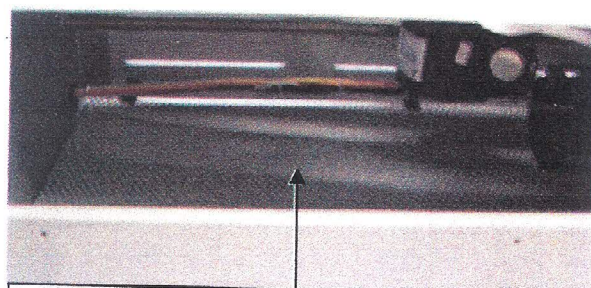


HD25 INDUSTRIAL CHASSIS COMPLETION

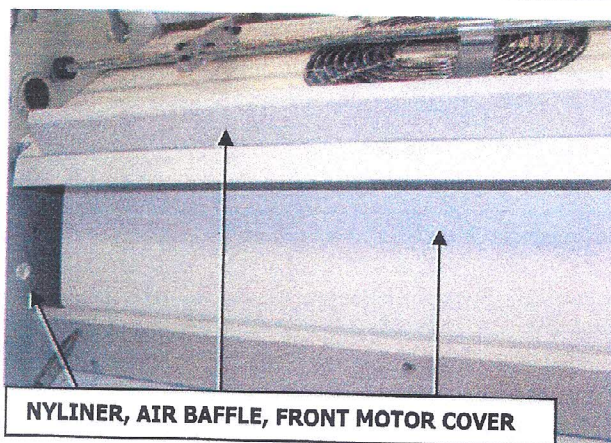
- 1) AFTER INTERNAL WIRING AND TYING, PLACE THE HD25 UPSIDE DOWN ON A WORKTABLE. CONNECT (3) TINNEMAN BRACKETS (PRT319) **LD01** TO THE BACK MOTOR COVER USING (3) 8 X ½ PH SMS. CONNECT (3) TINNEMAN BRACKETS TO SPACER BAR USING (3) 8 X ½ TH SMS.
- 2) ORIENT THE MOTOR COVER BOTTOM (H500 092.4BT) **AS04** OVER THE SIX TINNEMAN BRACKETS. SECURE THE MOTOR COVER BOTTOM TO THE BRACKETS USING (6) 8 X ½ PH SMS.
- 2) RETURN LAMINATOR TO UPRIGHT POSITION. ALIGN THE HD25 FRONT MOTOR COVER (H500 093.4FT) **AS04** WITH UPPER LIP HORIZONTAL AND OUTWARD, LOWER LIP DOWNWARD. SNAP INTO POSITION UNDER TOP MOTOR COVER LIP AND BEHIND SPACER BAR.
- 3) ALIGN THE HOLES ON THE AIR BAFFLE TOP (H500 181.4T) **AS04** WITH THE TOP MOTOR COVER HOLES AND THE FRONT MOTOR COVER HOLES. THREAD AN 8-32 X ½ PH THROUGH ALL THREE PIECES AND SECURE ON THE UNDERSIDE OF THE TOP MOTOR LIP WITH (3) #8 KEPS HEX NUT. CONNECT THE LOWER SECTION OF THE FRONT MOTOR COVER TO THE INSIDE OF THE SPACER BAR USING (3) 10-32 X ½ TH.
- 4) SLIDE A ½" FLAT WASHER SAE DOWN THE PREVIOUSLY ASSEMBLED CAM SHAFT AND INSERT CAM SHAFT FROM THE RIGHT SIDE PANEL THROUGH THE WHITE NYLINERS. THE LONGER SIDE OF THE CAM SHAFT WILL BE ON THE RIGHT. ADD ANOTHER ½" FLAT WASHER SAE TO THE LEFT SIDE CAM SHAFT AND SECURE WITH A CAM USING A 10-32 X ¾ SET SCREW INTO SHAFT OPENING.
- 5) CHECK WIRING ON EACH SIDE.



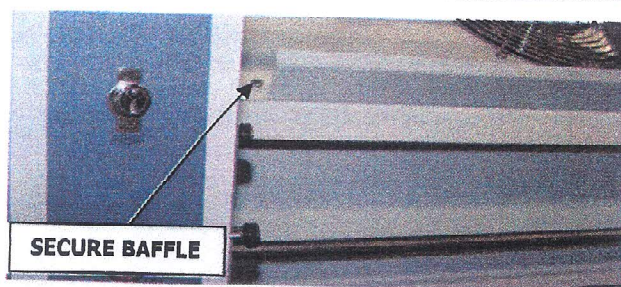
BOTTOM COVER ON
TINNERMAN BRACKETS



FRONT COVER BETWEEN TOP COVER & SPACER BAR

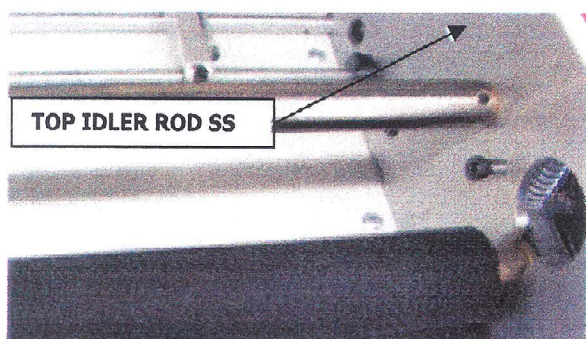
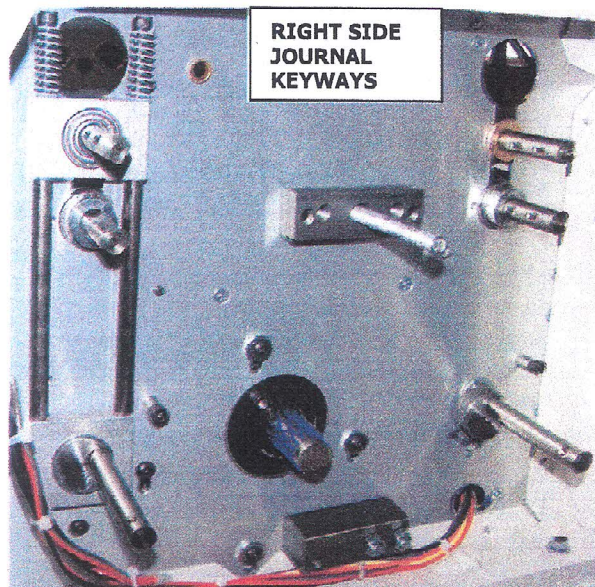
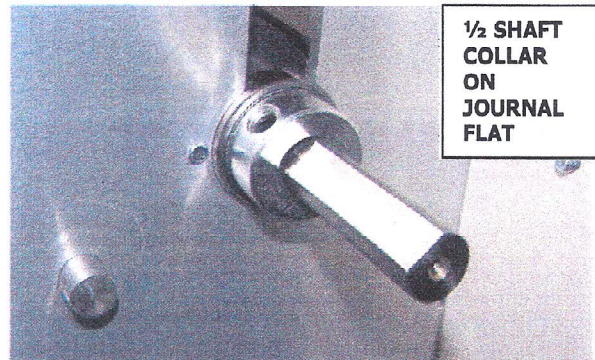


NYLINER, AIR BAFFLE, FRONT MOTOR COVER



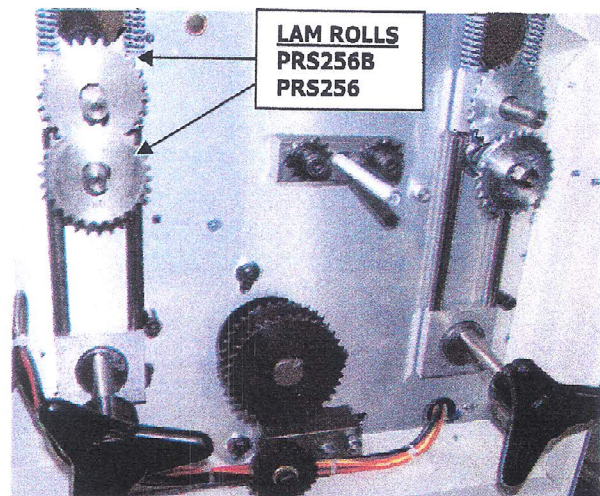
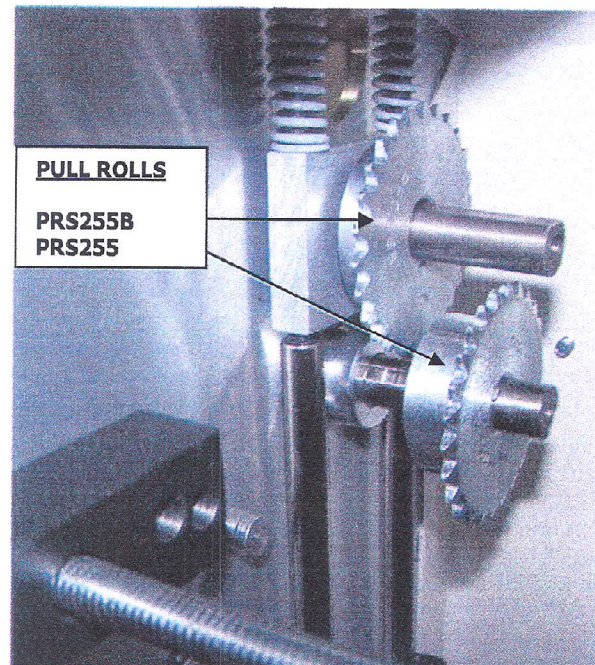
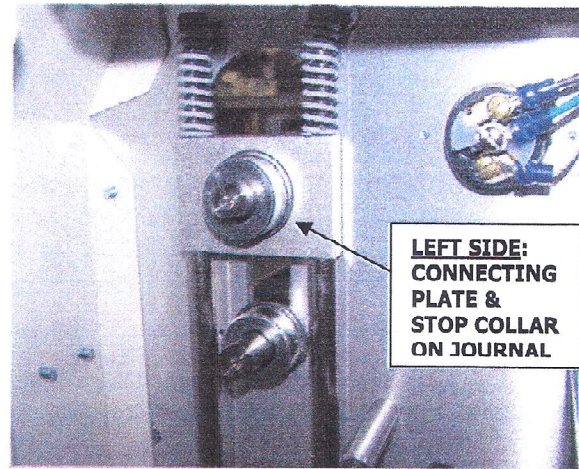
SECURE BAFFLE

- 6) PLACE THE BOTTOM FRONT AND REAR 25" HD RUBBER ROLLS (H500 040.4) **AS05** BETWEEN THE SIDE PANELS ORIENTED WITH THE KEYWAYS ON THE RIGHT SIDE.
- 7) SLIDE (4) 8ZZ BALL BEARINGS (PRB038) **AS02** ONE EACH OVER BOTH SIDES OF THE LOWER RUBBER ROLL JOURNALS AND PRESS THEM INTO THE SIDE PANELS AGAINST THE 10-32 X 1/4 TH.
- 8) CENTER THE BOTTOM RUBBER ROLLS BETWEEN THE SIDE PANELS. FROM THE OUTER SIDE PANEL SLIDE A 1/2 SHAFT COLLARS (PRC096) **AS09**, ONTO EACH JOURNAL AND SNUG THE STOP COLLAR TO BALL BEARINGS. SECURE STOP COLLAR ON FLAT OF JOURNAL, OPPOSITE KEYWAY ON RIGHT SIDE. THE BOTTOM RUBBER ROLLS SHOULD BE SECURE AND NOT SLIDE BACK AND FORTH BETWEEN SIDE PANEL. USE THE PLUG HOLES IN THE UPPER HOUSINGS TO REACH SHAFT COLLARS.
- 9) PLACE THE UPPER RUBBER ROLLS BETWEEN SIDE PANELS, AGAIN WITH THE KEYWAYS ON THE RIGHT SIDE.
- 10) SLIDE A WORKED OILITE BEARING (PRB039) **AS02** OVER EACH OF THE UPPER RUBBER ROLL JOURNALS, ORIENTED WITH THE FLANGE OUTWARD. THE FLAT SIDES OF THE OILITE BEARINGS FIT INTO SIDE PANELS.
- 11) FROM INNER PANELS TAP (2) OILITE BEARINGS (PRB046) **AS02** FLANGE INWARD BEHIND FRONT RUBBER ROLLS.
- 12) INSERT A 10-32 X 1/4 SET SCREW INTO THE RIGHT SIDE OF THE HD25 TOP IDLER ROD (H500 052.4T) **AS02** AND SECURE TOP IDLER ROD BETWEEN OILITE BEARINGS WITH (2) 3/8 X 1/2 SHOULDER BOLTS FROM OUTER PANEL.
- 13) BRUSH LOCTITE ANTI-SEIZE ONTO THE CIRCUMFERENCE OF ALL (4) CAMS. ORIENT THE CONNECTING PLATES WITH THE ROLLER BEARING EXCESS INWARD FLUSH OUTWARD. SLIDE CONNECTING

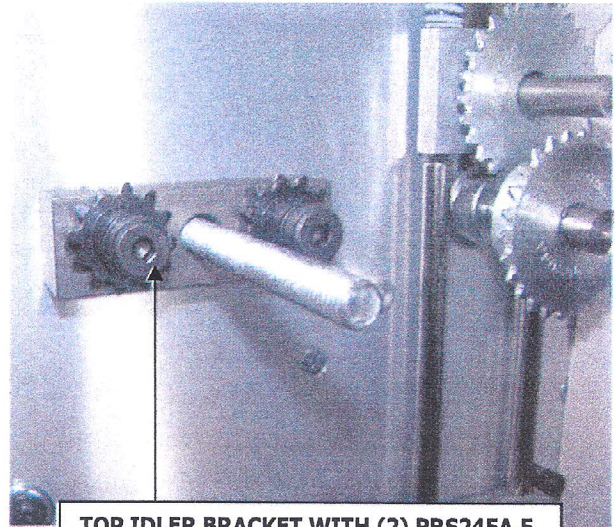


PLATES OVER UPPER RUBBER ROLL JOURNALS AND LOWER CAMS.

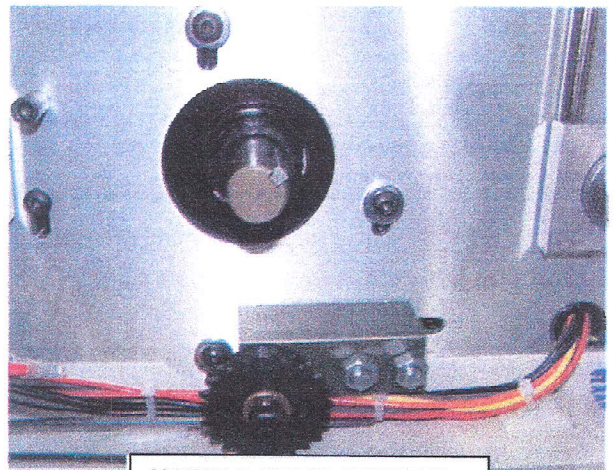
- 14) FOR PURPOSES OF ADJUSTMENT AND LATER TESTING, SECURE (2) BLACK CAM SHAFT HANDLES (PRH140) **AS09** ONTO THE RIGHT SIDE CAM SHAFT. USE A 1/4-20 X 3/8 SET SCREW IN EACH HANDLE.
- 15) RAISE AND LOCK THE TOP RUBBER ROLLS. ALIGN THE TOP AND BOTTOM RUBBER ROLLS. ON THE LEFT SIDE ONLY SNUG THE CONNECTING PLATES NEXT TO OILITE BEARING ON THE TOP JOURNAL AND THE CAM ON BOTTOM. SECURE BOTH LEFT TOP CONNECTING PLATES WITH A 1/2" SHAFT COLLAR (PRC096) **AS09** ON JOURNAL FLAT.
- 16) ON THE RIGHT SIDE TURN KEYWAYS UP AND INWARD ON ALL FOUR JOURNALS. TAP A #3 WOODRUFF KEY (MI03 KEY) **AS15** INTO THE INNER TOP RUBBER ROLL KEYWAYS.
- 17) THREAD A 1/4-20 X 3/8 SET SCREW INTO EACH SPROCKET USED. WITH THE HUB FACING *INWARD*, SLIDE A 25B26 1/2" BORE FACED SPROCKET (PRS255B) **AS03** ONTO THE TOP REAR PULL ROLL JOURNAL OVER THE KEY. SNUG TO CONNECTING PLATE, USE PLUG HOLES.
- 18) WITH THE HUB FACING *INWARD*, SLIDE A 25B27 1/2" BORE FACED SPROCKET (PRS256B) **AS03** ONTO THE TOP FRONT LAMINATING ROLL JOURNAL OVER KEY, SNUG WITH CONNECTING PLATE.
- 19) TAP A #3 WOODRUFF KEY (MI103) **AS15** INTO BOTH OUTER RIGHT SIDE BOTTOM RUBBER ROLL KEYWAYS.
- 20) WITH THE HUB FACING *INWARD*, SLIDE A 25B26 1/2" BORE SPROCKET (PRS255) **AS03** ONTO THE BOTTOM PULL ROLL, OVER KEY.
- 21) WITH THE HUB FACING *INWARD*, SLIDE A 25B36 1/2" BORE SPROCKET (PRS256) **AS03** ONTO THE BOTTOM LAMINATING ROLL, OVER KEY.



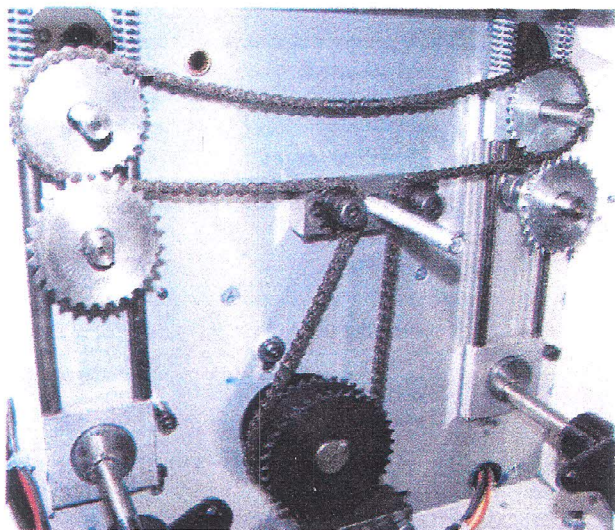
- 22) PLACE (2) 25B12 1/2" BORE SPROCKETS WITH BEARINGS (PRS245A.5) **AS03** EACH ON A 3/8 X 5/8 SHOULDER BOLT, HUB **OUTWARD**, TEETH INWARD. THREAD THE SHOULDER BOLTS INTO THE INNER HOLES OF THE TOP IDLER BRACKET. TIGHTEN, THE SPROCKETS SHOULD MOVE FREELY.
- 23) WITH THE HUB **INWARD**, TEETH OUTWARD PLACE THE 25B22 1/2" BORE WITH BEARING SPROCKET (PRS294.5) **AS03** ON A 3/8 X 7/8 SHOULDER BOLT. THREAD THIS INTO THE CHAIN ADJUSTER AND TIGHTEN.
- 24) ALIGN MOTOR KEYWAY UPWARD. SLIDE A 25B36 3/4" BORE SPROCKET (PRS260A) **AS03** WITH A 10-32 X 3/8 SET SCREW **HUB INWARD** ONTO MOTOR SHAFT OVER KEY, FLUSH WITH MOTOR. TIGHTEN SET SCREW. SLIDE ANOTHER 3/4 BORE SPROCKET (PRS260A) HUB INWARD, ONTO MOTOR SHAFT OVER KEY.
- 25) PUSH CHAIN ADJUSTER SPROCKET IN AND MEASURE DISTANCE FROM SIDE PANEL. MEASURE OUTER MOTOR SPROCKET TEETH EVEN WITH CHAIN ADJUSTER TEETH AND TIGHTEN MOTOR SPROCKET.
- 26) MEASURE AND ALIGN BOTTOM RUBBER ROLL SPROCKET TEETH WITH OUTER MOTOR TEETH, TIGHTEN.
- 27) MEASURE AND ALIGN TOP RUBBER ROLL SPROCKET TEETH WITH INNER MOTOR SPROCKET TEETH AND TIGHTEN.
- 28) BEFORE CONNECTING THE CHAINS, CHECK THAT THE CHAIN ADJUSTER IS TO THE FAR LEFT IN THE SLOT, THE MOTOR IS UP IN THE SLOTS AND THE RUBBER **ROLLS ARE OPEN**. CONNECT THE LONGEST CHAIN ONTO THE INNER MOTOR SPROCKET TEETH, TO THE INSIDE OF THE IDLER SPROCKET TEETH, AND ONTO THE INNER TOP ROLL TEETH. CONNECT USING A #25 CHAIN CONNECTOR.



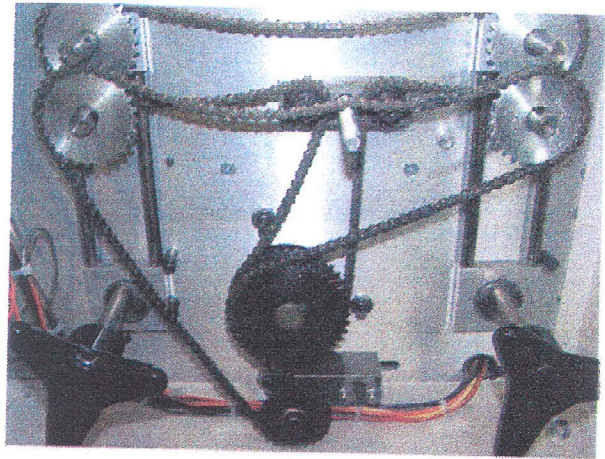
TOP IDLER BRACKET WITH (2) PRS245A.5



MOTOR & CHAIN ADJUSTER

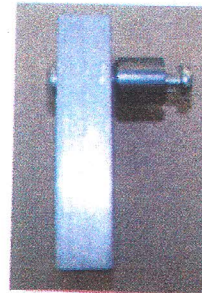


- 29) LAY THE SHORTER CHAIN ONTO THE LOWER CHAIN ADJUSTER SPROCKET TEETH, TO THE FRONT SIDE OF THE OUTER MOTOR SPROCKET TEETH AND AROUND THE OUTER BOTTOM RUBBER ROLL SPROCKET TEETH. SECURE CHAIN WITH A #25 CHAIN CONNECTOR.

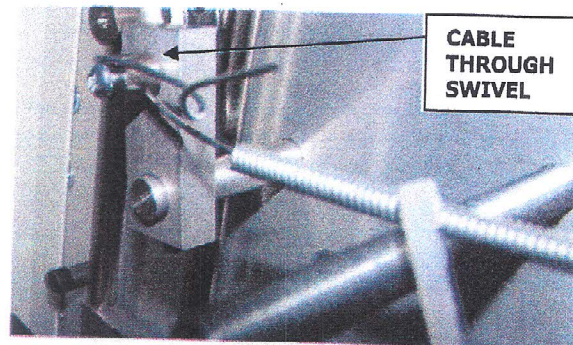


- 30) TIGHTEN THE INNER CHAIN BY LOOSENING THE (4) MOTOR SCREWS AND LETTING THE WEIGHT OF THE MOTOR PUT TENSION ON THE CHAIN. RETIGHTEN MOTOR SCREWS. TIGHTEN THE OUTER CHAIN BY MOVING THE CHAIN ADJUSTER TO THE RIGHT UNTIL THE DESIRED TENSION IS REACHED. WHEN THE RUBBER ROLLS ARE PUT IN THE "DOWN" POSITION THE CHAIN SHOULD BE AT OPTIMUM TENSION.

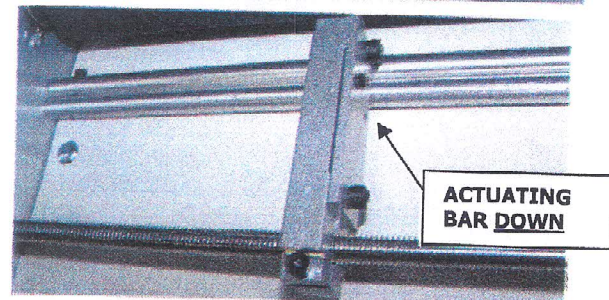
- 31) ASSEMBLE THE ACTUATING LEVER (H850 188.4) **AS03** BY SLIDING THE SWIVEL (H850 189.4) **AS03** THROUGH THE LEVER AND SECURING WITH A 6-32 X 1/4 PH. LOOSELY THREAD ANOTHER 6-32 X 1/4 PH INTO THE OTHER END OF THE SWIVEL. INSERT A 10-32 X 3/8 SET SCREW INTO THE END OF THE LEVER.



- 32) REMOVE WASHER AND NUT FROM THE SLITTER CHOKE CABLE (PRC089) **AS04** AND INSERT THE CABLE INTO THE LEFT HOUSING. WITH THE KNOB ON THE OUTER HOUSING, RETHREAD THE CABLE WASHER AND NUT ON THE INNER HOUSING.



- 33) SLIDE THE ACTUATING LEVER ONTO THE LEFT SIDE BOTTOM SLITTER ACTUATING BAR. ALLOW A GENEROUS AMOUNT OF CABLE AND CUT CABLE TO WORKING LENGTH. SLIDE CABLE SPRING SNUG TO HOUSING AND INSERT CABLE THROUGH HOLE IN SWIVEL, BEND CABLE.



- 34) THE TOP SLITTER ACTUATING BAR SHOULD BE LAYING FLAT TO THE REAR BEFORE ADJUSTING. BY PULLING THE SLITTER CHOKE CABLE KNOB, THE TOP ACTUATING BAR SHOULD BE UPRIGHT. ADJUST THE ANGLE OF THE ACTUATING LEVER TO ACHIEVE THE UPRIGHT

