

Alteration for table removal 721-06LT and 7228-06LT

To facilitate entrance through doorways it is possible to remove both the front and rear tables.

Machine width with both tables on = 150 cm (59")

Machine width with rear table removed = 96 cm (37,8")

Machine width with front and rear table removed = 70 cm (28")

IMPORTANT: The disassembling and assembling of the machine should only be done when the machine is disconnected to the wall. Capacitor C3 must be unloaded.

1. Remove all wooden panel of the machine (⚡ required tool found in tool box).
2. Remove the steel cover underneath the front and rear table by loosen the screws (⚡ required tool found in tool box).
3. On the table remove the six 4mm flat head allen screws holding the rear table panels in the **front** by the cutting stick (⚡ required tool found in tool box). It is not necessary to remove the center screw directly over the back gauge spindle.
4. Remove the machine cover. **Caution:** In the rear part of the cover is the left side the cable of switch S.13. Remove the two cables and return the cable into the rear table. Remove the plug of the flat band cable, going to the display. Screws are sealed with locking glue (⚡ required tool found in tool box).
5. Remove the following cable inside the switch box (located on the right side) of the rear table (⚡ required tool found in tool box):

Two wire cable on the terminal: brown on +
blue on -

Two wire cable from switch S19 on the PCB A4.

Press Clip of plug K16 on the PC board A1 and pull the plug.

Press Clip of plug K16 on the PC board A3 and pull the plug

All three wires should be returned into the rear table.

6. Remove the blue cable of switch S.14 underneath the rear table. Remove the brown wire of the plug connection of the switch 14. Remove the tube connections of the air table to the rear table carefully.
7. From the rear of the machine look underneath the table towards the front top right hand corner and remove the 13 mm bolt, likewise on the left side. Remove the rear 13 mm nuts on the right and left side frames of the machine (on mounting studs). Loosen the front 13 mm nuts on the left and right sides and remove one from the mounting studs. Have two people hold the rear sides of the table up while a third person takes the last nut off. Lift the table up slightly and then back away from the machine. Carefully set the table down on its side.

Note: Do not readjust the double nuts underneath the table on the mounting studs, these are factory set and affect table alignment.

Front table

8. Remove two 13 mm bolts from the foot pedal assembly, put pedal off to one side (➡ required tool found in tool box).
9. On top of the front table remove the five 4 mm flat head allen screws (knife side). Remove the small side lays on both sides, as well as the five tube connections underneath the front table along the cutting stick. Remove the 3 Phillips screws on each side from the cover of the light beam. Remove the three screws of the bracket with the light beam on, turn the bracket 180° and use one each of the hexagon screws M8x45 from the tool box and mount the bracket onto the sunked borehole (➡ required tool found in tool box).
10. Have two people hold the front table, as long as a third person has marked the height of the front table. Then remove the two 13 mm screws on each side, lift up the table and pull the front table gently out (approx. 10 cm). Take one screw on each side, and screw it into the machine frame (where the front table was mounted). Take some strong twine or packing string and pull it through the side table boltholes. Tie the twine around the screw in the machine frame and then let the table hang from the twine (➡ required tool found in tool box). Now the machine is on its smallest portable size (approx. 70 cm/ 28").

Reassembling tables

11. Remove the twine connection and the screws of the machine frame and put the front table back in its original position. Make sure, that all 5 rubber buffers are in their position and center the table with the five allen screws. Tighten the screws as long as the front plate is even with the cutting stick. Put four 13 mm screws into the front table and tighten them on the marked height. Re-attach the tube connections. Remove the screw M8x45 from bracket of the light beam, turn it 180° and mount it back to the front table (➡ required tool found in tool box).
12. Install rear table and center the table with the six 4 mm allen screws and snug them slightly. Tighten one 13 mm screw and two 13 mm nuts on each side underneath the table. Reattach foot pedal (➡ required tool found in tool box).
13. Reattach all electric connections to the switchboard and to the rear table. Reattach the flat band cable for the EC control. Reattach the tube connections (➡ required tool found in tool box).
14. Plug the machine into the wall and check operation. If the cutting line light is not shown up, the phase connections are incorrect and have to be changed.
15. Reattach all machine covers. Reattach the two cables of switch S.13 on the top cover.