



Fife Corporation

P.O. Box 26508, Oklahoma City, OK 73126, USA
Phone: 405.755.1600 / Fax: 405.755.8425
www.fife.com / E-mail: fife@fife.com

MAINTENANCE INSTRUCTIONS SYMAT 50 OFFSET PIVOT GUIDE ACTUATOR ADJUSTMENT

SYMAT 50 OFFSET PIVOT GUIDE

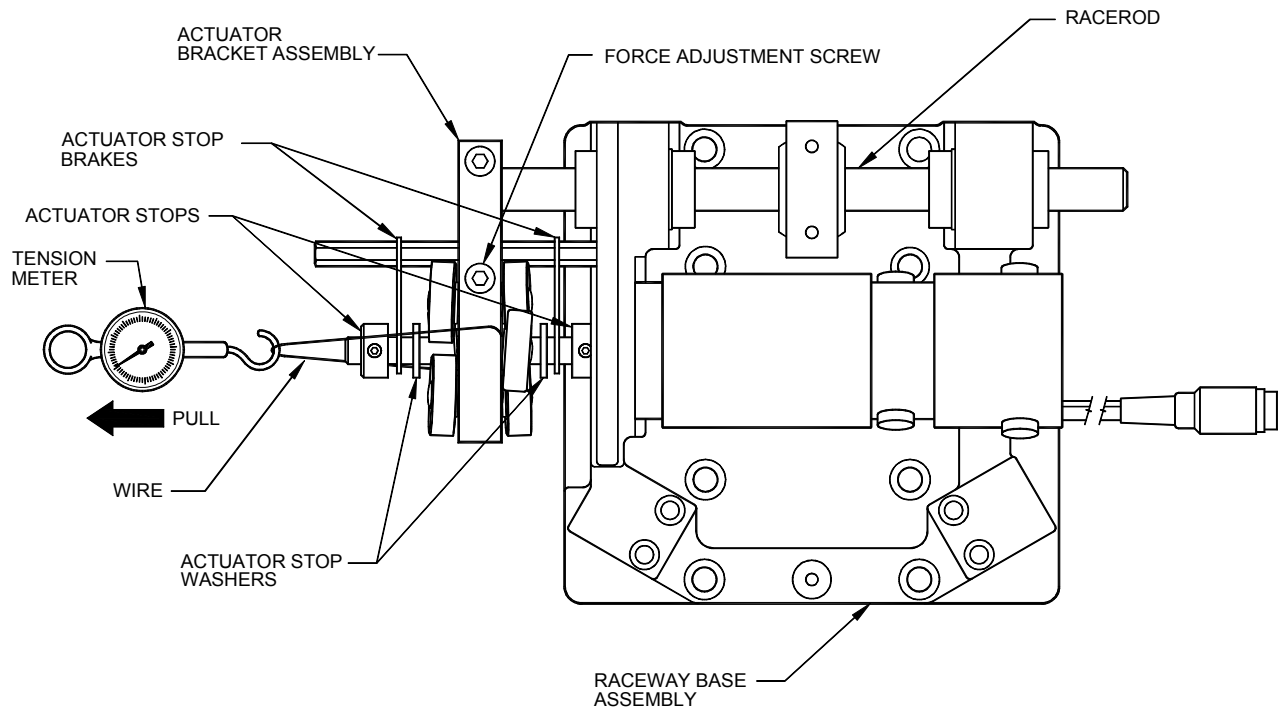


Figure 1.
SYMAT 50 OPG ACTUATOR BRACKET TEST

Actuator Bracket Test

To test actuator bracket assembly for excessive wear, proceed as follows:

1. Remove AC line power.
2. Remove actuator cover.
3. Loosen actuator bracket clamp that holds racerod and slide racerod out of actuator bracket assembly.
4. Tie wire around actuator bracket assembly
5. Attach a tension meter to the wire and pull in a direction parallel to the motor shaft. A force of 50 to 55 pounds should be observed before the actuator bracket assembly begins to slip on the shaft. If the bracket begins to slip before the required amount of force, adjust the *Force Adjustment Screw* until the proper slip force is attained. **If adjustment cannot be made, replace the actuator bracket assembly, actuator stops, actuator stop washers, and actuator stop brakes.**

NOTE: The actuator bracket assembly, actuator stops, actuator stop washers, and actuator stop brakes can be obtained as **Actuator Replacement Kit, Fife Part Number 87907-001.**



Carrier Block And Actuator Stop Alignment

Use the following procedures to align the exiting side carrier block:

1. Loosen the set screw in the spherical bearing and slide the carrier block to the correct position.
2. Place the center of the carrier block 4.552 inches (116 mm) from the inside edge of the actuator bracket assembly (see illustration below).

3. Retighten the set screw.

Should it become necessary to disassemble or, for any reason, move the actuator stops, they must be realigned. The **A** and **B** dimensions shown in the illustration below are the distances the stops should be spaced from the actuator mounting bracket. These distances vary according to the guide actuator stroke. Check the table below to determine the correct spacing.

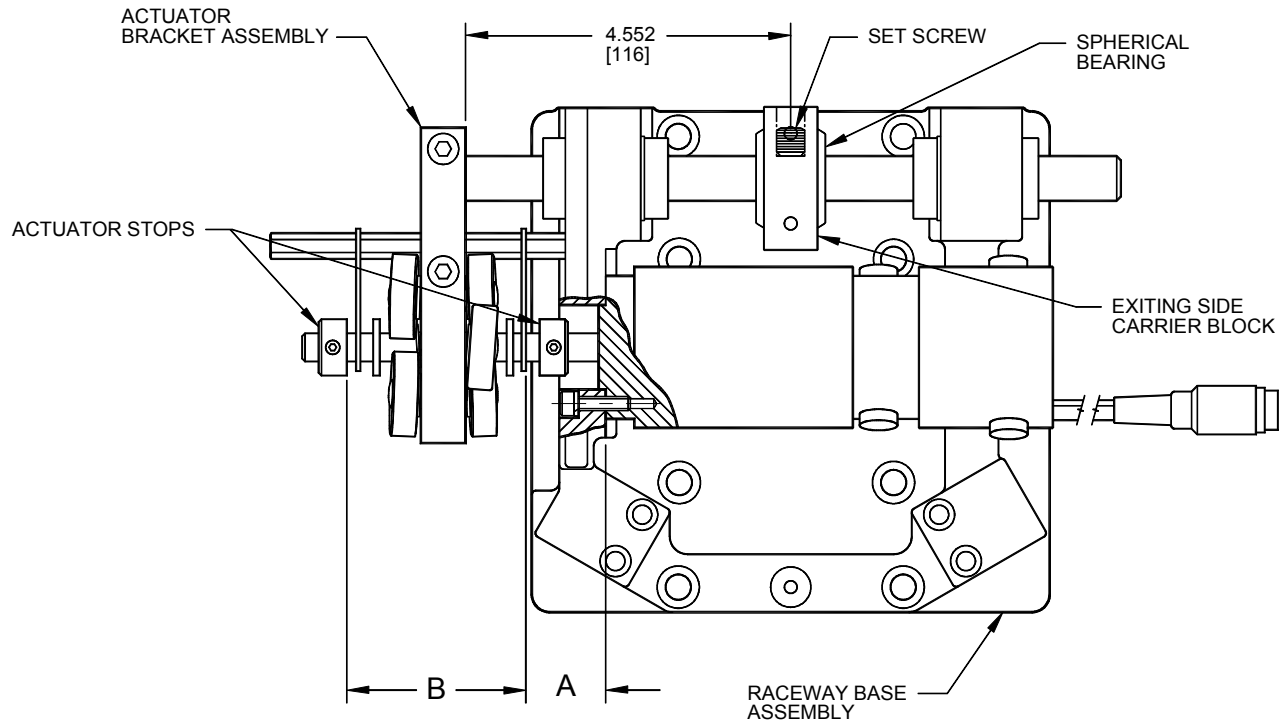


Figure 2.
SYMAT 50-LT OPG CARRIER BLOCK AND ACTUATOR STOP ALIGNMENT

RACEWAY ASSEMBLY No. 87576-	GUIDE ACTUATOR STROKE Inch (mm)	A DIMENSION Inch (mm)	B DIMENSION Inch (mm)
001	1.57 (40)	0.64 (16)	3.27 (83)
002	1.00 (25)	0.93 (24)	2.70 (69)
003	0.50 (13)	1.18 (30)	2.20 (56)