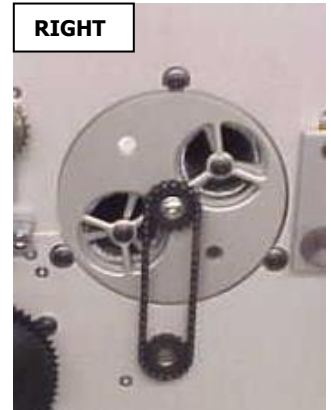
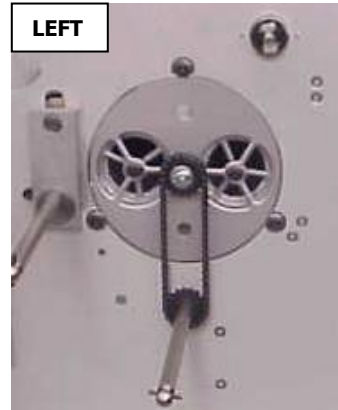


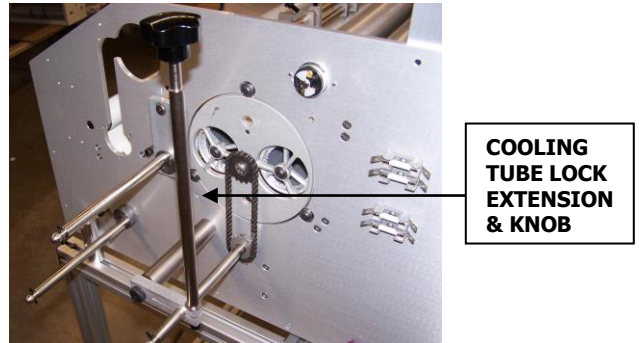
- 1) **ASSEMBLY BETWEEN SIDE PANELS, FITTING INTO APERTURE. SECURE THE CHILL ROLL ON THE REMAINING SIDE WITH (3) MORE ROLLER BEARINGS.**
- 2) **LEVEL THE CHILL ROLL COOLING TUBES HORIZONTALLY BY HAND AND PLACE THE (2) SMALLER #25 CUT CHAINS ON THE TEETH OF THE UPPER CHILL ROLL "TIMED" SPROCKETS AND THE LOWER CAM SHAFT "TIMED" SPROCKETS. CONNECT THE CHAINS ON BOTH SIDES WITH A CONNECTING LINK (PRC084) **AS07**.**
- 3) **PLACE THE SLITTER ASSEMBLY OILITE BEARING (PRB048) **AS08** SLEEVES INTO RIGHT AND LEFT SIDE PANEL CHANNELS. SLITTER BAR SUPPORTS ALIGN WITH SCREWS TOWARD THE REAR. CENTER THE TOP AND BOTTOM SLITTER BARS. SECURE THE SLITTER BAR SUPPORTS SNUG TO THE OILITE BEARING FLANGES ON THE INSIDE AND TIGHTEN LOWER SUPPORT SCREWS. TEST SLITTER MOVEMENT.**
- 4) **BRUSH "NEVER SEIZE" LUBRICANT ON THE CIRCUMFERENCE OF THE IDLER TUBE CAMS LOCATED BELOW THE SLITTER ASSEMBLY.**
- 5) **SLIDE THE SLITTER ACTUATING BLOCKS (I30 192.4) **RACK 16** OVER THE CAMS. ADJUST ON CAMS AND TOP SLITTER BAR. SECURE THE SLITTER ACTUATING BLOCK WITH A RETAINING RING (PRR191) **LD05** OF BOTH ENDS OF TOP SLITTER BAR.**
- 6) **FROM THE INNER LEFT SIDE PANEL BELOW THE CHILL ROLL APERTURE AND BEHIND THE CHILL ROLL CHAIN, INSERT A 3/8 X 3/4 (.375OAC12) **AS13** BSH. THREAD THE CAMLOCK SUPPORT STANDOFF (ID25 194.4) **RACK 15** FROM THE OUTER SIDE PANEL ONTO THE 3/8 X 3/4 BSH THREADS.**
- 7) **SLIDE CHILL ROLL CAMLOCK (ID25 196.4) **RACK 16** WITH THREADS DOWNWARD, OVER THE "TIMED"**



SPROCKET SPRING PIN ON THE CAM SHAFT. ADJUST CHILL ROLL CAMLOCK TO SECURE THE CAMLOCK SUPPORT STANDOFF USING A 1/2 X 5/8 SHOULDER BOLT. FROM CHILL ROLL CAMLOCK UNDERSIDE, INSERT A 5/16-18 X 1 1/2 SHCS. PLACE A 5/16 FLAT WASHER ON EXPOSED UPPER SOCKETHEAD THREADS.



- 8) BRUSH ANTI-SEIZE ON END THREADS OF THE SOCKETHEAD. THREAD A COOLING TUBE LOCK EXTENSION (I30 133.4) **RACK 16** DOWNWARD ONTO THE SOCKETHEAD ON CHILL ROLL CAM LOCK.



- 9) PLACE A BLACK KNOB (PRK174) **RACK 16** ONTO THE UPPER COOLING TUBE LOCK EXTENSION AND SECURE WITH A 10-32 X 3/8 SET SCREW.

- 10) PLACE A BUBBLE LEVEL ON THE ENDS OF THE COOLING TUBES AND ADJUST THE BUBBLE TO CENTER BY LOOSENING THE BUTTONHEAD ON THE CHILL ROLL TIMING BRACKET. USE AN ALLEN WRENCH. CHECK BOTH SIDES AND ADJUST AS NECESSARY.



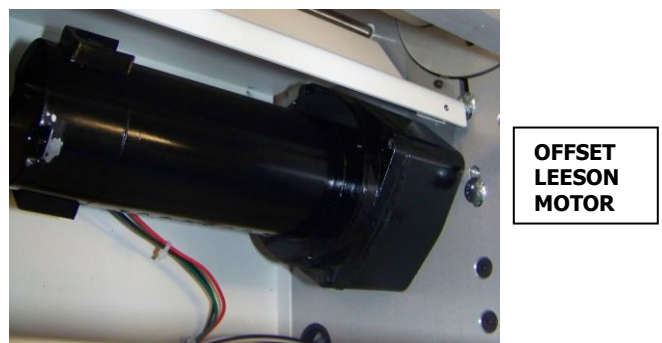
- 11) UNTHREAD THE COOLING TUBE LOCK EXTENSION AND SET ASIDE. THIS WILL BE REINSTALLED AFTER HOUSING PLACEMENT.



- 12) SECURE THE 6" FAN ASSEMBLY TO THE LEFT SIDE PANEL, FITTING THE FAN PLENUM OVER THE COOLING TUBE ROTATING MOUNTING DISC. THE CHANNELS IN THE PLENUM FACE **DOWNWARD**. THE CHAIN ON THE "TIMED" SPROCKET FITS IN BETWEEN THE PLENUM CHANNELS. FROM THE INNER SIDE PANEL INSERT (2) 10-32 X 3/4 TH, THREADING THEM INTO THE CLUTCH SPACERS ON THE OUTER FAN BRACKET.

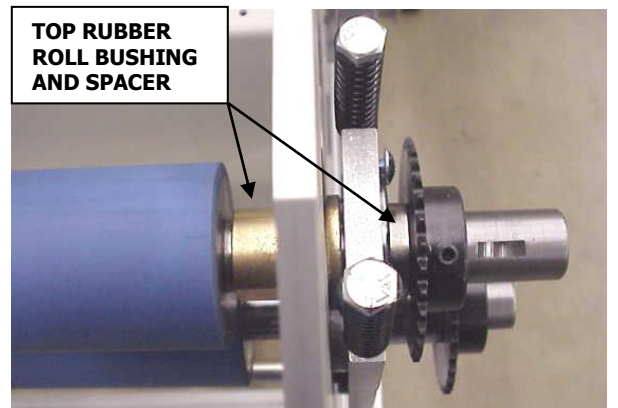
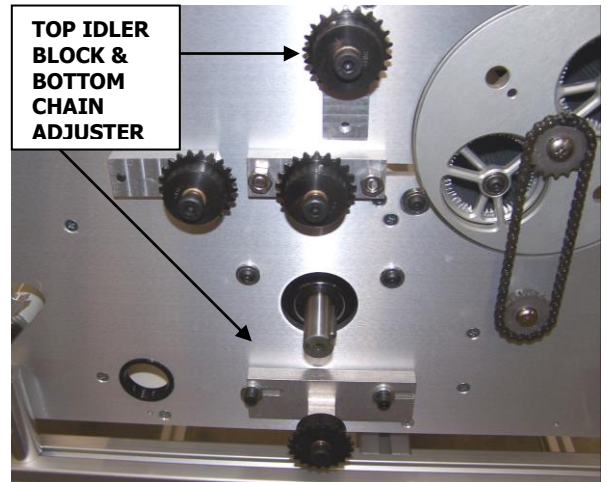


- 13) PLACE AN **OFFSET** LEESON MOTOR 180V (PRM2003) **AS05** IN THE BOTTOM MOTOR COVER, MOTOR SHAFT EXITING RIGHT SIDE PANEL, WIRES DOWNWARD. CRIMP RED MALE CONNECTORS ON WIRES. CONNECT UPPER MOTOR THREADS, UNDER THE TOP CHAIN



ADJUSTER, WITH A 1/4-28 X 1 BHSH AND NO WASHER. THE (2) MIDDLE THREADS CONNECT WITH A 1/4-28 X1 BHSH AND A 1/4 X 5/8 X 1/8 WILLIAMS FLAT WASHER ON EACH. THE LOWER MOTOR THREAD, ABOVE THE BOTTOM CHAIN ADJUSTER, CONNECTS WITH A 1/4-28 X 1 SHCS WITH NO WASHER.

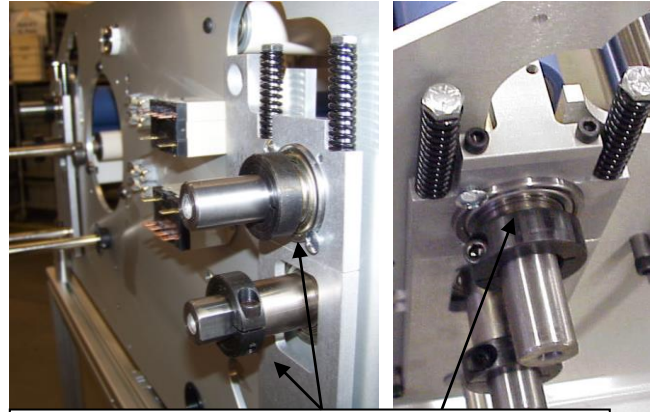
- 14) SECURE TOP IDLER SPROCKET BLOCK (I30 053.4) **RACK 15** WITH BOSS AND 25B21 SPROCKET *UPWARD* ON THE RIGHT PANEL, USE (2) 1/4-20 X 1/2 FHS.
- 15) PLACE (3) 25B21 1/2" BORE SPROCKETS (PRS253) **RACK 16** EACH WITH AN ARBOR PRESSED SLEEVE BEARING (PRB040) **RACK 16** ONTO A 3/8 X 7/8 SHOULDER BOLT. THREAD INTO IDLER SPROCKET BLOCK BOSS AND TOP CHAIN ADJUSTER. ON THE *BOTTOM CHAIN ADJUSTER* THE HUB IS *INWARD* THREADED INTO THE BOSS. ON THE *TOP IDLER SPROCKETS AND TOP CHAIN ADJUSTER* THE HUBS ARE *OUTWARD*.
- 16) INSTALL THE (4) I30 RUBBER ROLLS (I30 040.4) **AS22A** INTO THE CHASSIS WITH THE DOUBLE KEYWAYS ON THE RIGHT SIDE (MOTOR SIDE). REST THE TOP (2) RUBBER ROLLS IN THE FRONT AND REAR OVERHANG. CENTER AND MEASURE BOTTOM RUBBER ROLLS.
- 17) TAP (4) R14Z ROLLER BALL BEARINGS (PRB087) **AS09** OVER THE BOTTOM RUBBER ROLL JOURNALS AND INTO SIDE PANELS, SNUG WITH THE TRUSSHEAD SCREWS IN PANELS.
- 18) ADD (4) LARGE BOTTOM RUBBER ROLL SPACERS (I30 033.4) **RACK 15** ONE EACH ONTO BOTTOM RUBBER ROLL JOURNALS, SNUG WITH THE ROLLER BEARINGS. REMEASURE BOTTOM ROLLS.
- 19) ALIGN TOP RUBBER ROLLS WITH BOTTOM RUBBER ROLLS AND PLACE (4) WORKED OILITE BUSHINGS (PRB089) **RACK 2** ONTO THE TOP RUBBER ROLL JOURNALS, FLANGE OUTWARD. FIT THE WORKED SLEEVE OF THE BUSHINGS INTO THE SIDE PANEL SLOTS. REALIGN





**TOP AND BOTTOM RUBBER ROLLS.**

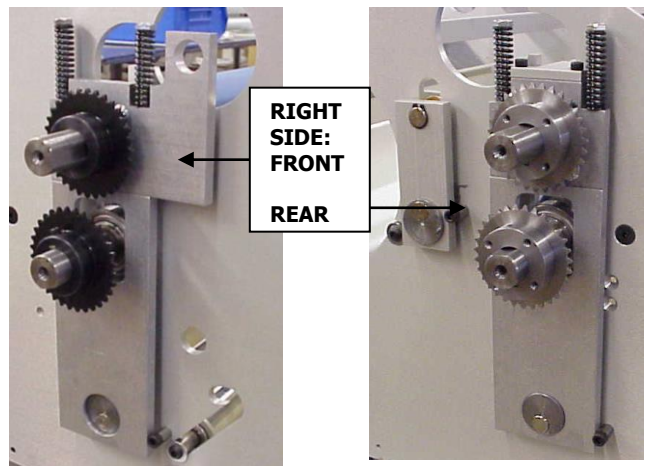
- 20) BRUSH "NEVER SEIZE" LUBRICANT ONTO THE CAM CIRCUMFERENCE AND TAP FRONT AND REAR CONNECTING PLATE ASSEMBLIES OVER TOP JOURNALS AND LOWER CAMS. THE EXCESS ROLLER BEARING IS OUTWARD. NOTE THE FRONT CONNECTING PLATE OFFSET IS FACING REAR FOR HEAT SHOE BOLT. SECURE *BOTH LEFT SIDE* BOTTOM RUBBER ROLL SPACERS TO THE ROLLER BALL BEARINGS WITH A 7/8" SPLIT SHAFT COLLAR (PRC112) **RACK 2**.



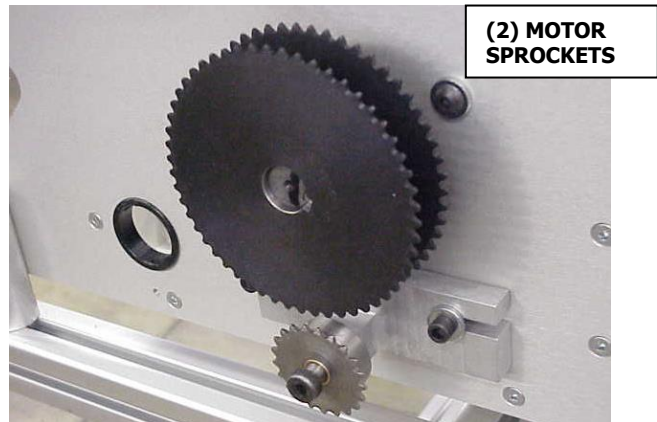
LEFT SIDE: SPLIT SHAFT COLLARS & TOP SPACERS

- 21) ADD (4) THINNER TOP RUBBER ROLL SPACERS (I30 032.4) **RACK 15** AFTER THE CONNECTING PLATES ARE ON. SECURE LEFT SIDE WITH 7/8" SPLIT SHAFT COLLARS. CHECK ALIGNMENT.

- 22) USE A RUBBER MALLOT TO TAP (4) 3/16 X .612 WOODRUFF KEYS (MI61KEY) **AS13** INTO THE RIGHT SIDE JOURNAL KEYWAY. USE THE *OUTER KEYWAYS* ON BOTH BOTTOM JOURNALS AND THE *INNER KEYWAYS* ON BOTH TOP JOURNALS. CHECK LEFT ALIGNMENT.



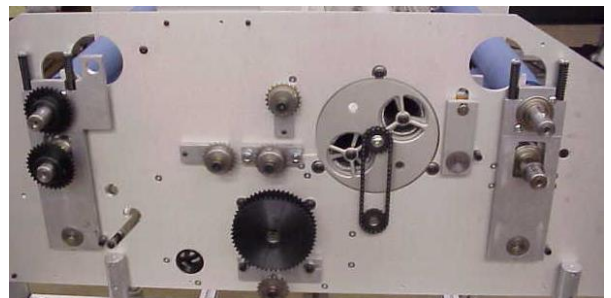
- 23) SLIDE (2) 25B32 7/8" BORE SPROCKETS (PRS258C) **RACK 14** OVER THE KEYS ON THE FRONT JOURNALS *BOTH HUBS OUTWARD*. SECURE THE TOP JOURNAL FIRST. TIGHTEN ON JOURNAL FLAT SIDE, FLUSH WITH TOP AND BOTTOM SPACERS. USE 1/4-28 X 3/8 SET SCREWS TO SECURE EACH.



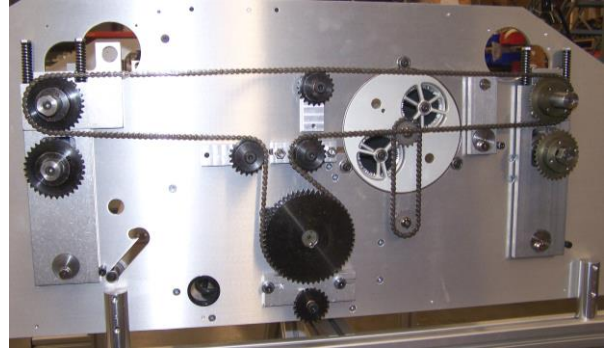
- 24) SLIDE (2) 25B31 SPROCKETS (PRS261) **RACK 16** OVER THE KEYS ON THE REAR JOURNALS *BOTH HUBS OUTWARD*. TIGHTEN ON JOURNAL FLAT SIDES, FLUSH WITH TOP AND BOTTOM SPACERS. USE 10-32 X 3/8 SET SCREWS.

- 25) CHECK THE LEFT SIDE CONNECTING PLATES WITH (4) 7/8" SPLIT SHAFT COLLARS TO BE SURE THEY ARE SNUG TO THE TOP AND BOTTOM SPACERS.

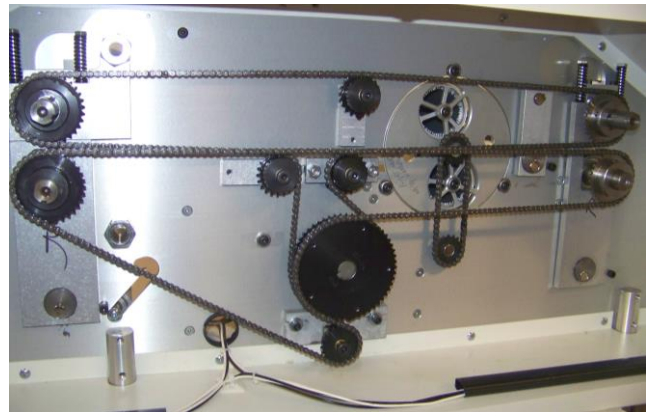
- 26) THREAD A 1/4-28 X 1/2 SET SCREW INTO (2) 25B54 MOTOR SPROCKETS (PRS285B) **RACK 16**. SLIDE SPROCKETS



OVER KEY IN MOTOR SHAFT, WITH THE *HUB INWARD*. PUSH THE BOTTOM CHAIN ADJUSTER SPROCKET ALL THE WAY INWARD AND ALIGN THE OUTER MOTOR SPROCKET TEETH 1/16" OUTWARD OF THE BOTTOM CHAIN ADJUSTER TEETH. SNUG INNER MOTOR SPROCKET TO OUTER MOTOR SPROCKET. TIGHTEN SET SCREWS.



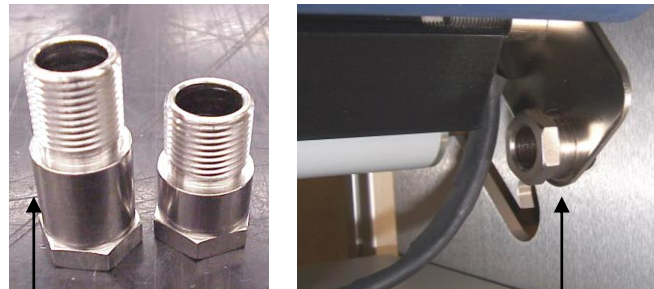
- 27) *WITH ROLLS UP*, CONNECT THE LONGER INNER CHAIN BY THREADING OVER TEETH OF BOTH TOP SPROCKETS AND TOP IDLER SPROCKET, TO THE INSIDE OF THE IDLER SPROCKET BLOCK AND TOP CHAIN ADJUSTER AND ON INNER MOTOR SPROCKET. TIGHTEN CHAIN BY SNUGGING TOP CHAIN ADJUSTER.



- 28) THE OUTER CHAIN LAYS ON TEETH OF BOTTOM RUBBER ROLL SPROCKETS, TO THE LEFT/FRONT OF THE OUTER MOTOR SPROCKET AND TO THE RIGHT/REAR OF THE BOTTOM CHAIN ADJUSTER SPROCKET. TIGHTEN OUTER CHAIN BY MOVING BOTTOM CHAIN ADJUSTER.

- 29) CHECK (4) FEET MOUNTING SHAFT EXTENTIONS FOR TIGHTNESS.

- 30) FROM **RACK 15** TEST THE SHORTER BOTTOM HEAT SHOE FASTENERS (I30 067.4) AND THE TOP HEAT SHOE FASTENERS (I30 068.4) IN THE BOTTOM AND TOP HEAT SHOE BRACKET OPENINGS AND THE SIDE PANELS TO BE CERTAIN FASTENERS WILL FIT EASILY. SAND WITH DREMME TOOL IF NECESSARY.



TALLER/TOP~SHORTER/BOTTOM HEAT SHOE FASTENER

- 31) THE BOTTOM HEAT SHOE ASSEMBLY IS SECURED BETWEEN SIDE PANELS WITH (2) BOTTOM HEAT SHOE FASTENERS INSERTED THROUGH THE RIGHT AND LEFT BOTTOM HEAT SHOE BRACKETS AND THROUGH THE SIDE PANELS. THE FASTENERS ARE SECURED ON OUTER SIDE PANELS WITH A 3/4-16 FINISHED HEX JAM NUT (.750LDB00) **AS13**. TIGHTEN WITH A 7/8 SOCKET HEAD RATCHET. THE HEATER AND SENSOR WIRES RUN THROUGH THE HOLLOW FASTENERS AND EXIT ON LEFT SIDE.

