

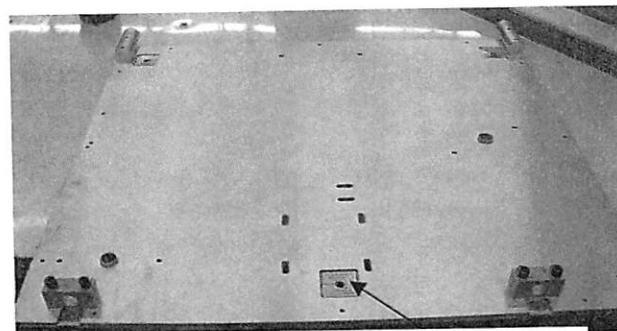
DUAL TS RELEASE LINER EP30, 44, 60

ASSEMBLY PROCEDURES

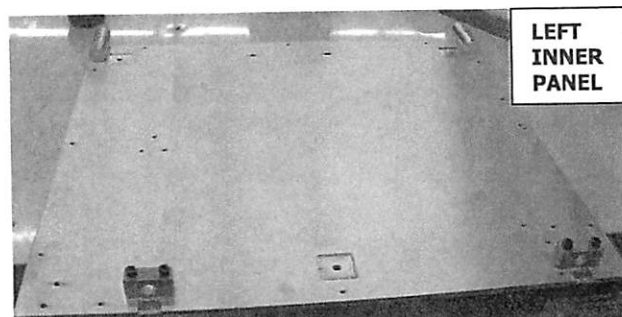
December 2013

DUAL TS RELEASE LINER EP30/44/60 STAND SIDE PANEL

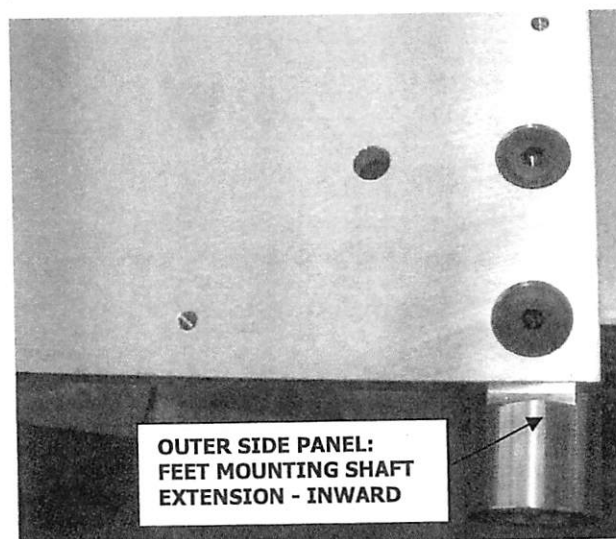
- 1) THE TAKE UP LEFT SIDE PANEL (TS 090.4L) D-01 FLOOR AND THE TAKE UP RIGHT SIDE PANEL (TS 090.4R) D-01 FLOOR REQUIRE SOME ASSEMBLY BEFORE SECURING SIDE PANELS BETWEEN THE STAND SPANNERS.
- 2) ORIENT THE TAKE UP RIGHT SIDE PANEL WITH THE (4) VERTICAL SLOTS UPWARD TO ACCOMMODATE RLT PARTS. THE LOWER COUNTERSINKS ARE OUTWARD AND THE SQUARE MILLED OUT POCKETS ARE INWARD.
- 3) ARBOR PRESS (2) 1/8" FLANGE OILITE BEARINGS (PRB078) RACK 10 INTO THE INNER RIGHT SIDE PANEL, FLANGE INWARD.
- 4) TAP AN OILITE WASHER (PRW338) RACK 10 ONTO THE SLEEVE OF BOTH OUTER OILITE BEARINGS. STAKE WASHERS TO BEARING IN THREE EQUIDISTANT LOCATIONS. USE A 5/8, .625 REAMER.
- 5) SECURE (2) FEET MOUNTING SHAFT EXTENTIONS (LC38 048.4) AS13 TO EACH OF THE INNER SIDE PANELS, THROUGH THE OUTER, LOWER COUNTERSUNK HOLES. USE 5/16-18 X 1 1/4 FSH.
- 6) DIRECTLY BELOW THE UPPER MILLED POCKETS, SECURE (2) MACHINE MOUNTING BLOCKS (TS 048.4) LOFT 0 TO EACH INNER SIDE PANEL, WITH THE OFFSET MIDDLE HOLE ON THE MOUNTING BLOCK CLOSER TO THE SIDE PANEL. USE 5/16-18 X 1 1/4 SHCS.
- 7) USE A 10-32 TAP AND OPEN THE THREADED HOLE ON THE PAINTED, LONG SIDE OF (2) REWIND ROLL BRACKETS (EP30 006.4) RACK 8. PRESS A SPI KNOB (PRK176) AS08 ONTO (2) 10-32 X 1 1/2 SHCS. THREAD



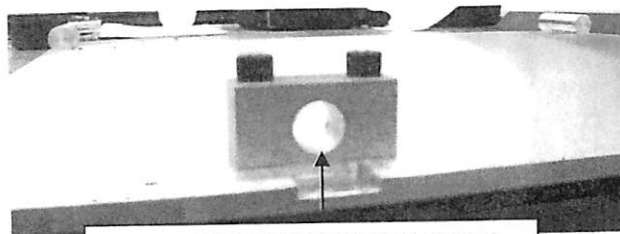
RIGHT SIDE PANEL: TOP-MILLED POCKET



LEFT
INNER
PANEL



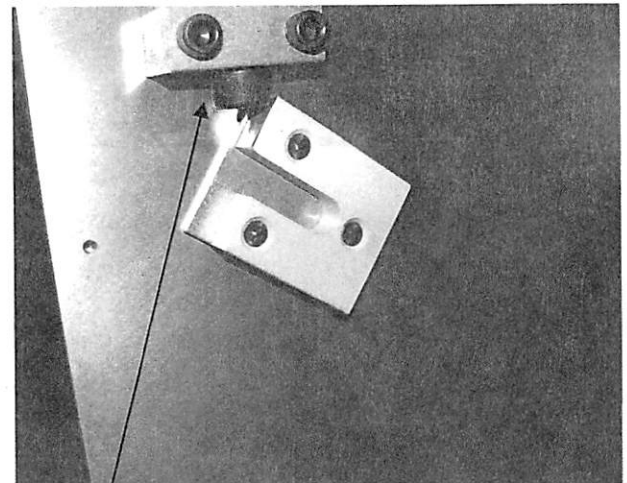
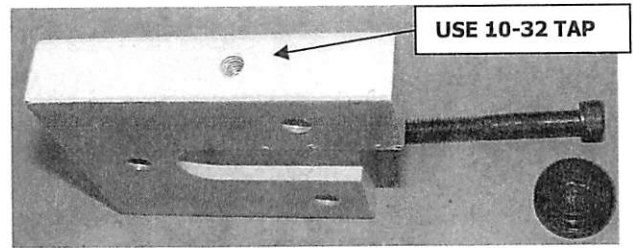
OUTER SIDE PANEL:
FEET MOUNTING SHAFT
EXTENSION - INWARD



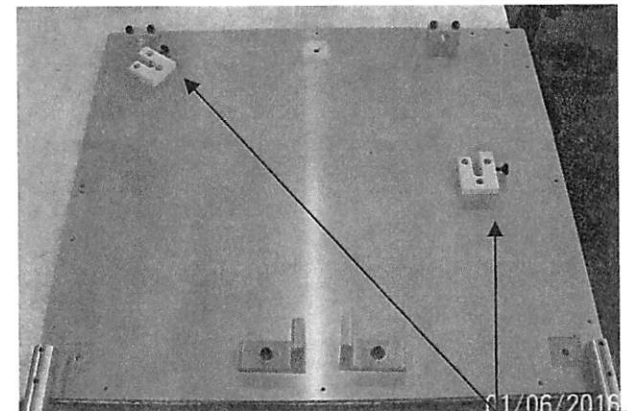
OFFSET HOLE ON MOUNTING BLOCK

ONTO (2) 10-32 X 1 1/2 SHCS. THREAD THIS SCREW INTO OPENED LOCATION.

- 8) ON THE INNER LEFT SIDE PANEL SECURE THE (2) REWIND ROLL BRACKETS, EACH WITH (2) REWIND BRACKET SPACERS (EP30 057.4) RACK 8 USING (6) 10-32 X 1 FHMS. ONE SET OF REWIND BRACKET AND SPACERS LOCATE UPRIGHT AND THE OTHER SET LOCATE OFFSET, DIRECTLY BELOW THE FRONT MOUNTING BLOCK. ****THE OFFSET REWIND ROLL BRACKET WILL NEED TO BE LOOSENED WHEN SECURING SIDE PANEL TO LAMINATING MACHINE MOUNTING SHAFT WITH 1/2-13 X 1 1/2 SHCS AS13.**
- 9) **LOOSELY** SECURE (2) STAND GUSSETS (LC38 135.4G) LOFT 1 TO THE INNER RIGHT AND LEFT STAND SIDE PANELS. ORIENT THE GUSSETS WITH THE BREAK INWARD. USE 5/16-18 X 1 SHCS, EACH WITH A 5/16 FLAT WASHER. THE GUSSETS WILL BE TIGHTENED AFTER THE STAND EXTRUSIONS ARE SECURED BETWEEN THEM.
- 10) THE DUAL RELEASE LINER TAKE UP STAND SIDE PANELS CAN NOW BE SECURED BETWEEN THE STAND EXTRUSIONS. FURTHER ASSEMBLY CONTINUES AFTER THAT POINT.

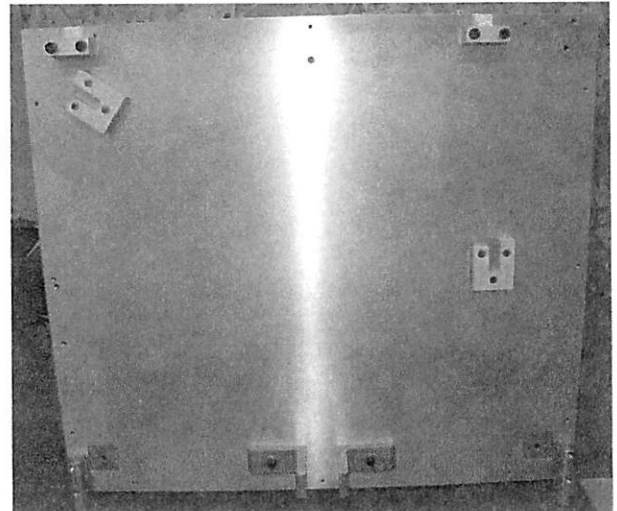
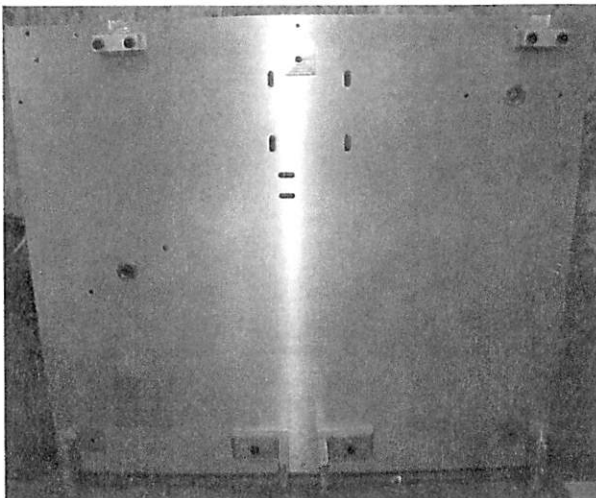


1/2-13 X 1 1/2 SHCS IN *BEFORE* OFFSET REWIND ROLL BRACKET & REWIND BRACKET SPACER, LOOSEN WHEN SECURING TO MACHINE FEET



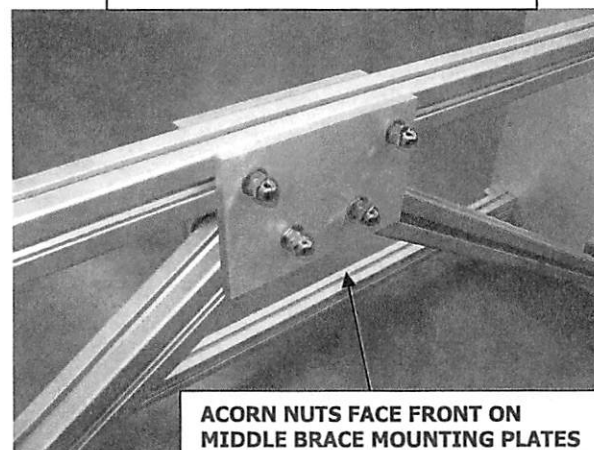
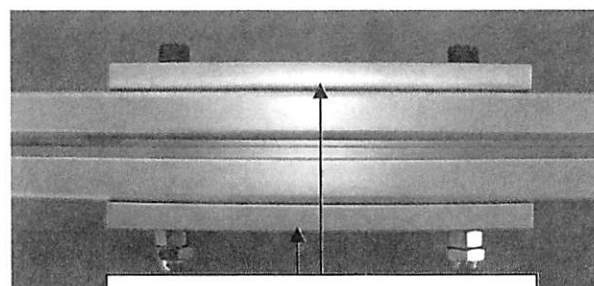
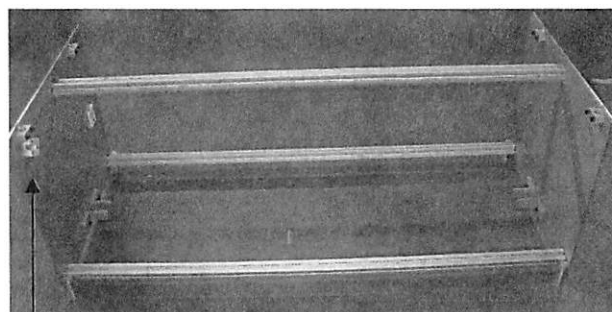
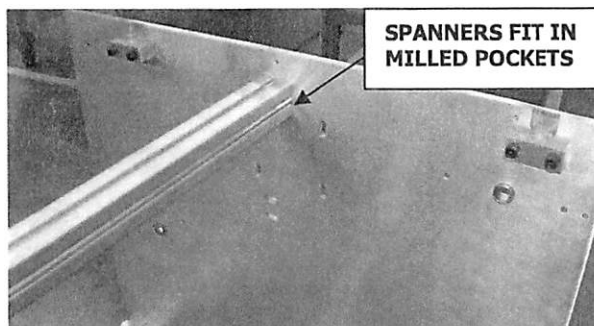
RIGHT SIDE: *INNER* SIDE PANEL

LEFT SIDE: GUSSETS & *UPRIGHT* REWIND BRACKETS



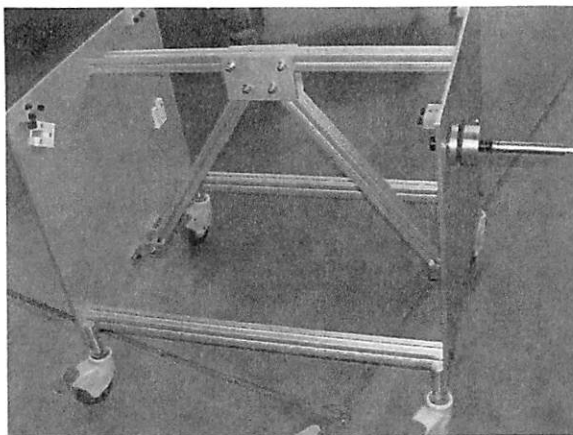
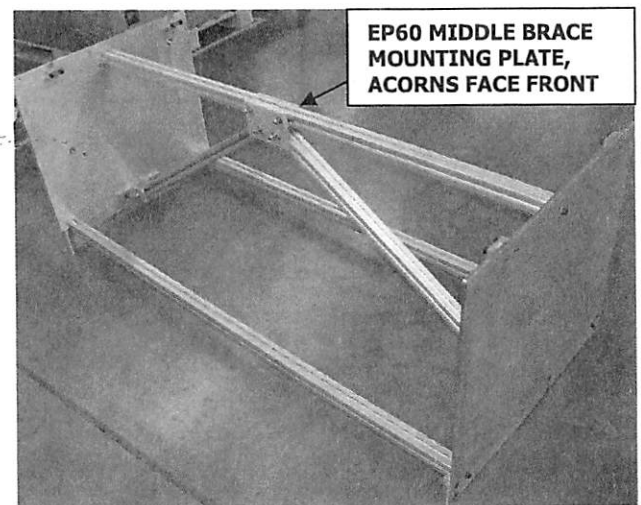
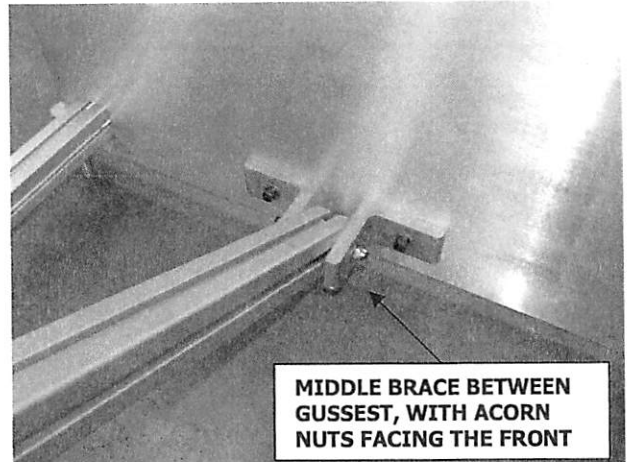
DUAL TS RELEASE LINER EP 30/60 STAND EXTRUSION ASSEMBLY

- 1) THE RIGHT AND LEFT STAND SIDE PANELS ARE CONNECTED WITH THE STAND SPANNERS. IT IS HELPFUL TO HAVE *TWO PEOPLE* DURING THIS PROCEDURE, AS PANELS ARE HEAVY AND SPANNERS MUST BE HELD IN THE MILLED POCKETS WHILE TIGHTENING.
- 2) THE UPPER, *OFFSET REWIND ROLL BRACKET* FACES THE FRONT OF THE STAND. TS, TS30 OR TS44 PLACE (2) BOTTOM WIDTH STAND SPANNERS (TS 135.4B) LOFT 1 INTO LOWER, *INNER* MILLED POCKETS. *LOOSELY* THREAD BOTTOM SPANNERS WITH 5/16-18 X 1 SHCS. SPANNER SHOULD NOT SPIN OUT OF MILLED POCKET WHILE THREADING.
- 3) *LOOSELY* SECURE THE TOP WIDTH STAND SPANNER (TS 135.4T) LOFT 1 BETWEEN UPPER MILLED POCKETS OF RIGHT AND LEFT STAND PANELS. BE CERTAIN THE SPANNER MIDDLE HOLES ARE FACING FRONT AND BACK. SECURE THE LEFT SIDE PANEL TO THE TOP SPANNER WITH A 5/16-18 X 1 SHCS. SECURE THE RIGHT SIDE PANEL TO TOP SPANNER WITH A 5/16-18 X 1 FHSC.
- 4) *LOOSELY* SECURE THE (2) MIDDLE BRACE MOUNTING PLATES (I30 135.4I) LOFT 1 TO THE FRONT AND REAR TOP WIDTH SPANNER. *FROM THE REAR* INSERT (2) 5/16-18 X 3 SHCS, EACH WITH A 5/16-18 FLAT WASHER. ADD ANOTHER 5/16 FLAT WASHER ONTO THE FRONT THREADS, THEN A 5/16-18 HEX NUT AND A 5/16-18 ACORN NUT, SNUG.
- 5) ALIGN HOLES ON (2) MIDDLE STAND BRACES (TS 135.4J) LOFT 1 WITH LOWER HOLES IN THE MIDDLE BRACE MOUNTING PLATE *AND* BETWEEN THE *LOOSE* GUSSETS ON THE LOWER SIDE PANEL. INSERT (2) 5/16-18 X 3 SHCS, EACH WITH A 5/16 FLAT WASHER FROM

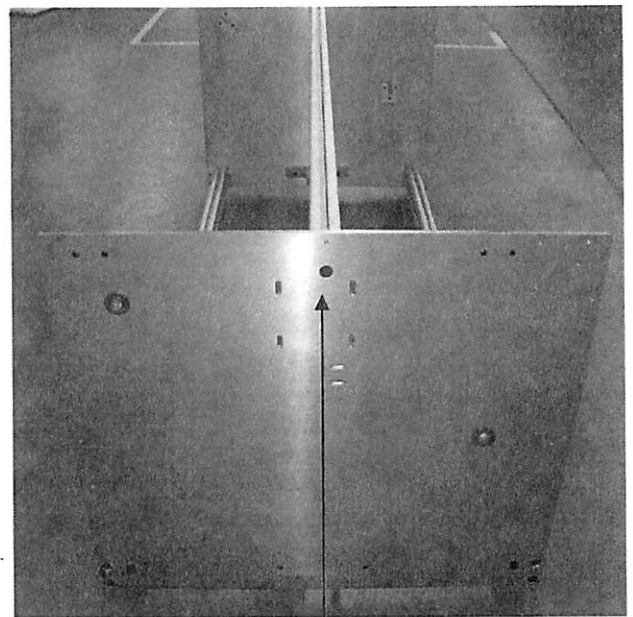


THE REAR THROUGH THE MOUNTING PLATE AND MIDDLE BRACES. PLACE ANOTHER 5/16 FLAT WASHER, 5/16-18 HEX NUT AND 5/16-18 ACORN NUT ON THE FRONT THREADS.

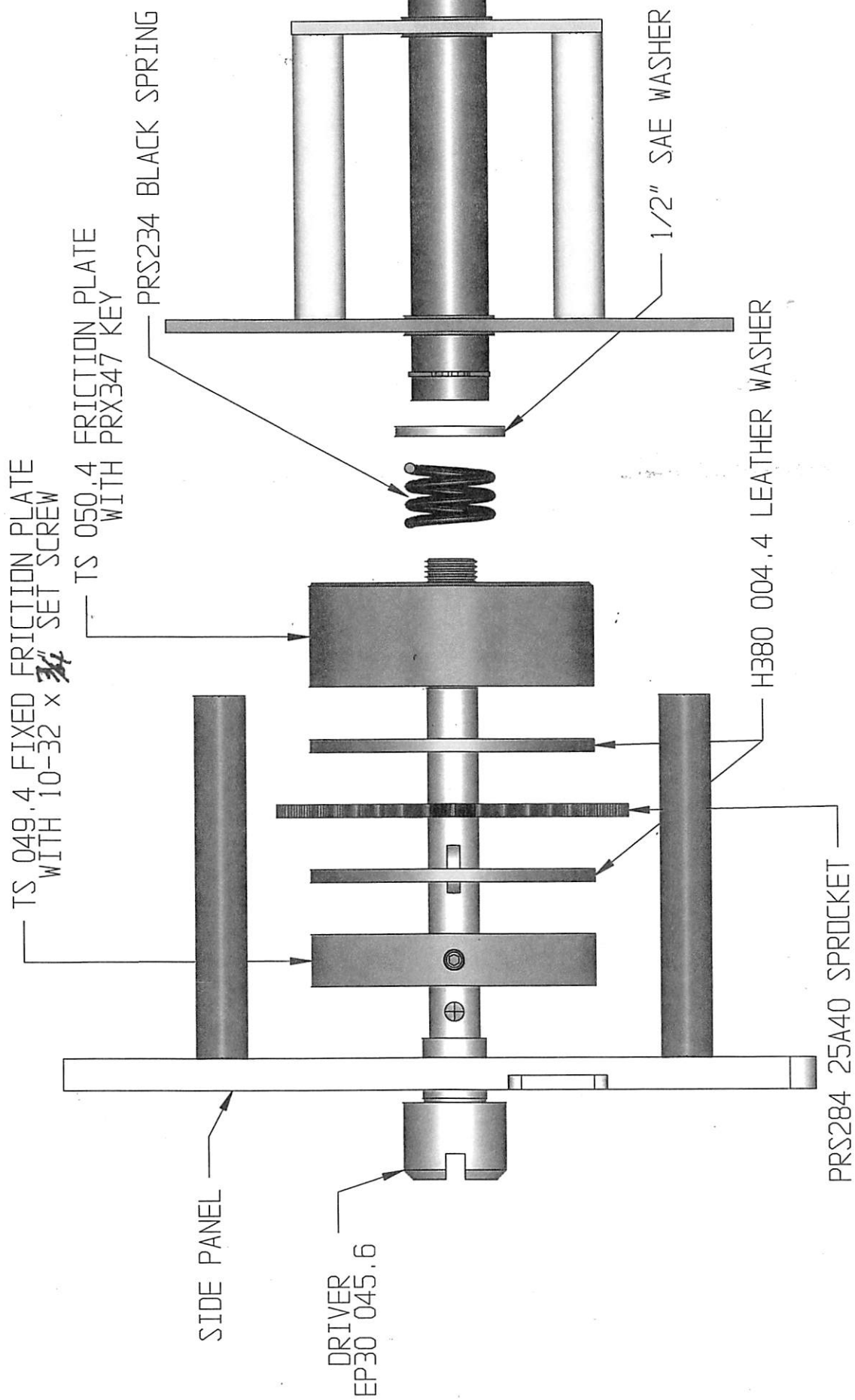
- 6) ALIGNING HOLES WITH MIDDLE BRACES AND GUSSETS, FROM THE REAR INSERT A 5/16-18 X 3 SHCS WITH 5/16 FLAT WASHER AND ON THE FRONT THREADS SECURE WITH ANOTHER 5/16 FLAT WASHER AND 5/16-18 ACORN NUT.
- 7) *TIGHTEN* ALL SCREWS, ALL THE WAY AROUND THE STAND. USE A WRENCH TO TIGHTEN HEX AND ACORN NUTS. BE CERTAIN SPANNERS STAY IN MILLED POCKETS WHILE TIGHTENING.
- 8) PLACE THE DUAL RELEASE LINER TAKE UP STAND ASSEMBLY ON A TABLE, TO FACILITATE FURTHER WORK.



FRONT OF EP30 DUAL RELEASE LINER STAND

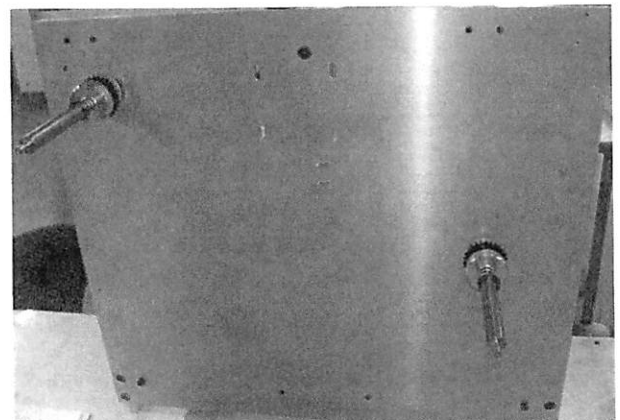
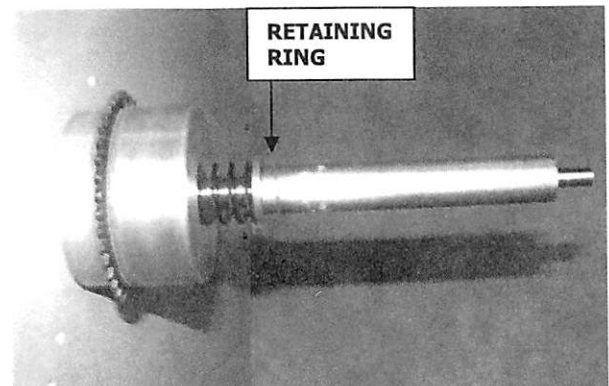
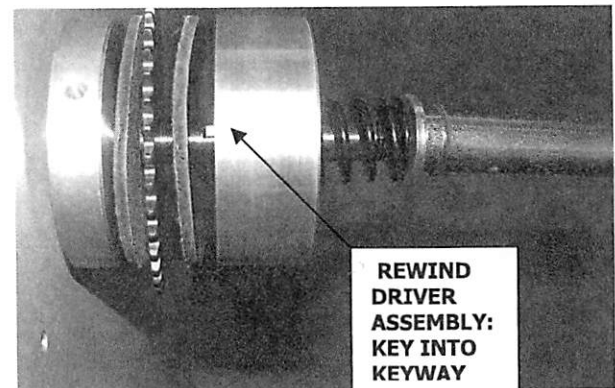
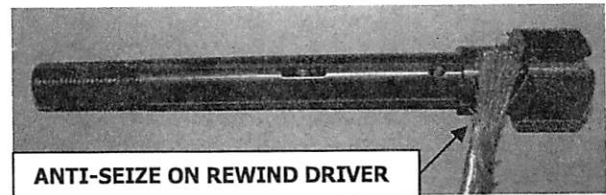


RIGHT SIDE: TOP SPANNER WITH FLATHEAD SCREW

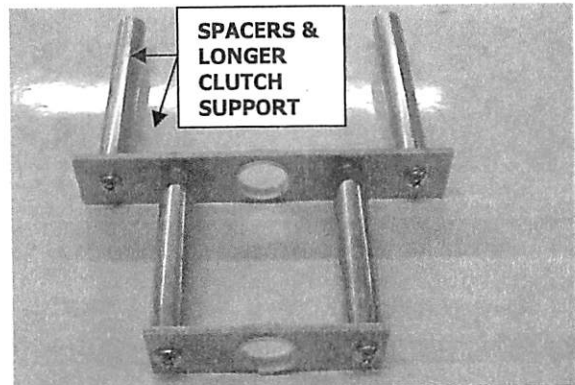


DUAL TS RELEASE LINER EP 30/60 REWIND DRIVER & CLUTCH SUPPORT

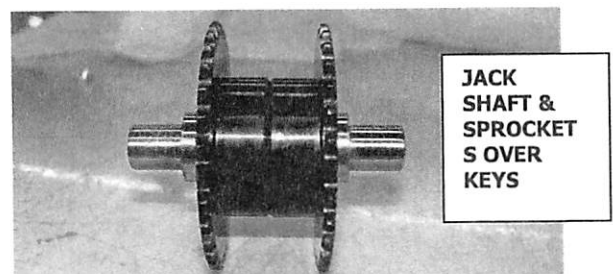
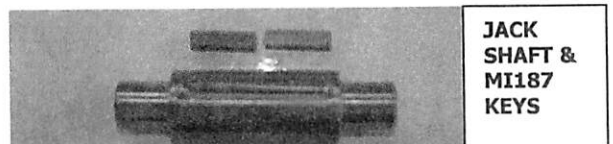
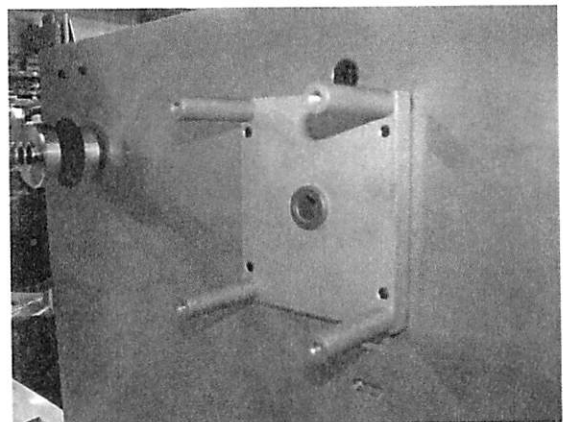
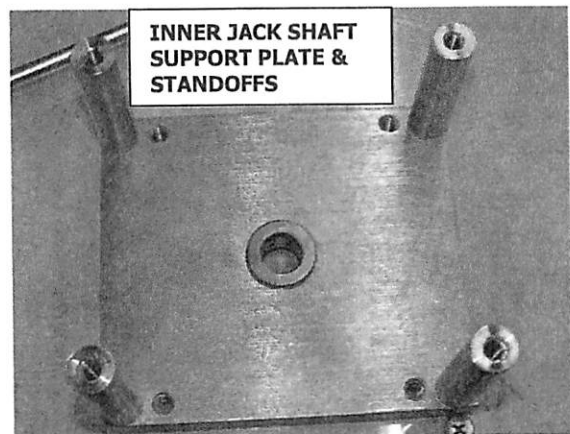
- 1) **RIGHT SIDE PANEL:** OPEN THE (2) OILITE BEARINGS WITH A .625 REAMER, STORED IN TOM MANN'S WORKBOX. INSERT REAMER FROM INNER STAND SIDE PANEL, REAMING OUTWARD. CLEAN REAMER AND REPLACE IN WORKBOX.
- 2) BRUSH ANIT-SEIZE ONTO PORTION OF REWIND DRIVER THAT RESTS IN THE OILITE BEARING. FROM INNER RIGHT SIDE PANEL INSERT REWIND DRIVER ASSEMBLY C (EP30 045.6) RACK 8 THROUGH BRASS FLANGE. FROM OUTER PANEL ADD IN ORDER: FIXED FRICTION PLATE (TS 049.4) LOFT 0 CONTAINING A 10-32 X $\frac{3}{4}$ SET SCREW TIGHTENED INTO REWIND DRIVER ASSEMBLY HOLE. ** BE SURE THINNER SIDE OF FIXED FRICTION PLATE IS TOWARD SIDE PANEL. ADD A LEATHER DISC 1/8 X $\frac{1}{2}$ ID X 2 $\frac{3}{4}$ OD (H380 004.4) AS08, THEN A 25A40 $\frac{1}{2}$ BORE SPROCKET (PRS284) LOFT 0. *THIS SPROCKET HAS NO HUB.* ADD ANOTHER LEATHER DISC (H380 004.4). PUT HD KEY (PRX347) AS09 INTO REWIND DRIVER ASSEMBLY KEYWAY. SLIDE ON FRICTION PRESSURE PLATE (TS 050.4) LOFT 0 WITH THE COUNTERBORE FACING OUTWARD. SLIDE A BLACK SUPPLY ROLL TENSION SPRING (PRS234) SUPPLY ROLL CART FITTING INTO THE COUNTERBORE. ADD A $\frac{1}{2}$ " FLAT WASHER SAE (.500KKC01) AS13. BRUSH ANTI-SEIZE ON REWIND DRIVER ASSEMBLY THREADS. SLIDE A $\frac{3}{4}$ " RETAINING RING (PRR192) AS08 INTO THE GROOVE ON THE TENSION NUT (EP30 046.4) RACK 8 THE TENSION NUT HAS REVERSE THREADS. SNUG ON TENSION NUT, FIRING BLACK SPRING. THERE ARE TWO REWIND DRIVERS ON PANEL.
- 3) ASSEMBLE (2) CLUTCH SUPPORTS BY USING A TOTAL OF (12) 10-32 X $\frac{1}{2}$ PHMS SCREWS. CONNECT PARTS LOCATED IN RACK 8 AS FOLLOWS: USE (2) SCREWS



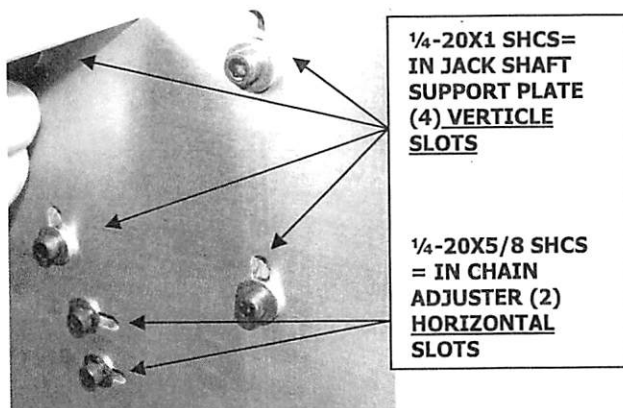
AND ATTACH ENDS OF LONGER, INNER CLUTCH SUPPORT C (EP30 076.4) TO (2) LONGER INNER CLUTCH SPACERS C (EP30 078.4). USE (2) SCREWS ON SHORTER, OUTER CLUTCH SUPPORT C (EP30 077.4) TO (2) SHORTER OUTER CLUTCH SPACERS C (EP30 079.4). USE (2) SCREWS FOR OUTER CLUTCH SPACERS TO INNER CLUTCH SUPPORT. INSERT (2) $\frac{3}{4}$ " SHAFT NYLINERS (PRB068) AS07 FROM INSIDE OUTWARD, FLANGE TOWARD STAND SIDE PANEL. SLIDE OVER REWIND ASSEMBLYS AND SECURE WITH 10-32 X $\frac{3}{4}$ BHCS.



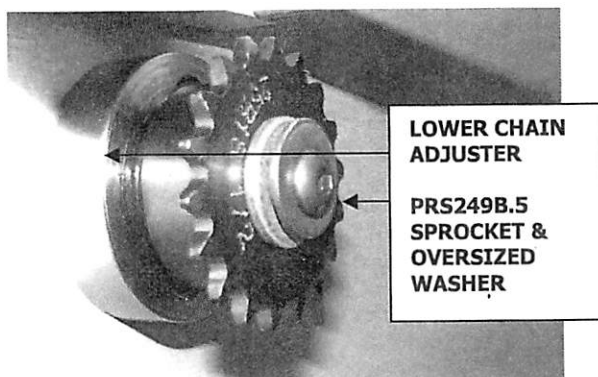
- 4) ARBOR PRESS AN OILITE BEARING (PRB048) AS08 INTO THE *INNER JACK SHAFT SUPPORT PLATE* (TS 309.4) LOFT 0, WHICH HAS (8) SCREW OPENINGS, THE OILITE FLANGE IS LOCATED OPPOSITE COUNTERSINKS. THREAD ON (4) JACK SHAFT SUPPORT PLATE STANDOFFS (TS 311.4) LOFT 0 USING $\frac{1}{4}$ -20 X 1 FHSC. OPEN THE OILITE BEARING WITH A .505 REAMER.
- 5) PLACE A $\frac{1}{4}$ X $\frac{5}{8}$ X $\frac{1}{8}$ FLAT WASHER ON EACH OF (4) $\frac{1}{4}$ -20 X 1 SHCS. INSERT FROM INNER RIGHT SIDE PANEL THROUGH VERTICAL SLOTS AND *LOOSELY* SECURE INNER JACK SHAFT SUPPORT PLATE. THE INNER JACK SHAFT SUPPORT PLATE MUST SLIDE UP AND DOWN EASILY TO ADJUST CHAIN LATER.
- 6) INSERT (2) KEYS (MI187) AS08 INTO THE KEYWAY OF A JACK SHAFT (TS 314.4) LOFT 0. KEY ENDS MAY NEED SANDING TO FIT IN KEYWAY.
- 7) SLIDE (2) 25B32 $\frac{3}{4}$ " BORE SPROCKETS (PRS258A) RACK 8, ORIENTED WITH *HUB INWARD* ON BOTH, SO THE TEETH ARE BOTH OUTWARD OVER THE JACK SHAFT KEYS. THREAD A 10-32 X $\frac{3}{8}$ SS INTO BOTH SPROCKETS. SLIDE THE JACK SHAFT INTO THE BEARING ON SUPPORT. MEASURE TO EQUAL DISTANCE BETWEEN INNER SPROCKET TEETH AND TEETH ON REWIND SHAFTS. SECURE THE SET SCREW ON *INNER JACK SPROCKET*, *SNUG* OUTER SPROCKET.



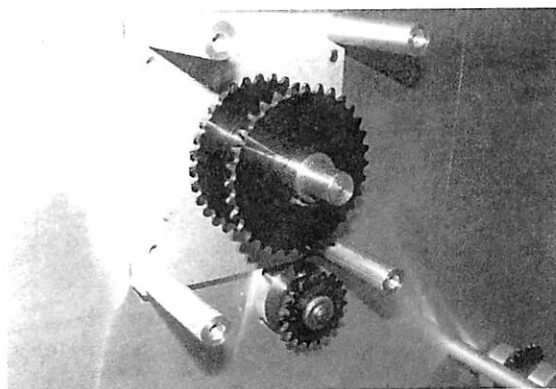
- 8) **LOOSELY** SECURE THE LOWER CHAIN ADJUSTER (TS 315.4) LOFT 0 BELOW THE JACK SHAFT SUPPORT ASSEMBLY. PLACE A $\frac{1}{4}$ " FLAT WASHER ON EACH OF (2) $\frac{1}{4}$ -20 X 5/8 SHCS AND INSERT THEM FROM THE INNER RIGHT SIDE PANEL THROUGH THE HORIZONTAL SLOTS. THREAD INTO LOWER CHAIN ADJUSTER. ADJUSTER MUST MOVE BACK AND FORTH IN HORIZONTAL CHANNEL.



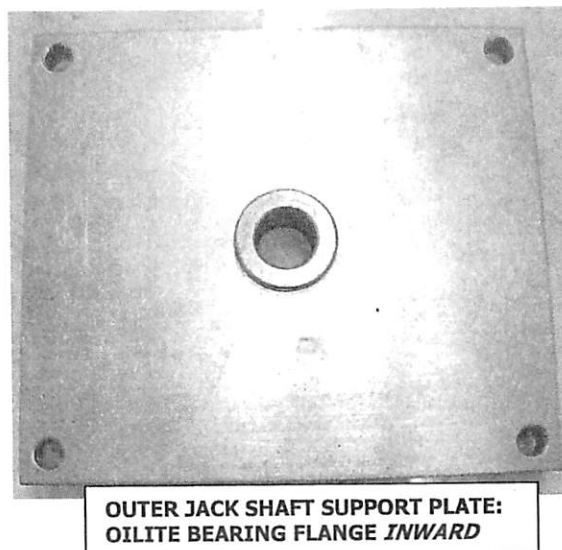
- 9) REMOVE AND DISCARD SET SCREW FROM THE *FLOATING* 25B18 3/8 SPROCKET WITH BUSHING (PRS249B.5) RACK 8. SLIDE SPROCKET ONTO THE LOWER CHAIN ADJUSTER SHAFT WITH TEETH AND OILITE FLANGE OF THE SPROCKET OUTWARD. TO HOLD THE SPROCKET ON CHAIN ADJUSTER SHAFT, PLACE A $\frac{1}{4}$ " FLAT WASHER ON A 10-32 X $\frac{1}{2}$ BHSH. CENTER AND HOLD THE WASHER AS YOU TIGHTEN SCREW, AS THE WASHER IS OVERSIZED FOR A #10 SCREW.



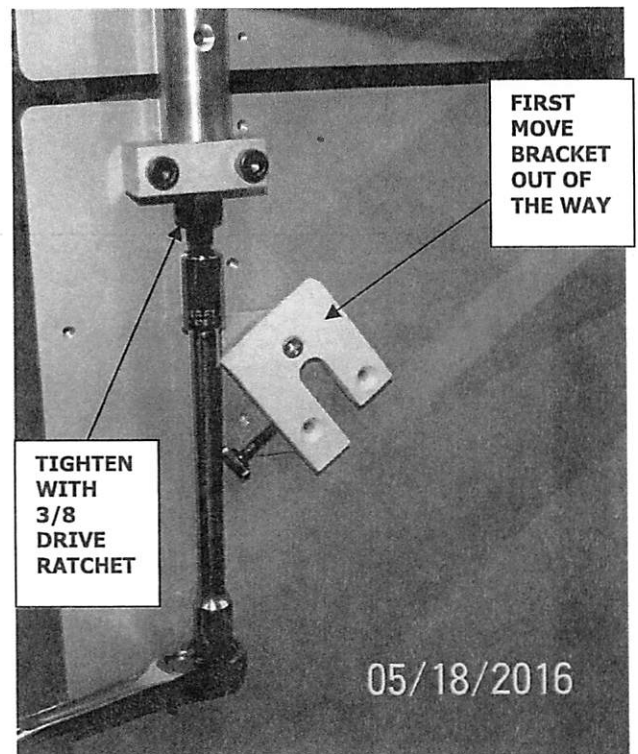
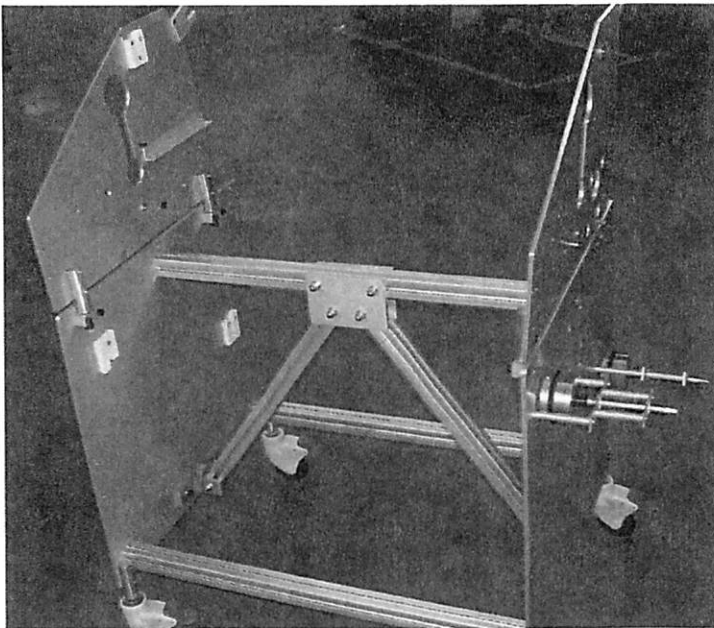
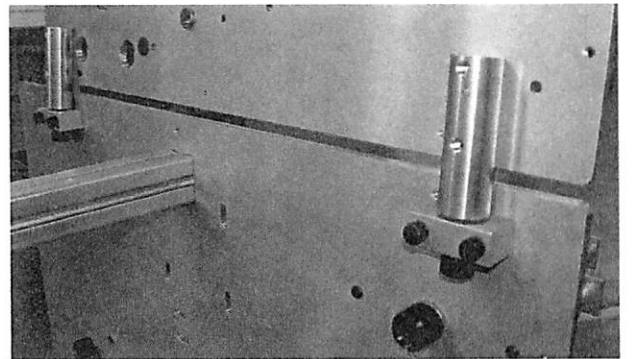
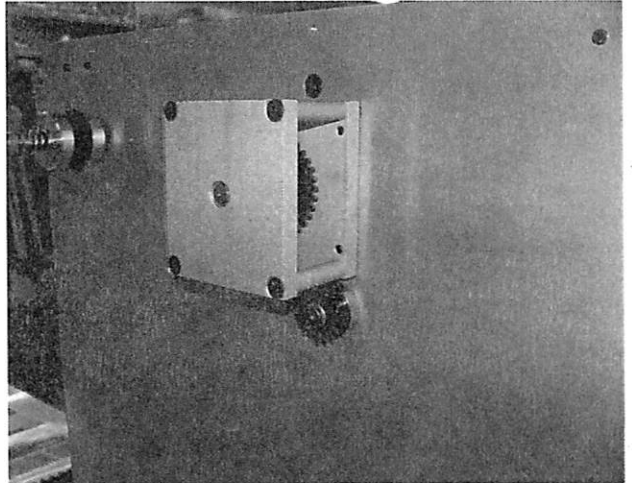
- 10) ARBOR PRESS AN OILITE BEARING (PRB048) AS08 INTO THE OUTER JACK SHAFT SUPPORT PLATE (TS 310.4) LOFT 0, WITH THE BEARING FLANGE OPPOSITE THE COUNTERSUNK OPENINGS. OPEN THE OILITE BEARING WITH A .505 REAMER.



- 11) SLIDE THE OUTER JACK SHAFT SUPPORT PLATE OVER THE OUTER JACK SHAFT, OILITE FLANGE *INWARD*, AND SECURE THE JACK SUPPORT TO JACK SHAFT STANDOFFS WITH (4) $\frac{1}{4}$ -20 X 1 FSH. THE SPROCKETS MUST SPIN FREELY ON THE JACK SHAFT AFTER TIGHTENING OUTER JACK SHAFT SUPPORT PLATE. IF IT IS TOO TIGHT, THE JACK SHAFT ENDS NEED TO BE SANDED BACK.

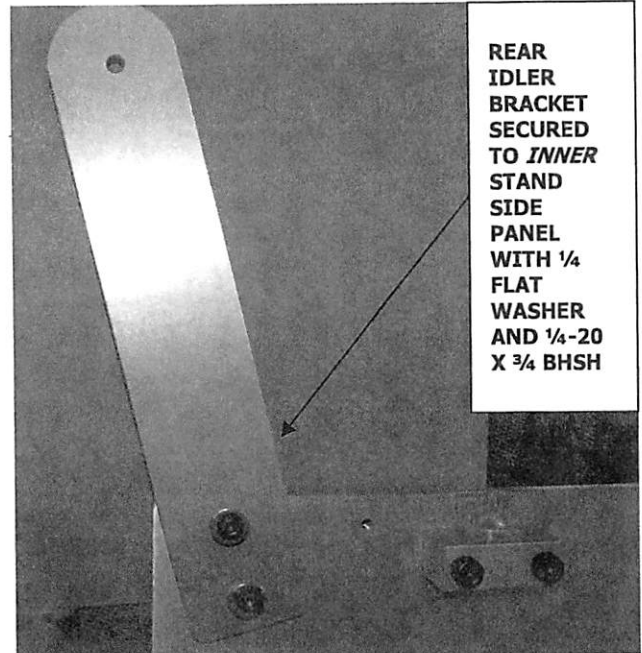


- 12) AFTER PANEL ASSEMBLIES, LOOSELY CONNECT THE EP30, EP44 OR EP60 SIDE PANELS TO THE DUAL TS RELEASE LINER STAND. USE (4) $\frac{1}{2}$ -13 X 1 $\frac{1}{2}$ SHCS (.500PAA24) AS13 FROM THE UNDERSIDE OF THE MOUNTING BLOCKS ON THE STAND SIDE PANELS. THE UPPER REWIND BRACKET AND SPACER ON THE INNER LEFT STAND PANEL HAS TO BE MOVED OUT OF THE WAY, AND RETIGHTENED AFTER THE $\frac{1}{2}$ -13 X 1 $\frac{1}{2}$ SHCS IS THREADED INTO THE FEET MOUNTING SHAFTS OF THE EP SIDE PANELS. TIGHTEN WITH A $\frac{3}{8}$ DRIVE SOCKET RATCHET LOCATED IN WB09.

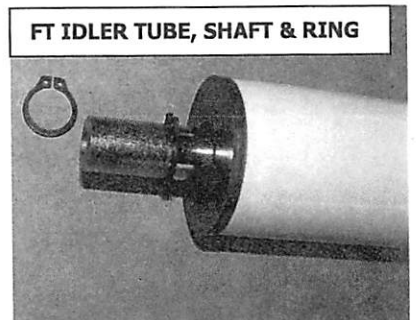
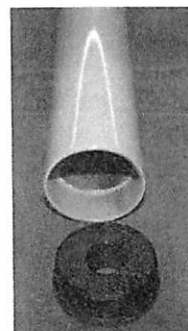


DUAL TS RELEASE LINER EP60 IDLER TUBE & IDLER TUBE BRACKETS

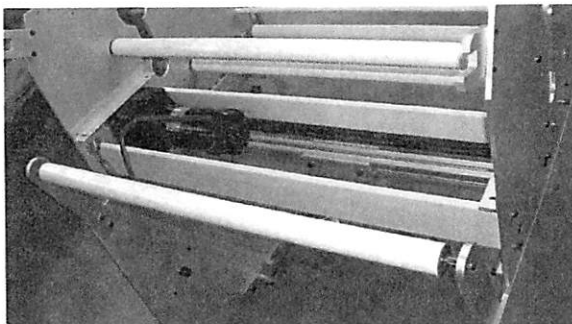
- 1) BEFORE SECURING BRACKETS AND IDLER TUBES, BE SURE THE 90 VOLT GEAR MOTOR AND EXIT TABLE ARE ON THE EP CHASSIS.
- 2) SECURE THE ~~SECURE~~ (2) REAR IDLER BRACKETS (TS 350.4) LOFT 0 ONE EACH TO THE REAR, *INNER* STAND SIDE PANELS. PLACE A $\frac{1}{4}$ FLAT WASHER ON EACH OF (4) $\frac{1}{4}$ -20 X $\frac{3}{4}$ BSH. INSERT SCREW THROUGH CLEARANCE HOLES IN THE BRACKET AND THREAD INTO THE STAND SIDE PANEL.
- 3) PREPARE A FEEDTABLE IDLER TUBE (D60 054.4 D-01, EP30 AS17, EHR44 AS15) BY FIRST TAPPING (2) NYLATRON IDLER BEARINGS (PRB086A) AS13 INTO THE ENDS OF THE IDLER TUBE. INSERT THE REAR IDLER SHAFT (TS 351.4) LOFT 0 THROUGH THE NYLATRON BEARINGS AND SECURE SHAFT ON BOTH ENDS WITH A RETAINING RING (PRR191) LD05 FITTING INTO THE SHAFT GROOVE.
- 4) SECURE THE IDLER TUBE ASSEMBLY BETWEEN THE REAR IDLER BRACKETS. IT IS HELPFUL TO HAVE TWO PEOPLE DO THIS, AS IT IS AWKWARD TO HOLD AND SECURE. USE (2) $\frac{1}{4}$ -20 X $\frac{3}{4}$ BH SOCKET SCREWS, EACH WITH A $\frac{1}{4}$ FLAT WASHER.



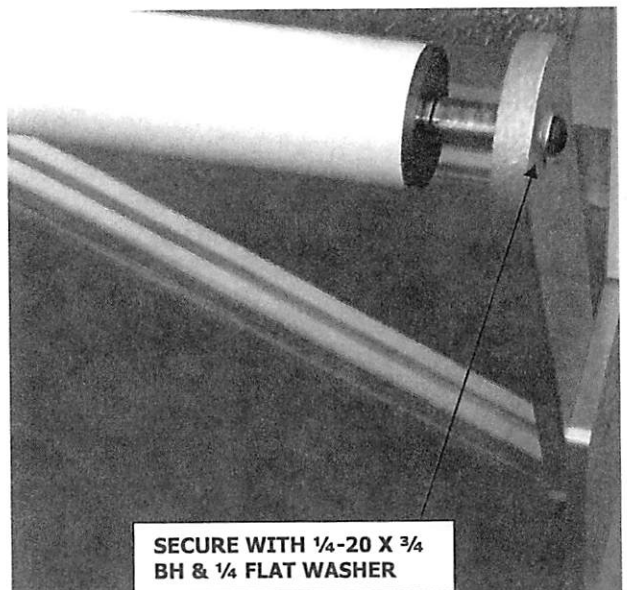
REAR IDLER BRACKET SECURED TO *INNER* STAND SIDE PANEL WITH $\frac{1}{4}$ FLAT WASHER AND $\frac{1}{4}$ -20 X $\frac{3}{4}$ BSH



FT IDLER TUBE, SHAFT & RING



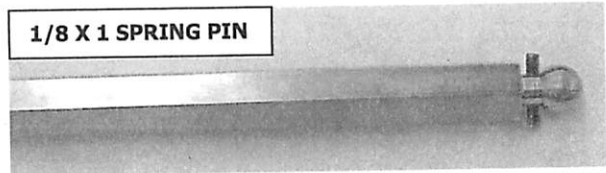
SECURE GEAR MOTOR BEFORE REAR BRACKET & IDLER TUBE



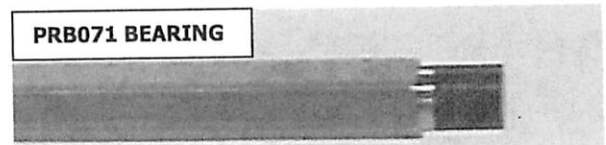
SECURE WITH $\frac{1}{4}$ -20 X $\frac{3}{4}$ BH & $\frac{1}{4}$ FLAT WASHER

DUAL TS RELEASE LINER EP30, 44,60 SCRAP REWIND ASSEMBLY

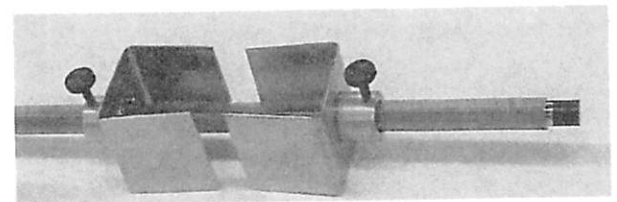
- 1) **PREPARE (2) SCRAP REWIND SHAFTS (EP30, 44, 60 056.4) LOFT 3. TAP A 1/8 X 1" SPRING PIN (.125J0016) INTO THE BALL END OF BOTH SCRAP REWIND SHAFTS. ARBOR PRESS SPRING PIN SO EVEN AMOUNTS SHOWING ON EITHER SIDE OF SCRAP REWIND SHAFT BALL.**
- 2) **SLIDE (2) BLACK PLASTIC BEARINGS (PRB071) RACK 8, ONE EACH ONTO THE OTHER END OF THE REWIND SHAFT. IF THE PLASTIC BEARING IS NOT SNUG, USE LOCTITE BLACK 380 INSTANT ADHESIVE GLUE TO SECURE BEARING TO SHAFT.**
- 3) **THREAD (4) 3/4" SPI KNOBS (PRK178) AS08, ONE EACH INTO (4) CORE GRIPPER AND HUB (E850 207.6B) RACK 1. SLIDE THE CORE GRIPPERS ONTO THE REWIND SHAFT WITH THE HUBS OUTWARD ON BOTH. TIGHTEN SPI KNOBS ON FLAT OF SHAFTS TO SECURE GRIPPERS.**
- 4) **INSERT SHAFT SPRING PIN INTO REWIND DRIVER, SLIDE PLASTIC BEARING INTO REWIND DRIVER BRACKET.**
- 5) **ACORN NUTS ON STAND WILL FACE THE FRONT.**



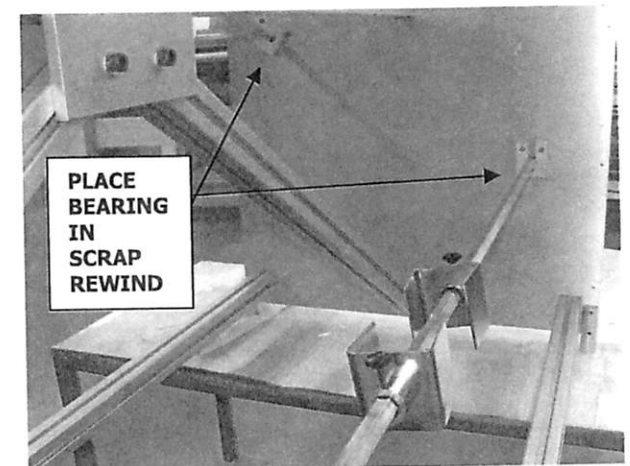
1/8 X 1 SPRING PIN



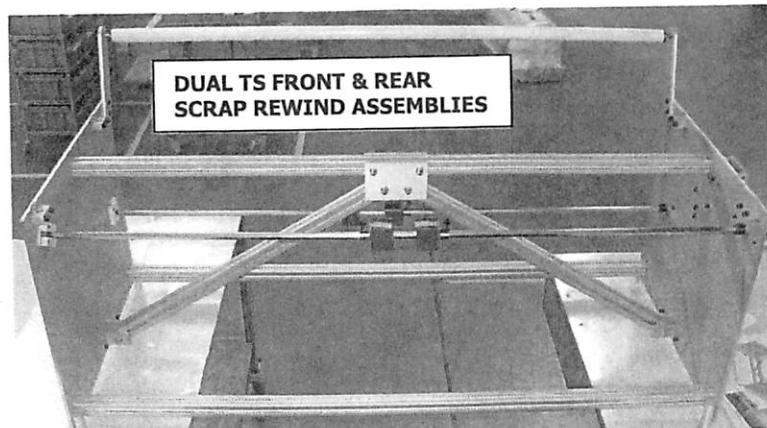
PRB071 BEARING



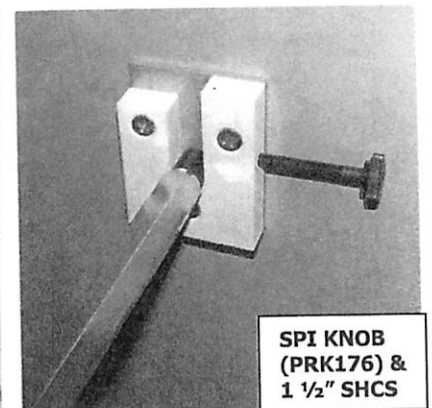
CORE GRIPPERS & PRK178 3/4" SPI KNOBS



PLACE BEARING IN SCRAP REWIND



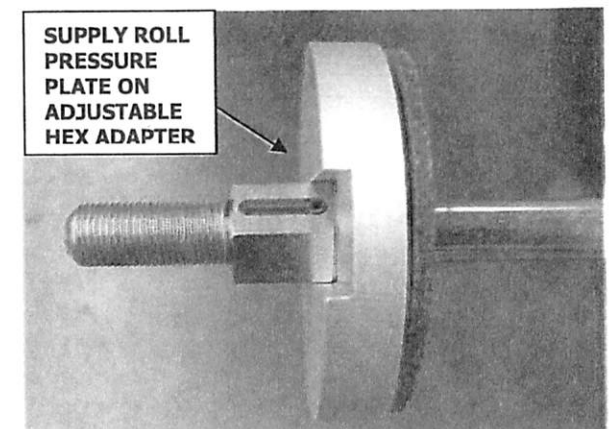
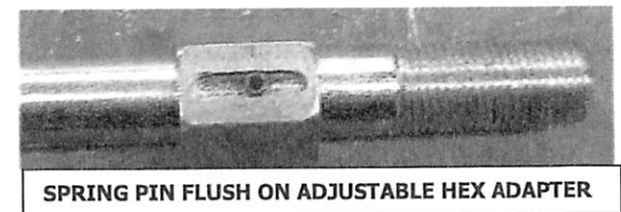
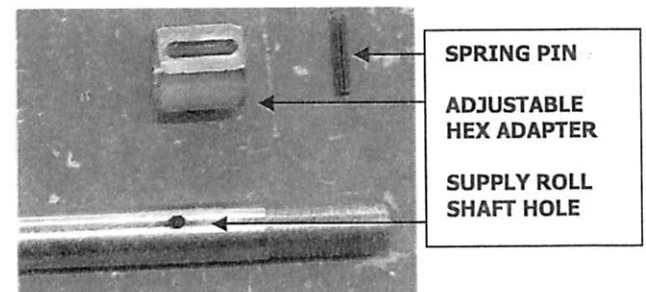
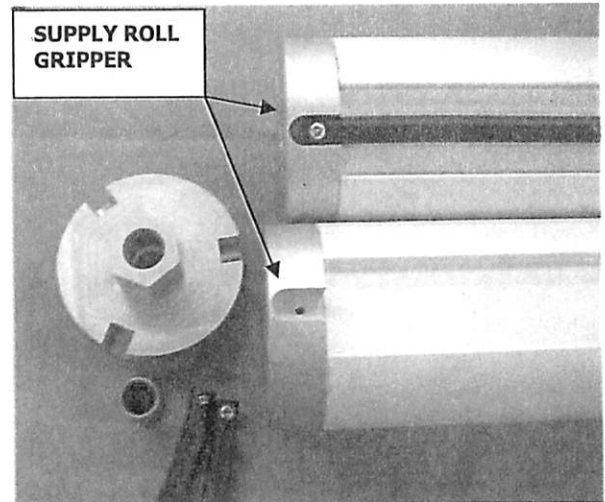
DUAL TS FRONT & REAR SCRAP REWIND ASSEMBLIES



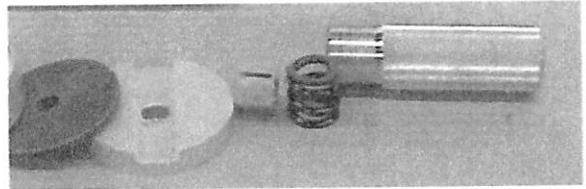
SPI KNOB (PRK176) & 1 1/2" SHCS

DUAL TS RELEASE LINER EP60 SUPPLY ROLL ASSEMBLY

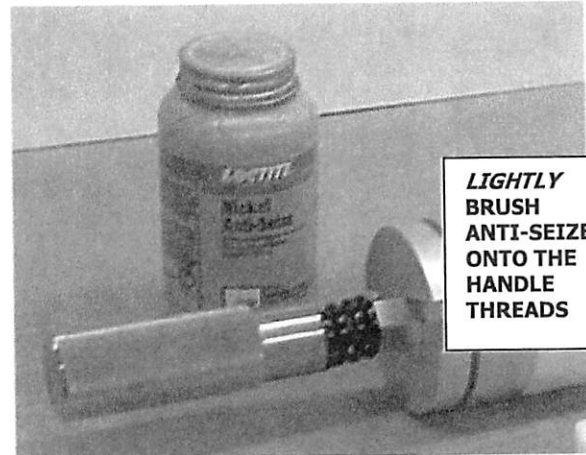
- 1) PREPARE THE (1) DUAL TS STAND SUPPLY ROLL ASSEMBLY, THE SAME AS THE EP60 SUPPLY ROLL ASSEMBLY.
- 2) INSERT (6) 6-32 X 1/2 RH INTO BOTH ENDS OF (3) RUBBER SUPPLY ROLL GRIPPERS (EP60 003.4B) LOFT3. SET RUBBER GRIPPERS ASIDE.
- 3) ALIGN THE SUPPLY ROLL END CAP (I30 008.4) AS08 SO THE THREADED PORTIONS FOR THE GRIPPER SCREWS ARE VISIBLE IN THE RECESSED CHANNELS OF THE SUPPLY ROLL EXTRUSION (EP60 002.4B) LOFT3. TAP THE END CAP HEXES INTO THE SUPPLY ROLL CORES.
- 4) SECURE THE SUPPLY ROLL GRIPPERS BETWEEN THE THREADED END CAPS USING THE 6-32 X 1/2 RH IN GRIPPERS.
- 5) SLIDE AN ADJUSTABLE HEX BUSHING ADAPTER (D105 022.4) AS08 ONTO SUPPLY ROLL SHAFT (EP60 011.4A) LOFT3. ALIGN HEX BUSHING OPENING OVER SHAFT OPENING. USE TOOL AND START A 1/8 X 3/4 SPRING PIN (.125J0012) THROUGH HEX CHANNEL INTO SHAFT. REMOVE TOOL AND PRESS SPRING PIN FLUSH WITH HEX BUSHING ADAPTOR.
- 6) SLIDE SUPPLY ROLL PRESSURE PLATE (LC38 007.4) AS08 ONTO SUPPLY ROLL SHAFT MAKING CERTAIN SPRING PIN ON ADJUSTABLE HEX ADAPTOR IS BETWEEN RECESS ON PRESSURE PLATE.
- 7) SLIDE A 1/8 X 1/2 ID X 2-3/4 OD LEATHER DISC (H380 004.4) AS08 ONTO SUPPLY ROLL SHAFT NEXT TO PRESSURE PLATE. INSERT SHAFT WITH THIS ASSEMBLY THROUGH THE SLEEVE BEARINGS ON THE SUPPLY ROLL END CAPS.
- 8) DUPLICATE THE OTHER END OF THE SUPPLY ROLL WITH ANOTHER LEATHER DISC, PRESSURE PLATE, AND A SUPPLY



ROLL HEX ADAPTER (LC38 023.4) AS08
FITTING INTO PRESSURE PLATE RECESS.



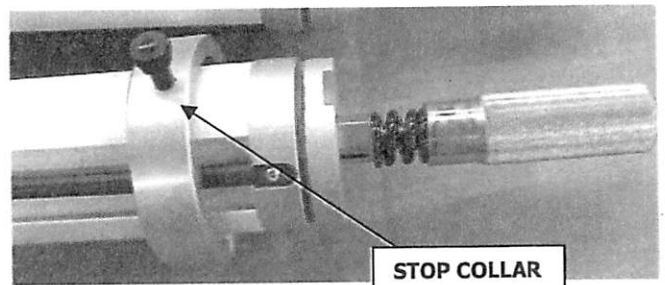
- 9) BRUSH LOCTITE ANTI-SEIZE ON END
THREADS OF SUPPLY ROLL SHAFT. SLIDE
ON SUPPLY ROLL TENSION SPRING
(PRS222) AS08 AND THREAD ON
KNURLED SUPPLY ROLL TENSION KNOB
(D105 001.4) AS01. IF THREADS ARE
OVER PLATED, TRIM WITH DIE/THREAD
CHASER. TIGHTEN KNOB UNTIL SPRING
PIN IS CENTERED IN ADJUSTABLE HEX.



LIGHTLY
BRUSH
ANTI-SEIZE
ONTO THE
HANDLE
THREADS

- 10) COMPLETE SUPPLY ROLL ON OTHER END
BY ADDING ANTI-SEIZE TO END THREADS,
ADD A TENSION SPRING AND KNURLED
SUPPLY ROLL TENSION KNOB.

- 11) FROM AS09 THREAD A 5/16-18 X 1"
PLASTIC MOLDED THUMBSREW (PRK184)
INTO A STOP COLLAR-CORE CHUCK (D105
004.4). SECURE STOP COLLAR ON ROLL.

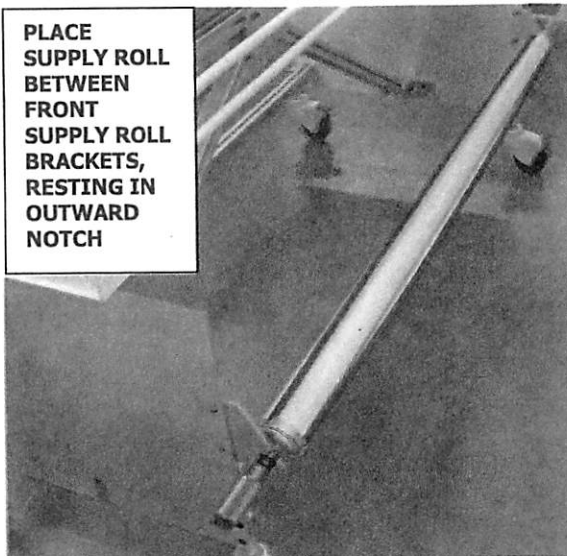


STOP COLLAR

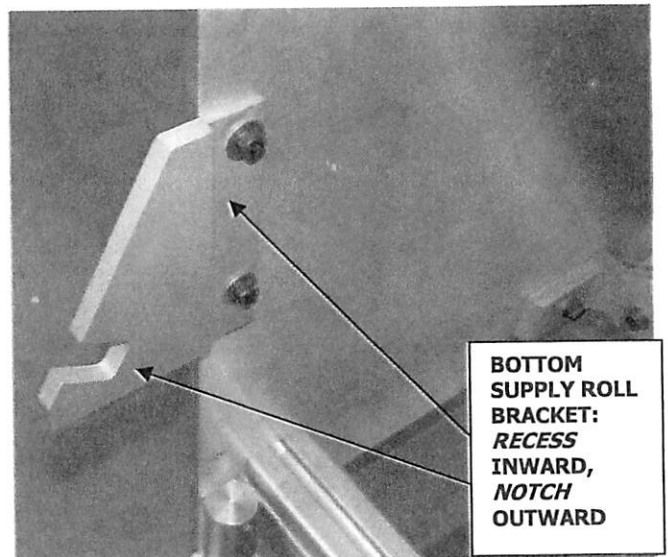
- 12) WITH NOTCH UPWARD AND RECESS
INWARD, SECURE A BOTTOM SUPPLY
ROLL BRACKET LEFT (E850 005.4R) AND
RIGHT (E850 005.4L) AS01 TO THE
INNER FRONT PANELS. ** LEFT ON
RIGHT AND RIGHT ON LEFT. USE 1/4-20
X 5/8 SHCS EACH WITH A 1/4 FLAT
WASHER. PLACE SUPPLY ROLL
ASSEMBLY BETWEEN BRACKETS.

Rack 21

PLACE
SUPPLY ROLL
BETWEEN
FRONT
SUPPLY ROLL
BRACKETS,
RESTING IN
OUTWARD
NOTCH

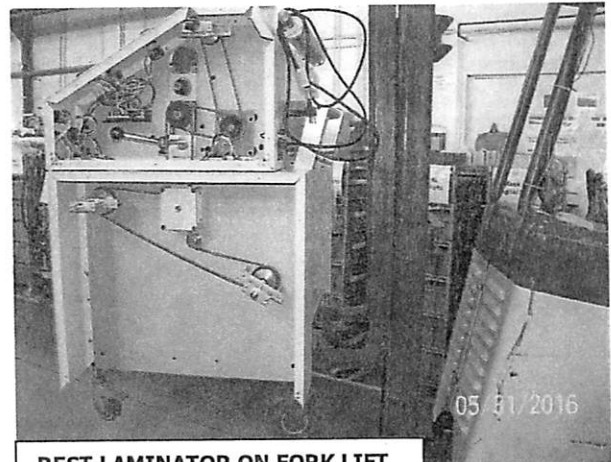


BOTTOM
SUPPLY ROLL
BRACKET:
RECESS
INWARD,
NOTCH
OUTWARD

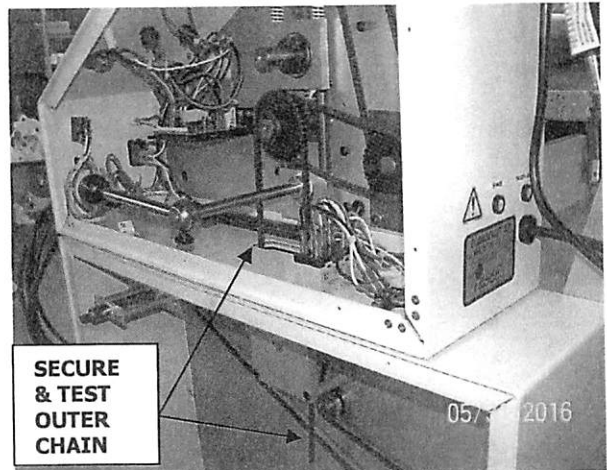


DUAL TS RELEASE LINER EP60 TOP & BOTTOM HOUSINGS

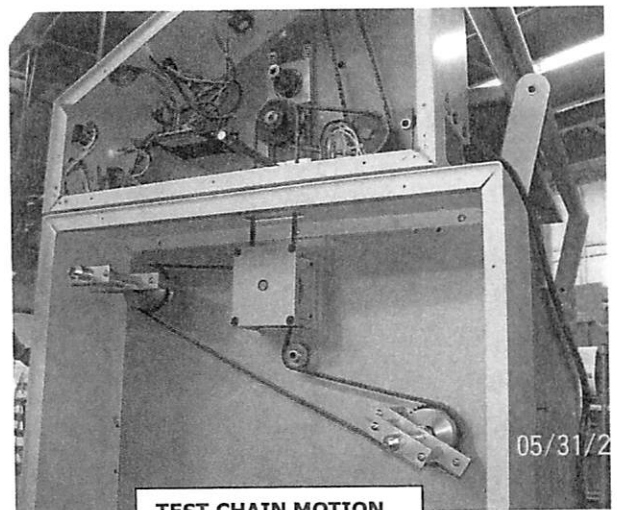
- 1) THE TS HOUSING TOP AND BOTTOMS ARE LOCATED IN UPPER LOFT 0. THE INNER ENDS OF THE TOP AND BOTTOMS ARE STAMPED AS PAIRS. THAT IS TO SAY: TOP "D" SHOULD BE PAIRED WITH BOTTOM "D."
- 2) HOUSINGS AND OUTER DRIVE ROLL AND JACK CHAIN SPROCKET INSTALLATION WILL BE MUCH EASIER, IF THE LAMINATOR IS RAISED AND LEFT RESTING ON A FORK LIFT WHILE WORK IS BEING DONE.
- 3) THE HOUSING TOP RIGHT (TS 094.4TR) FITS OVER THE TS RIGHT SIDE PANEL, WITH THE *INNER* HOUSING NOTCH MATCHING WITH PANEL MILLED POCKET. THE TOP RIGHT HOUSING HAS A SLOT IN THE UPPER PORTION FOR THE DRIVE ROLL/JACK CHAIN. **REMOVE THE SCREWS HOLDING THE UPPER REWIND SUPPORT AND SHIFT SUPPORT TO REACH HOUSING SCREW HOLE BEHIND IT. REPLACE SUPPORT SCREWS. SECURE THE TOP HOUSING TO THE PANEL WITH (9) 10-32 X 1/4 OR 3/8 THMS.
- 4) NOW SECURE THE OUTER JACK SHAFT CHAIN THROUGH BOTH HOUSINGS. TURN ON LAMINATOR TO BE CERTAIN CHAIN SPROCKETS ARE ALIGNED. ADJUST CHAIN TENSION AS NEEDED.
- 5) SECURE THE MATING PAIR HOUSING BOTTOM LEFT/RIGHT (TS 094.4B) USING (3) 10-32 X 3/8 THMS.
- 6) SECURE THE FRONT AND BACK CORNERS OF THE TOP AND BOTTOM HOUSINGS TOGETHER WITH HOUSING CORNER BRACES (D105 098.4) RACK 1. **THE TOP HOUSING LOCATES ON THE OUTSIDE OF THE BOTTOM HOUSING. USE (4) 8-32 X 3/8 FHMS IN THE COUNTERSUNK HOLES AND SECURE THE CORNER BRACKES ON THE INNER



REST LAMINATOR ON FORK LIFT



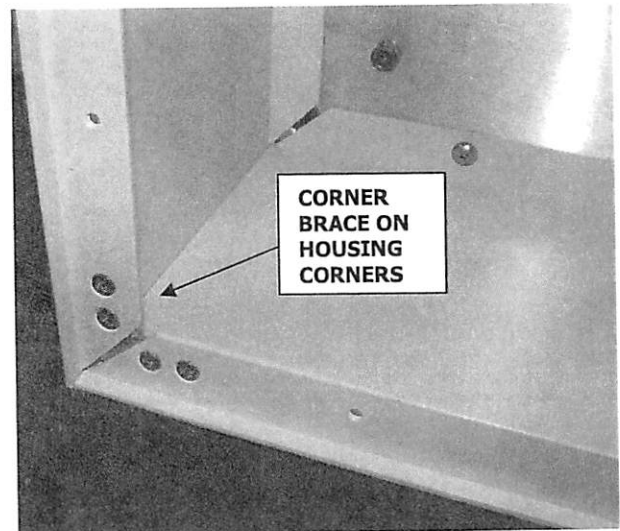
SECURE
& TEST
OUTER
CHAIN



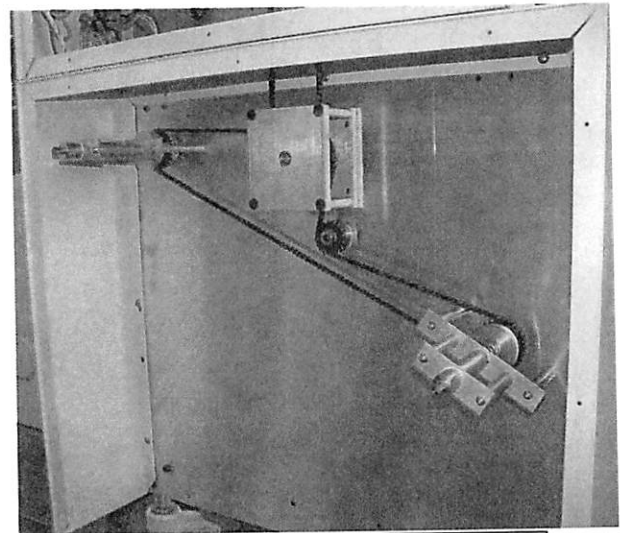
TEST CHAIN MOTION

HOUSING WITH (4) 8-32 KEPS HEX NUTS. TIGHTEN WITH A WRENCH.

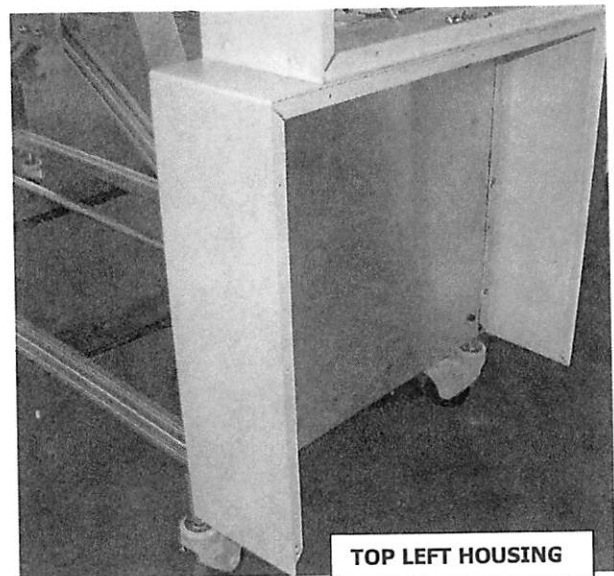
- 7) SECURE THE HOUSING TOP LEFT (TS 094.4TL) OVER THE LEFT STAND SIDE PANEL USING (9) 10-32 X 3/8 THMS.**
- 8) SECURE THE MATING PAIR HOUSING BOTTOM LEFT (TS 094.4B) TO THE LEFT STAND PANEL WITH (3) 10-32 X 3/8 THMS.**
- 9) SECURE THE LEFT TOP AND BOTTOM HOUSING CORNERS WITH (2) CORNER BRACKETS, SECURED WITH (4) 8-32 X 3/8 FH MS AND (4) #8 KEPS HEX NUTS.**



**CORNER
BRACE ON
HOUSING
CORNERS**



TOP RIGHT HOUSING

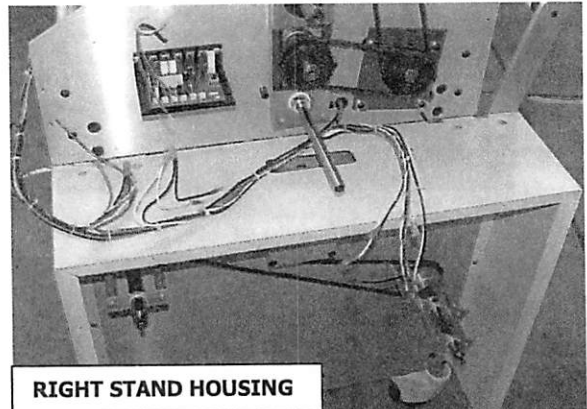


TOP LEFT HOUSING

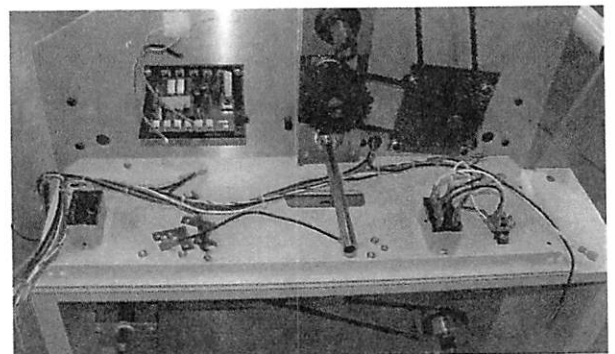
DUAL TS RELEASE LINER EP30,44,60

MACHINE-TO-RELEASE LINER

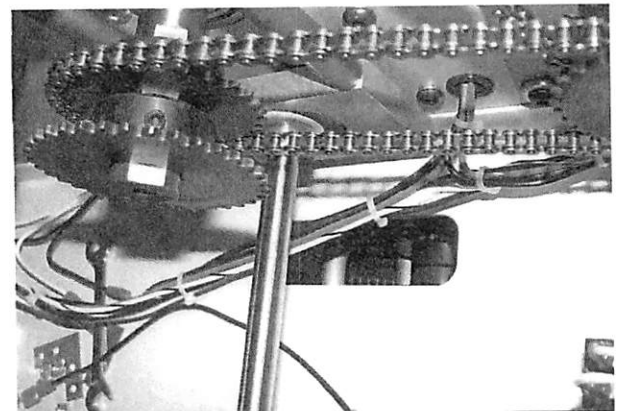
- 1) THE MACHINE RIGHT BOTTOM (TS 096.4) LOFT 0 IS ASSEMBLED THE SAME AS THE REGULAR EP RIGHT BOTTOM. THE DIFFERENCE IS THE CHANNEL TO ACCOMMODATE THE CHAIN RUNNING FROM THE RIGHT BOTTOM RUBBER ROLL, THROUGH THE MACHINE HOUSING, THE RIGHT STAND HOUSING AND CONNECTING TO THE OUTER SPROCKET ON THE JACK SHAFT.
- 2) SECURE THE MACHINE RIGHT BOTTOM USING (2) 8-32 X $\frac{1}{4}$ TH MS. THE REAR LOCATION IS HELD BY THE GROUND SCREW.
- 3) FROM AS23 PLACE THE 25B36 $\frac{7}{8}$ BORE SPROCKET (PRS260) WITH A $\frac{1}{4}$ -28 X $\frac{3}{8}$ SET SCREW, HUB INWARD, ON THE OUTER, RIGHT BOTTOM RUBBER ROLL SHAFT, NEXT TO THE SPROCKET CONNECTING TO THE MOTOR.
- 4) ALIGN THE OUTER SPROCKET ON THE JACK SHAFT OF THE STAND WITH THE 25B36 OUTER SPROCKET ON THE BOTTOM RUBBER ROLL JOURNAL. TIGHTEN SET SCREWS.
- 5) PLACE THE REMAINING STAND CHAIN ON THE TEETH OF THESE OUTER SPROCKETS AND SECURE CHAIN WITH LINK. TIGHTEN BOTH SPROCKET SET SCREWS.



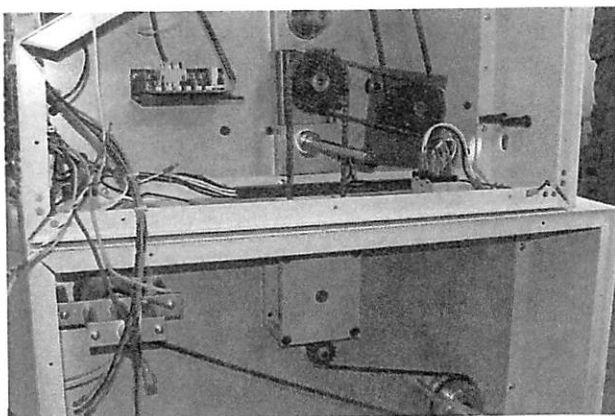
RIGHT STAND HOUSING



MACHINE RIGHT BOTTOM



MACHINE RIGHT BOTTOM WITH 25B36 SPROCKET



DUAL TS RELEASE LINER EP60 HOUSING COVERS

- 1) SECURE THE TOP AND BOTTOM STAND HOUSING WITH (2) HOUSING CORNER BRACKETS (D105 098.4) RACK 2. USE 8-32 X 3/8 THMS, EACH WITH A #8 KEPS HEX NUT ON THE INSIDE.
- 2) THE LEFT HOUSING COVER (TS 095.4L) LOFT 1 CAN BE PLACED IN THE INNER LIP OF THE TOP AND BOTTOM LEFT HOUSING. ALIGN HOLES ON COVER. SECURE COVER WITH 8-32 X 1/4 THMS.
- 3) THE RIGHT HOUSING COVER (TS 095.4R) LOFT 1 CAN BE PLACED IN THE INNER LIP OF THE TOP AND BOTTOM RIGHT HOUSING, FITTING THE HOUSING OPENINGS OVER THE REWIND SHAFT ENDS. SECURE HOUSING COVER TO TOP AND BOTTOM HOUSINGS WITH 8-32 X 1/4 THMS.
- 4) CENTER AND ALIGN (2) INTERNATIONAL INCREASE DECREASE LABELS (LAB42A) RACK 10. ADHERE LABELS ABOVE REWIND SHAFTS.
- 5) THREAD A 10-32 X 1/4 SET SCREW INTO EACH OF (2) KNOBS (PRK179) RACK 8. PLACE KNOBS ON ENDS OF REWIND SHAFT AND SECURE ON FLAT SIDE OF SHAFT.

