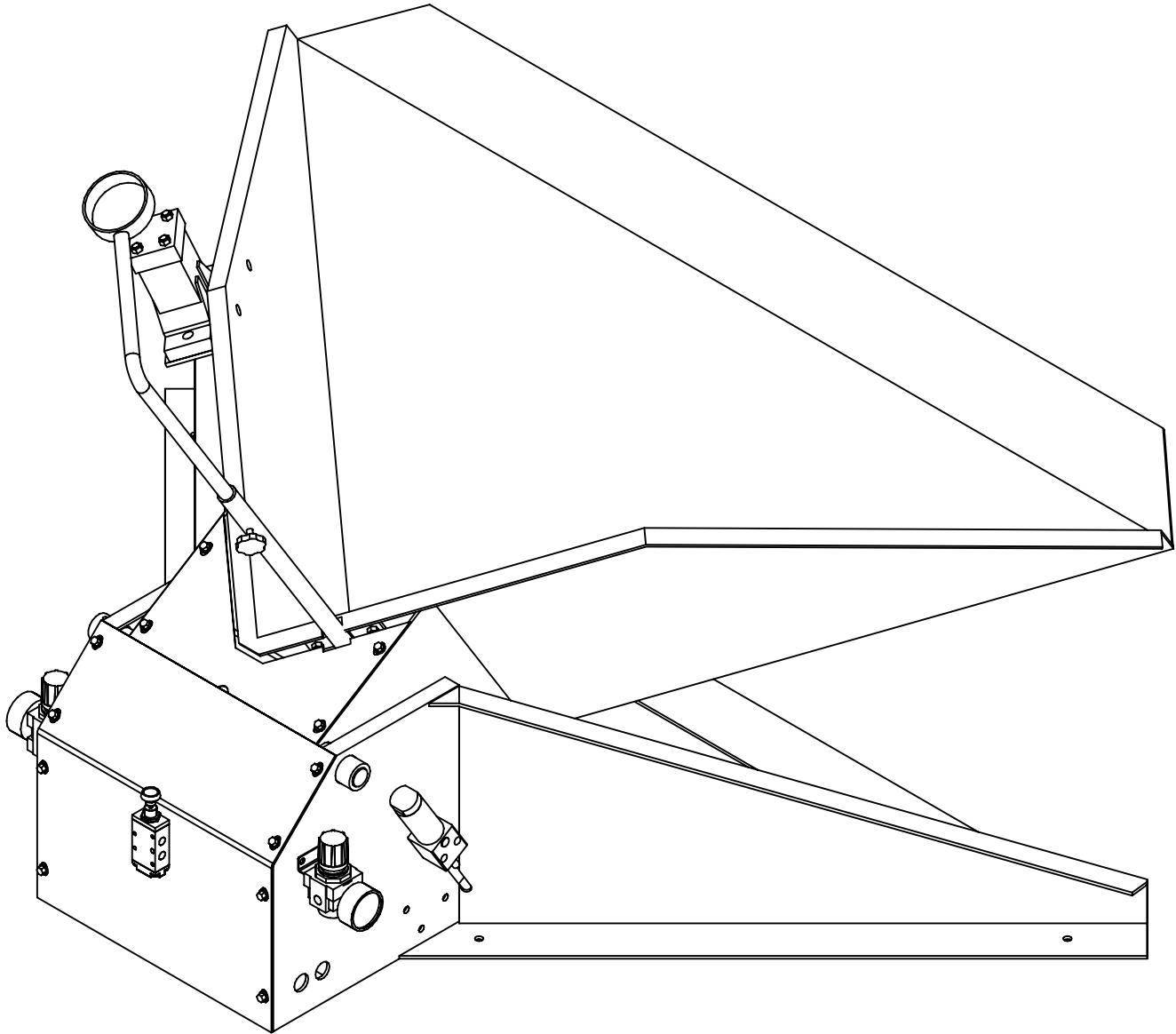


FLOOR LEVEL TILT TABLE
MANUAL
25-6000



WARNING!

UNIT MUST BE COMPLETELY ANCHORED
TO FLOOR BEFORE OPERATING.

FAILURE TO DO SO COULD CAUSE
UNIT TO TIP OR REACT VIOLENTLY.

ADJUSTABLE GAYLORD HOLDER MUST BE
SECURELY LOCKED INSIDE GAYLORD
BEFORE OPERATING.

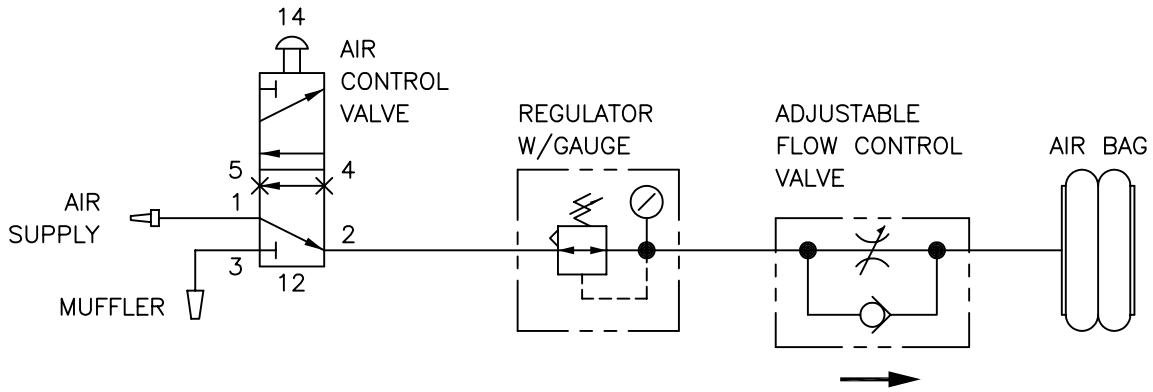
INJURY OR DEATH COULD RESULT.



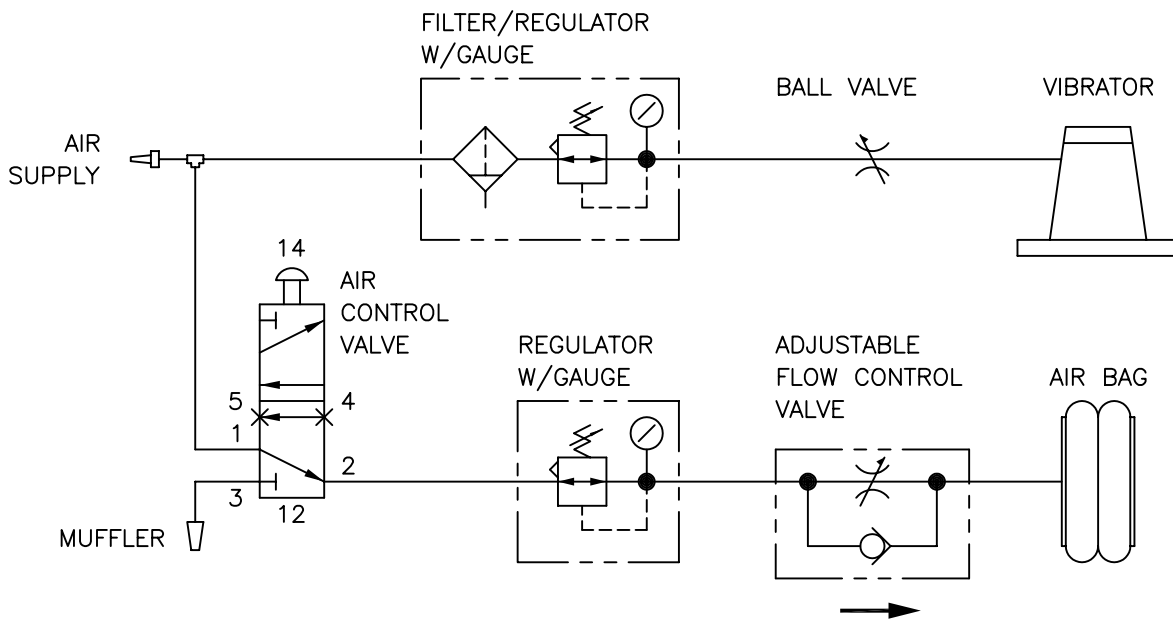
INTERNATIONAL MATERIAL CONTROL SYSTEMS INC.

510 E. 40th. ST. HOLLAND, MI. 49423 PHONE (616) 355-2800 FAX (616) 355-2890

FLOOR LEVEL TILT TABLE PNEUMATIC SCHEMATIC'S

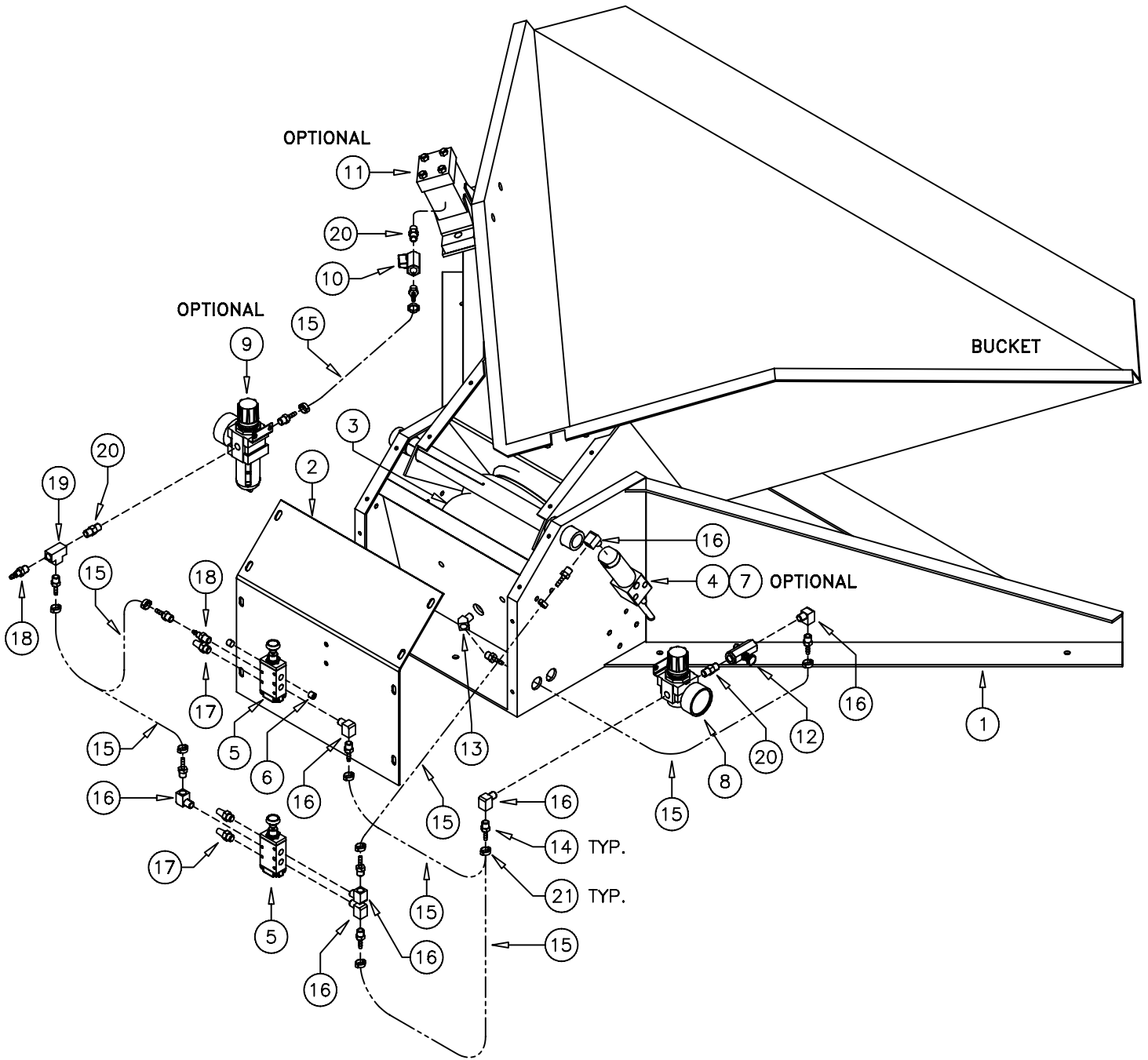


STANDARD



STANDARD WITH VIBRATOR

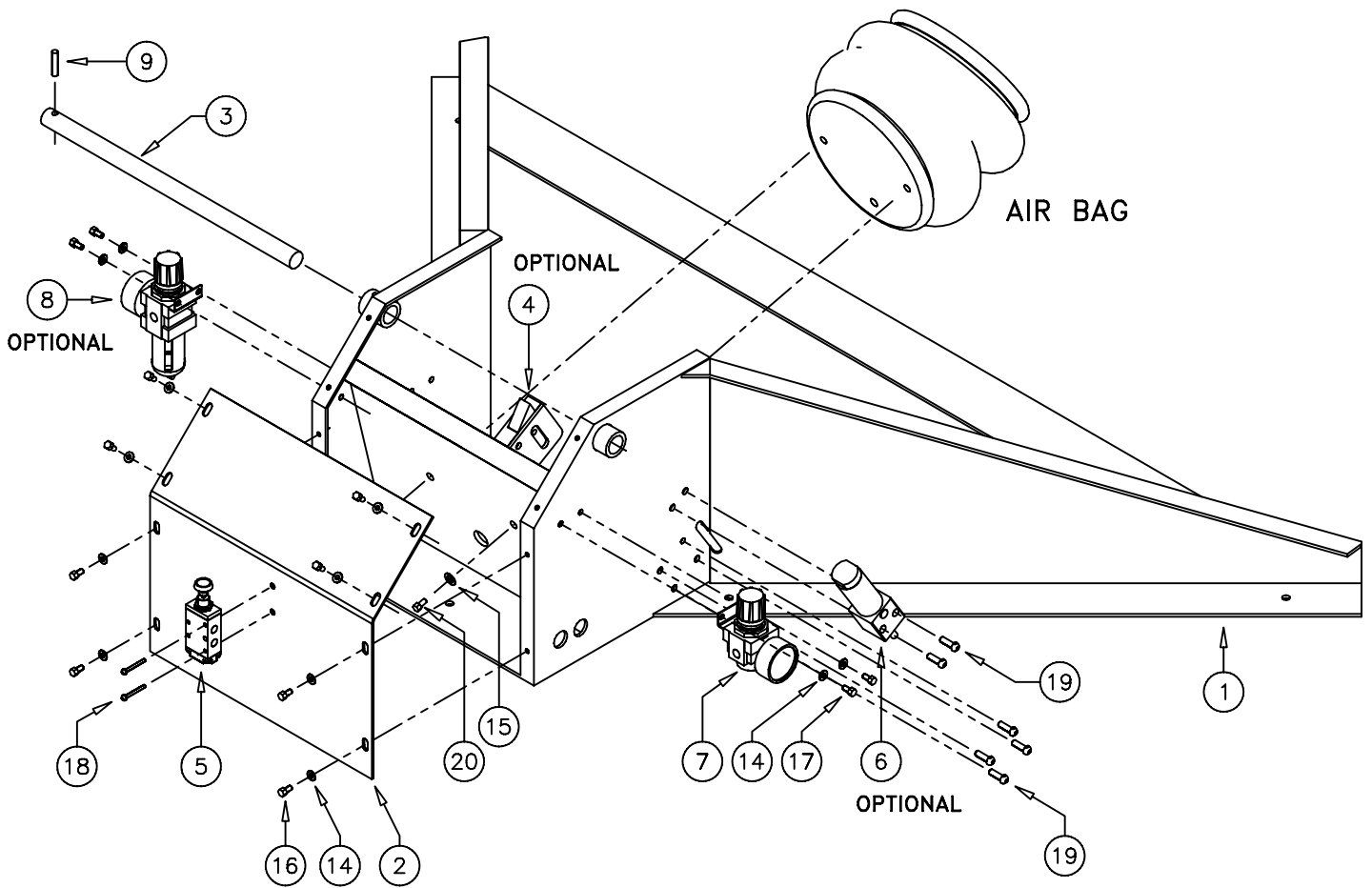
FLOOR LEVEL TILT TABLE PNEUMATIC'S



ITEM No.	QUANTITY	PART No.	DESCRIPTION
1	1	25-6002-000	FLOOR LEVEL TILT TABLE BASE
2	1	25-6003-000	BASE COVER
3	1	25-0004-000	AIR BAG
4	1	25-0016-000	SAFETY DEVICE (LATCH) PIECES
5	1	02-0121-000	AIR CONTROL VALVE, 3-WAY
6	2	02-1007-001	PLUG
7	1	02-0123-000	AIR CYLINDER
8	1	02-0009-000	REGULATOR W/GAUGE
9	1	02-0016-000	FILTER / REGULATOR W/GAUGE
10	1	02-0017-000	BALL VALVE
11	1	02-0018-000	VIBRATOR

ITEM No.	QUANTITY	PART No.	DESCRIPTION
12	1	02-0003-000	FLOW CONTROL VALVE
13	1	02-0004-000	ELBOW, 45°, 1/4"
14	10	02-0005-000	HOSE BARB
15	5	02-0007-000	HOSE: 1/4", 19", 28"
16	4	02-0008-000	ELBOW, 90°, 1/4"
17	1	02-0012-000	SILENCER
18	1	02-0013-000	SNAP-ON HOSE COUPLING
19	1	02-0014-000	TEE, 1/4"
20	3	02-0015-000	NIPPLE, 1/4"
21	10	04-0008-000	RING CLAMP, 9/16"
22	1	04-0009-000	RUBBER GROMMET

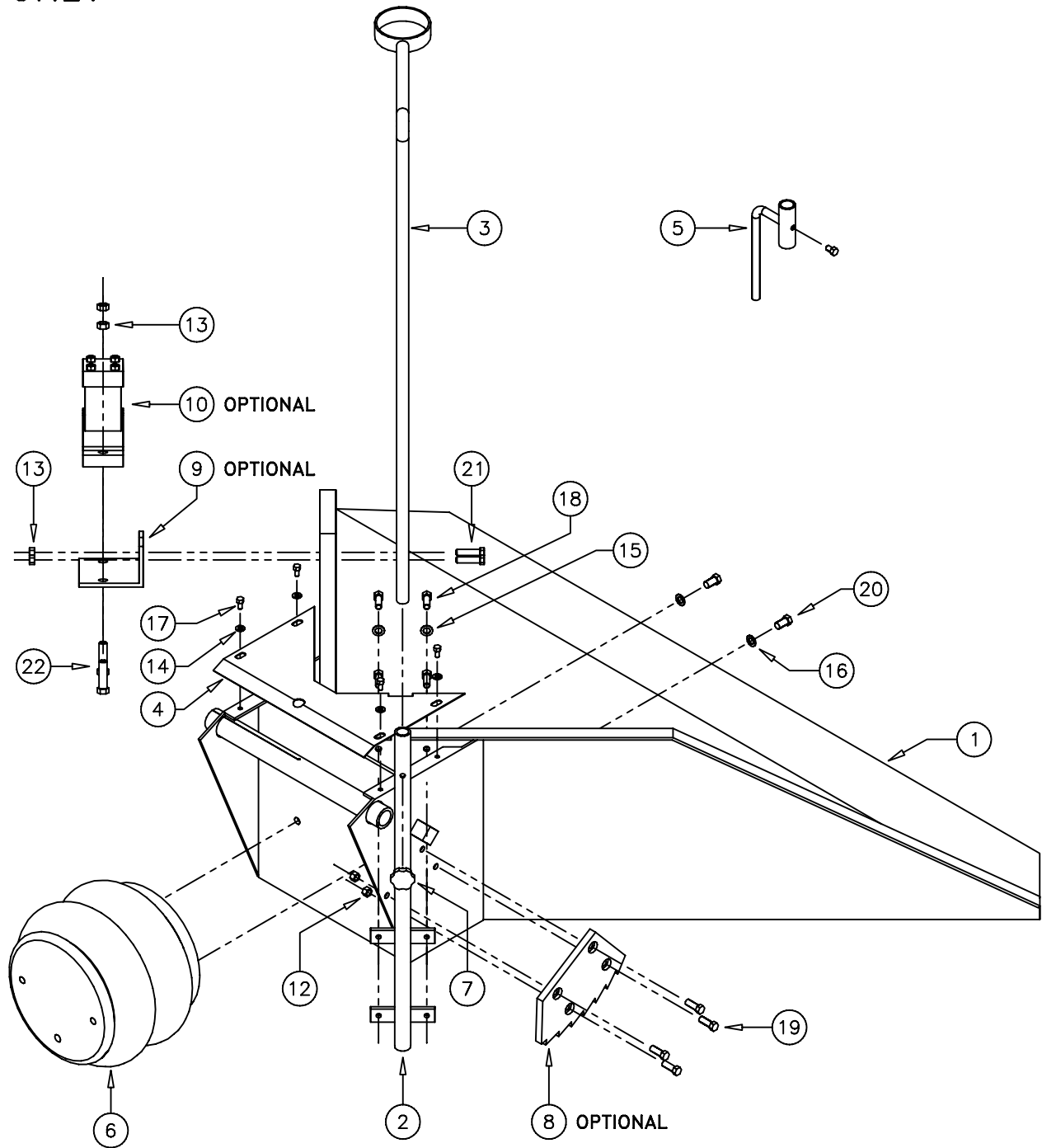
FLOOR LEVEL TILT TABLE BASE



ITEM No.	QUANTITY	PART No.	DESCRIPTION
1	1	25-6002-000	FLOOR LEVEL TILT TABLE BASE
2	1	25-6003-000	BASE COVER
3	1	25-6006-000	PIVOT SHAFT
4	1	25-0016-000	SAFETY DEVICE (LATCH) PIECES
5	1	02-0121-000	AIR CONTROL VALVE, 3-WAY
6	1	02-0123-000	AIR CYLINDER W/ROD CLEVIS
7	1	02-0009-000	REGULATOR W/GAUGE
8	1	02-0016-000	FILTER / REGULATOR W/GAUGE
9	1	00-5001-000	5/16 x 1-1/2 HARDENED ROLL PIN
10			
11			

ITEM No.	QUANTITY	PART No.	DESCRIPTION
12	2	00-4023-001	10-24 KEPS NUT
13	4	00-4023-002	1/4-20 KEPS NUT
14	10	00-2012-002	1/4 FLAT WASHER
15	2	00-2012-004	3/8 FLAT WASHER
16	8	00-0049-004	1/4-20 x 1/2 HXHDCS
17	4	00-0049-005	1/4-20 x 3/4 HXHDCS
18	2	00-0051-004	10-24 x 1-1/2 BUTHDSOCS
19	6	00-0053-002	5/16-18 x 1 BUTHDSOCS
20	2	00-0050-012	3/8-16 x 1 HXHDCS
21	1	00-0057-000	5/16-18 x 1-3/4 SHOULDER BOLT
22			

FLOOR LEVEL TILT TABLE BUCKET



ITEM No.	QUANTITY	PART No.	DESCRIPTION
1	1	25-6005-000	FLOOR LEVEL TILT TABLE BUCKET
2	1	25-0007-000	WAND RETAINER BRACKET
3	1	25-5052-000	WAND RETAINER
4	1	25-6004-000	COVER PLATE
5	1	25-6008-000	ADJUSTABLE GAYLORD HOLDER
6	1	25-0004-000	AIR BAG
7	1	25-0002-000	KNOB, PLASTIC, 5/16"
8	1	25-0016-001	RATCHET PLATE
9	1	25-0017-000	VIBRATOR MOUNTING PLATE
10	1	02-0018-000	VIBRATOR
11			

ITEM No.	QUANTITY	PART No.	DESCRIPTION
12	4	00-4026-001	5/16-18 CENTER LOCK NUT
13	4	00-4024-006	3/8-16 NYLON LOCK NUT
14	4	00-2012-002	1/4 FLAT WASHER
15	4	00-2012-003	5/16 FLAT WASHER
16	2	00-2012-004	3/8 FLAT WASHER
17	4	00-0049-004	1/4-20 x 1/2 HXHDCS
18	4	00-0050-006	5/16-18 x 1 HXHDCS
19	4	00-0053-007	5/16-18 x 1-1/4 FLSDHDCS
20	2	00-0050-012	3/8-16 x 1 HXHDCS
21	2	00-0051-003	1/2-13 x 1-1/2 BUTHDSOCS
22	2	00-0051-002	1/2-13 x 2 BUTHDSOCS

INSTRUCTION MANUAL (Continued)

This manual was prepared to give Tilt-Table owners the information they need to set up the unit when it arrives, maintain it in good running condition and to repair in case of a breakdown. PLEASE READ and UNDERSTAND MANUAL before operating unit.

ADJUSTMENT'S

1.) Automatic Tilt Adjustment

The regulator located between the control valve and the air bag governs the air pressure in the bag and adjusts the automatic tilt. To adjust the regulator, turn the knob counterclockwise until it stops. Pull the knob up, the pressure gauge should read "0". Place a container of material on the table, lock adjustable Gaylord holder in place firmly inside leading corner of container, remove a sufficient amount of material so the container will need to be tipped. Turn the knob slowly clockwise increasing the pressure until the table starts to lift. If you are going to use the table as an automatic unit, lock the regulator knob in this position. To operate the unit automatically, place a full container on the table and pull the knob up. The container will tip when it becomes light enough to be tilted with the set air pressure. For manual operation, increase the pressure slightly so the table will tilt when the container is somewhat fuller. Then just set the container on the table and pull the knob up when you want the container to tip. Do not increase the pressure so high that you could accidentally tip a full container of material.

2.) Flow Control Adjustment

A flow control is located just behind the pressure regulator. This needle valve will adjust the speed at which the table will move up and down. Turn the knob clockwise to slow the table down and counterclockwise to speed it up.

INSTRUCTION MANUAL

This manual was prepared to give Tilt-Table owners the information they need to set up the unit when it arrives, maintain it in good running condition and to repair in case of a breakdown. PLEASE READ and UNDERSTAND MANUAL before operating unit.

SET UP

Move the unit to where it will be installed. Remove the packaging material including the skid. Set the unit in the exact location where it will be used. Mark the hole locations of the feet. Anchor the unit to the floor.

We recommend using 1/2" ram set tru-bolts for concrete or 1/2" X 6" lag bolts in wood. Run your air line to the tilt-table.

Run the unit up and down a couple of times before trying the unit under a load.

DO NOT RUN the unit up with a load without first anchoring it to the floor.

Failure to do so could result in injury or death.

Structural warranty is void if unit is not bolted down.

WARNING

Never take anything loose or do maintenance on the Air System unless the bucket is all the way down and there is no pressure on the system.

DO NOT inflate to more than 100 p.s.i.

Failure to do so could result in injury or death.

NOTICE!!!

WAND RETAINER AND BRACKET MUST BE ASSEMBLED BEFORE USE.

SAFETY DEVICE

In the event of an airline or air bag failure, ratchet mechanism should activate. If this happens disconnect shop air, keep all personnel clear of tilt table. Support tilt table top with fork lift, empty and remove Gaylord (material container). While table top is still supported, check entire system for damage and replace any defective parts. Once parts are replaced, reassemble tilt table. You will have to lift and tilt back end of bucket up while moving bucket back into place. Reconnect shop air and run bucket up and down to make sure ratchet operates smoothly and does not bind.

OPERATION (No Safety Device)

The tilt table operates with a two position hand knob control. When the knob is in the DOWN position, the line pressure is off, exhaust port is open and the bag remains flat. When the knob is lifted, exhaust port is closed and line pressure is released to the air bag through the regulator, pressurizing the air bag.

OPERATION (With Safety Device)

With control knob DOWN, exhaust port for air bag is open, bag remains flat and at the same time air cylinder is pressurized deactivating ratchet assembly. When the knob is lifted, exhaust port is closed and air bag is pressurized. At this time air cylinder de-pressurizes activating ratchet assembly.

NOTICE!!!

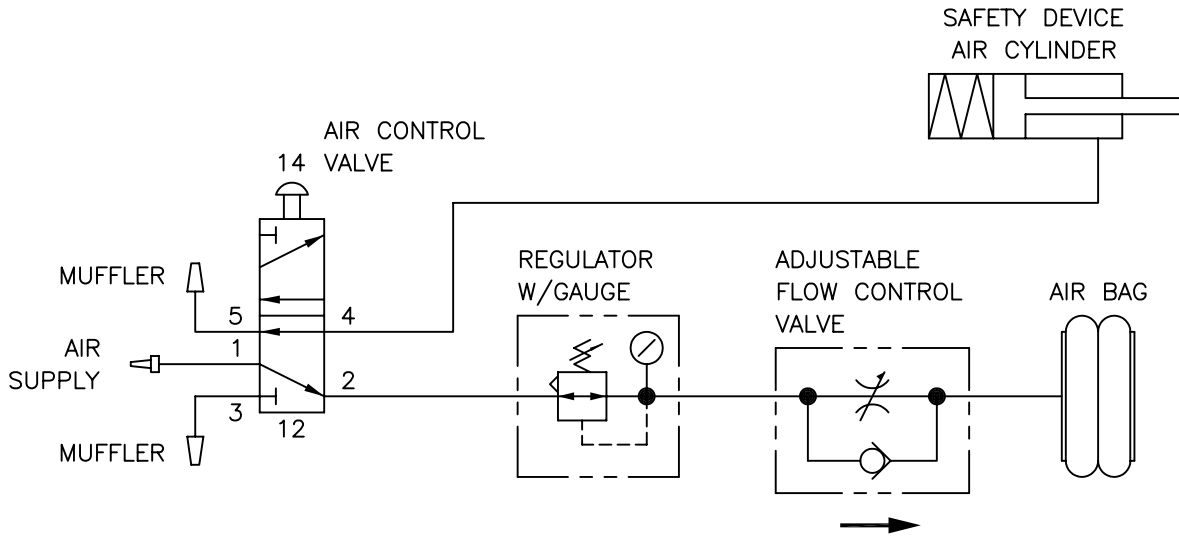
Safety Device is intended to add a degree of safety to tilt table operation. It is not intended to be used in place of other safety devices, guards or rules.

MAINTENANCE

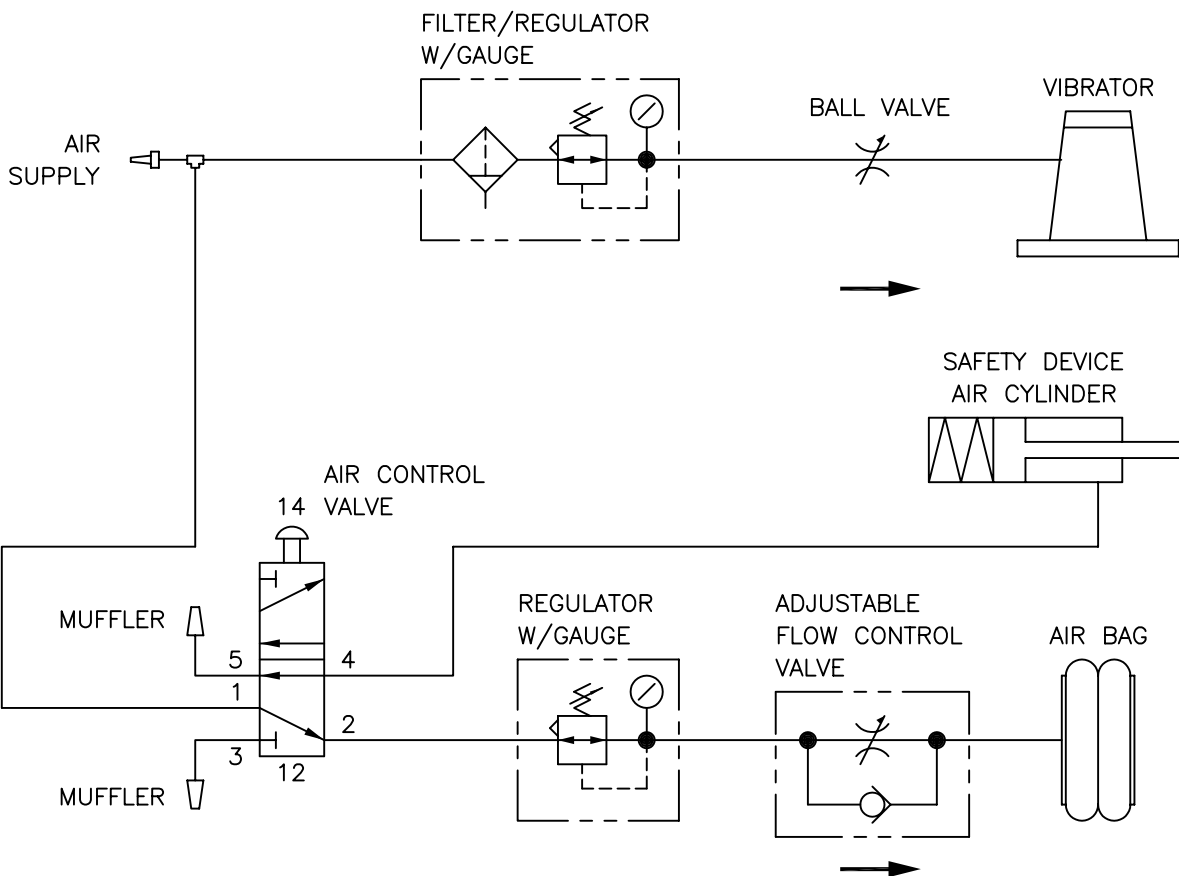
- 1.) The sleeve bearing that the table pivots on should be greased regularly when in use.
- 2.) If your unit is equipped with a Vibrator, the air filter should be cleaned regularly.

We use all no-lube parts in our Pneumatic System so no oiling is necessary.

FLOOR LEVEL TILT TABLE PNEUMATIC SCHEMATIC'S



STANDARD WITH SAFETY DEVICE



STANDARD WITH SAFETY DEVICE & VIBRATOR