1/2" HEX WRENCH	VACUUM TO CLEAR ANCHOR BOLT HOLES	5/8" X 3" L - EYE BOLTS FOR LIFTING PEDESTAL
1 1/16" HEX WRENCH	EXTENSION CORDS	SLINGS
3/4" ALLEN HEX	LADDERS	PERSONAL PROTECTIVE EQUIPMENT
5/8" ALLEN HEX	MAN LIFT	RECOMMENDED 8,000 LB FORKLIFT OR CRANE TO LIFT THE TPA 25 INTO POSITION (NO TOOL)
3/8" ALLEN HEX	PLUMBING TOOLS	
5/16" ALLEN HEX	ELECTRICAL TOOLS / HOLE PUNCH	
WILTON 6516B C-CLAMPS	LAYOUT PRINT & TAPE MEASURE	

ALL SPECIFIED NOTES AND REQUIREMENTS ARE TYPICAL REFER TO EACH PROJECT PROFILE DRAWING FOR AND CUSTOM FEATURES.

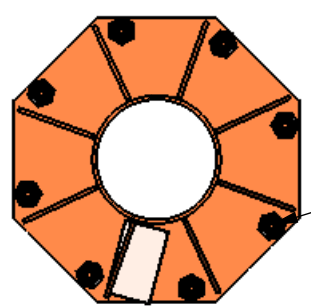
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TPA 25 - INSTALLATION INSTRUCTIONS			
SCALE: 1:24	DATE: 14-Aug-14	DRAWN BY: WAK	
CLASS CODE: 500	DWG NO: TPA 25 INSTALL	SHT: 1 of 4	REV:



- NO GROUTING IS NEEDED TO INSTALL THIS PEDESTAL:
1. BE SURE TO PLACE THE WASHERS UNDER THE JACKS - ON THE CONCRETE.
 2. SEAT THE ANCHOR BOLTS BEFORE LEVELING.
 3. LEVEL THE PEDESTAL BEFORE INSTALLING THE MANIPULATOR.
 4. PLACE A LEVEL ON THE BEARING MOUNTING SURFACE TO LEVEL TO PEDESTAL.



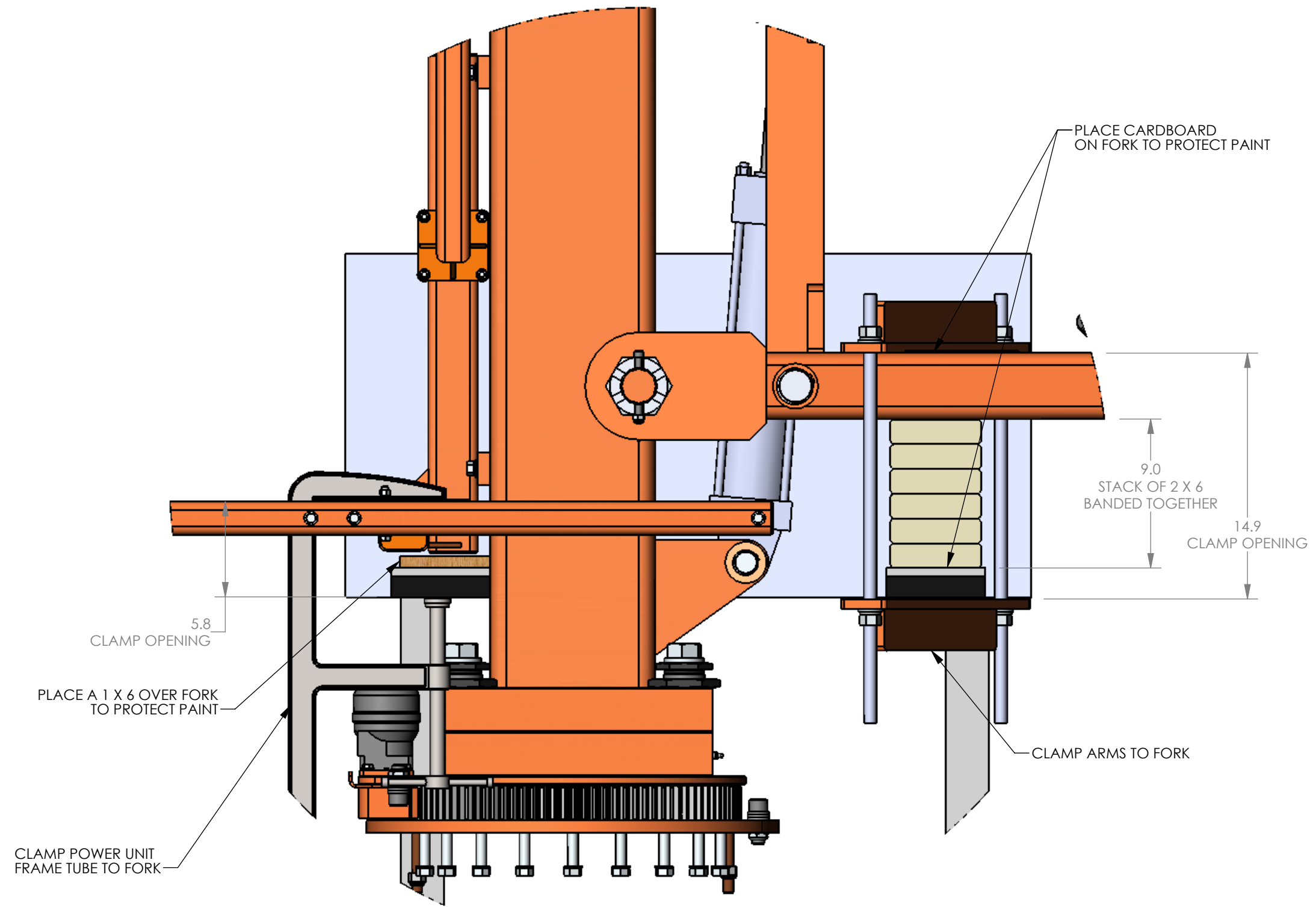
SECTION C-C

SEAT BOLTS AT 250-350 FT-LBS [340-476 N-M]
 LOOSEN AND THEN TORQUE TO 250 FT-LBS [340 N-M]
 RECHECK AFTER ONE WEEK OF SERVICE
 CHECK EVERY PERIODIC EVALUATION

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TPA 25 - INSTALLATION INSTRUCTIONS			
SCALE: 1:24	DATE: 14-Aug-14	DRAWN BY: WAK	
CLASS CODE: 500	DWG NO: TPA 25 INSTALL	SHT: 2 of 4	REV:



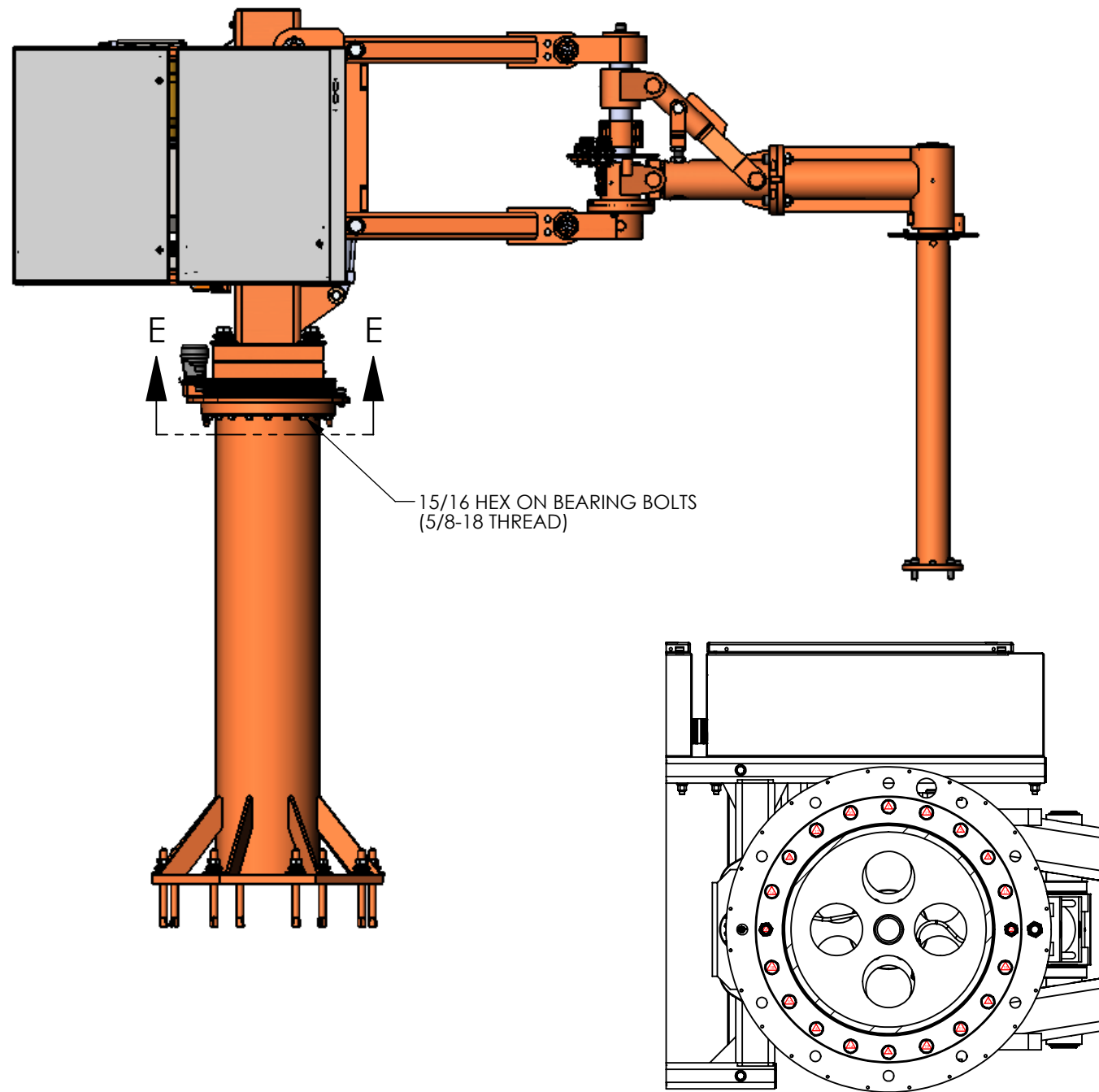
DETAIL J

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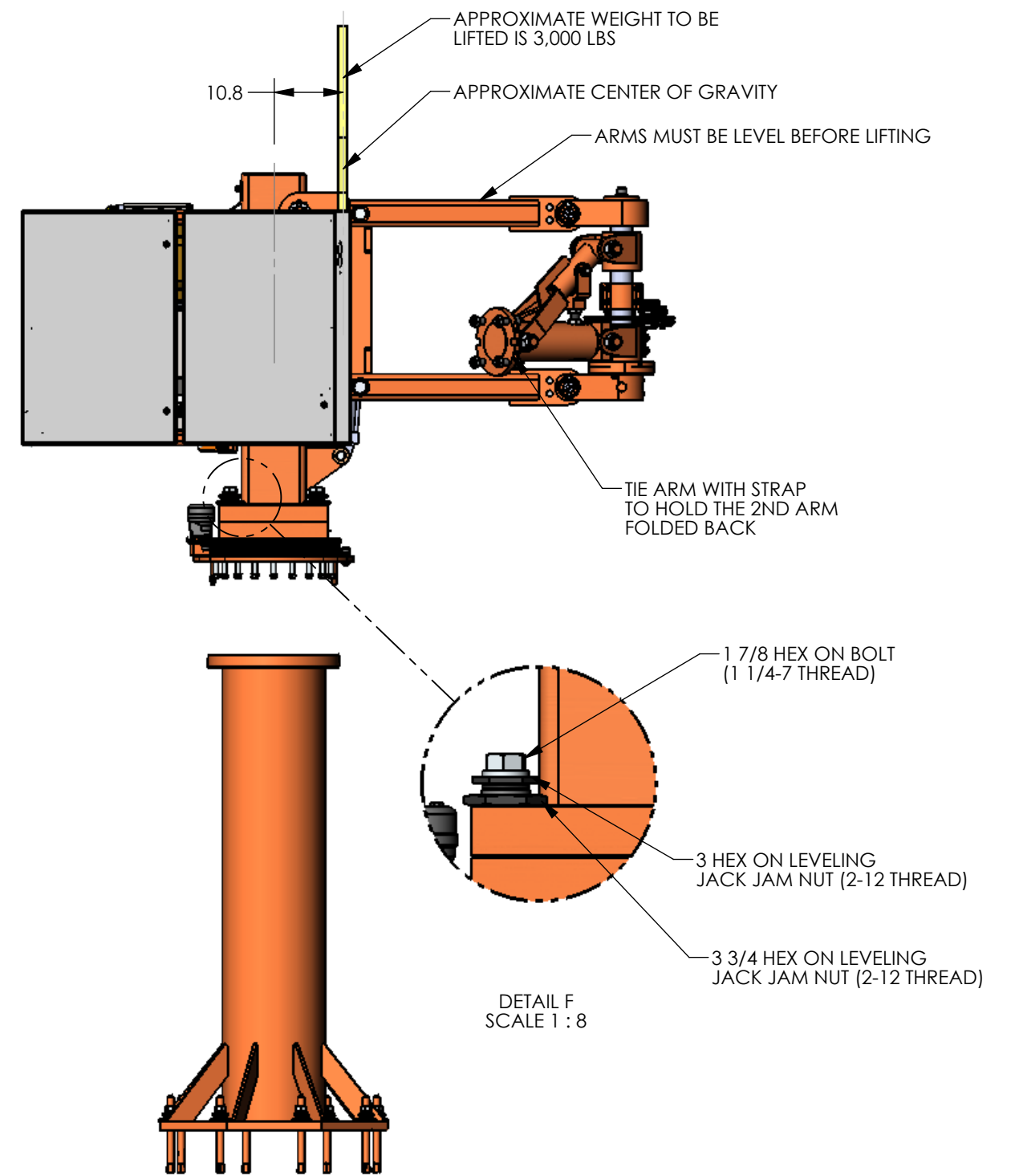


TPA 25 - INSTALLATION INSTRUCTIONS

SCALE: 1:7	DATE: 14-Aug-14	DRAWN BY: WAK
CLASS CODE: 500	DWG NO: TPA 25 INSTALL	SHT: 3 of 4 REV:



SECTION E-E
SCALE 1 : 12



TORQUING THE BEARING BOLTS:

1. SEQUENCE FOR THE FIRST 10 BOLTS SHOWN.
2. ADD SERVICE GRADE THREAD LOCKER TO THE BOLTS.
3. TORQUE THE BOLTS TO 28 FT/LBS FOLLOWING THE SEQUENCE BELOW AND THEN ROTATE THE BEARING ONE FULL TURN EACH DIRECTION MAKING SURE THE BEARING ROTATES FREE.
4. TORQUE THE BOLTS TO 56 FT/LBS FOLLOWING THE SEQUENCE BELOW AND THEN ROTATE THE BEARING ONE FULL TURN EACH DIRECTION MAKING SURE THE BEARING ROTATES FREE.
5. FINAL TORQUE THE BOLTS TO 83 FT/LBS FOLLOWING THE SEQUENCE BELOW AND THEN ROTATE THE BEARING ONE FULL TURN EACH DIRECTION MAKING SURE THE BEARING ROTATES FREE.

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TPA 25 - INSTALLATION INSTRUCTIONS

SCALE: 1:24	DATE: 14-Aug-14	DRAWN BY: WAK
CLASS CODE: 500	DWG NO: TPA 25 INSTALL	SHT: 4 of 4 REV: