

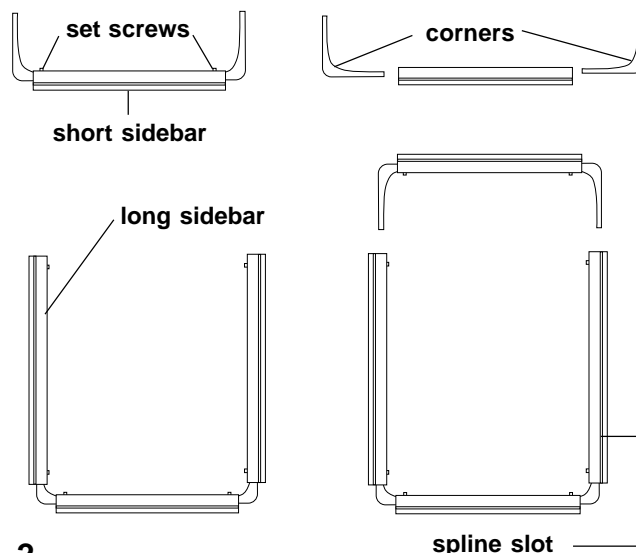
M, A and A-40 Series

RETENSIONABLE FRAME ASSEMBLY

A. Assemble frame (see Fig. 1)

1. Back off set screw enough to slide corners into channel.
2. Insert corners into short sidebars spline slot up as shown
3. Attach long sidebars - make a "U"
4. Attach last short sidebar with corners
5. Compress frame (corners pushed all the way in to each sidebar)

Fig. 1



B. Mount mesh (see Fig. 2)

1. Place frame on table - slot side up
 2. Place foam riser pad inside frame, under mesh to support mesh level
 3. Lay mesh on frame, fabric should extend 2 inches beyond side bar on all sides
 4. Insert longer spline toward center of the screen
 5. Holding spline down with one finger, fold mesh over the spline and towards the center of the screen
 6. Pull fabric to remove slack after first spline is inserted
 7. Insert shorter spline toward center of the screen over the first spline and the mesh
 8. Centrally locate both of the splines along the length of each sidebar
- (**Note:** For wire or coarse mesh (56 & larger) use larger spline only.)

Fig. 2

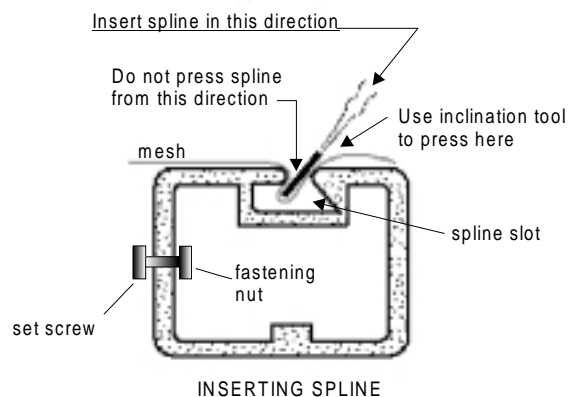


Fig. 3

C. Tension mesh

1. Expand frame with tension jacks (See Fig. 3 and Fig. 4) by inserting each jack into each end of the same channel and turning each jack knob exactly the same simultaneously.
 2. Note corner marks for size control
 3. Tighten set screws
 4. Tension fabric 3 directions
 5. Read tension meter on the 4th (sidebar expansion)
- Note:** Do not exceed 10 newtons mesh tension until the corners are softened. (See Step D on the next page).

Fig. 4

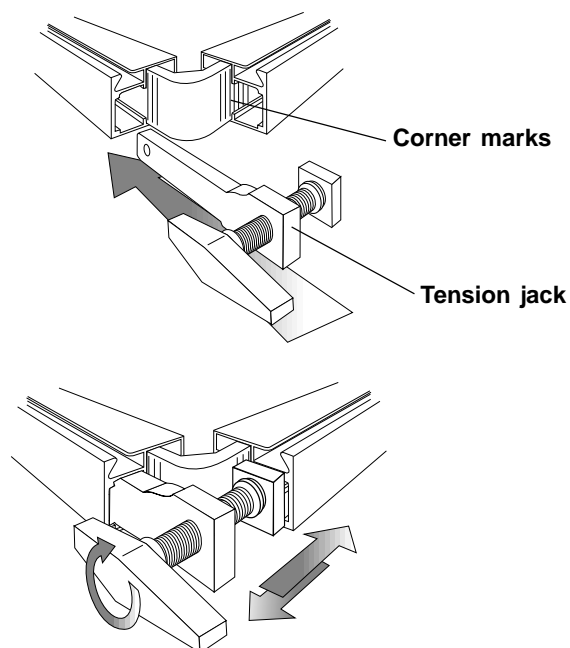


Fig. 5

D. Corner Softening (see Fig. 5)

1. Once corner begins to tension, using insertion tool, press down on large spline and press corner area of mesh down simultaneously.
2. Repeat on all remaining corners to soften the mesh corners
3. Return to tensioning steps in part C.

E. Retensioning/ work hardening

1. You may retension at any time
2. New mesh will relax
3. Tension the mesh to 30-40 Newtons
4. Allow frame to set 1 1/2 - 2 hrs. allowing for full relaxation
5. Retension mesh to desired Newtons.
6. With ultra H.T. (100 Newtons) two or three relaxation period must occur taking 6-8 hrs.
7. Working (printing mesh) will cause mesh to stretch/relax.
8. Retension, Step C, as this occurs.
9. Once fully work hardened mesh will no longer relax.

