

QUALITY SYSTEM

Armedica Manufacturing Corp. AM-420 ASSEMBLY OUTLINE

F420-AO, Rev. B, Issued 06/07/07

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Purpose:

This procedure establishes the methods, materials and acceptance criteria to be used as an assembly guide.

Scope:

This procedure enforces the integrity for this device.

References:

Armedica Manufacturing Corp. Quality Manual, Operating Procedures and Product Specifications.

Definitions:

N/A

Work Instruction

General Instructions:

Note: These instructions are to be used in conjunction with proper training from a person authorized and assigned to perform training on the assembly of this device.

All fasteners have an optimal tension requirement for the device to function properly. Instruction on determining the correct tension of the various fasteners for the proper operation of the device will be part of the initial training process. Supervisor must approve any variation from the established guidelines.

Apply grease to all shoulder bolts, and other parts where unwanted friction may occur. Shoulder bolts are to be FULLY TIGHTENED using a standard "L" type hex key.

Assemble per exploded diagrams, photographs and written instructions.

Re-inspect all painted and plated parts during assembly to ensure surfaces are free of defects.

Assembly Instructions:

Step 1: Place (1) 18701 fixed traction top frame upside down on assembly table. Insert (4) 03015 1 x 2 plugs into 18701 fixed traction top frame.

Step 2: Install (4) 03060 Leveler Glides into 3/8" nuts on both 18707 fixed traction legs. Insert (8) 03015 1 x 2 plugs into both 18707 fixed traction legs.

Step 3: Attach (2) 18707 legs to the top using (4) 02047 ½ - 13 - 2 ¾ hex head screws, (4) 03011 washer rhw-207 finish cap, (4) 03012 black bolt cover, and (4) 02095 ½ - 13 thin nylock nuts. Insert (2) 12511 strap hooks modified to 90 degree bend opposite side of machine stand on top frame using the same screws and nuts for the legs.

Step 4: Attach (1) 18703 fixed traction machine stand to base using (1) 02048 ½ - 13 x 1 ¾ hex head screw in top tube.

Assembly Instructions (continued):

Step 5: Attach (1) 18709 fixed traction brace tube to the legs using (2) 02048 ½ - 13 x 1 ¾ hex head screws, (2) 03011 washer rhw-207 finish cap and (2) 03012 black bolt cover.

Step 6: Insert (1) 18705 fixed machine stand into 18703 fixed traction machine stand. Insert (1) modified 03071 2 ¼ x 3/8 knob w/stem (grind a point on the end of the knob).

Step 7: Attach (1) 14508 400 adapter board to 18705 fixed machine stand using (4) 02045 ¼ - 20 x 1 hex head screws.

Step 8: Attach (1) 13526 cam and (1) 12527 lock puller to 13521 rod using (1) 02037 ¼ - 20 x 1 button head screw and (1) 02101 10 - 32 x 1 phillip head screw.

Step 9: Insert (1) 13521 400 cam lock rod through top frame. Attach (1) 12519 gear rack plunger using (1) 02099 10 - 32 x 1 ¼ Philip head screw, (2) 02097 10 - 32 nut, and (1) 02089 10 - 32 nylock nut.

Step 10: Attach (2) 02165 ½ plastic washers, (2) 02095 ½-13 thin nylock nuts, (2) 02135 ½-13 thin nuts, and (2) 03070 knobs to 13521 400 cam lock threaded rod. Insert (2) 03010 1 x 1 plugs into 18701 top frame. Hold knob in locked position and tighten nuts to the knobs.

Step 11: Attach (2) 12711 ANG 1-1/2 SQ to (1) 18690 ANG 1-1/2x2x27 right and (1) 18692 ANG 1-1/2x2x27 left using (4) 02100 ¼ - 20 nylock nuts. Clear paint from bushings on 18690 and 18692. Attach (4) 03066 bearings to bushings on 18690 and 18692. These assembled make the roller frame.

Step 12: Grease rolling tracks on 18701 top frame. Fit (1) roller frame into rolling tracks on 18701 top frame.

Step 13: Attach (1) 12311 active trac gear to 14705 fixed traction upholstered foot board using (2) 02073 ¼ - 20 x 1 ½ flat head screws.

Step 14: Attach (1) 14705 fixed traction upholstered foot board to 18701 top frame using (4) 02065 #14 x 1 screws. Attach (1) 14706 fixed traction upholstered head board to 18701 top frame using (4) 02065 #14 x 1 screws. Attach (1) 14707 fixed traction shelf to legs using (4) 02045 ¼ -20 x 1 hex head screws and to 18709 brace using (1) 02070 14 x 1 ¾ screw.

Packing Instructions:

Step 15: Detach 18709 fixed traction brace tube from 18707 fixed traction legs. Detach 14707 fixed traction board shelf from 18707 fixed traction legs leaving 18709 fixed traction brace and 14707 fixed traction board shelf connected.

Packing Instructions (continued):

Step 16: Remove 18703 fixed traction machine stand from 18701 top frame.

Step 17: Clean all upholstery with approved cleanser. Wrap 14705 and 14706 with 90 inches of 06015 foam. Place packing foam side down into 06201 carton bottom.

Step 18: Gather (4) 02047 ½ - 13 x 2 ¾ hex head screws, (4) 02095 ½ - 13 thin nylock nuts, (3) 02048 ½ - 13 x 1 ¾ hex head screws, (4) 02045 ¼ - 20 x 1 hex head screws, (6) 03011 finish cap washer, (6) 03012 finish bolt cover, and (2) 12511 modified strap hooks. Wrap and fasten

Step 19: Detach 18707 fixed traction legs from 18701 top frame. Wrap 18707 fixed traction legs with 54 inches of 06015 foam. Place onto 18701 top frame in 06201 carton bottom.

Step 20: Wrap 14707 fixed traction board shelf with 90 inches of 06015 packing foam. Place on top of 18707 fixed traction legs in 06201 carton bottom.

Step 21: Cover 06201 bottom carton with 06200 top carton. Fasten with (3) strips of 06025 black polystrap using (12) 06001 edge protectors on corners to protect carton.

Step 22: Wrap 18703 fixed traction machine stand with 78 inches of 06015 packing foam. Place in box and seal with packing tape.

Step 23: Affix appropriate shipping and warning labels to packaging.

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PARTS LIST BY: ITEM NO.

<u>ITEM NO.</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>QUANTITY</u>
5	03015	PLUG 1x2x14GA	12
9	02100	NUT NYLOCK 1/4-20	4
14	03010	PLUG 1x1x14GA	2
25	03060	GLIDE 3/8-16x1-1/2	4
30	02070	SCREW HEX WASHER HEAD #14x1-3/4	1
34	03070	KNOB WING 1/2X13 ID	2
40	02065	SCREW HEX WASHER HEAD #14x1	8
44	02135	NUT HEX FIN JAM 1/2-13	2
79	12511	BAR 1/8x1x2-3/4 STRAP HOOK (MODIFIED)	2
86	03066	BEARING KILLIAN F300 1/2 ID 1-1/8	4
88	02095	NUT NYLOCK JAM 1/2-13	6
89	02165	WASHER NYLON 1/2 ID	2
90	02045	SCREW HEX HEAD CAP 1/4-20x1	8
92	12519	GEAR RACK PLUNGER LOCK	1
93	12527	BAR 1/8x1-1/4x2-13/16 LOCK LINK	1
94	13526	BUSH CAM .515 ID LOCK MECH	1
105	14508	BD PLY 400 ADAPT FORMICA 3/4x10x12	1
113	02101	SCREW PAN HEAD PHIL 10-32x1	1
114	02099	SCREW PAN HEAD PHIL 10-32x1-1/4	1
115	02097	NUT HEX FIN 10-32	2
116	02089	NUT NYLOCK 10-32	1
125	02073	SCREW FLAT HEAD PHIL 1/4-20x1-1/2	2
126	13521	ROD 1/2x23 THD'D 400 CAM LOCK	1
127	02037	SCREW BUTTON HEAD SOC 1/4-20x1	1
128	02047	SCREW HEX HEAD CAP 1/2-13x2-3/4	4
129	02048	SCREW HEX HEAD CAP 1/2-13x1-3/4	3
130	03071	KNOB W/STEM 2-1/4x3/8-16x1	1
131	12311	BAR GEAR 1/2SQx7-3/4 AT LOCK	1
132	12711	ANG 1-1/2SQx15-3/4 FIXED ROLLER END	2
133	14705	BD UPH 27x42 FIXED TRACTION FOOT	1
134	14706	BD UPH 27X34 FIXED TRACTION HEAD	1
135	14707	BD UPH 12x66-1/2 SHELF FIXED TRACTITION	1
136	18690	ANGLE 1-1/2x2x27 FIXED ROLLER FRAME RIGHT	1
137	18692	ANGLE 1-1/2x2x27 FIXED ROLLER FRAME LEFT	1
138	18701	FRAME TOP FIXED TRACTION	1
139	18703	FRAME FIXED TRACTION MACHINE STAND	1
140	18705	FRAME FIXED TRACTION MACHINE STAND UPPER	1
141	18707	LEG FRAME FIXED TRACTION	2
142	18709	TUBE 1x1x64-1/2 FXD TRACTION BRACE	1
143	03011	WASHER RHW-207 FINISH CAP	6

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144	03012	CAP FINISH BLACK BOLT COVER	6
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127	02037	SCREW BUTTON HEAD SOC 1/4-20x1	1
90	02045	SCREW HEX HEAD CAP 1/4-20x1	8
128	02047	SCREW HEX HEAD CAP 1/2-13x2-3/4	4
129	02048	SCREW HEX HEAD CAP 1/2-13x1-3/4	3
40	02065	SCREW HEX WASHER HEAD #14x1	8
30	02070	SCREW HEX WASHER HEAD #14x1-3/4	1
125	02073	SCREW FLAT HEAD PHIL 1/4-20x1-1/2	2
116	02089	NUT NYLOCK 10-32	1
88	02095	NUT NYLOCK JAM 1/2-13	6
115	02097	NUT HEX FIN 10-32	2
114	02099	SCREW PAN HEAD PHIL 10-32x1-1/4	1
9	02100	NUT NYLOCK 1/4-20	4
113	02101	SCREW PAN HEAD PHIL 10-32x1	1
44	02135	NUT HEX FIN JAM 1/2-13	2
89	02165	WASHER NYLON 1/2 ID	2
14	03010	PLUG 1x1x14GA	2
143	03011	WASHER RHW-207 FINISH CAP	6
144	03012	CAP FINISH BLACK BOLT COVER	6
5	03015	PLUG 1x2x14GA	12
25	03060	GLIDE 3/8-16x1-1/2	4
86	03066	BEARING KILLIAN F300 1/2 ID 1-1/8	4
34	03070	KNOB WING 1/2X13 ID	2
130	03071	KNOB W/STEM 2-1/4x3/8-16x1	1
131	12311	BAR GEAR 1/2SQx7-3/4 AT LOCK	1
92	12519	GEAR RACK PLUNGER LOCK	1
93	12527	BAR 1/8x1-1/4x2-13/16 LOCK LINK	1
79	12511	BAR 1/8x1x2-3/4 STRAP HOOK (MODIFIED)	2
132	12711	ANG 1-1/2SQx15-3/4 FIXED ROLLER END	2
126	13521	ROD 1/2x23 THD'D 400 CAM LOCK	1
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135	14707	BD UPH 12x66-1/2 SHELF FIXED TRACTITION	1
136	18690	ANGLE 1-1/2x2x27 FIXED ROLLER FRAME RIGHT	1
137	18692	ANGLE 1-1/2x2x27 FIXED ROLLER FRAME LEFT	1
138	18701	FRAME TOP FIXED TRACTION	1
139	18703	FRAME FIXED TRACTION MACHINE STAND	1
140	18705	FRAME FIXED TRACTION MACHINE STAND UPPER	1
141	18707	LEG FRAME FIXED TRACTION	2

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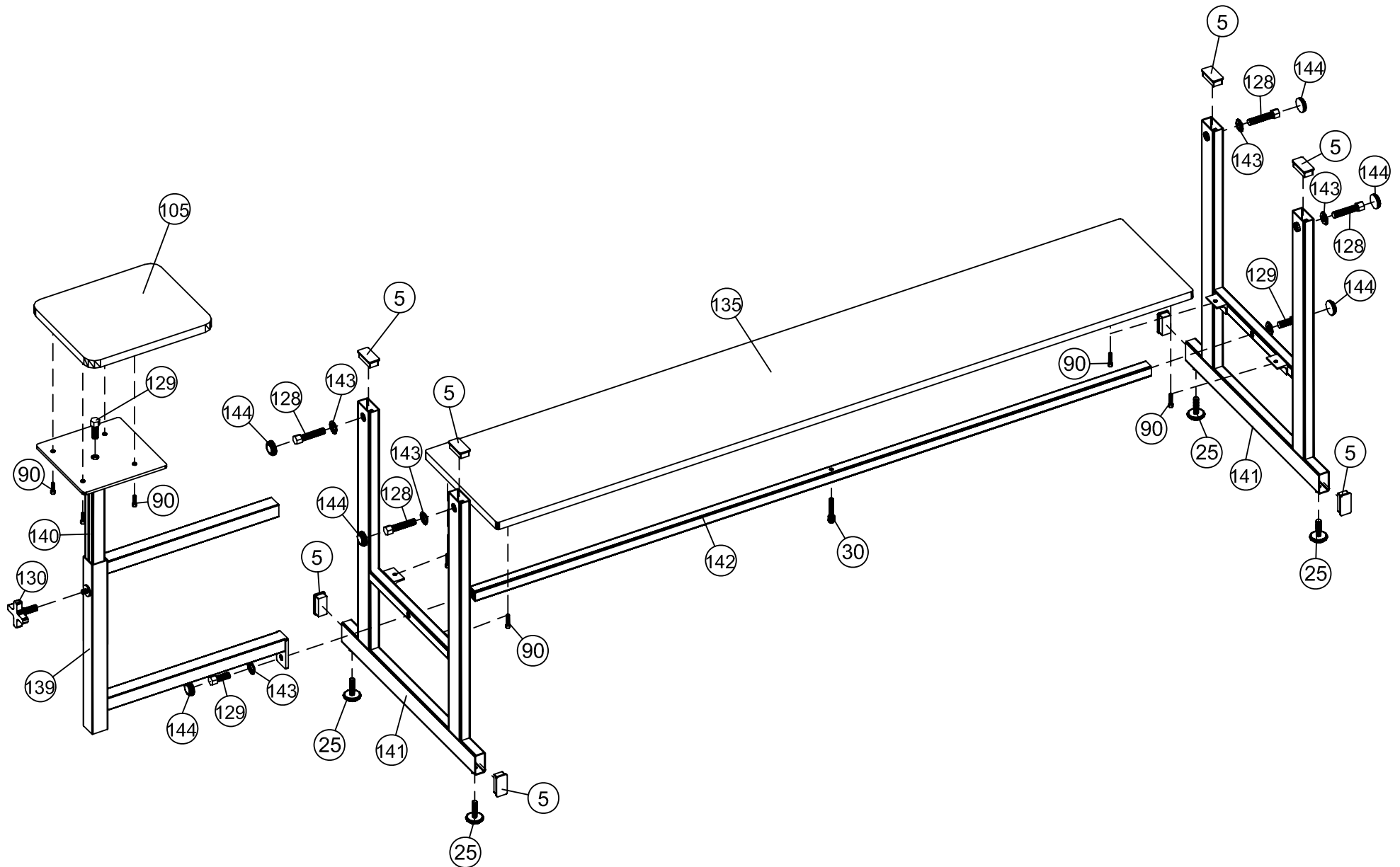
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142	18709	TUBE 1x1x64-1/2 FXD TRACTION BRACE	1
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BOTTOM FRAME AM 420



TOP FRAME AM 420

