ECONOCRAFT 60 NRTL
SIDE PANELS & CHASSIS

1) ON RIGHT AND LEFT SIDE PANEL (EP30 090.4R AND EP30 090.4L) AS15 TAP IN (2) ¼ X 1 SPRING PINS. LOCATE PINS IN FRONT OF CAM SHAFT HOLE FLUSH ON INSIDE OF MACHINE, TO STABILIZE CONNECTING PLATE AND BEHIND DRIVE ROLL, ABOVE FEED/EXIT TABLE BRACKET, FLUSH WITH OUTSIDE OF SIDE PANEL TO STEADY EXIT TRAY.

2) PLACE A #8 STAR WASHER ON THE THREADS OF AN 8-32 X 1 BHSH. THREAD THROUGH THE INNER RIGHT REAR SIDE PANEL UNDER MOTOR HOLES AND TIGHTEN. THIS WILL BE THE GROUND SCREW CONNECTION. THE HOUSING WILL FIT OVER THIS SCREW.

3) ON UPPER RIGHT SIDE PANEL ARBOR PRESS (1) OILITE BUSHING (PRB078) AS14 1/8" FLANGE INSIDE. ON OUTSIDE TAP ON (2) OILITE WASHERS (PRW338) AS14, STAKE CORNERS. REAM W/ .625.

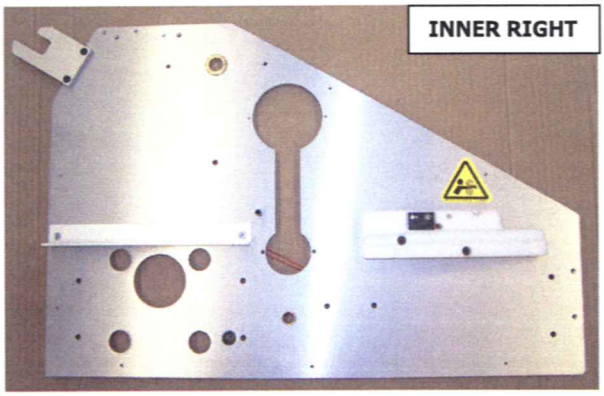
4) PRESS A REAMED OILITE BEARING (PRB048) AS15 INTO CAM OPENINGS, WITH FLANGE OUTWARD.

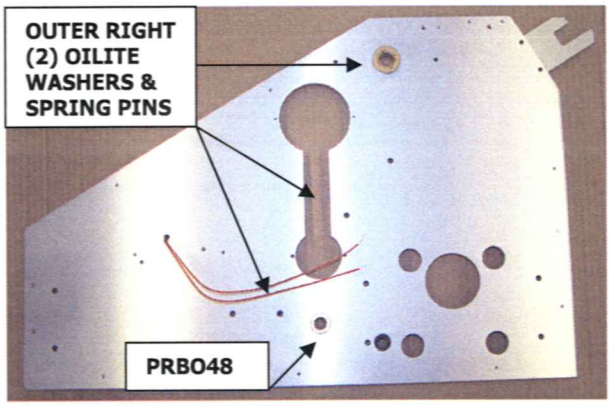
5) ADD (2) MEDIUM SNAP BUSHINGS (PRB063) AS15 FLANGE OUTWARD, ON BOTH PANELS FOR RACEWAY WIRES.

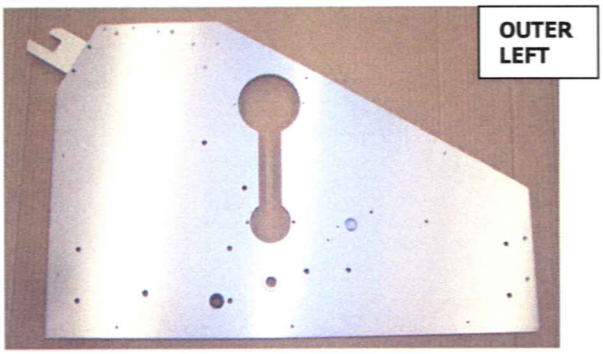
6) ATTACH (1) FEED/EXIT TABLE BRACKET (EP30 098.4) AS14 TO THE INSIDE ON EACH SIDE PANEL USING (4) 8-32 X 3/8 FH. LOCATED BRACKETS ABOVE MOTOR HOLES ON RIGHT AND PARALLEL ON LEFT, FOR EXIT TABLE. THE BREAK OR BEND IS TO THE LOWER PORTION OF THE SIDE PANEL.

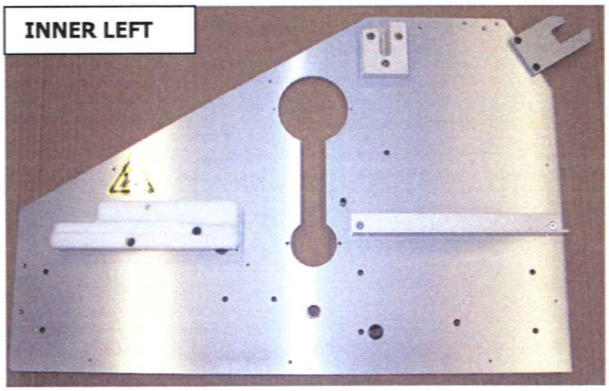
7) ON INSIDE LEFT PANEL ADD REWIND ROLL BRACKET C (EP30 006.4) AS14 AND REWIND BRACKET SPACER (EP30 057.4) AS15 USING (3) 10-32 X 1 FH.

8) CONNECT SIDE PANELS WITH (2) SPACER BAR C (EP60 110.4) AS16



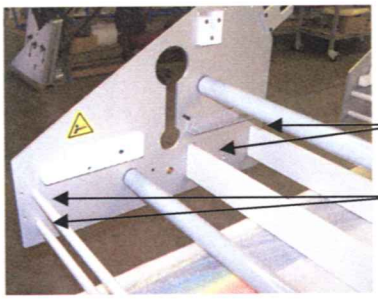




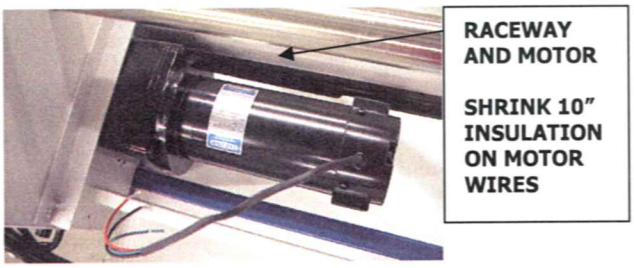


VERTICALLY INCLINED USING (8) ¼-20 X ¾ BH EACH WITH A ¼ HIGH COLLAR LOCK WASHER AND LOCTITE. LOCATE ON EACH SIDE OF MOTOR POSITION.

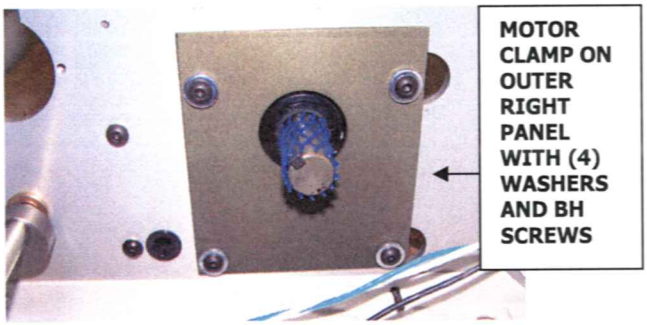
9) ATTACH (2) FRONT STABILIZER C (EP60 216.4) AS16 UNDER FRONT EDGE OF FEEDTABLE BRACKETS WITH (4) ¼-20 X ¾ BH, ¼ LOCK WASHER AND LOCTITE.



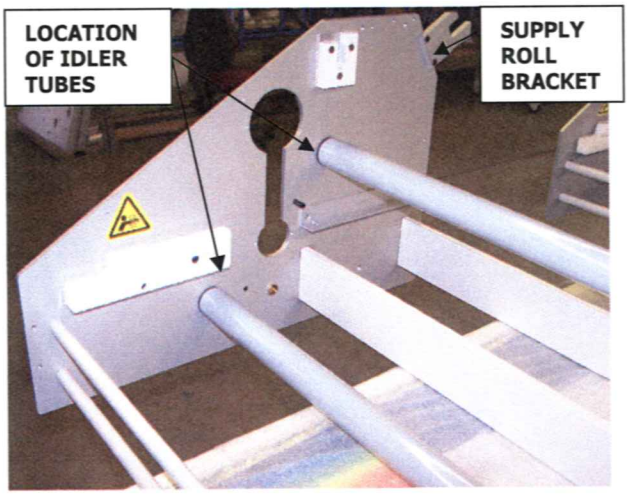
10) CUT ELECTRICAL RACEWAY (PRC076) AS16 MEASURED TO RUN BETWEEN MEDIUM SNAP BUSHINGS. USE GEAR MOTOR (PRM1000) AS09 TO GAUGE ENTRANCE OF MOTOR WIRES INTO RACEWAY. CUT AN INCH WIDE SPACE FOR MOTOR WIRES, TRIM EDGES. REMOVE STICKY COVERING AND ALIGN LOWER EDGE WITH INSIDE BOTTOM SPACER BAR BETWEEN BUSHINGS.



11) ATTACH A 90 VOLT GEAR MOTOR ALONG WITH MOTOR CLAMP PLATE C (EP30 058.4) AS15 ON OUTSIDE WITH (4) ¼ X 5/8 X 1/8 FLAT WASHER AND (4) ¼-28 X 1 BHSH. HOLD MOTOR SO IT IS UPWARD TOUCHING FEEDTABLE BRACKET AND IS TOWARD FRONT. SCREWS WILL BE LOOSENED LATER SO MOTOR WEIGHT TIGHTENS CHAINS. HEAT SHRINK 6" OF 3/8 INSULATION TUBING (PRI164) CAB01 OVER WIRES FROM MOTOR TO RACEWAY. CRIMP (3) FIF RED MALE CONNECTORS (PRT330) ON WIRES.

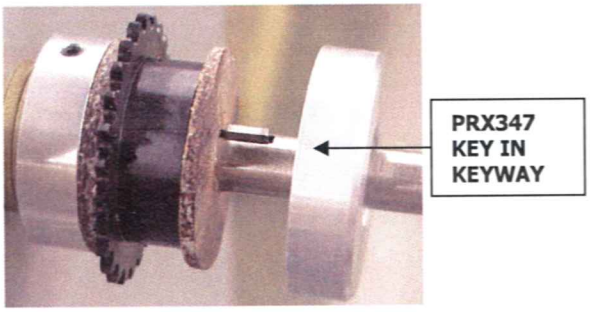


12) TAP (4) IDLER BEARING NYLATRON (PRB086A) AS31 INTO ENDS OF (2) IDLER TUBES (D60 052.4) AS32. SLIDE (2) SPREADER BARS (D60 110.4) AS32 THROUGH NYLATRON BEARINGS AND ATTACH TO SIDE PANELS WITH (4) ¼-20 X ¾ BH, ¼ LOCK WASHERS AND LOCTITE. LOCATE IDLERS UNDER FEED TABLE BRACKETS AND ABOVE EXIT TABLE BRACKETS IN REAR.

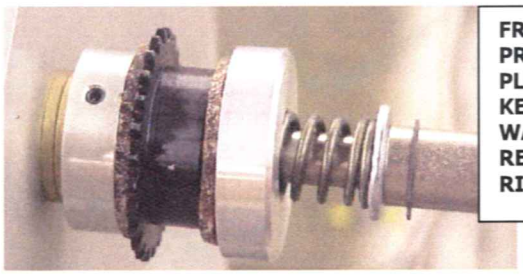


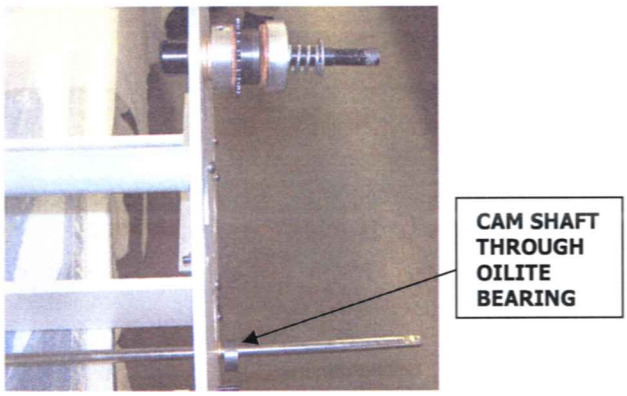
13) ATTACH (2) UPPER SUPPLY ROLL BRACKETS (EP30 008.4) AS14 TO INSIDE REAR OF SIDE PANELS WITH (4) 10-32 X ¾ BHSH.

14) INSERT REWIND DRIVER ASSEMBLY C (EP30 045.6) AS14 FROM INSIDE RIGHT SIDE PANEL THROUGH BRASS FLANGE.

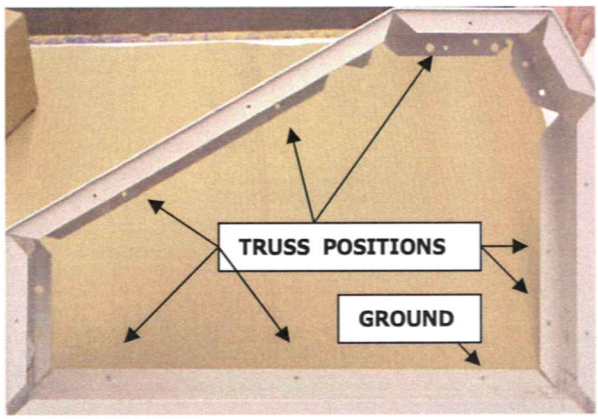


FROM OUTSIDE ADD IN ORDER: FIXED FRICTION PLATE C (EP30 007.4) AS14 WITH 10-32 X ¾ SET SCREW TIGHTENED INTO REWIND DRIVER ASSEMBLY HOLE. **BE SURE THINNER SIDE OF FIXED FRICTION PLATE IS TOWARD SIDE PANEL. ADD LEATHER DISC (PRW336) AS04. THEN A 5/8 BORE SPROCKET (PRS255A) AS14 CONTAINING AN ARBOR PRESSED BEARING ½ X 5/8 X ½ (PRB043) CP03 HUB OUT/TEETH IN. ADD ANOTHER LEATHER DISC AS04. PUT HD KEY (PRX347) CP01 INTO REWIND DRIVER ASSEMBLY KEYWAY. SLIDE ON FRICTION PRESSURE PLATE (H685 007.4A) AS14 WITH COUNTERBORE TOWARD OUTSIDE. EP REWIND SPRING (PRS226) AS15 FITS INTO COUNTERBORE. ADD ½" WASHER SAE (.500KKC01). PUT ANTI-SEIZE ON REWIND DRIVER ASSEMBLY THREADS AND ADD TENSION NUT C (EP30 046.4) AS14 WHICH HAS REVERSE THREADS. TENSION NUT RECEIVES ¾" RETAINING RING (PRR192) CP01 ON GROOVE BY WASHER.



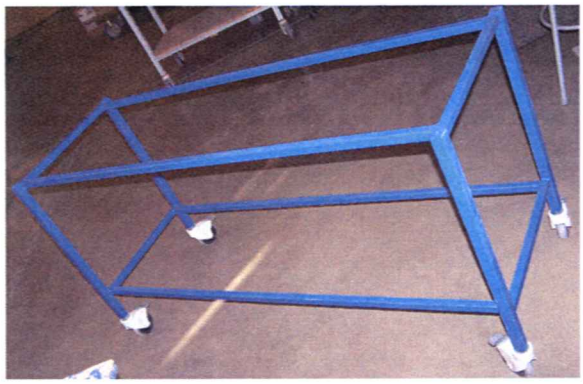


15) INSERT RUBBER ROLL CAM SHAFT (EP60 130.4) AS16 WITH LONGER END AND FLAT CUT FOR HANDLE ON RIGHT, THROUGH THE REAMED OILITE BEARINGS. ADD A CAM (H850 133.4) CP03 TO EACH END OF THE SHAFT ON THE OUTSIDE OF SIDE PANELS AND SECURE IN SHAFT HOLES. USE A 10-32 X ¾ SS TO SECURE CAMS.



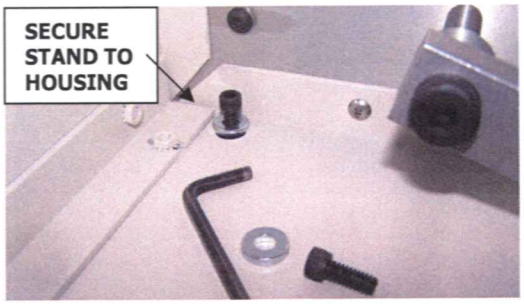
16) SECURE RIGHT HOUSING C (EP30 094.4R) AS15 AND LEFT HOUSING C (EP30 094.4L) AS15 TO SIDE PANELS USING 8-32 X ¼ TH. THE RIGHT SIDE FITS OVER THE GROUND SCREW.

17) REMOVE BOLTS IN PAINTED EP60 STAND (EP60 135.4) LOFT2 AND SET BOLTS ON "RECEIVING DESK" IN ASSEMBLY AREA. ADD (4) "INHOUSE" CASTERS INTO BOLT THREADS. SET STAND UPRIGHT AND RETAP ¼-20 THREADS BEFORE SECURING HOUSINGS. LOCK CASTORS.

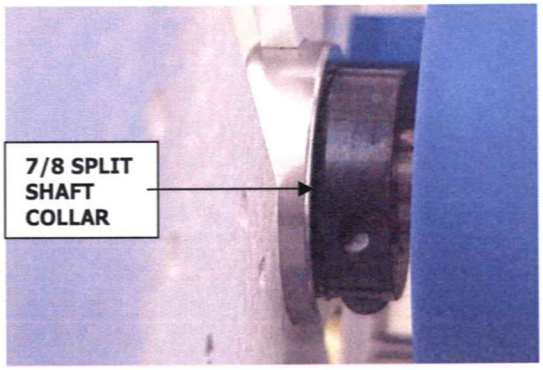


18) USING TWO PEOPLE MOVE THE CHASSIS WITH HOUSINGS ONTO THE STAND, ALIGNING HOUSING OPENINGS OVER

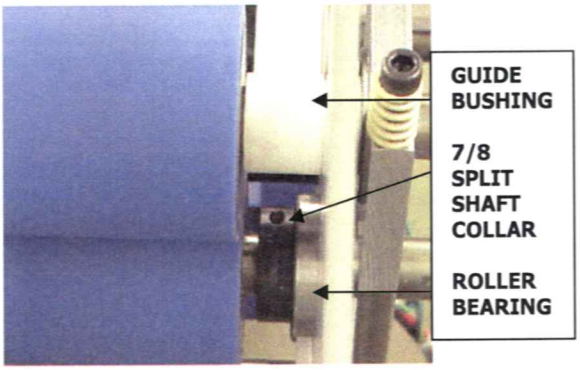
¼-20 THREADED STAND ENDS. SECURE HOUSINGS TO STAND WITH ¼-20 X 5/8 SHCS EACH WITH A ¼ X 5/8 X 1/8 WASHER. TIGHTEN WITH AN ALLEN WRENCH.



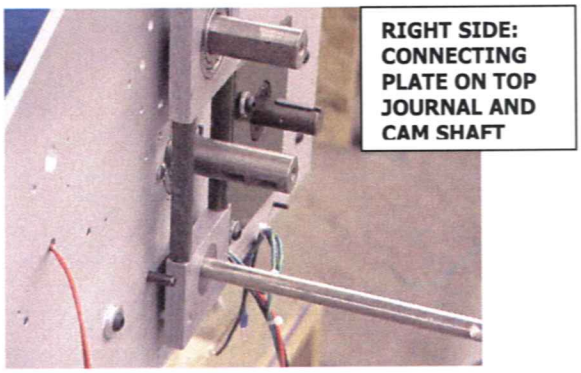
19) INSERT (1) 60" RUBBER ROLL (D60 040.4) LOFT1 INTO ROLL APERTURES IN SIDE PANELS. THIS REQUIRES TWO PEOPLE FOR SAFETY. ALIGN EDGE OF RUBBER WITH OUTSIDE EDGE OF EXIT TABLE BRACKET. SLIDE A 7/8 SPLIT SHAFT COLLAR (PRC112) AS27 ONTO BOTH JOURNALS AND SET THEM ON THE INSIDE OF SIDE PANELS. TAP A BALL BEARING (PRB087A) AS15 ONTO BOTH JOURNALS, FLUSH WITH OUTSIDE OF SIDE PANEL. SECURE THE BALL BEARINGS WITH (4) 10-32 X ¼ TH. SLIDE THE 7/8 SPLIT SHAFT COLLAR ON THE INSIDE FLUSH WITH INNER BALL BEARING AND TIGHTEN SHAFT COLLAR.



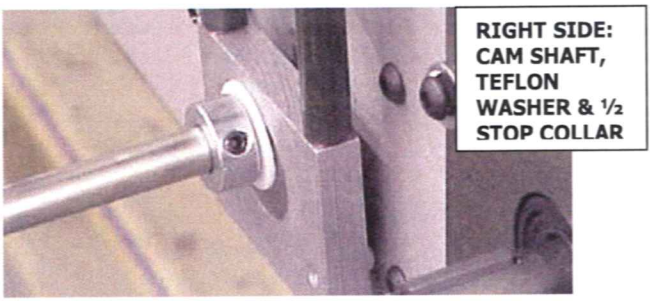
20) INSERT THE UPPER 60" RUBBER ROLL ALIGNING RUBBER WITH BOTTOM RUBBER ROLL. ADD TO EACH JOURNAL A TOP RUBBER ROLL GUIDE BUSHING (EP42 044.4) AS14 THE CHANNEL FITS IN BOTH SIDE PANELS, WITH LONGER SLEEVE ON THE INSIDE.



21) BRUSH "ANTI-SEIZE" LUBRICANT ON CIRCUMFERENCE OF RIGHT AND LEFT CAMS. SLIDE CONNECTING PLATE ASSEMBLIES ONTO TOP RUBBER ROLL SHAFT AND OVER CAMS.



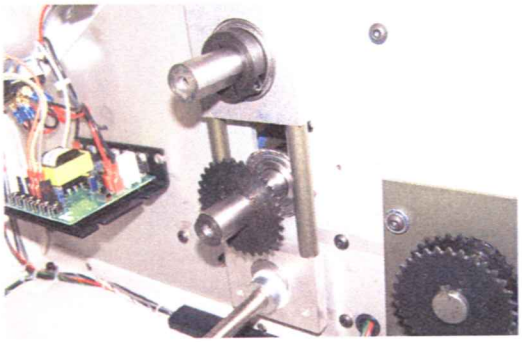
22) SLIDE A TEFLON WASHER (PRW337) AS14 ONTO BOTH ENDS OF CAM SHAFT FLUSH WITH CAMS. TIGHTEN A ½ INCH SHAFT COLLAR (PRC096) CP03 NEXT TO BOTH TEFLON WASHERS, LEAVING A SLIGHT GAP. ON BOTH TOP RUBBER ROLL JOURNALS SNUG CONNECTING PLATE TO GUIDE BUSHING, THEN SLIDE A 7/8 SPLIT SHAFT COLLAR TIGHT TO BALL BEARING AND SECURE.

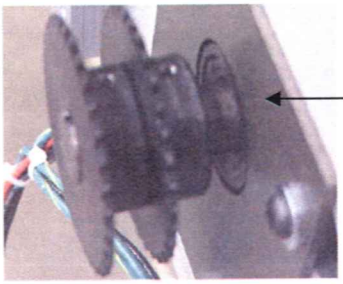


23) LAY ASIDE INDEPENDENT WIRES FROM WIRING HARNESS FOR ECONOCRAFT 60" NRTL (PRW360U) AS15. FROM RIGHT SIDE PANEL INSERT BLACK HARNESS WIRES INTO BUSHING AND RUN INSIDE

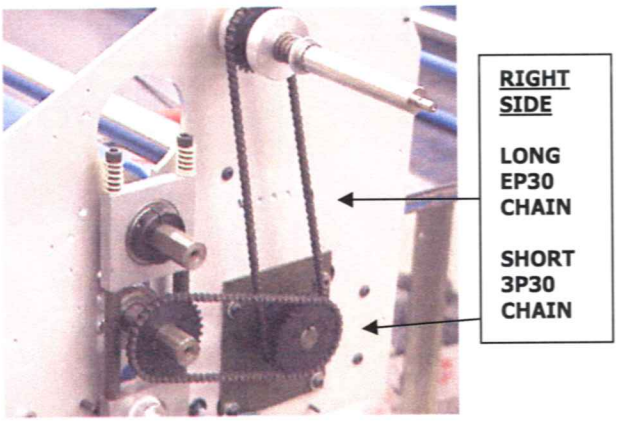
RACEWAY EXITING LEFT SIDE PANEL BUSHING.

24) PLACE A 10-32 X ¼ SET SCREW IN (2) 25B32 ¾ SPROCKETS (PRS258A) AS14. SLIDE SPROCKETS ONTO MOTOR SHAFT OVER KEY BOTH HUBS INWARD. A FRACTION OF MOTOR SHAFT SHOWS ON OUTSIDE. INNER SPROCKET TEETH SHOULD LINE UP WITH TEETH OF SPROCKET ON REWIND DRIVER. CHECK THIS WITH STRAIGHT EDGE RULER AND TIGHTEN THE INNER MOTOR SPROCKET ON INNER MOTOR SHAFT KEY.





25) INSERT (3) ¼-28 X ½ SET SCREW INTO (3) 25B32 7/8 BORE SPROCKETS (PRS258C) AS20. SLIDE (1) OF THESE SPROCKETS ONTO RIGHT SIDE BOTTOM RUBBER ROLL JOURNAL, SPROCKET HUB OUTWARD. ALIGN TEETH ON RUBBER ROLL SPROCKET WITH TEETH ON OUTER MOTOR SPROCKET. TIGHTEN SET SCREWS. THE REMAINING (2) SPROCKETS ATTACH TO LEFT SIDE.

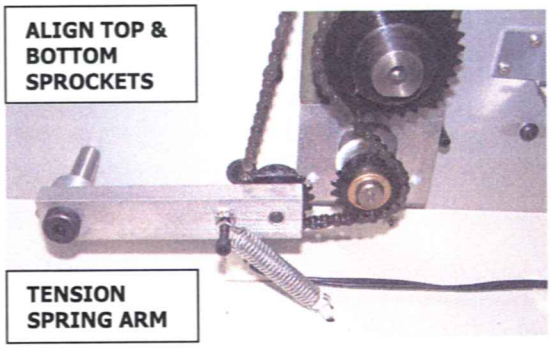


26) MOTOR SIDE: CONNECT THE LONGER EP30 CHAIN BETWEEN INNER MOTOR SPROCKET TEETH AND REWIND DRIVER SPROCKET TEETH. CONNECT SHORTER EP30 CHAIN BETWEEN OUTER MOTOR TEETH AND JOURNAL SPROCKET TEETH.

27) SLIDE (2) REMAINING SPROCKETS BOTH HUB OUTWARD ONTO LEFT SIDE JOURNALS. THE SPROCKET TEETH WILL ALIGN WITH THE TENSION SPRING ARM SPROCKET TEETH. USE RULER TO ALIGN.

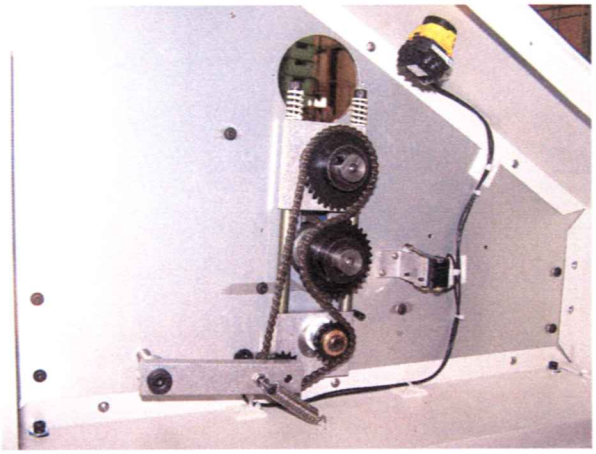
28) PLACE SPROCKET WITH BUSHING (PRS249A.5) AS15 ONTO THE CAM SHAFT, WITH HUB INWARD, OILITE FLANGE OUTWARD. SECURE WITH A SNAP RING (PRR191) LD06.

29) SECURE TENSION SPRING ARM BY HOOKING ONE END OF LEE SPRING (PRS223) AS15 BETWEEN #10 FH AND #10 KEPS WITH THE OTHER SPRING END CABEL TIED TO THE HOUSING FLOOR THROUGH (2) HOLES PROVIDED. ALIGN TENSION ARM SPROCKET TEETH WITH BOTTOM ROLL SPROCKET TEETH AND TIGHTEN SET SCREW. ALIGN TEETH ON



TOP AND BOTTOM ROLL, TIGHTEN SET SCREWS.

30) ON RIGHT HOUSING ADHERE A START/STOP CONTROL PANEL LABEL (LAB EP60-1) AS14 CENTERED ON UPPER CONTROL OPENINGS. BELOW THE START/STOP CONTROL PANEL LABEL ADHERE THE MAIN POWER LABEL (LAB EP60-2) AS14. ON THE LEFT HOUSING CENTER A DOMED LEDCO EMBLEM (LAB05A) CP03 FURTHER BELOW THE EMERGENCY STOP BUTTON THAN SHOWN IN PHOTO.



PREVIOUS EP60 HOUSING THAT WERE NOT NRTL