

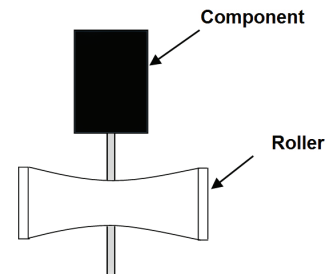
# Service Procedure

## CF8 Transport Wheels Idler Gear Lash Adjustment

### Check Timing & Alignment

To verify transport wheel timing and inspect alignment:

1. Verify that timing for transport wheels system is properly set per *Transport Wheel Shim Maintenance Instructions* (PN 817-1-18). Details in 6. *Set Timing*.
2. To check transport wheel alignment:
  - a. Run 5 to 10 components and stopping the machine before the components reach the bending station 6 & 7.
  - b. With a component in transport wheels, manually index a component into stations 6 & 7 bringing the wire clamp down so it almost touches the leads.
  - c. With an inspection mirror, verify that the leads are in the center of the roller. If the leads:
    - are centered on the roller, no adjustment is needed.
    - are not centered on the roller, perform the following adjustment.



### Idler Gear Lash Adjustment

To set the idler gear lash adjustment for the CF8 Transport Wheels System:

1. Unplug the machine power.
2. Using a 1/8" Allen wrench, remove 6 button head screws securing the cabinet to the base and upright.
3. Loosen the lock nuts supporting the Idler Gear Bracket (shown at right):
  - a. Use a 3/16" Allen wrench on the front of the upright.
  - b. Use a 7/16" open/box wrench on the lock nut.
4. Push the idler gear bracket in the indicated direction and/or rotate the transport wheel square shaft until component leads are centered on the roller.
5. With leads in the proper position, tighten the screw on the idler gear bracket.
6. Manually index 2 to 3 more components into position and check that the transport wheels did not move while tightening the idler gear.

