

MDS track gate

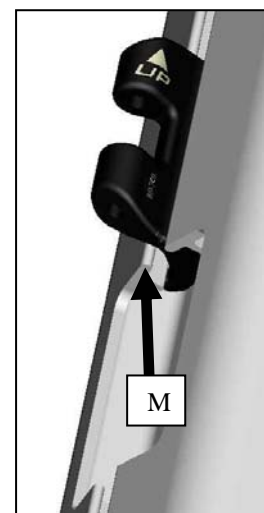
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General

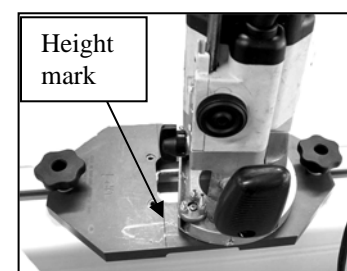
This instruction describes how to cut out for and fit MDS track gate.
For reference see MB M 1480 NMP.

Cut out for 505-519-01

1. Turn the mast to an aft side up position.
2. Use a router fitted with a **Ø18,8 mm guide collar** and a **Ø8 mm drilling bit**.
3. Attach the jig V-679 to the mast, (with boom bracket centre hole downwards) by first turning the “anchor” parallel to the sail slot and then pushing it into the sail slot
4. Before tightening of the attachment bolts, they should be turned so that the “anchors” are orthogonal to the sail slot. The “key” plates should point to port and starboard when the jig is attached.
5. Choose the right centre hole depending on which boom bracket is going to be used, see mast spec. Don't use excessive force when tightening the attachment bolts, the anchors then might break from fatigue.
6. Lubricate the mill bit and mast wall thoroughly before milling. Extra stops for lubrication might be necessary.
7. Put router on the jig, start the router, and lower it to the correct depth in the sail groove.
8. Mill anti-clockwise pushing the router along the edges of the template hole in the jig, then mill clockwise to make sure all contours is correctly milled.
9. Remove any burrs and grind the edges. **C**
10. Grind the upper corners (pic 1) carefully. **M**
11. Clean around sail slot and blow away all burrs.





Pic 1



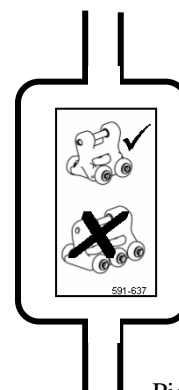
Pic 2

Cut out for 507-309-01

1. Turn the mast to an aft side up position.
2. Use a router fitted with a **Ø18,8 mm guide collar** and a **Ø8 mm drilling bit**.
3. Attach the jig **V-1004** to the mast, by first turning the “anchor” parallel to the sail slot and then pushing it into the sail slot
4. Before tightening of the attachment bolts, they should be turned so that the “anchors” are orthogonal to the sail slot. Don't use excessive force when tightening the attachment bolts, the anchors then might break from fatigue.
5. Fit jig after height measure (see mast spec. or PHB 1480) on mast and the mark on the jig V-1004, see pic 2
6. Lubricate the mill bit and mast wall thoroughly before milling. Extra stops for lubrication might be necessary.
7. Put router on the jig, start the router, and lower it to the correct depth in the sail groove.
8. Mill anti-clockwise pushing the router along the edges of the template hole in the jig, then mill clockwise to make sure all contours is correctly milled.
9. Use a drill-bit Ø 6,3 mm to drill four holes in the mill jig V-1004, see pic 2.
10. Remove any burrs and grind the edges. 
11. Grind the upper corners (pic 1) carefully. 
12. Clean around sail slot and blow away all burrs.

Label on C156, 175, 193.

Before putting the track gate in place on **C156, 175, 193**, clean the middle wall with alcohol and fit the label 591-637 in the middle of the cut out. See pic 3.



Pic 3

Assembly 505-519-01

1. Put the track gate assembly into place by pushing the gate and the lower part down into the cut-out. (See pic 4)
2. Lock the track gate assembly in position by pushing it in and then up.

Note: The “release”-arrow on the track gate should be pointing down.



Pic 4

Assembly 507-309-01

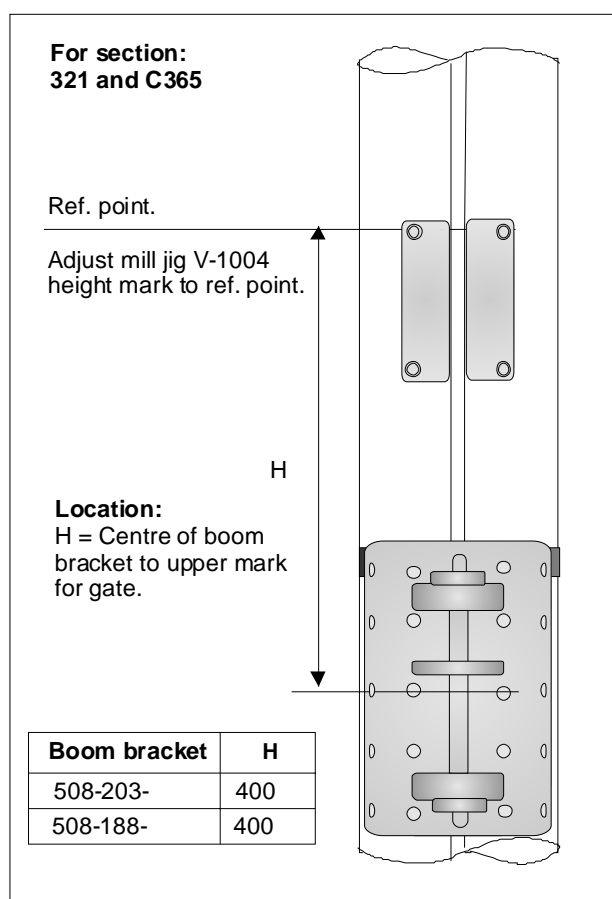
1. Tap and fit helicoil M6 into the four \varnothing 6,3 mm hole, see pic 5.
2. Put the track gates assembly into place and fit the screws with grease, tighten the screws moderately (See pic 6)



Pic 5



Pic 6



Check points

- Check that the spring loaded gate works properly.
- Check that 507-309-01 aligns with groove.