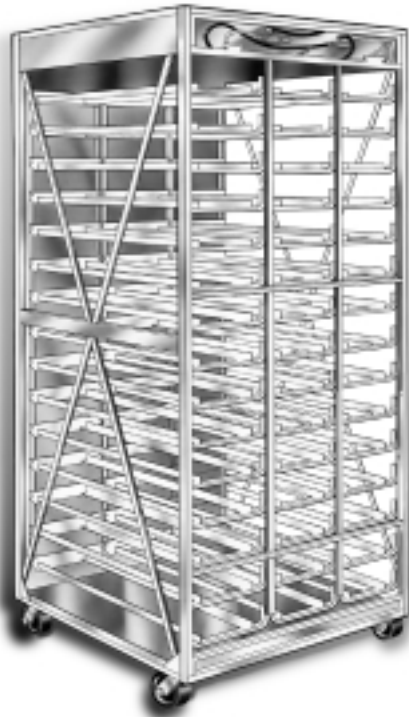


# *Jamesway Incubator Systems*

---

## 3-Column Incubator Rack Assembly Instruction and Parts



A member of the Marmon Group of companies



MANRAK  
Revision E

**Jamesway Incubator Co. Ltd.**  
**International Office**  
30 High Ridge Court  
Cambridge, Ont., Canada  
N1R 7L3

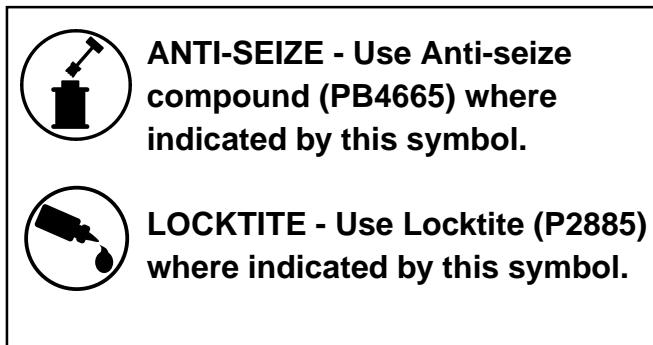
tel: (519) 624-4646  
fax: (519) 624-5803  
email for customer service:  
service@jamesway.com



*This book and its contents are the property of the Jamesway Incubator Company Ltd.  
Reproduction in whole or in part, by any means, without permission of Jamesway Incubator Company Ltd. is prohibited.  
© 2000 Jamesway Incubator Company Ltd.*

# CONTENTS

Important Assembly Notes .....	5
Assembly of Outer Frame .....	6
Installation of Casters .....	8
Installation of the Turner Shaft .....	9
Installation of Turning Bars .....	11
Installation of Egg Tray Frames .....	12
Installation of Hanging Bars .....	14
Installation of Rail Spacers .....	15
Squaring and Tightening the Rack .....	16
Installation of Tray Spacers .....	18
Installation of the Drive Bar Assembly .....	19
Installation of the Air Cylinder and Tubing .....	20
Installation of Turn Sensor .....	21
Final Inspection .....	22
Application of Locktite .....	23
Accessories .....	24
Replacement Parts for Racks .....	24
Caster Identification .....	24
Replacement Parts for Casters .....	25
Incubator Rack Tester .....	26
Index .....	27
Inspection Procedure .....	29





# IMPORTANT ASSEMBLY NOTES

A Jamesway technician must supervise the assembly of all incubator racks. The assembly check lists supplied with the instructions in each incubator rack pack must be used for each rack. Careful, methodical assembly of each incubator rack will prevent many problems with rack turning.

A correctly assembled rack should turn smoothly and easily with an air pressure of 25 PSI.

Tighten all Allen Head Cap screws using only the Allen key supplied in the hardware pack. Apply only hand leverage for tightening fasteners. Over tightening fasteners will cause buckling of the back panel and result in poor turning.

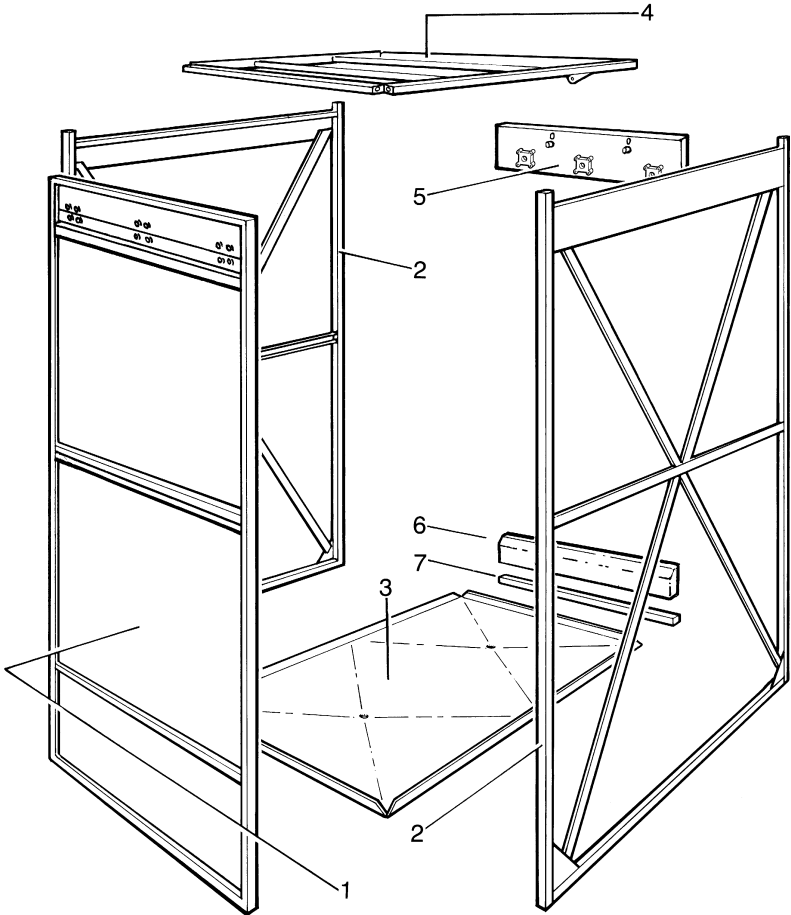


Figure 1

Item	Part No.	Description
1	AB4099	Back Panel Assembly (Chicken)
	AB5847	Back Panel Assembly (Turkey)
2	AB4101B	Side Frame Assembly (Chicken)
	AB5849	Side Frame Assembly (Turkey)
3	MB15019	Bottom Panel
4	AB4110B	Top Frame Assembly
5	AB5309	Front Bearing Panel Assembly (Imperial Eastman)
	AB5467	Front Bearing Panel Assembly (Bulkhead)
6	MB15022	Bottom Front Panel
7	AB4103	Bottom Rib and Nut Assembly

## ASSEMBLY OF OUTER FRAME

**Step 1:** Place the back panel (Item 1) onto several long blocks of wood (or other supports) laid upon the floor (Figure 2). The lumber from the incubator rack packing crates is ideal for this purpose. Attach the side frames (Item 2) loosely to the back panel (Figure 3) using Items 4 and 5.

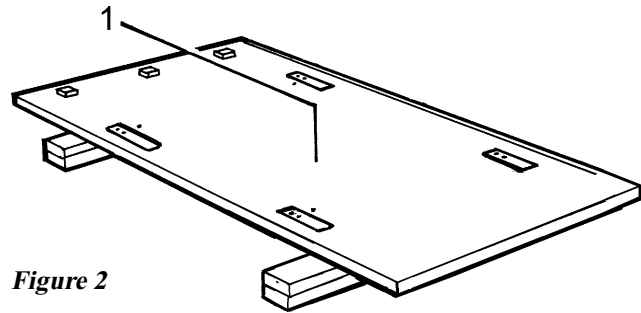


Figure 2

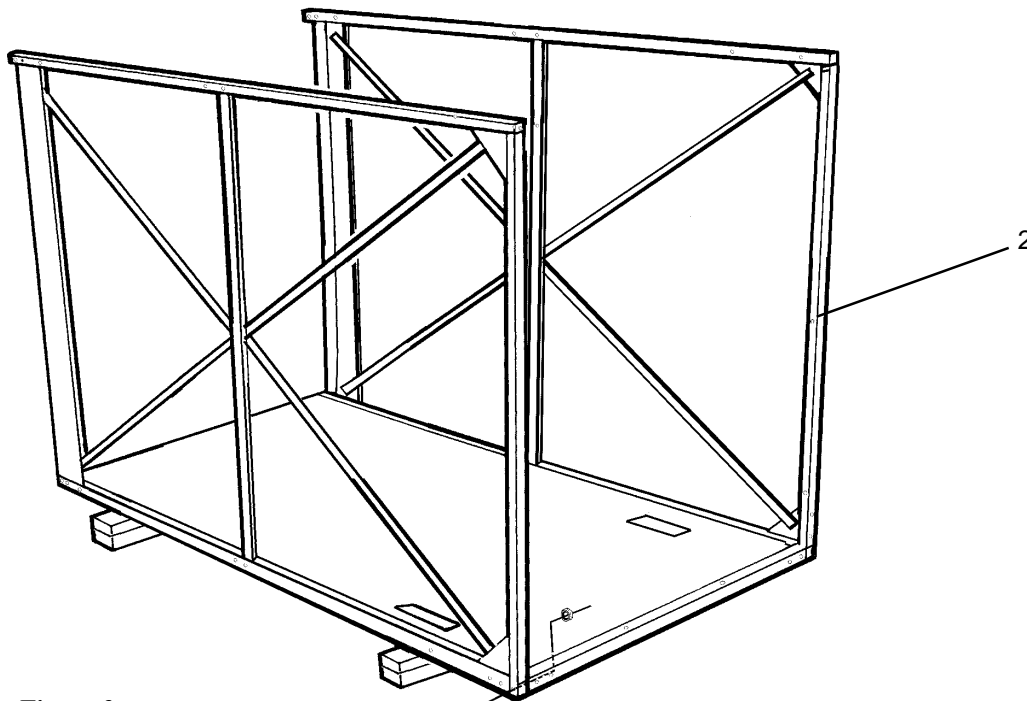


Figure 3

**Step 2:** Insert the top frame assembly (Item 3) and attach loosely using Items 4 and 5, (Figure 3).

Item	Part No.	Description
1	AB4099	Back Panel Assembly (Chicken)
	AB5847	Back Panel Assembly, (Turkey)
2	AB4101B	Side Frame Assembly, (Chicken)
	AB5849	Side Frame Assembly, (Turkey)
3	AB4110B	Top Frame Assembly
4	O880510	5/16"-18 x 5/8" Allen Head Cap Screw
5	O490500	5/16" - 18 Hex Lock Nut

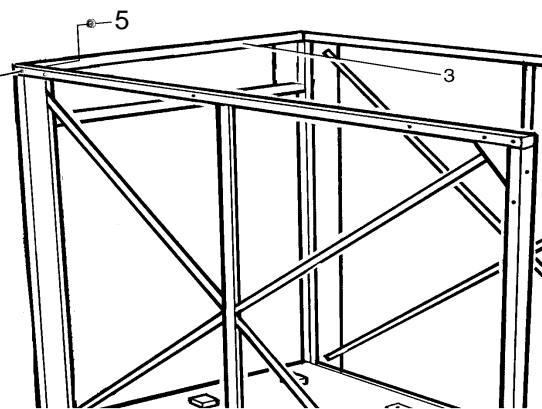


Figure 4

**Step 3:** Insert the bottom panel (Item 1) between the side frames (Item 2) with the folded edges facing up (Figure 5). Loosely secure using Items 3 and 4.

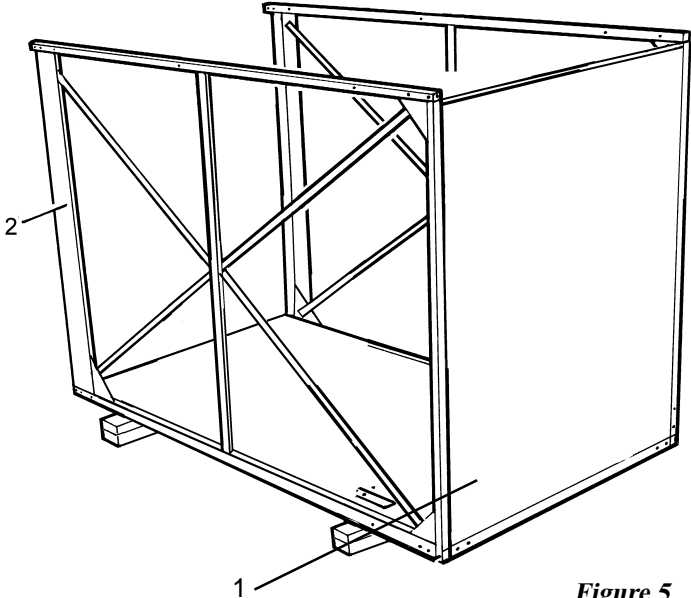


Figure 5

**Step 4:** Insert the rib and nut assembly (Item 6) between the side frames and secure loosely with Items 3 and 4.

Insert the bottom front panel (Item 7) above the rib and nut assembly (Item 6) with the bevelled edge facing inward and towards the top of the rack. Secure loosely with Items 3 and 4. Square the rack in all directions and hand tighten all screws. **Do not over tighten.**

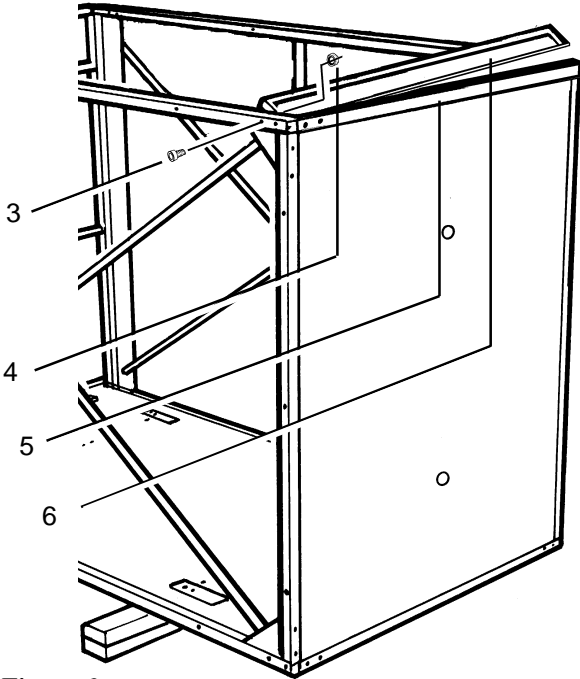
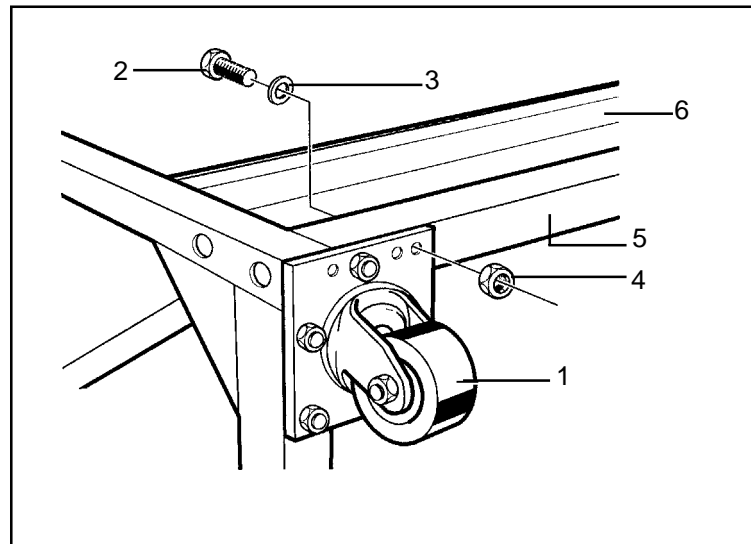


Figure 6

Item	Part No.	Description
1	MB15019	Bottom Panel
2	AB4101B	Side Frame (chicken)
	AB5849	Side Frame (turkey)
3	O880510	5/16" - 18 x 5/8" Allen Head Cap Screw
4	O490500	5/16" - 18 Hex Lock Nut
5	AB4103	Rib and Nut Assembly
6	MB15022	Bottom Front Panel

## INSTALLATION OF CASTERS



**Figure 7:** polyolefin caster with “X” plate shown

**Step 5:** Install casters (Item 1) using Items 2,3 and 4 as shown in Figure 7.

Item	Part No.	Description
1	PB3157	V-Groove Swivel Caster Steel
	PB4355A	Polyolefin Swivel Caster
	PB4720	V-Groove Swivel Caster Nylon
2	O240528	5/16" - 18 x 1-3/4" Hex Head Cap Screw
3	O660500	5/16" Flat Washer
4	O490500	5/16" - 18 Hex Lock Nut
5	AB4103	Rib and Nut Assembly
6	MB15022	Bottom Front Panel

## INSTALLATION OF THE TURNER SHAFT

**Step 6:** Apply Antiseize compound the inside of each of the three (3) bearing blocks (Item 2).

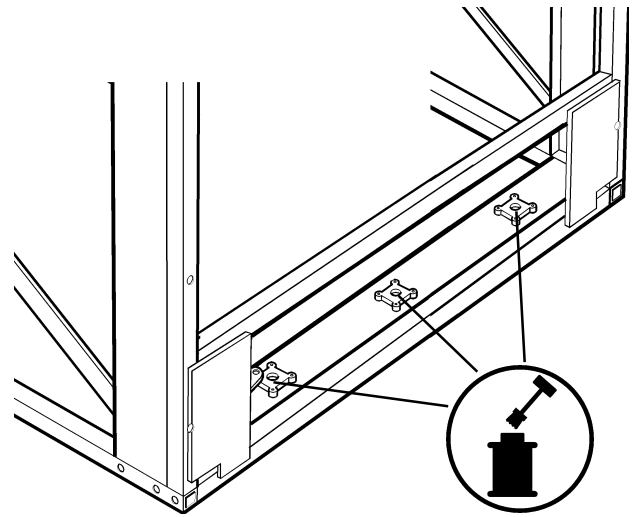


Figure 8

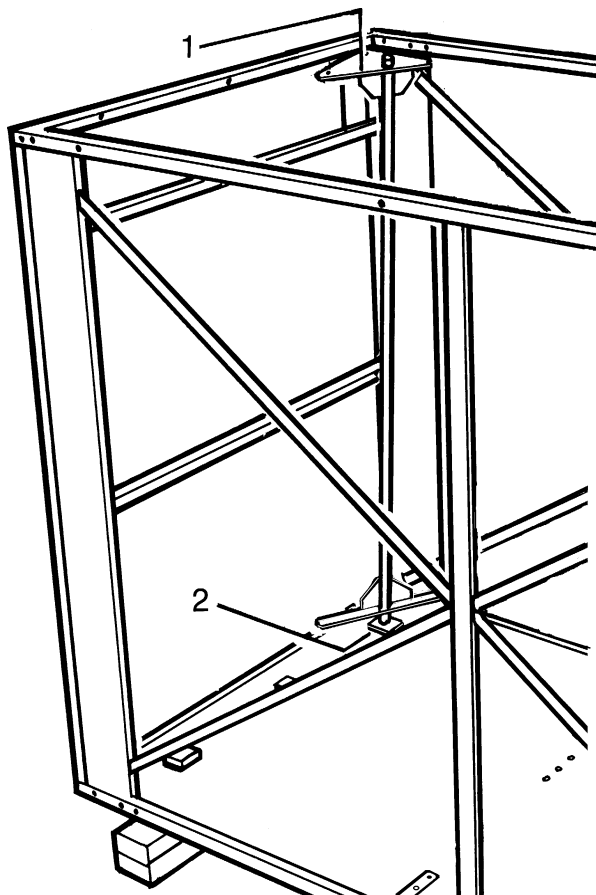


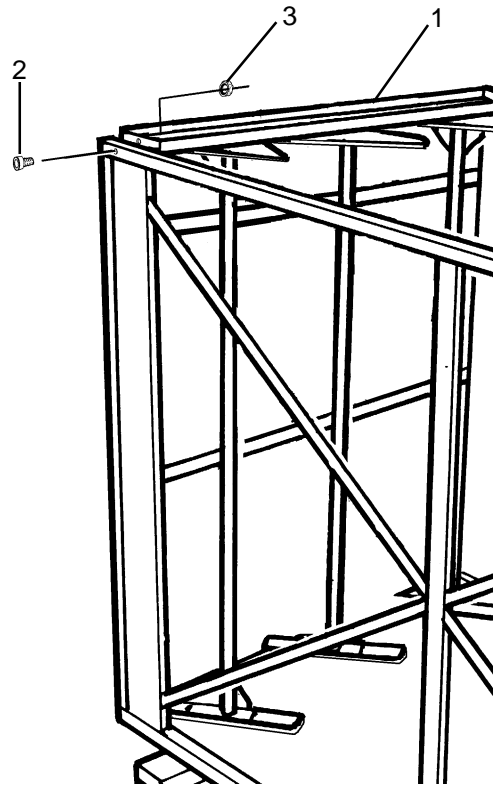
Figure 9

Item	Part No.	Description
1	AB3553	Turner Shaft Assembly
2	PB4911	Bearing Block (Qty.3)

**Step 7:** Insert a turner shaft assembly (Item 1) into each bearing block (Item 2) of the back panel (Figure 9).

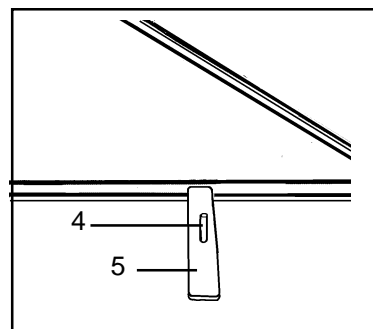
**Step 8:** Carefully place the front bearing panel over the three (3) turner shafts and between the side frames and the top frame (Figure 10). Secure loosely with Items 2 and 3.

Item	Part No.	Description
1	AB5309	Front Bearing Panel Assembly (Imperial Eastman)
	AB5467	Front Bearing Panel Assembly (Bulkhead)
2	O880510	5/16" - 18 x 5/8" Allen Head Cap Screw
3	O490500	5/16" - 18 Hex Lock Nut
4	PB3919	3/16" x 2 Lg. Roll Pin
5	MB17501	Wear Strip

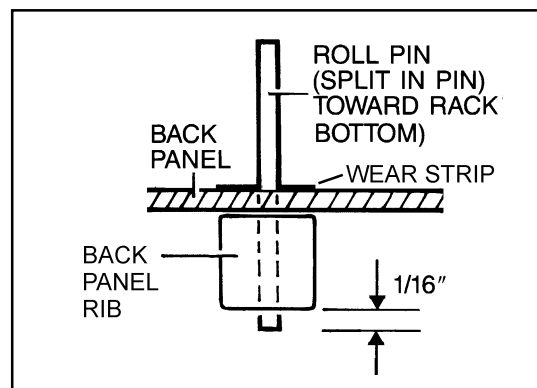


**Figure 10**

**Step 9:** Rotate the wear strips (Item 5) 90° to align with holes in the back panel (Figure 11). Drive the roll pins (Item 4) through the wear strips, back panel, and back panel frame rails (Figure 11). The roll pins should extend 1/16" (1.6 mm) through the frame rails. Ensure that the split in the roll pins faces down towards the casters. (Figure 12).



**Figure 11**



**Figure 12**

## INSTALLATION OF TURNING BARS

**Step 10:** Place a turning bar assembly (Item 2) onto the back panel. Carefully insert the top pin (the short pin) of the turning bar through the hole in the turner shaft end piece (Figure 13). Repeat with the five (5) more turning bars.

Force a retaining ring (Item 3) over each short pin to prevent the turner bar assembly from dragging on the back panel (Figures 14 and 15).

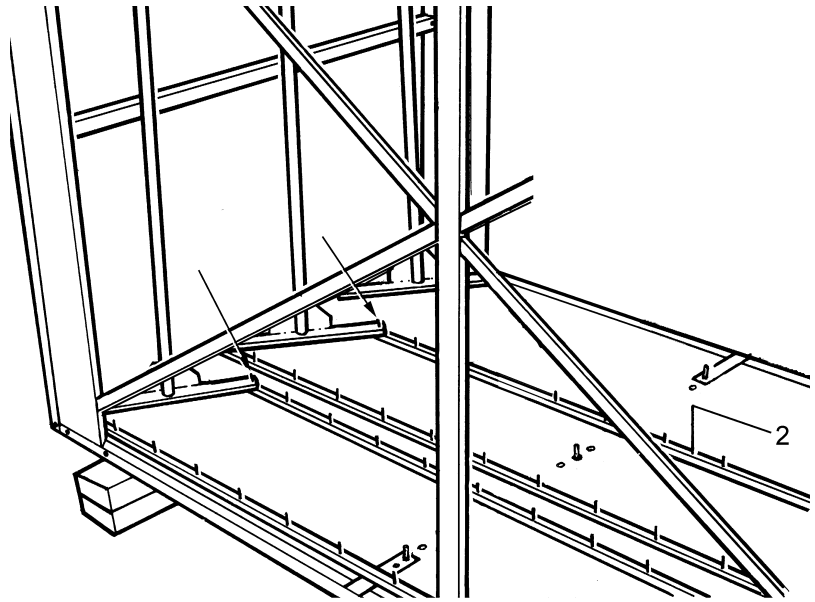


Figure 13

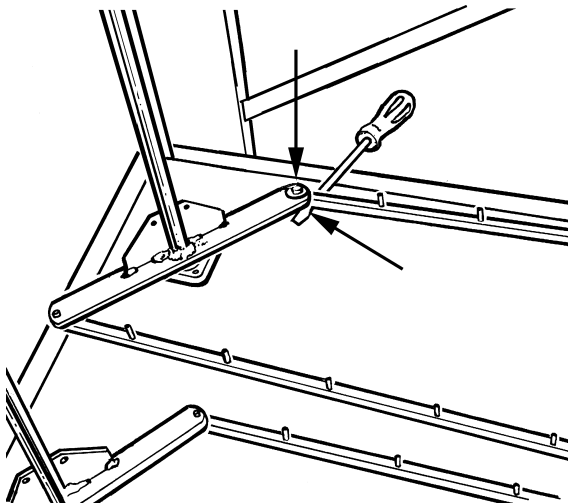


Figure 14

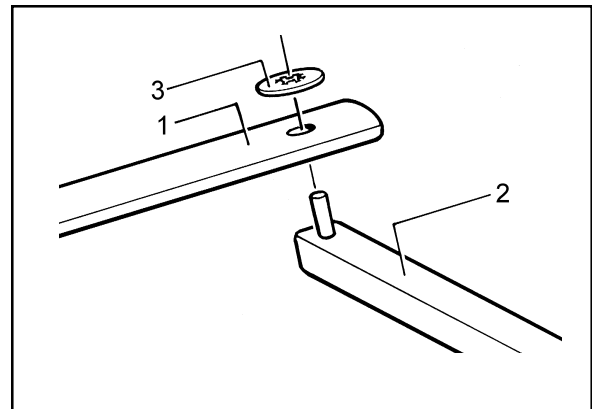


Figure 15

Item	Part No.	Description
1	AB3553	Turner Shaft Assembly
2	AB5696	Hanging Bar Assembly (Chicken)
	AB5848	Hanging Bar Assembly (Turkey)
3	PB3774	Retaining Ring

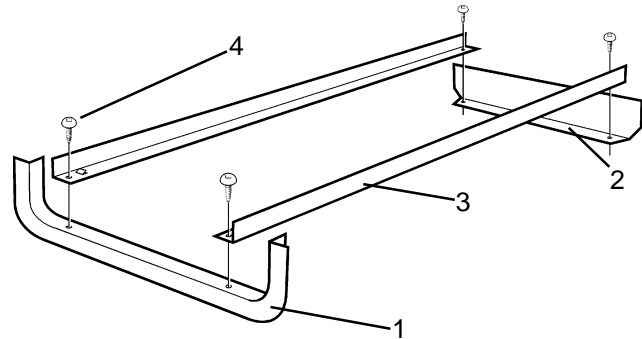
## INSTALLATION OF EGG TRAY FRAMES

**Note:** When assembling the egg tray frames, **it is very important** to use the proper torque setting on your drill. The proper way to set up your drill is to use the low end power setting then turn the clutch setting until the screw bottoms out. Back up the setting by one (1) and check that the screw does not go all the way down. If the screw does go all the way down, adjust your setting up by one (1). This setting should allow the screw to go in without over tightening.

**Step 11:** Assemble each of the egg tray frames. For each frame, attach the front and rear frame rails by fastening the frame rails (Items 1, 2, 3) with Item 4 (Figure 16).

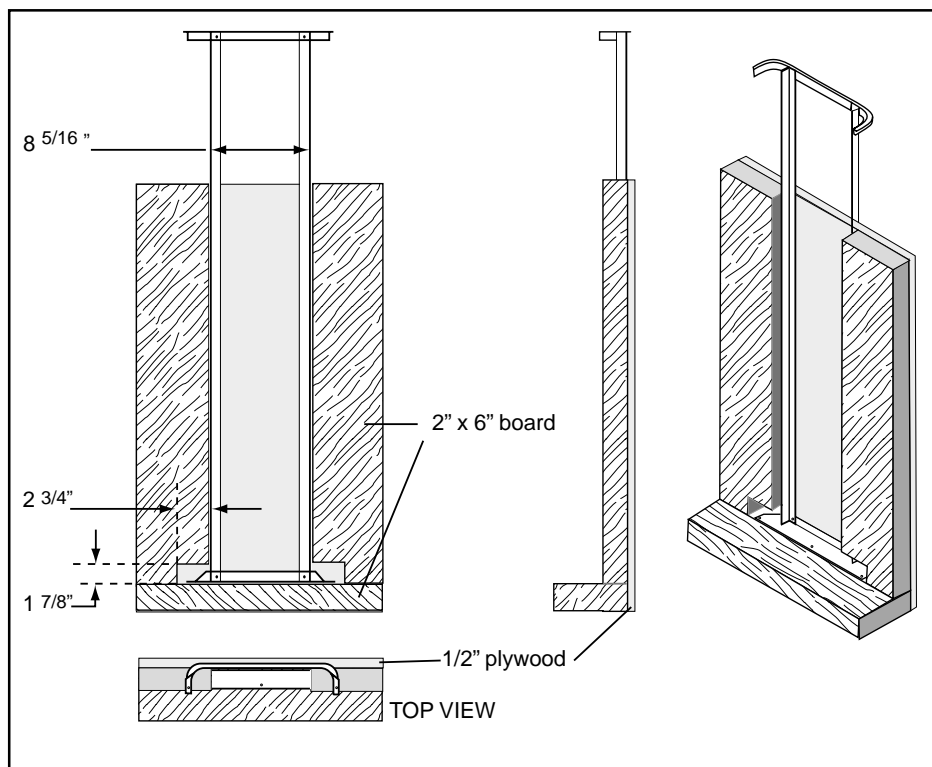
**Note:** there are 45 frames for a chicken rack, 39 frames for a turkey rack.

**Step 12:** Check each egg tray frame for squareness before installing them into the rack. This can be done by constructing and using an egg tray frame template as illustrated in Figure 17. The materials required can be taken from the crate that the egg trays come in. The template should allow for 1/32" on both sides of the rail for easy placement and removal of the egg tray frames. Failure to square egg trays when assembled, may lead to extreme interference and further correction as in Step 23 .



**Figure 16**

Item	Parts No.	Description
1	MB16816	Front Frame Rail, (Chicken)
	MB16856	Front Frame Rail, (Turkey)
2	MB16705	Rear Frame Rail, (Chicken)
	MB16857	Rear Frame Rail, (Turkey)
3	MB17732	Frame Rail, (Chicken)
	MB17733	Frame Rail, (Turkey)
4	P6067	No. 8 x 3/8" Quadrex Screw



**Figure 17**

**Step 13:** Beginning at the bottom of the rack, place one egg tray frame assembly (Item 1) over each pair of pins on the adjoining turning bars. Tilt all the egg tray frames against the bottom front panel, towards the casters (Figure 19).

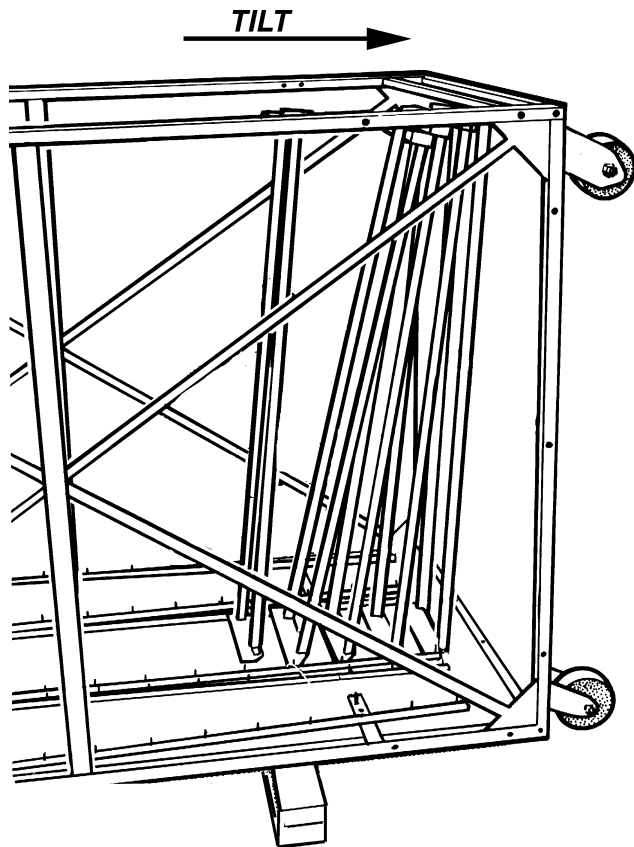


Figure 19

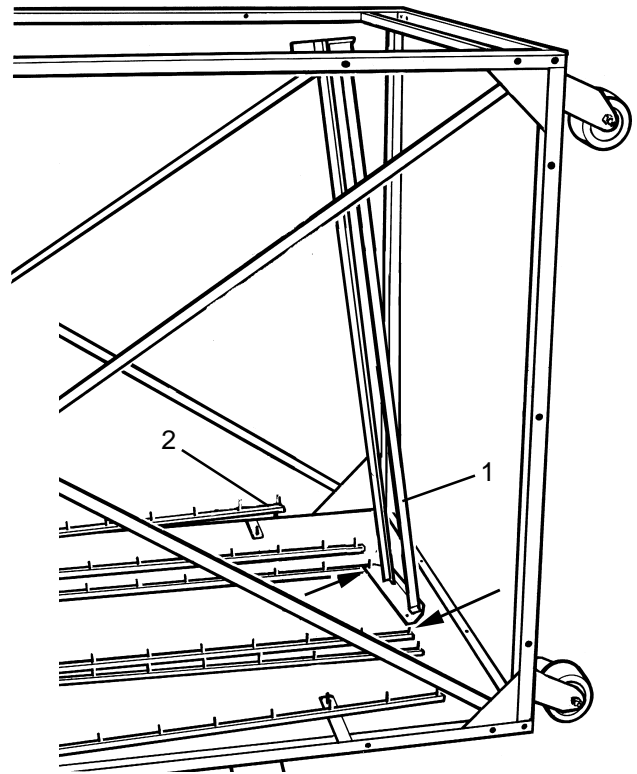


Figure 18

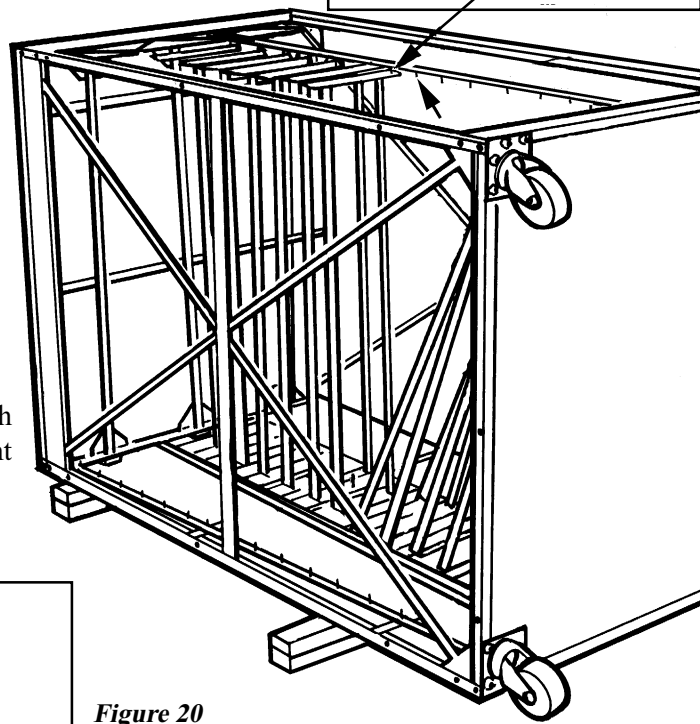
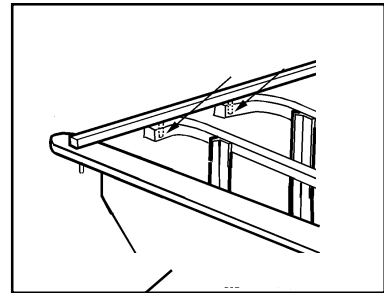
Item	Part No.	Description
1	AB6096	Egg Tray Frame Assembly (Chicken)
	AB5852	Egg Tray Frame Assembly (Turkey)
2	AB5696	Turning Bar Assembly (Chicken)
	AB5848	Turning Bar Assembly (Turkey)

## INSTALLATION OF HANGING BARS

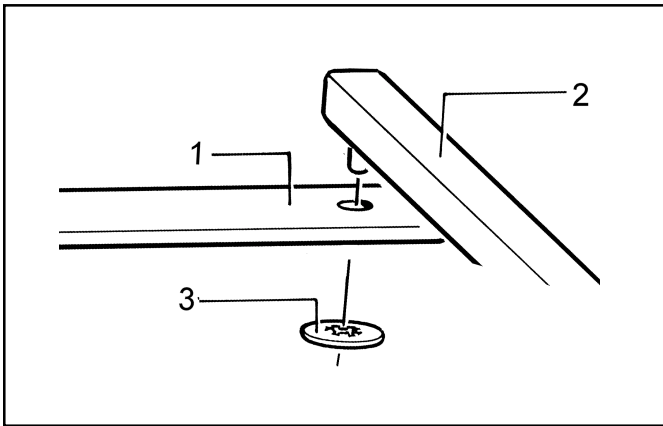
**Step 14:** Insert a turning bar (Item 2) through the outer front end of each outside turner shaft, and one turning bar into the centre turning shaft. Carefully insert the pins of the turning bars through the holes in the front egg tray frame rails (Figure 20A).

Slide the outside turning bars under the side frame end rail. Install the remaining three (3) turning bars. Tilt all egg tray frames against the bottom panel, towards the casters (Figure 20).

**Figure 20A**



**Step 15:** Attach retaining rings (Item 3) over each turning bar pin that protrudes through the front of each turner shaft (Figure 21).



**Figure 21**

**Figure 20**

Item	Part No.	Description
1	AB3553	Turner Shaft Assembly
2	AB5696	Hanging Bar Assembly (Chicken)
	AB5848	Hanging Bar Assembly (Turkey)
3	PB3774	Retaining Ring

## INSTALLATION OF RAIL SPACERS

**Step 16:** Insert the front rail spacers (Item 1) and fasten loosely with Item 2 (Figure 22).

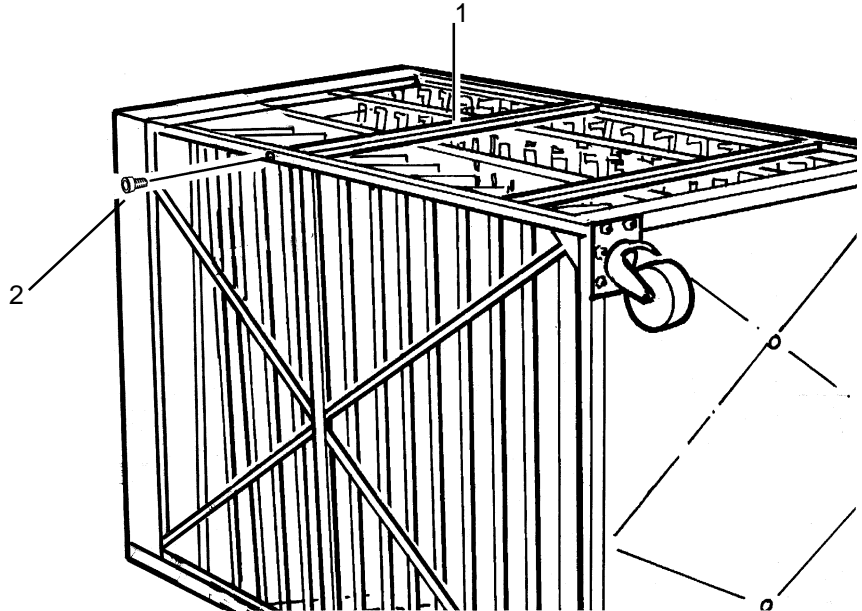


Figure 22

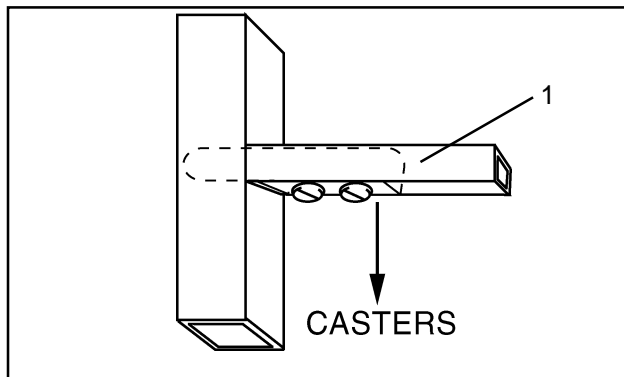


Figure 23

Item	Part No.	Description
1	AB4113	Front Rail Spacer Bar Assembly
2	O880510	5/16" - 18 x 5/8" Allen Head Cap Screw

**Note:** The screws securing the wear strips must face towards the casters (Figure 23).

Stand rack up on its casters.

## SQUARING AND TIGHTENING THE RACK

**Note:** As the rack is squared and all fasteners tightened, apply only hand leverage using the Allen keys supplied in each hardware package.

**Step 17:** Tighten the side frames to the top frame in all four (4) corners as in Figure 24.

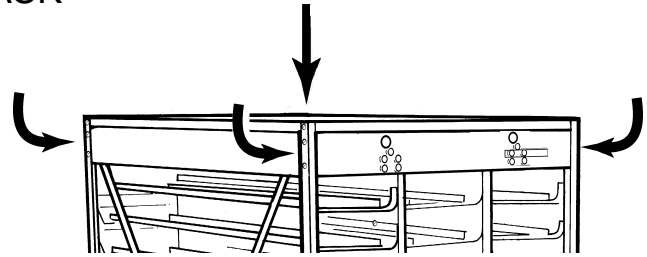


Figure 24

**Step 18:** On one (1) side only, tighten down the bolts that attach that particular side frame to its casters as in Figure 25.

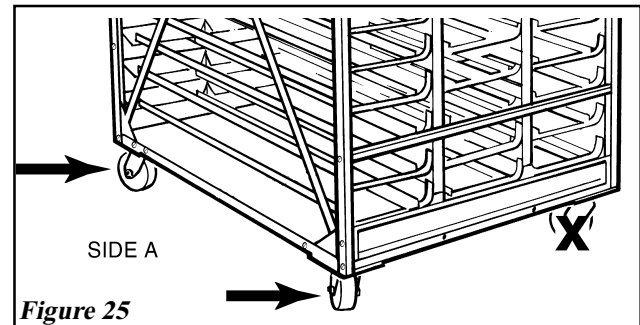


Figure 25

**Step 19:** Check for squareness using either the front or the back of the incubator rack as in Figure 26.

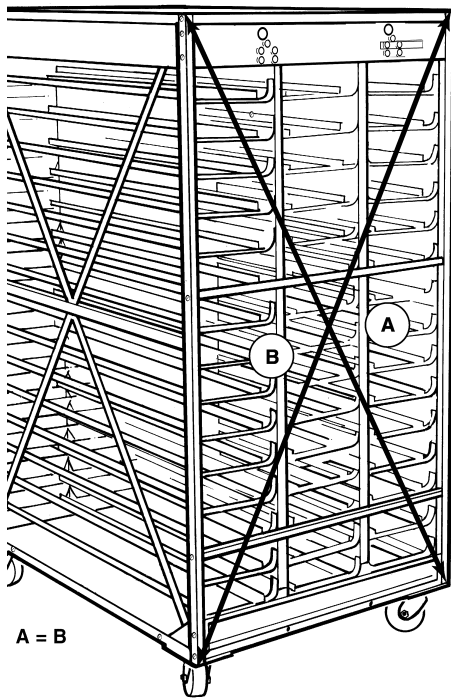


Figure 26

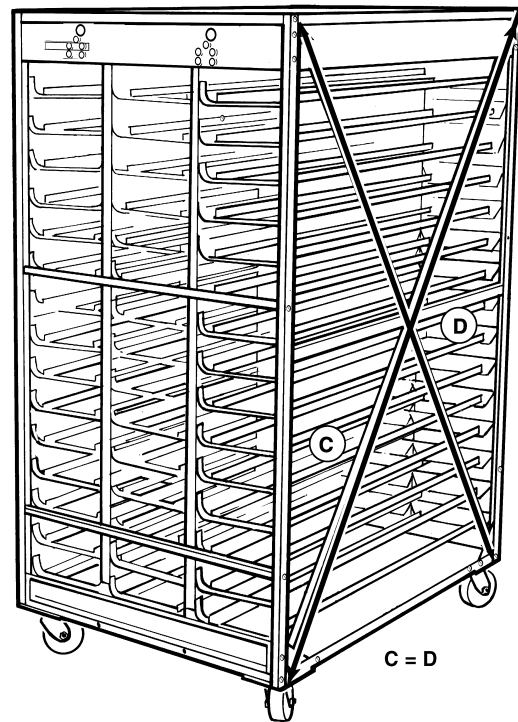


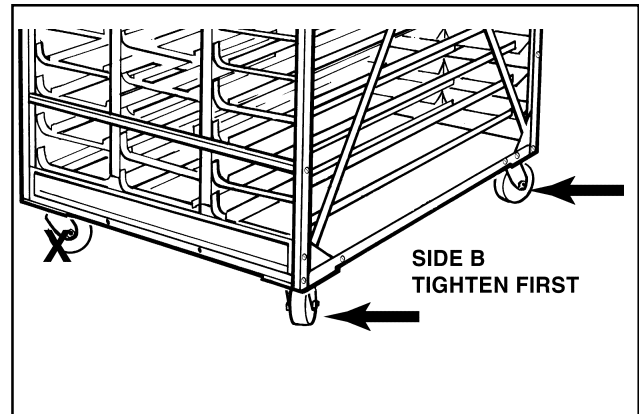
Figure 27

**Step 20:** On the opposing side of the casters that were tightened, adjust the frame left or right until the incubator rack is squared as in Figure 27.

**Step 21:** Tighten the casters on the opposing side first, as in Figure 28. Then tighten the bolts of the first two (2) casters.

**Step 22:** Tighten the rest of the bolts on the incubator rack using only hand leverage and the Allen keys provided.

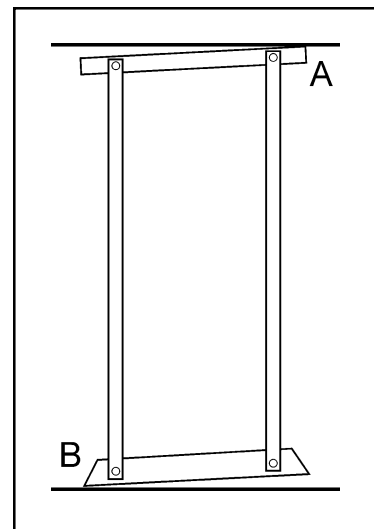
**Step 23:** Your Jamesway Technician will inspect the rack for free movement of egg tray frames. Check each column of Egg Tray Frames for smooth, easy turning.



*Figure 28*

**Correct all drag points, points of wear, and interference between moving and stationary parts.**

If individual egg tray frames are not squared properly when assembled, severe drag points can occur at diagonally opposite corners, "A" and "B". (See Figure 29). This causes extreme interference when multiplied by 30 or 45 egg tray frames. This condition can generally be corrected, even at this stage of assembly, by manipulating the egg tray frame from the front of the rack.



*Figure 29*

## INSTALLATION OF TRAY SPACERS

**Step 24:** When all points of interference are corrected, install three (3) tray spacers (Item 2) using Item 1 and Item 3. Water pump pliers (Channel-lock pliers) work well for this purpose (Figure 31). Item 3, the gauge is used to position the tray spacer assembly the proper distance from the front rail spacer bar. After the rivet (Item 1) is in place, remove the tray spacer gauge. Apply a small amount of Antiseize compound between Items 1, 2 and 4. **Install the tray spacers so that those on the outer two (2) columns always point towards the centre of the rack.**

**Step 25:** Square the front rail spacers to the side frames.

**Note:** The front rail spacers must be square to the front of the side frames, otherwise the tray spacers may pull out of the turning bars during turning.

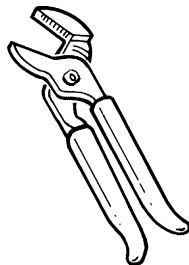


Figure 31

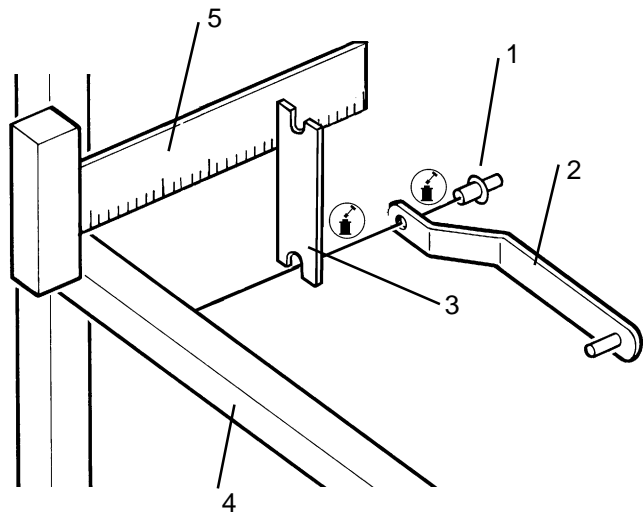


Figure 30

Item	Part No.	Description
1	P6060	1/4" x 3/16" Drive Rivet
2	AB3556	Tray Spacer Assembly
3	MB17260	Tray Spacer Clearance Gauge
4	AB4113	Front Rail Spacer Bar Assembly
5		Square, not supplied

INSTALLATION OF THE DRIVE BAR ASSEMBLY

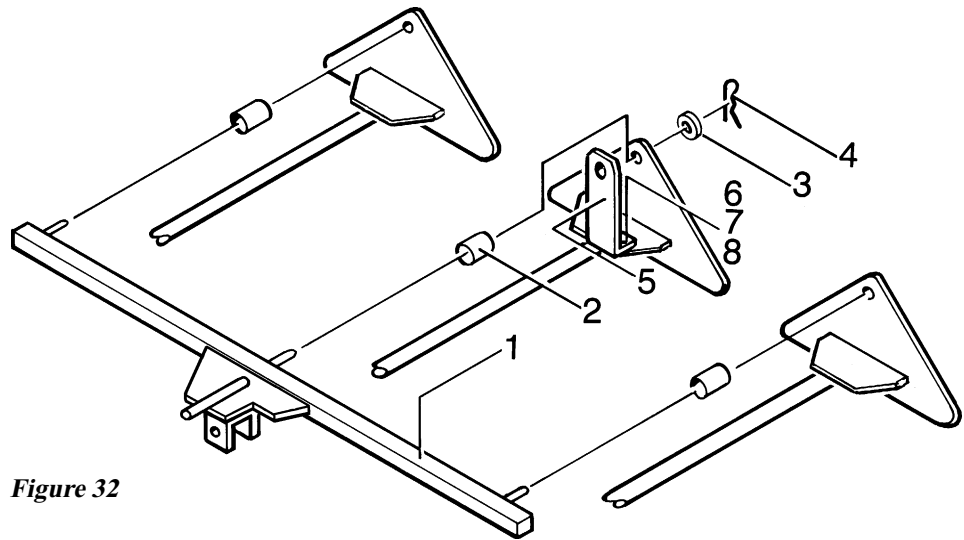


Figure 32

**Step 26:** Lay the rack onto the floor and rest the back panel on the wood supports or use a step ladder with the rack upright. **Do not use the rack as a ladder.** Install the drive bar assembly (Item 1) using Items 2, 3 and 4. Item 3, the SAE washer, must be installed as shown to reduce the lateral movement of the drive bar. Install the cylinder support (Item 5) using Items 6, 7 and 8. Keep the cylinder support at the outer end of the drive bar support pin to avoid interference with the drive bar. (Figures 32 and 33).

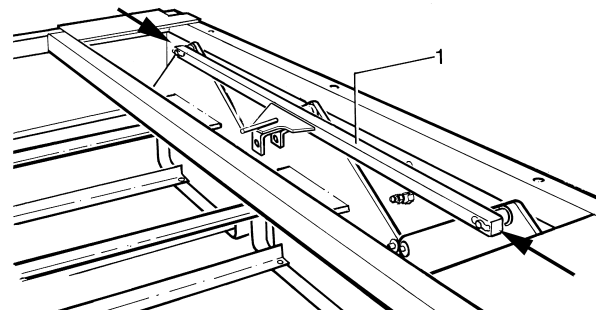


Figure 33

**Step 27:** Stand the rack up on its casters (if necessary). Check the turning of the columns of egg tray frames. All columns should turn easily and in unison. Correct all points of interference. Lay the rack on the floor and rest the back panel on the wood supports or continue with the panel in the upright position.

Your Jamesway Technician must now make an inspection

Item	Part No.	Description
1	AB3558	Drive Bar Assembly
2	PB12	Spacer Washer
3	P454	1/4" SAE Washer
4	P976	Cotter Pin 3/32" x 3/4"
5	MB16597	Cylinder Support Bracket
6	P336	1/4"- 20 x 3/4" Hex Head Bolt
7	P463	1/4" Lock Washer
8	P557	1/4"-20 Hex Nut

## INSTALLATION OF THE AIR CYLINDER AND TUBING

**Step 28:** Remove both of the elbow and orifice assemblies (Item 2) from the tubing on the front bearing panel. Apply thread sealant or Teflon tape to the threads of Item 2. Take care not to cover the hole in the orifice. Install Item 2 carefully into the air cylinder (Item 1) as in Figure 34.

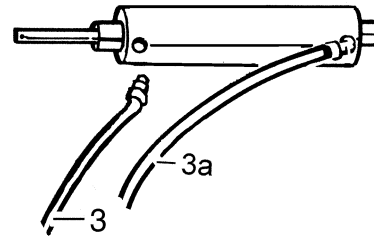


Figure 34

Ensure that the elbow and orifice assemblies are on the side away from the front bearing panel and are directed as shown (Figures 35 and 36). Install the cylinder into the rack using Items 4, 5 and 6.

**Step 29:** From the front bearing panel, cut off 16" (41 cm) of the black 1/4" tubing (Item 3) and 13" (33 cm) of the clear 1/4" tubing (Item 3a). Ensure that the end of the tubing is cut squarely. Install the tubing, Items 3 and 3a, as shown. Attach the Quick Disconnects (Items 7 and 8) to the ends of the tubing on the front bearing panel.

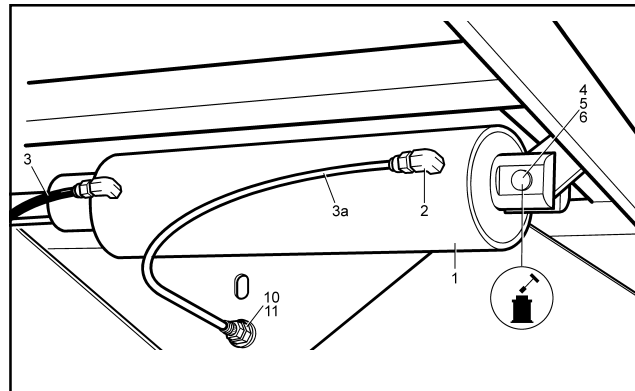


Figure 35

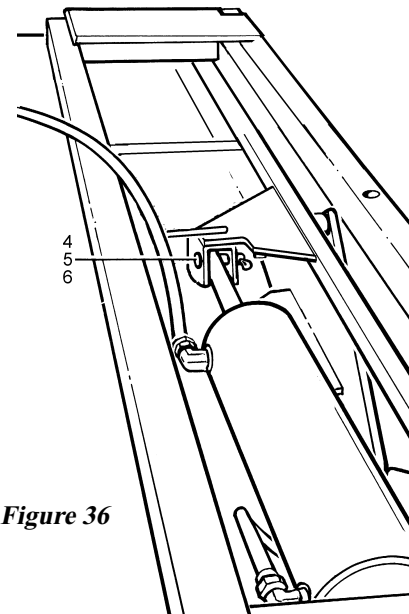


Figure 36

Item	Part No..	Description
1	PB3173	Air Cylinder 1/2" Shaft
2	AB3559P	Elbow and Orifice Assembly
3	P4254	1/4" Black Tubing
3a	P4253	1/4" Clear Tubing
4	P2968	Clevis Pin 1/4 x 1/4
5	P545	1/4" SAE Washer
6	P976	Cotter Pin 3/4 x 3/4
7	PB1989	'Kwik' Connect Insert Imperial Eastman or
	PB4389	Brass Plug (Foster) Bulk Head
8	PB1800	'Kwik' Connect Imperial Eastman
	PB4390	Brass Socket (Foster) Bulk Head
9	PB3294	Compression Nut with Ferrule
10	P3090	Brass Connector
11	MB17191	Spacer

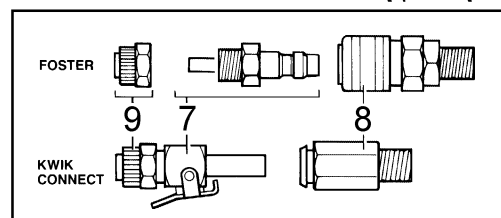


Figure 37

## INSTALLATION OF TURN SENSOR

**Step 30:** Install the turn switch assembly (Item 1) onto the turner shaft assembly using Items 2,3 and 4. Insert the cord assemblies (Items 8 and 9) beneath the drive bar assembly and through the holes in the front bearing panel. Secure the cables with Items 5, 6 and 7. The end of the moulded plug of Item 8 should extend 15" (38 cm) beyond Item 5. The end of Item 9 should extend 17" (43 cm) beyond Item 5.

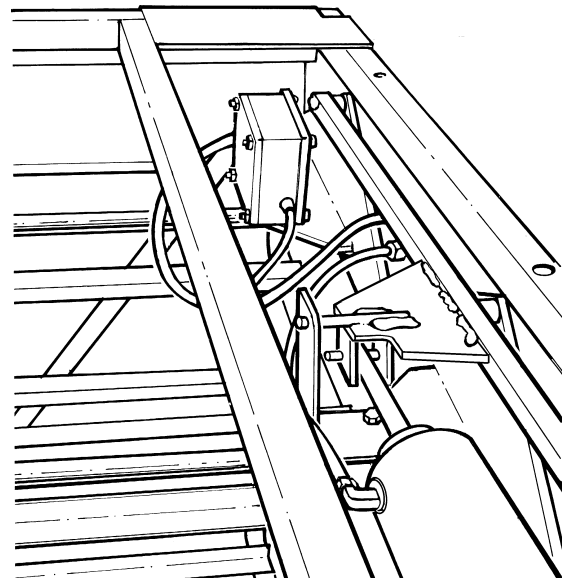


Figure 38

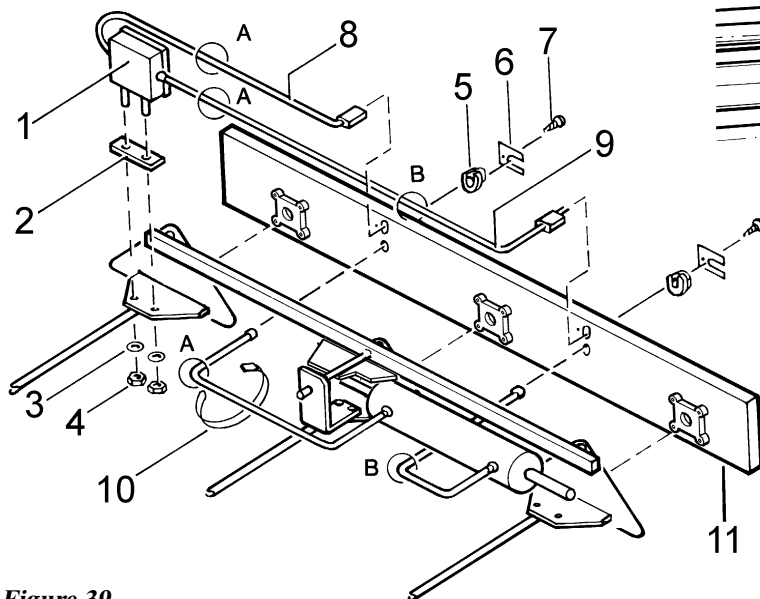


Figure 39

**Note:** Route the cord assemblies and air lines so as not to interfere with any moving parts (Figure 38). Secure the cord assemblies to the air lines at locations A and B using Item 10 (Figure 39).

Item	Part No.	Description
1	AB5874	Turn Switch Box Assembly
2	MB16292	Shim
3	P463	1/4" Lockwasher
4	P557	1/4"-20 Hex Nut
5	P814	Strain Relief Bushing
6	MB15420	Retainer
7	P6067	#8 x 3/8" Self Tapping Screw
8	PB3849	Cord Assembly, Female
9	PB3850	Cord Assembly, Male
10	PT1181	Cable Tie
11	AB5467	Ft. Bearing Panel (Bulkhead)
	AB5309	Ft. Bearing Panel (Imp. Eastman)

## FINAL INSPECTION

**Step 31:** Stand the rack up on its casters (if necessary). Turn the columns of egg tray frames to left and right, checking for smooth, easy turning. Ensure that the interconnect cables and air lines do not catch on any parts, or interfere with smooth turning of the rack. Correct any point of interference.

**Step 32:** Install the top panel (Item 1) and the inspection cover (Item 2) using Items 3 and 4. The inspection cover must lap over the top panel. See Figures 41 and 42.

**Step 33:** Check rack for squareness in all directions. Check all fasteners. Ensure fasteners are not too tight.

**Step 34:** Add Item 5 to the hanging pins of the centre tier in the following positions (counting from the top):

Chicken Rack 9-10-11-14-15

Turkey Rack 8-9-10-12-13.

The retaining rings should be placed on the inside as shown. See Figure 43. This procedure will eliminate any possibility of egg tray frames falling from the pins.

**Step 35:** Connect electrical cords together and place neatly into front bearing panel along with air lines. (Figure 42).



Figure 41

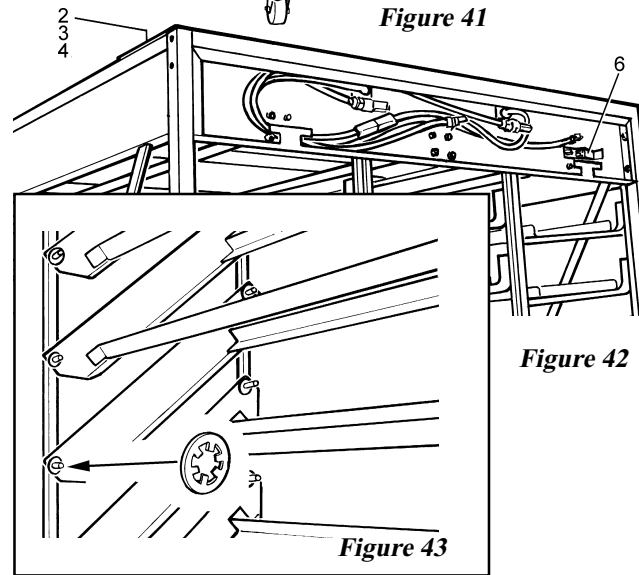


Figure 42

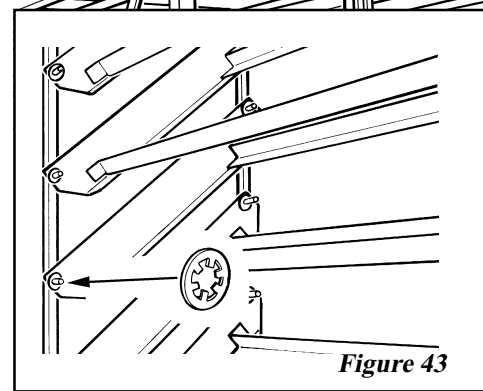


Figure 43

Item	Parts No.	Description
1	MB15025	Top Panel, galvanized or,
	MB8062	Top Panel, stainless steel or,
	PB5298	Top Panel, plastic
2	MB15026	Inspection Cover, galvanized or,
	MB8061	Inspection Cover, stainless steel or,
	PB5304	Inspection Cover, plastic
3	O240528	5/16" - 18 x 1-3/4" Hex Head Cap Screw
4	O490500	5/16" - 18 Hex Head Lock Nut
5	PB3774	Retaining Ring
6	MB10858	Card Retainer Clip
7	P6082	#10 x 1/2" Self Drilling Stainless Steel Screw for stainless steel or plastic (not shown)

## APPLICATION OF LOCKTITE

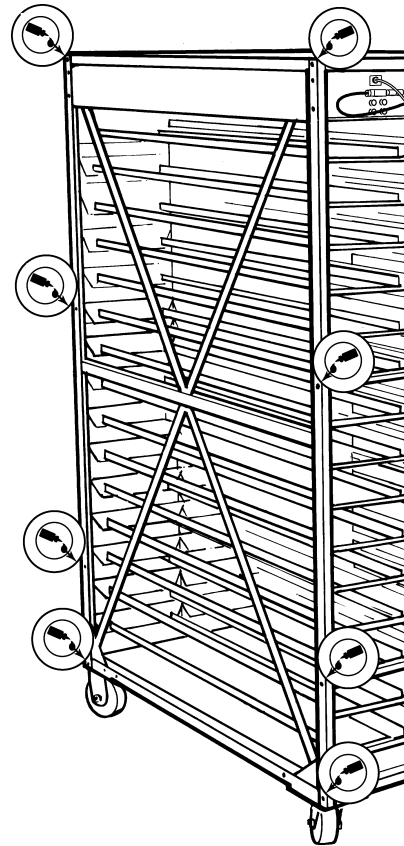
**Step 36:** When it is concluded that the rack is square and that there are no points of interference with the egg tray frames; Locktite should be applied to the cap screws in these locations:

between both side frame assemblies and the front rail spacers,

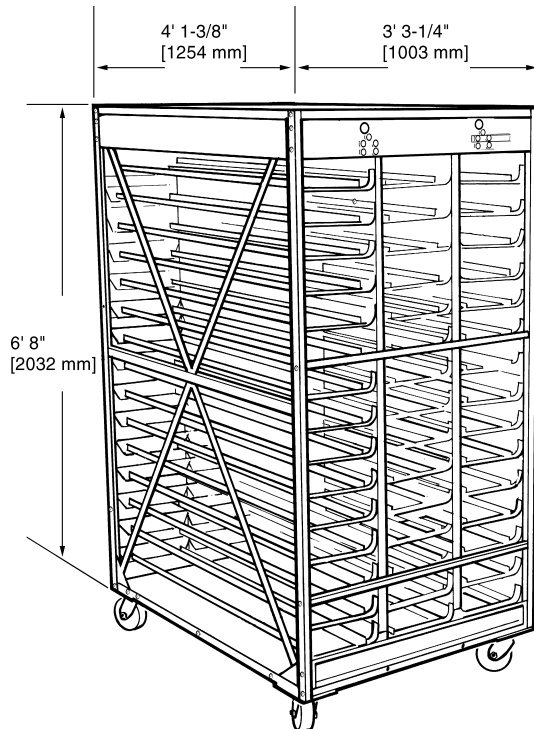
between both side frame assemblies and the horizontal back rails,

between both side frame assemblies and the bottom rail assemblies,

between both side frame assemblies and the top frame assemblies. See Figure 44.



**Figure 44**

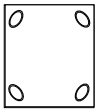


**Figure 45**  
Final Rack Dimensions

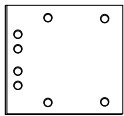
## REPLACEMENT PARTS FOR RACKS

Item	Chicken Incubator		Turkey Incubator	
	Parts Number		Parts Number	
Single Rack (shell only)	FB5681		FB5682	
Egg Tray Frames (un-assembled)	FB5685		FB5686	
Bearing Panel	Bulhead	FB5683	FB5683	
	Imperial Eastman	FB5684	FB5684	
Casters	V Groove, steel	AB4115A	AB4115A	
	Polyolefin	AB5466	AB5466	
	V Groove, nylon	AB6149	AB6149	

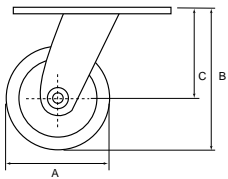
### CASTER IDENTIFICATION



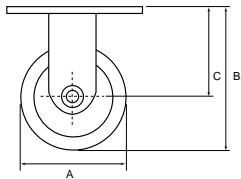
"Y" plate



"X" plate



swivel caster



rigid caster

Plate	Type		Parts No.	Dimensions (inches)			
				A	B	C	
"X" Plate	V Groove	Swivel	PB3157	4	5.5	3.5	
	cast iron	Rigid	N/A				
	Polyolefin	Swivel	PB4355A	4.625	6.313	4	
"Y" Plate	Polyolefin	Rigid	PB4853	4.625	6.313	4	
	V Groove	Swivel	PB4720	4	5.5	3.5	
	nylon	Rigid	N/A				
"Y" Plate	V Groove	Swivel	PB1761	4	5.5	3.5	
	cast iron	Rigid	PB4399				
	Polyolefin	Swivel	Rigid	PB3613A	5	6.5	4
				PB4033A	4	5.5	3.5
				PB3614A	5	6.5	4
				PB4032A	4	5.5	3.5
				PB4353	4.625	6.313	4
V Groove	Swivel	PB4718	4	5.5	3.5		
nylon	Rigid	PB4719					
Special	Polyolefin	Swivel	PB3709	3.5	4.688	2.938	

Figure 46: Caster Identification

REPLACEMENT PARTS FOR CASTERS

Item	Part No..	Description
1	PB3224	Retainer Washer
2	PB3224	Bearing and Sleeve
3		V Groove Wheel
4	PB3809	Inner Sleeve
5	PB4717	Nylon Wheel
6	PB1761C	Steel Wheel Assembly
7	PB3251	Axle
8	PB3223	Thrust Washer
9	PB3253	Axle Nut Washer
10	PB3252	Axle Nut
11	PB3222	Bearing and Sleeve
12	PB3809	Inner Sleeve
13	AB6761	Axle Assembly Kit
14	AB5760	Bearing Repair Kit
15	PB3761	Grease Fitting

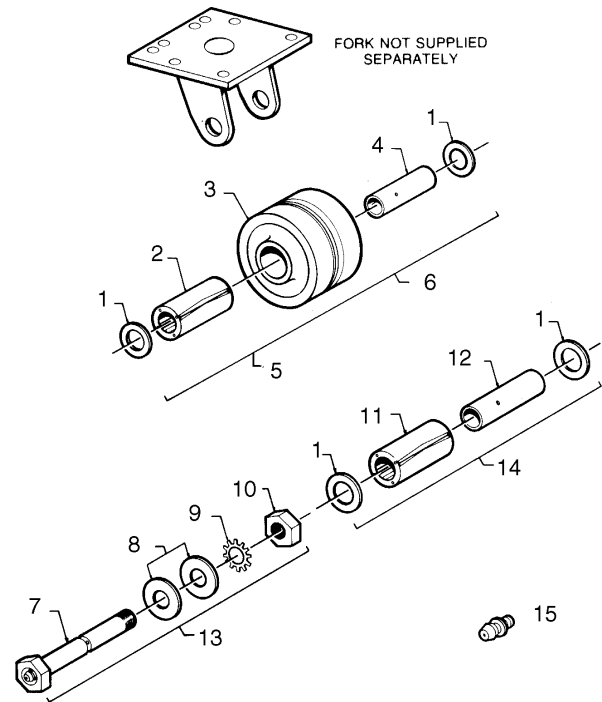


Figure 47: V Groove Caster (Steel) - PB3157  
(Nylon) - PB4720

Item	Part No.	Description
1	PB4447	Seal and Thrust Washer
2	PB3222	Bearing and Sleeve
3		Wheel
4	PB3809	Inner Sleeve
5		Wheel Assembly
6	PB3251	Axle
7	PB3223	Thrust Washer
8	PB3253	Axle Nut Washer
9	PB3252	Axle Nut
10	AB5761	Axle Assembly Kit
11	CK1015	Bearing Repair Kit
12	PB3761	Grease Fitting

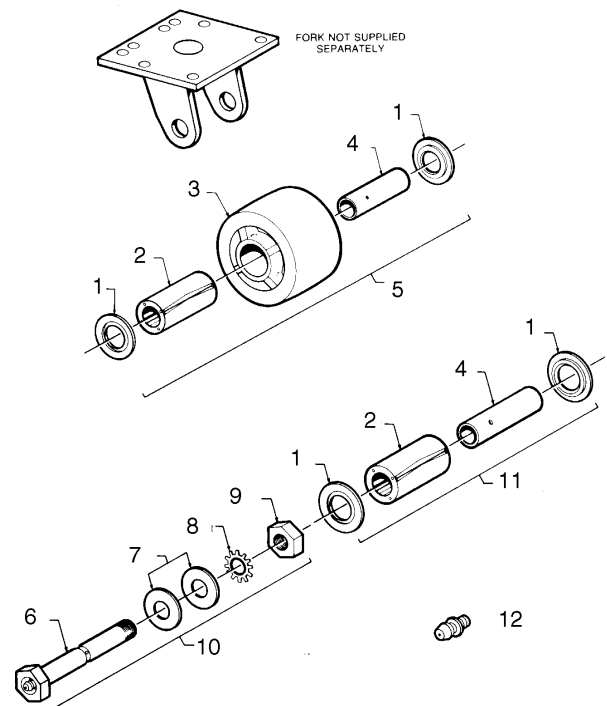
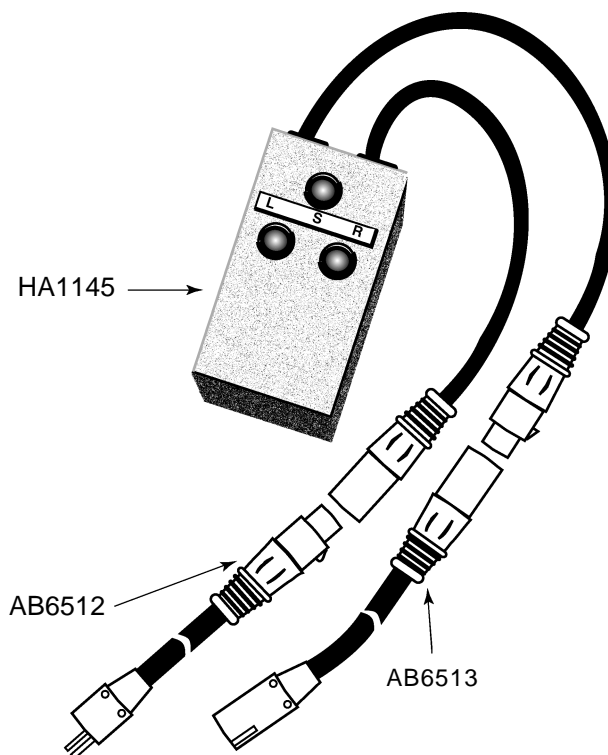


Figure 48: Polyolefin Caster - PB4355A

## INCUBATOR RACK TESTER

For 3-Column Racks order HA1145 Inc. Rack Tester plus AB6512 male extension cable and AB6513 female extension cable.



## INDEX

**A**

AB3553 .....	9, 11, 14
AB3556 .....	18
AB3558 .....	19
AB3559P .....	20
AB4099 .....	5, 6
AB4101B .....	5, 6, 7
AB4103 .....	5, 7, 8
AB4110B .....	5, 6
AB4113 .....	15, 18
AB4115A .....	24
AB5309 .....	5, 10
AB5466 .....	24
AB5467 .....	10, 21
AB5696 .....	11, 13, 14
AB5760 .....	25
AB5761 .....	25
AB5848 .....	11
AB5849 .....	7
AB5874 .....	21
AB6096 .....	13
AB6149 .....	24
AB6512 .....	26
AB6513 .....	26
AB6761 .....	25

**C**

CK1015 .....	25
--------------	----

**F**

FB5681 .....	24
FB5682 .....	24
FB5683 .....	24
FB5684 .....	24
FB5685 .....	24
FB5686 .....	24

**H**

HA1145 .....	26
--------------	----

**M**

MB10858 .....	22
MB15019 .....	5, 7
MB15022 .....	5, 7, 8

MB15025 .....	22
MB15026 .....	22
MB15420 .....	21
MB16292 .....	21
MB16597 .....	19
MB16705 .....	12
MB16816 .....	12
MB17191 .....	20
MB17260 .....	18
MB17501 .....	10
MB17732 .....	12
MB8061 .....	22
MB8062 .....	22
MP5304 .....	22

**O**

O240528 .....	8, 22
O490500 .....	6, 7, 8, 10, 22
O660500 .....	8
O880510 .....	6, 7, 10, 15

**P**

P2885 .....	3
P2968 .....	20
P3090 .....	20
P336 .....	19
P4253 .....	20
P4254 .....	20
P454 .....	19
P463 .....	19, 21
P557 .....	19, 21
P6060 .....	18
P6067 .....	12, 21
P814 .....	21
P976 .....	19, 20
PB12 .....	19
PB1761C .....	25
PB1800 .....	20
PB1989 .....	20
PB3157 .....	8, 24, 25
PB3173 .....	20
PB3222 .....	25
PB3223 .....	25
PB3224 .....	25
PB3251 .....	25
PB3252 .....	25
PB3253 .....	25
PB3294 .....	20
PB3614A .....	24

---

INDEX ,CONTINUED

PB3761 .....	25
PB3774 .....	11, 14, 22
PB3809 .....	25
PB3849 .....	21
PB3850 .....	21
PB3919 .....	10
PB4032A .....	24
PB4033A .....	24
PB4353 .....	24
PB4355A .....	25
PB4399 .....	24
PB4447 .....	25
PB4665 .....	3
PB4717 .....	25
PB4719 .....	24
PB4720 .....	24, 25
PB4853 .....	24
PB4911 .....	9
PB5298 .....	22
PB5304 .....	22
PT1181 .....	21

1. Review the assembly instructions before beginning rack assembly.
2. The Assembler is to identify himself on the attached paper where noted and place the paper under the card clip on front bearing panel.
3. A Jamesway technician will inspect as per the attached procedure, mark the attached paper and then tick off that each individual test has been completed.
4. The Assembler will finish the assembly and indicate on the paper that the assembly is completed.
5. The rack is then to be tested for air pressure and the test verified on the paper.
6. Leave the papers with the racks until all are completed.

Inspection Check List	1	2	3	4	5	6
Egg Tray Frames square to Frame and free floating (end play)	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Retaining Rings in place on Hanging Bars	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Retaining Rings in place on center tier where specified	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Front Rail Spacers at 90° to Rack Face	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Wear Strips and Clips undamaged—front and back	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Hanging Bars straight	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Air Line Fittings on correct side of Air Cylinder	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Both tiers turn without abnormal interference	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

Rack No. _____	Rack No. _____
Pre-assembled by _____	Pre-assembled by _____
Inspected by _____	Inspected by _____
Final assembly by _____	Final assembly by _____
Tested by _____	Tested by _____
Ready for setting? _____	Ready for setting? _____
Rack No. _____	Rack No. _____
Pre-assembled by _____	Pre-assembled by _____
Inspected by _____	Inspected by _____
Final assembly by _____	Final assembly by _____
Tested by _____	Tested by _____
Ready for setting? _____	Ready for setting? _____
Rack No. _____	Rack No. _____
Pre-assembled by _____	Pre-assembled by _____
Inspected by _____	Inspected by _____
Final assembly by _____	Final assembly by _____
Tested by _____	Tested by _____
Ready for setting? _____	Ready for setting? _____