

**TOMORROW'S
MANUFACTURING
LEADERSHIP
TODAY**

Technical Bulletin

Bulletin Number: 490 Revision Number: R-00

Release Date: August 11, 1994 Revision Date: _____

SUBJECT: NUT RETAINER HOUSING BRACE KIT

MODELS AFFECTED: All Dixie-Narco Venders.

REASON: To enhance the venders' ability to withstand prying on the main door and minimize damage to the cabinet.

ORDER: 432,052,800.04 Nut Retainer Housing Brace Kit

Kit Contents:

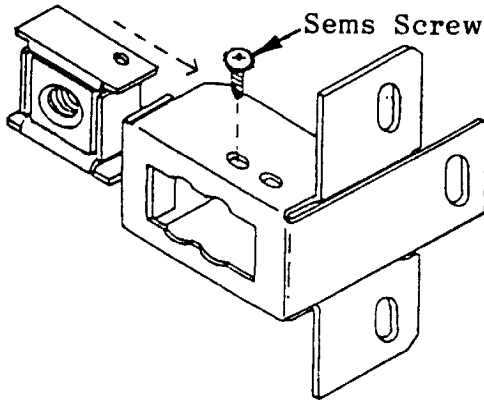
2 - 432,050,770.03	Nut Retainer Housing Brace
4 - 900,301,500.01	Phil Pan Screw (Self Drilling) #8-18x $\frac{1}{2}$
2 - 900,301,960.11	Phil Pan Sems Screw #8-32x $\frac{1}{4}$

To Install:

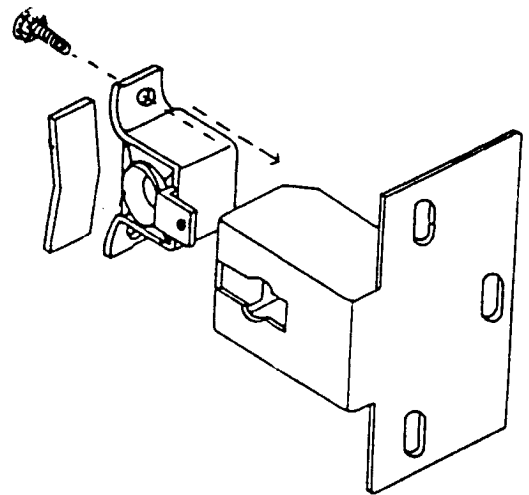
1. Determine if you have an old style or new style nut retainer housing. See figures 1 and 2.
2. Position the top brace so the end with (4) four holes (see figure 3) will attach to the nut retainer housing, and the opposite end with the (6) six holes (see figure 3) will attach to the stack.
- 3a. On new style nut retainer housings, remove the screw in the top of the nut retainer housing that aligns with one of the four holes in the brace.
- 3b. On old style nut retainer housings, you will need to mark the left brace mounting hole on the nut retainer housing (see figure 3) and drill a $\frac{9}{64}$ " hole in the nut retainer housing.
4. Position the brace and start, but do not tighten, the screw to secure the brace to the nut retainer housing.
5. Select the two holes in the opposite end of the brace that align with the hem channel on the stack.

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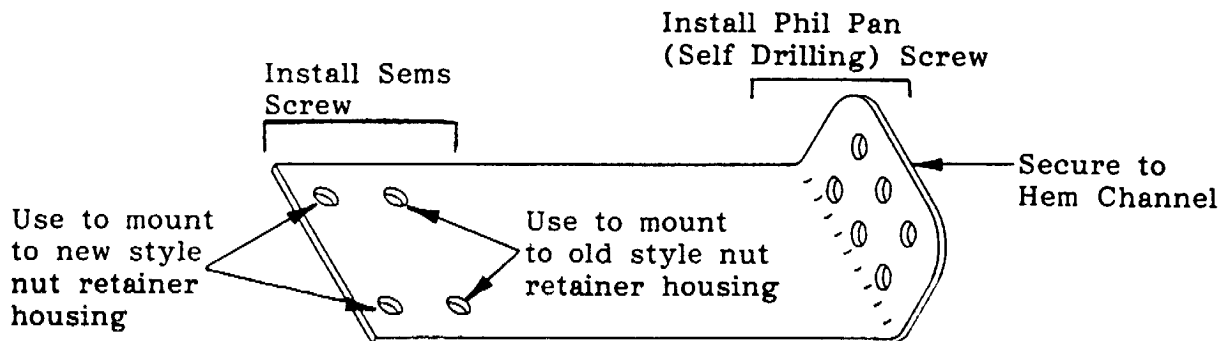
6. Install, but do not tighten, the (2) two self drilling screws in these holes.
7. Tighten the sems screw that secures the brace to the nut retainer housing.
8. Tighten the (2) two self drilling screws that secure the brace to the stack.
9. Position the bottom brace so the end with the (4) four holes (see figure 3) will attach to the nut retainer housing, and the opposite end with the (6) six holes (see figure 3) will attach to the stack.
- 10a. On new style nut retainer housings, remove the screw in the bottom of the nut retainer housing that aligns with one of the four holes in the brace. You will need to mark the oblong hole of the nut retainer housing on the nut cage and drill one 9/64" hole in the cage.
- 10b. On old style nut retainer housings, you will need to mark the left brace mounting hole on the nut retainer housing (see figure 3) and drill a 9/64" hole in the nut retainer housing.
11. Repeat steps 4, 5, 6, 7, and 8 for the bottom brace.



New Style
Figure 1



Old Style
Figure 2



432,050,770.03
Brace
Figure 3