



Shelf Kit Installation Instructions

1. **Building Shelf Kit.** The 1" 8020 kit is numbered to make it real easy to put together. They slide together as in the picture below (Fig. 1). Simply match up the numbers and lightly tighten up the ¼" bolts using an allen wrench. Flip the shelf kit upside down and loosen the bolts so the shelf kit is completely flat and then firmly tighten the bolts. Don't go more than about 10-15 ft.lbs of pressure.
2. **Marking the Shelf.** Take the shelf kit and figure out where you will install it on the autodrive aluminum plate. You will need to set the shelf onto the Shelf Kit slightly offset. The front will be about 2" from the edge of the shelf kit and to the side about 2.5". It isn't exact, you just want the bolts in the Adjustable Mount Kit for the MK6 to be exposed. See Figures 2 and 3. Mark the shelf so you know where the middle lines of the Shelf Kit line up to install the shelf. Verify your lines after you have fully installed the Shelf Kit.
3. Use the MK6 mount template provided and mark the shelf where the MK6 will be installed. Keep in mind, the tube coming off the MK6 should be about 1" from the primer tube assembly on your press. Make sure the 2 front bolts will clear the Shelf Kit rail. Make sure the right two bolts will clear the Shelf Kit rail. See Figures 2 and 3. Drill your 4 holes for the Adjustable Mount Kit bolts.
4. **Installing the Shelf Kit.** Install the 3 45 degree angle brackets on the bottom each leg. Lightly tighten them until you figure out where to drill your holes in the autodrive aluminum plate. The three brackets include Qty: 3 10-32 x 1" screws with washers and a nylon lock nut. They are intended to be put entirely through the aluminum plate. Once you place the shelf kit on your plate, mark the three holes on the aluminum plate and then drill the 3 holes entirely through the aluminum plate (To ensure proper placement and alignment, I would recommend drilling one hole at a time). It will be easier to get the washer and locknut on the bottom of each screw if you put 2 2x4s under the autodrive plate so you can get your fingers under the plate. **(NOTE:** Some Autodrive Plates have a space in the front left corner in front of the brain. Use the provided spacer to level out the area where the corner bracket will be installed.) See Figure 3 below.

5. **Installing the Shelf.** Verify your lines once again before doing your drilling. You will use the Qty: 8 of the 1/4-20 Roll-In T-Nut with Ball Springs (Fig. 2) to attach the shelf to the shelf kit. Place 2 of the Roll-In T-Nut into each shelf rail with the half moon facing down. They go into the slot from the top by placing them sideways and then dropping them in to the slot. They will slide back and forth and will be your nut for each of the screws you purchased for the shelf. VERIFY your lines again on the shelf. Drill the 8 holes, 2 for each leg of the shelf kit. Use the 1/4-20 screws you bought to secure the shelf to the Shelf Kit by aligning them with the Roll-In T-Nut.
6. **Installing MK6.** Install the 4 bolts of the Adjustable Mount Kit bolts to your shelf. See Figures 4 and 5. You will first need to remove the 4 aluminum spacers that are currently installed on the MK6 mount plate. It will require a metric allen wrench. Be careful with the MK6 without the spacers – there is nothing flat for it to rest on until you place them on the Adjustable Mount Kit bolts.
 - a. Now you need to level the MK6 by placing a small level on the top of the bowl and adjust the two nuts until the MK6 is level in both directions. Place the washer and locknut on the top of the MK6 mount plate and secure it to the nuts. Recheck your level in both directions.
 - b. Finalize your installation by plugging in the power, sensor plug to the controller along with the power.
 - c. You will plug the controller in to the right plug of the transformer. The transformer is already set for 110V source and 220V out on the right plug.

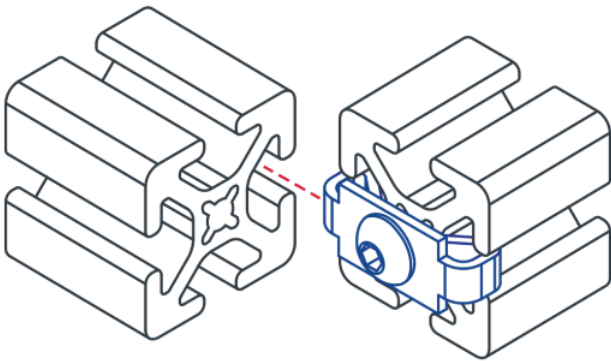



Figure 1



Figure 2



Figure 3



~2.0"

~2.5"

Note how the bolts are clear from the Shelf Kit rails.

