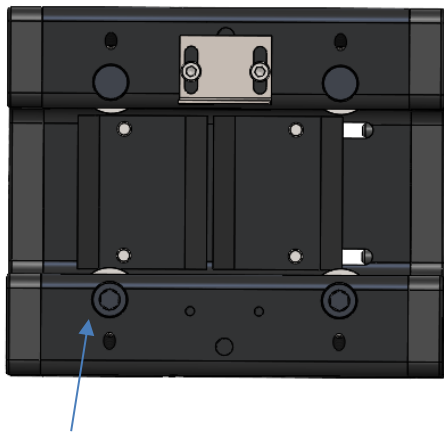


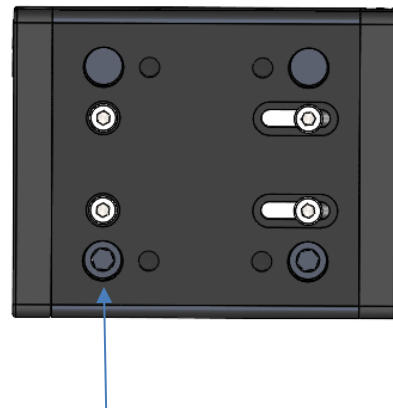


Macron 6 Cart Installation & pre-load adjustment process

1. First remove the lubricating end caps on the cart to simplify installation.
2. Use a hex wrench to drive the eccentric pins all the way into the cart body. This will pull the eccentric rollers as far away from the actuator beam as possible.

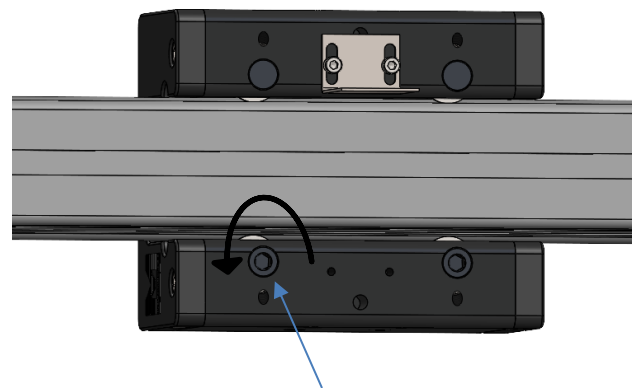


M6S eccentric pins (bottom of cart)



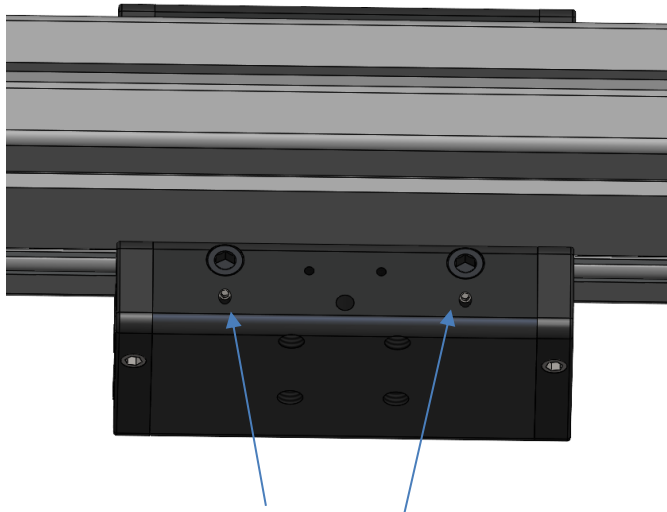
628 eccentric pins (top of cart)

3. Slide the cart onto the profile in the proper orientation.
4. Using a torque-controlled screwdriver, turn each **eccentric pin counterclockwise** until a torque of 5 in-lbs is reached. This will set the proper pretension for the adjustable rollers on the rail.

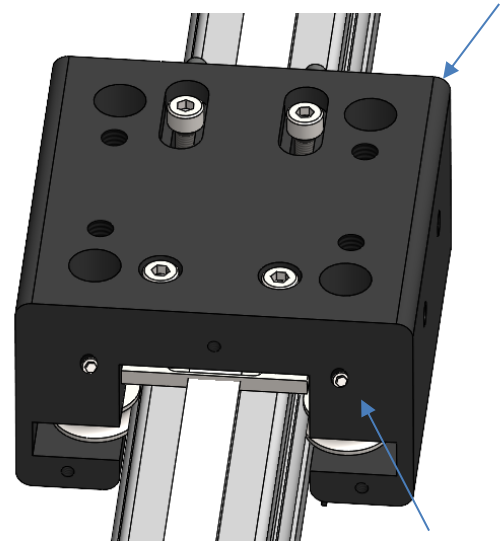




5. Once the proper torque is reached on the eccentric rollers, tighten the set screws in the side of the bearing block to hold the position of the shafts.



M6S set screw locations



628 set screw locations (remove end caps)

6. Slide cart back and forth along rail – there should be no play in any plane. Observe rollers for rotation. Cart should not bind. Re-adjust as required.
7. Reconnect belt tension assembly to the cart.

Caution: do not over pre-load the cart. This process is intended to ensure roller contact with the guide rails to allow for component and assembly tolerance variation. Overloading causes excess wear on bearings and drive system.