

Triumph® Models 5550/5551

Rear Table Removal & Re-installation

Procedures

July 18, 2003

Removing Rear Table:

- Note:
- (1) Power up the machine to make sure everything is operating properly. Ensure backgage is in the rear position.
 - (2) Pay particular attention to where it is stated “Remove” or “Loosen”.
 - (3) MBM Corporation assumes no responsibility for any damage which may occur during this procedure.
- Caution:
- (1) The rear table has fixing points which were adjusted and sealed by paint when assembled. It is **FORBIDDEN** to adjust/misadjust these points when performing this procedure.
 - (2) Read and understand entire procedure prior to commencing this procedure.

Procedure:

- 1) Remove 6-7mm HH screws from the backgage cover.
- 2) Remove 2-7mm HH screws from protection panel for encoder.
- 3) Remove 6-7mm HH screws from electrical cover panel.
- 4) **(5550 only)** Remove 2-5mm allen screws from side panel.
- 4a) For 5551-EP photo curtain:
Caution: Do not disconnect A2 PCB & DO NOT DROP during following procedure.
 - a) Release the cable from the plastic channel.
 - b) Remove 2-10mm HH bolts, 1-10mm nut and allen alignment stud.
 - c) Set photo curtain aside carefully.
 - d) Remove 4 Phillips screws from top cover, front and rear.
- 5) **(5550 only)** Remove 7-7mm HH screws on front cut button plate & 2-7mm HH Screws from safety instruction panel & remove backgage hand wheel cable.
- 6) Label and remove backgage motor (M3) wires, then remove 2-13mm nuts from backgage motor plate. Remove motor.
Caution: If not careful performing step 7, damage to the encoder disc may occur.
- 7) Put a screwdriver through hole in spindle, behind bearing block. Remove 2-22mm jam nuts on backgage spindle, remove pulley, 2 collars and 1 keyway. Remove 2-13mm HH bolts from bearing housing and backing plate, then remove bearing housing and plate from spindle.
- 8) Remove 6-6mm allen screws from under front table, 3 vertical & 3 horizontal.
- 9) Note the plates will fall down during this procedure. Remove 2-4mm Allen screws for cut stick, on the front.
- 10) Locate and remove ST4 & 5 from the A2 PCB, push through frame gently.
- 11) Loosen 1-13mm nut forward of the SW 14 (front end switch), spindle side.

Continued ▼

Removing Rear Table: (continued)

- 12) Loosen 3-6mm allen screws, vertical under the front of backage table.
- 13) Remove 3-6mm allen screws from the LHS plate for backage.
- 14) Remove 2-6mm allen screws and hook plates from under backage table, near power cord.
- 15) Loosen 2-10mm HH bolts from front table stop plates located left & right of cut stick. Using two people, now the back table may be removed.

■ End of rear table removal.

Re-Installation of Rear Table:

Procedure:

- 1) Re-install the rear table making sure it is seated as before it was removed. Mount bearing plate on front of spindle and 2-13mm bolts. Do not fully tighten.
- 2) Install 3-6mm allen screws in front table, rear support plate.
- 3) Install keyway, spacer, pulley, spacer and 2-22mm nuts on spindle.
- 4) Install 3-6mm allen screws in front side of rear table support. Tighten 3-6mm allen screws on the back.
- 5) Install backage motor (M3), wires, 1-13mm nut, belt and tension snugly.
- 6) Route cables ST4 & 5 and mount to A2 PCB.
- 7) Tighten 1-13mm nut forward of S14 (front end switch).
- 8) Install RH side plate on rear table using 3-6mm allen screws, install 2-6mm allen screws for hook plates, Tighten 2-10mm HH bolts for front table stop plates.
- 9) For 5550: Install front cut button panel assembly, align & secure using 7-7mm HH screws.
- 10) Install cut stick and tighten 2-4mm allen screws. Except for the two 13mm bolts, go over each nut, bolt, allen screw to ensure all are tightened properly.
- 11) Plug in, turn on and test backage to ensure it operates properly. It is normal to re-adjust the bearing plate as needed. Backage must move in both directions in a fluid motion and without strain or unusual sounds. Also, observe that the encoder disk and/or sensor have not become damaged during this procedure.
- 12) Tighten 2-13mm bolts in the spindle bearing housing.
- 13) Install left & right forward side panels using 2-5mm HH bolts for each panel.
- 14) **(5551 only)** Install 1-3mm allen screw alignment stud for photo curtain.
- 15) Install top cover on rear table using 6-7mm screws.
- 16) Install rear electrical cover panel using 6-7mm screws.
- 17) Install front safety instruction panel using 2-7mm screws
- 18) **(5551 only)** Install top cover using 2 phillips screws.
- 19) **(5551 only)** Install photo curtains using 2-10mm HH bolts and 1-10mm nut.

■ END of Rear Table Re-Installation