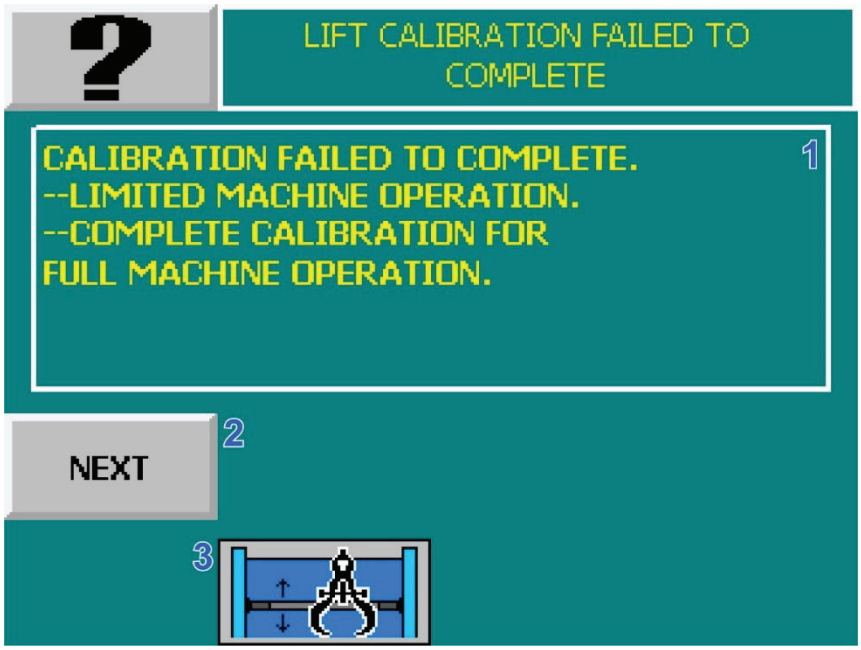
*Figure 161: Calibrate Lift Screen for an Incomplete Calibration*




The error can not be cleared and the machine will not operate until the calibration is completed successfully.

1. Press the Next button [#2] to go to the first screen of the calibration procedure (page 188).

2. Repeat the calibration procedure.

3. Once the calibration procedure has successfully completed, press the Manual/Reset button [M#3]. The error message will clear.

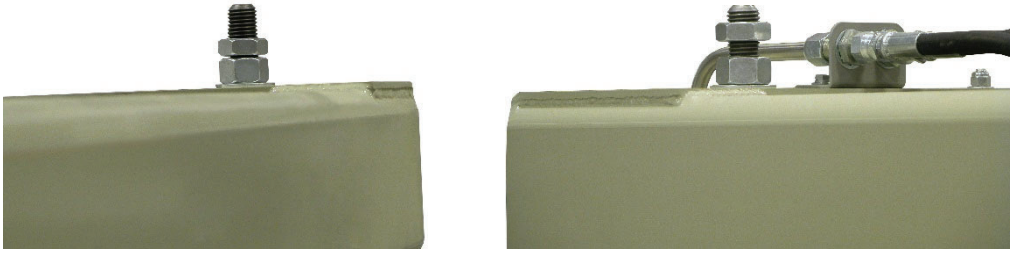
## Adjusting Chain Length

**WARNING** **Before performing entering any hazardous area, be sure to follow the Hazardous Energy Lockout Procedure on page 13.**

When inspecting the chains, check for wear between the pins and the bushings of the chain links. This can eventually increase the overall length of the chain, lowering the level of the lift conveyor and causing extra waste sheets to be left on the conveyor. It can also cause the machine to fault and shut down because the top limit of travel cannot be reached. Excessive chain stretch can also cause the lift to hit the floor.

If these problems begin to occur, the chain length can be adjusted. Adjustments must be made equally to both sides. If more than a slight adjustment is necessary to correct the problem, the chains should be replaced. After any adjustment, make sure the jam nut is reinstalled with removable Lock-Tite.

*Figure 162: Lift Chain Adjustment Bolts*



Operator-side Chain Adjustment Bolt  Drive-side Adjustment Bolt

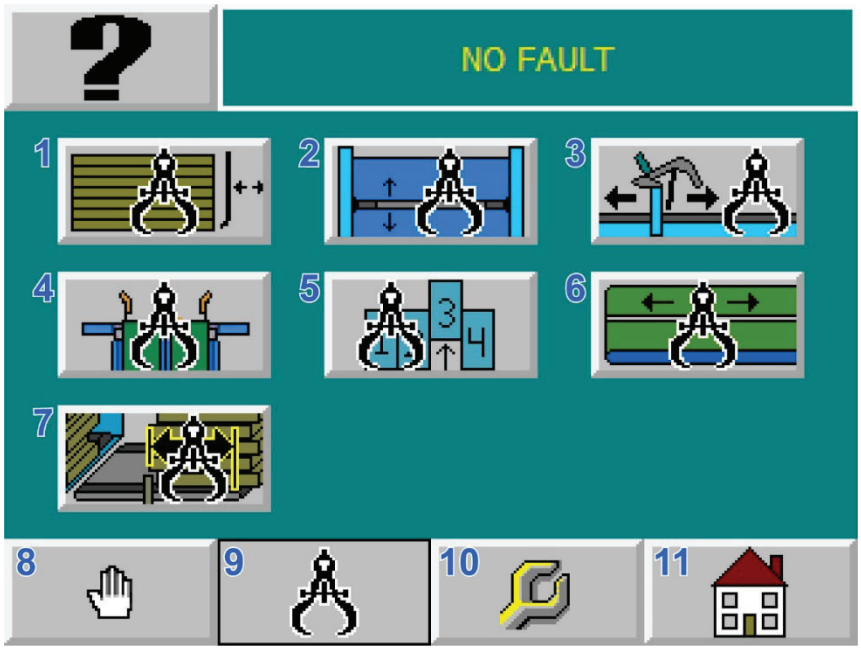
1. Log-in as Maintenance (page 113).

2. The Maintenance Home Screen appears (page 351).

*Figure 163: Maintenance Home Screen*


3. Press the Calibration button [#3].

*Figure 164: Calibration Screen with All Options*




4. Press the Calibrate Lift button [#3]. The Calibrate Lift screen (page 359) appears.

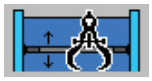


*Figure 165: Calibrate Lift Screen for Step 1*

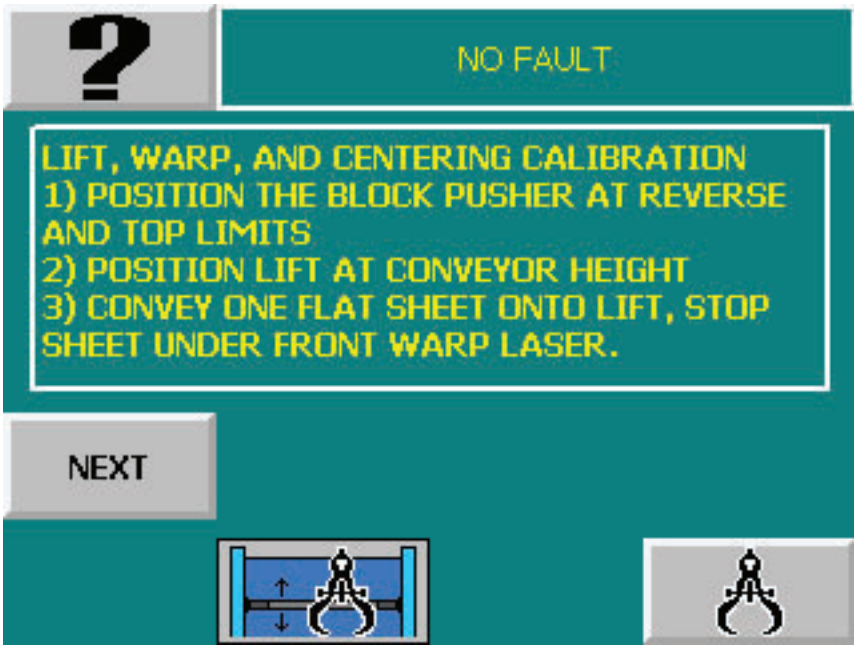
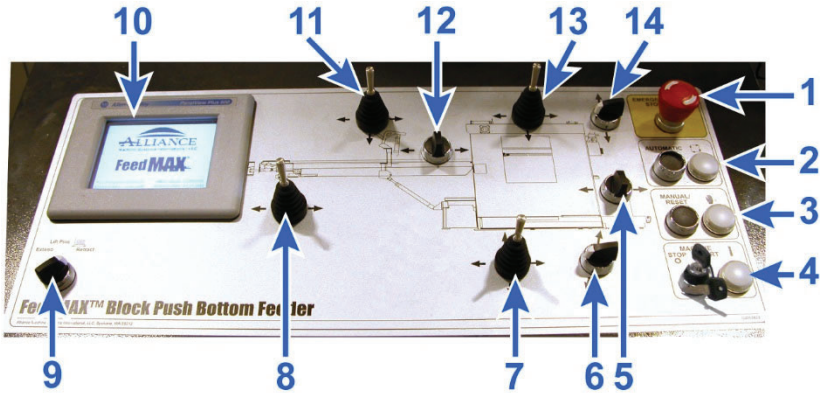


*Figure 166: Main Operator Station (Designated [M#])*




Legend:

1. Emergency Stop button
2. Automatic button
3. Manual/Reset button
4. Machine Stop/Start key switch
5. Separation Conveyor Fwd/Rev switch
6. Lift Traverse Shift switch
7. Lift Fwd/Rev/Up/Down joystick
8. Extendo Jog and Up/Down joystick
9. Lift Pins Extend/Retract switch (opt.)
10. Touch Screen
11. Shingle Gate Up/Down & Hold-down Roller Left/Right joystick
12. Shingle Gate Fwd/Rev joystick (opt.)
13. Block Pusher Fwd/Rev/Up/Down joystick
14. Block Pusher Plate Up/Down switch

5. Hold the Lift Forward/Reverse/Up/Down joystick [#7] down until the lift stops moving or reaches the floor.

6. Adjust the lift chain adjustment bolts at the top front corners of the main frame until the lift is just above the floor or bottom of the pit and is level. Both sides must be adjusted equally so the lift assembly remains leveled.

**WARNING** **If adjusting or checking the height of the lift will require entering the hazard area of the machine, the machine must be locked out using the Hazardous Energy Lockout Procedure on page 13.**

7. Repeat steps 3 through 6 until the lift no longer touches the floor when lowered as far as it will go and is level.

8. Calibrate the lift per Calibrating the Lift on page 187.

If the chains can not be adjusted enough, the chains must be replaced. All lift chains should be replaced at the same time to prevent uneven wear.

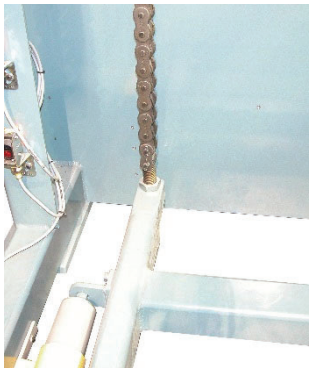
# Check and Adjust Lift Assembly Leveling

**WARNING** **Before performing any maintenance or entering any hazardous area, be sure to follow the Hazardous Energy Lockout Procedure on page 13.**

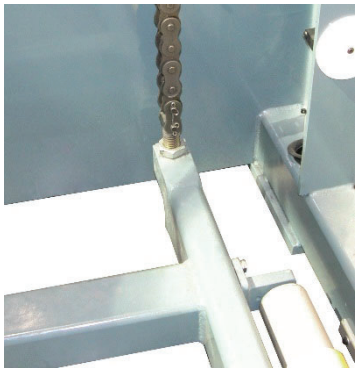
For proper operation, the lift assembly must be level side-to-side and front-to-back. If the lift is not level side-to-side, blocks will skew when they are pushed onto the Extendo. If it is not level front-to-back, trailing sheets will be left, increasing the load on the shingle gate and wear on the Extendo belts. Narrow loads are more prone to tip when the lift assembly is not level.

1. Lower lift to bottom limit.
2. Lockout machine according to the procedure explained in the Hazardous Energy Lockout Procedure on page 13.
3. Use a level to check how level the lift is from side-to-side and front-to-back.
4. Place a 6 ft. to 8 ft. straight edge across the lift conveyor and infeed conveyor to ensure they are level with each other.
5. Adjust the lift leveling bolts (one at each corner of the bottom of the lift). Maintain the 12" TOR height of the lift.

*Figure 167: Upstream Lift Leveling Bolts*



Operator Side



Drive Side

6. Repeat steps 2 through 5 until the lift is completely level.
7. Remove lockout.
8. Calibrate the lift per Calibrating the Lift on page 187.