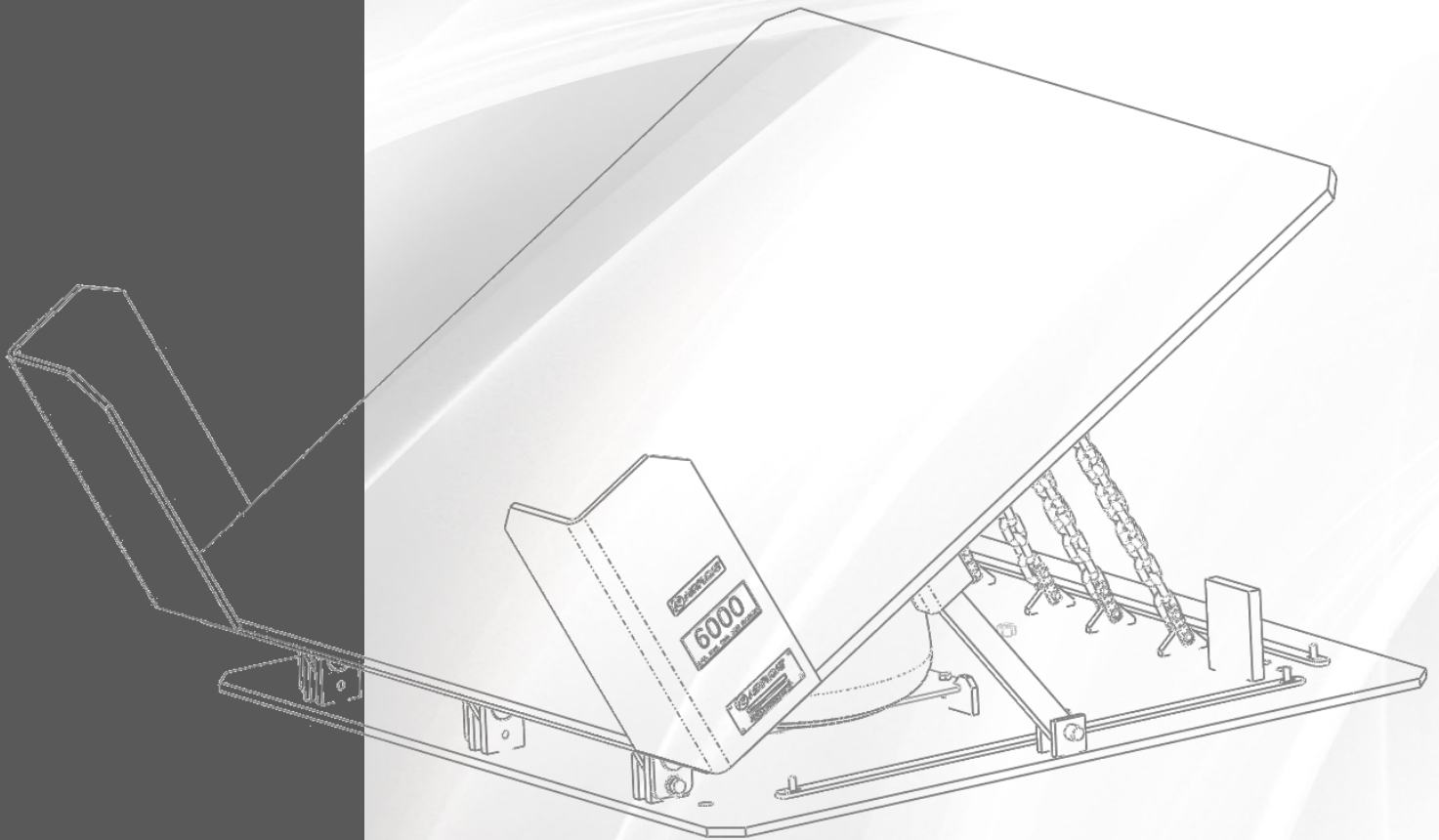




STANDARD OPERATING MANUAL PNEUMATIC TILT TABLES



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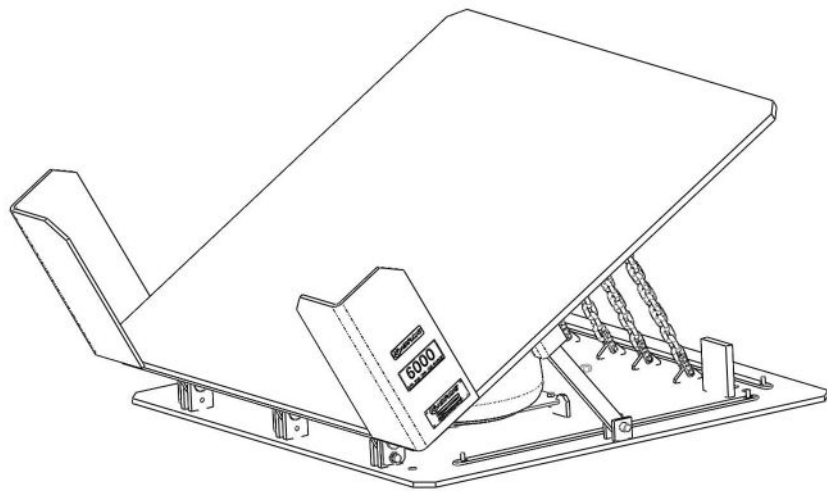
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I. DESCRIPTION OF EQUIPMENT

This equipment consists of a tilting platform which is hinged on a fixed rigid base that is bolted (lagged) to the floor or to lift table top. The platform is actuated by a control valve (hand or foot operated) which inflates an air spring within the tilt stand.

Maximum load and tilt angle varies depending on specific model. A debris skirt acts as a barrier to keep pinch points at a minimum.

II. MODELS



2,000 lb. Capacity Tilts

<u>Model Number</u>	<u>Tilt Angle</u>	<u>Model Number</u>	<u>Tilt Angle</u>
ST020-4444	30°	ST021-4444	45°
ST020-4450	30°	ST021-4450	45°
ST020-4456	30°	ST021-4456	45°
ST020-5044	30°	ST021-5044	45°
ST020-5050	30°	ST021-5050	45°
ST020-5056	30°	ST021-5056	45°
ST020-5644	30°	ST021-5644	45°
ST020-5650	30°	ST021-5650	45°
ST020-5656	30°	ST021-5656	45°
ST020-6244	30°	ST021-6244	45°
ST020-6250	30°	ST021-6250	45°
ST020-6256	30°	ST021-6256	45°

4,000 lb. Capacity Tilts

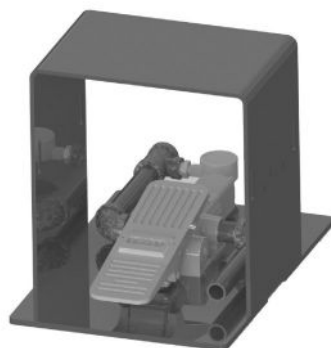
<u>Model Number</u>	<u>Tilt Angle</u>	<u>Model Number</u>	<u>Tilt Angle</u>
ST022-4450	30°	ST023-4450	45°
ST022-4456	30°	ST023-4456	45°
ST022-5050	30°	ST023-5050	45°
ST022-5056	30°	ST023-5056	45°
ST022-5650	30°	ST023-5650	45°
ST022-5656	30°	ST023-5656	45°
ST022-6250	30°	ST023-6250	45°
ST022-6256	30°	ST023-6256	45°

6,000 lb. Capacity Tilts

<u>Model Number</u>	<u>Tilt Angle</u>	<u>Model Number</u>	<u>Tilt Angle</u>
ST024-5050	30°	ST025-5050	45°
ST024-5056	30°	ST025-5056	45°
ST024-5650	30°	ST025-5650	45°
ST024-5656	30°	ST025-5656	45°
ST024-6250	30°	ST025-6250	45°
ST024-6256	30°	ST025-6256	45°

III. SET-UP INSTRUCTIONS

1. Set unit on floor at location. **IMPORTANT: DO NOT** lift or transport the tilt stand with lifting device attached to the tilting platform. Damage to the air spring may result.
2. Once the installation area has been chosen, set the unit onto the floor and mark the holes located on the base of the tilter.
3. Move the tilt stand to the side and drill holes in the floor. Use four anchor bolts (Readhead® or Hilti®) with appropriate flat washers to secure the tilt stand base to the floor (as specified by Safebilt).
4. If hand (or foot) controls were supplied, locate where desired and make air connection to inlet of valve on the hand (or foot) control.



Optional Foot Control

IV. OPERATING INFORMATION

Raising and Lowering Unit

To Raise the Unit: Activate control valve in the “Lift” position (hand control example shown below). Once the operator releases the valve, the platform will hold its position until the operator readjusts.

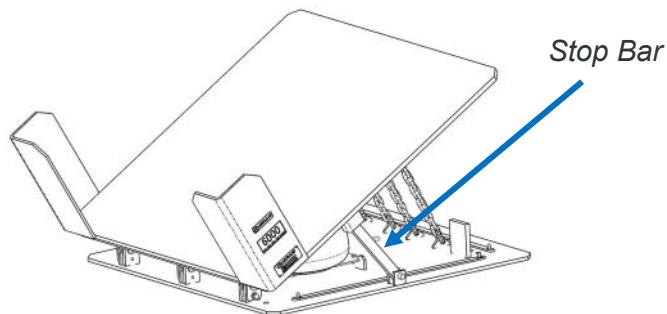
To Lower the Unit: Activate control valve in the “Lower” position to lower until the unit becomes horizontal.



V. SERVICE AND MAINTENANCE

To Replace Air Spring on Lift (Unloaded Unit Only)

1. Raise unit to full height.
2. Remove debris skirt and lock the tilt table by rotating the stop bar(s) into a position that will lock the tilt top from falling down



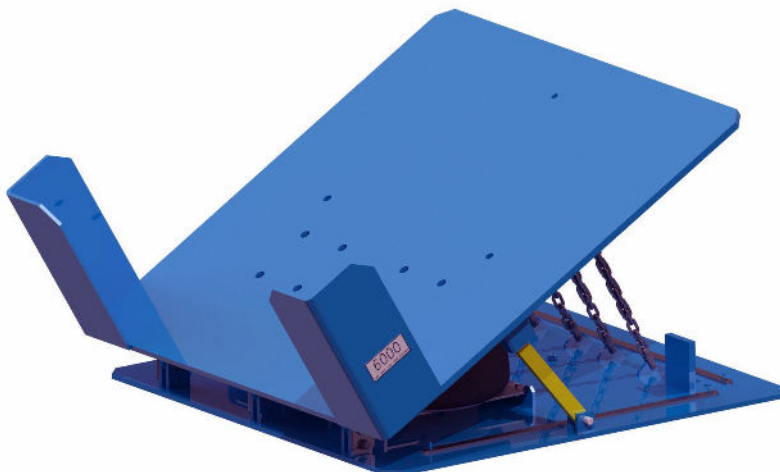
3. Drain air line to table and lock out.
4. Remove air inlet plumbing and eight (8) 3/8” cap screws securing air spring top and bottom
5. To reinstall, reverse the above procedure.

VI. TROUBLESHOOTING

Problem	Cause	Remedy
Station will not tilt.	Valve not operating properly.	Inspect for air on inlet and outlet side. Repair or replace.
	Damaged air spring.	Inspect and replace.
	Too much weight.	Ensure that the load is within the capacity of the unit. Redistribute or lighten load
Tilt sections will not go down completely.	Chain not retracting.	Inspect assembly.
	Low air pressure.	60 PSI min. — 80 PSI max.
	Exhaust filter clogged.	Inspect and replace.

VII. SPARE PARTS

Model Number	Air Spring	Hand Ctrl. Valve	Foot Ctrl. Valve
ST020-XXXX	ASPF6810	VSD6003	VSD6004
ST021-XXXX	ASPF6810	VSD6003	VSD6004
ST022-XXXX	ASPF6810	VSD6003	VSD6004
ST023-XXXX	ASPF6810	VSD6003	VSD6004
ST024-XXXX	ASPF6810	VSD6003	VSD6004
ST025-XXXX	ASPF6810	VSD6003	VSD6004



LIMITED WARRANTY

Align Production Systems (APS) warrants all of its products to be free of defects in material and workmanship for a period of one (1) year from date of shipment to the original purchaser or 2,000 operating hours, whichever comes first, provided purchaser gives APS prompt notice of the alleged defect(s) and, if requested by APS, returns the defective items, freight prepaid (F.O.B. APS’s plant in Decatur, Illinois). THE WARRANTIES SET FORTH HEREIN ARE IN LIEU OF ALL OTHER WARRANTIES, WHETHER EXPRESS OR IMPLIED, INCLUDING, WITHOUT LIMITATION, FITNESS FOR A PARTICULAR PURPOSE AND MERCHANTABILITY, ALL OF WHICH ARE EXPRESSLY DISCLAIMED.

For any claim under warranty, APS may elect to repair or replace the defective component or components. All claims for warranty must be accompanied by a Return Goods Authorization number, which may be obtained from APS. This warranty does not cover, and APS is not responsible for, any labor or other expense for inspections, removal or reinstallation of components or products.

This warranty does not cover, among other things, damages resulting from foreign matter or water, negligence, accident, unreasonable use, abuse or misuse, alterations not authorized by APS, failure to provide reasonable and necessary maintenance or failure to follow operating instructions or load limits. IN ADDITION, IN NO EVENT SHALL APS BE LIABLE FOR ANY SPECIAL, INDIRECT, INCIDENTAL, CONSEQUENTIAL OR CONTINGENT DAMAGES, WHETHER OR NOT IT HAS BEEN ADVISED OF THE POSSIBILITY OF SUCH DAMAGES.

APS makes no representation that the product complies with local, state or federal safety/product standards codes. If the product fails to comply in any way with those codes, it shall not be considered a defect in materials or workmanship, and APS shall not be liable for any damages resulting from noncompliance. This limited warranty is provided to the original purchaser (meaning the original end user) and is nontransferable. This limited warranty constitutes the complete and final agreement regarding APS warranty obligations for the product.

ALIGN PRODUCTION SYSTEMS BRAND LINEUP



Airfloat



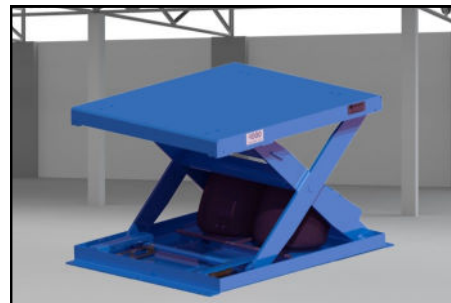
Silvestrini NA



Axial Industrial Turntables



Tecbo Tooling



Safebilt