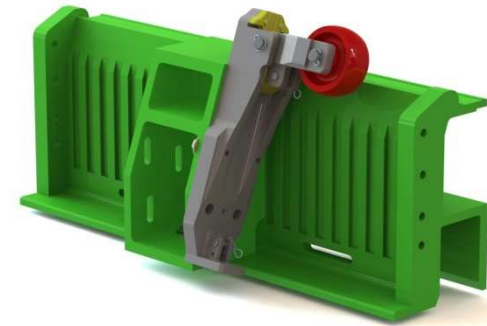


Tilt Tray Sorter System Carriage *Tip Up Replacement*



1

- ✓ Engage and secure sorter shutoff switch.
- ✓ Disconnect electric controller from tip up assembly.
- ✓ Disconnect the air line from the tip up assembly.

2

- ✓ Retract tip up actuator if extended.
- ✓ Remove three bolts from tip up body.
- ✓ Remove tip up assembly from tip up mounting block.

3

- ✓ Install new tip up assembly with three attachment bolts.
- ✓ Check for proper alignment and adjust as necessary.
- ✓ Check for secure fit.

4

- ✓ Install air line to tip up assembly.
- ✓ Install electric controller contacts to tip up assembly.

5

- ✓ Check all for secure fit.
- ✓ Check for proper activation and freedom of motion.
- ✓ Disengage sorter shutoff switch.

6

WARNING
Make sure to engage and secure sorter shutoff switch in Step 1.

WARNING
Do not disengage sorter cutoff switch until certain all personnel and equipment are clear.