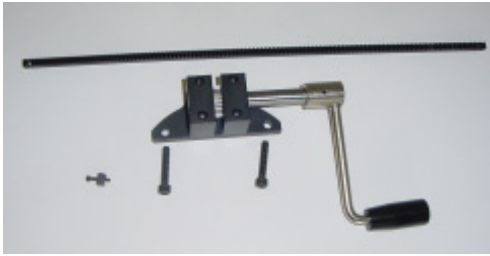


Automation Devices, Inc.

C230 & C230L HEIGHT ADJUSTMENT INSTRUCTIONS



Check both the C075 column and the C001 gear housing casting to ascertain whether they have been properly machined to accept the installation of the C230 Height Adjustment Kit (see photo 1). If not, those parts can be ordered from the factory.

Tap the two gear-rack mounting holes in the column for a #4-40 thread. Slide the gear-rack down through the slot in the C001 gear housing. Fasten the gear rack to the column at the top with the #4-40 x 1/4" screw (C178) provided and at the bottom using the C238 Rack Stop and the #4-40 x 5/8" screw (5218) provided (see photo 2).

Center the gear housing in the middle of the gear-rack and tighten the column clamp to keep it from moving up or down. Remove the two screws indicated in photo 3 from the bottom of the gear housing and inject oil-tight sealant (Permatex) into the empty screw holes. Secure the pinion-gear/crank-handle assembly to the underside of the gear housing as shown in photo 3 using the two 1/4-20 x 1 1/4" screws (6212) provided. **Do Not Tighten** the screws at this point.

Check for play in the crank-handle. Excessive play indicates that the pinion-gear teeth are not properly positioned relative to the teeth on the gear-rack. Use a block of wood and a hammer to tap the pinion-gear/crank-handle assembly back toward the gear-rack and check for play in the crank-handle. When properly adjusted, the crank-handle will have approximately three degrees of motion.

The two screws securing the pinion-gear/crank-handle assembly to the underside of the gear housing can now be tightened. Loosen the column clamp and check to ascertain that the crank-handle motion is smooth and consistent as the pinion-gear rides over the entire length of the gear-rack.

Warning: the height adjustment components can be damaged if the machine is transported without securing the gear housing on the column prior to moving the machine.

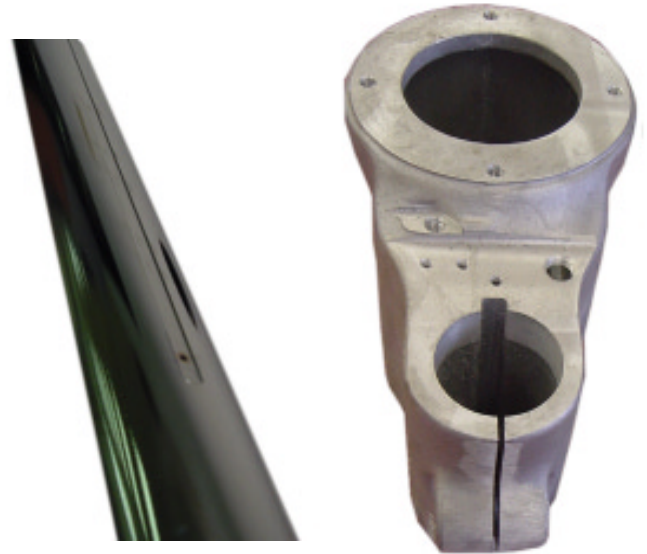


Photo 1



Photo 2

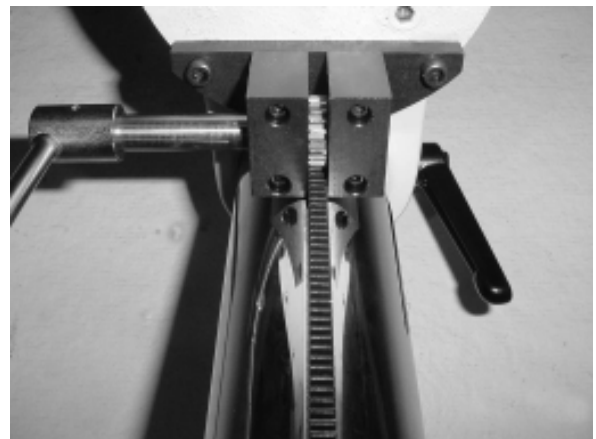


Photo 3

IN05.01

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