

# **DIGITAL RELEASE LINER TAKE-UP**

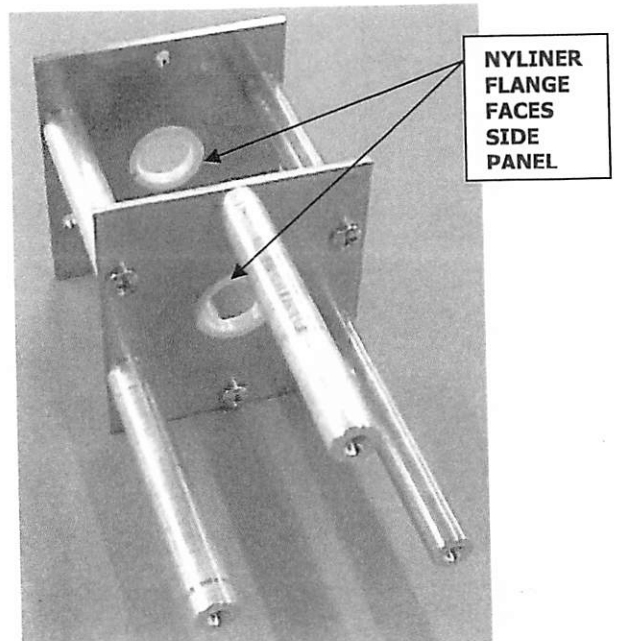
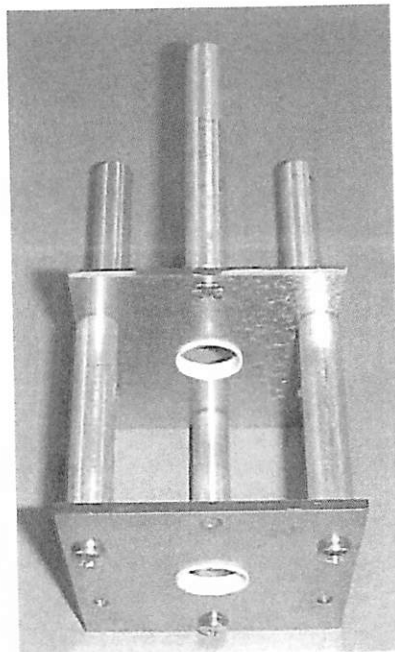
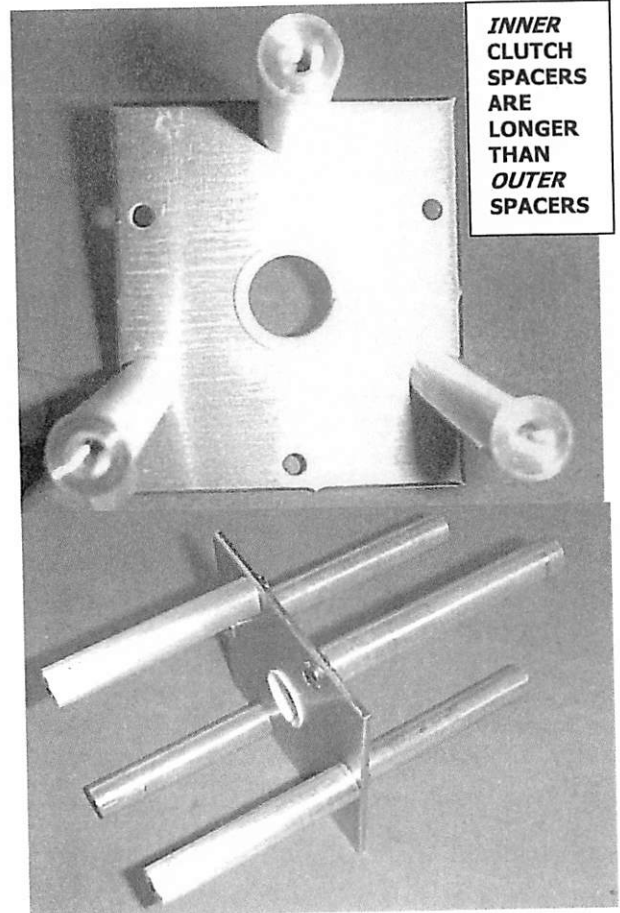
042 / 065

## **ASSEMBLY PROCEDURES**

**APRIL 2002, UPDATED AUGUST 2008**

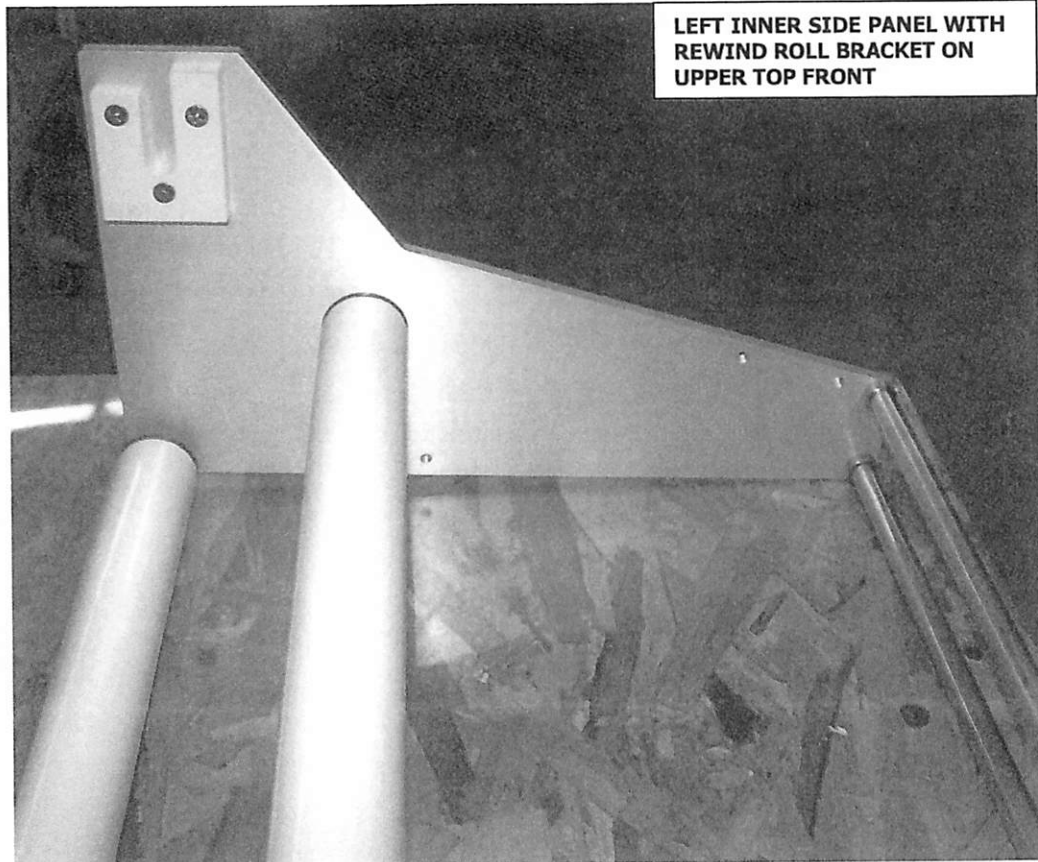
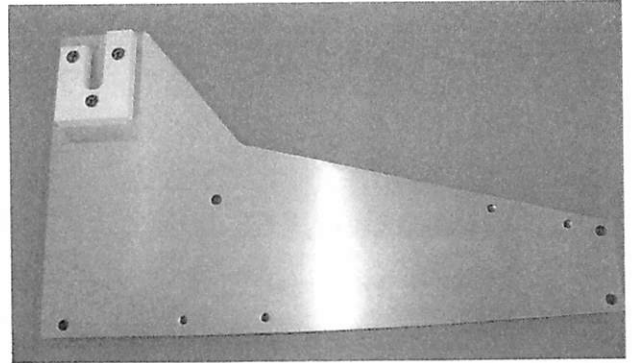
# DI60 RELEASE LINER TAKE-UP CLUTCH SUPPORT ASSEMBLY

- 1) INSERT A WHITE NYLINER  $\frac{3}{4}$ " SHAFT (PRB068) AS07 WITH FLANGE ON *INNER CLUTCH SPACER* SIDE INTO SCRAP REWIND SUPPORT PLATE (D105 204.4) RACK 22. MAKE (2) OF THESE.
- 2) ATTACH (3) INNER CLUTCH SPACER C (EP30 078.4) RACK 8 ON NYLINER FLANGE SIDE USING (3) 10-32 X  $\frac{1}{2}$  PH. THE SPACERS ARE POSITIONED WITH ONE ON TOP OF RECTANGULAR REWIND SUPPORT PLATE AND TWO IN BOTTOM HOLES OPPOSITE EACH OTHER.
- 3) ATTACH (3) OUTER CLUTCH SPACER C (EP30 079.4) RACK 8 WHICH ARE SHORTER THAN THE INNER SPACERS, ON OTHER SIDE OF SCRAP REWIND SUPPORT PLATE IN REMAINING HOLES USING (3) 10-32 X  $\frac{1}{2}$  PH.
- 4) INSERT ANOTHER NYLINER INTO THE SECOND SCRAP REWIND SUPPORT PLATE, FLANGE FACING IN TOWARD OUTER CLUTCH SPACERS.
- 5) SECURE SECOND SCRAP REWIND SUPPORT PLATE TO OUTER CLUTCH SPACERS WITH (3) 10-32 X  $\frac{1}{2}$  PH.



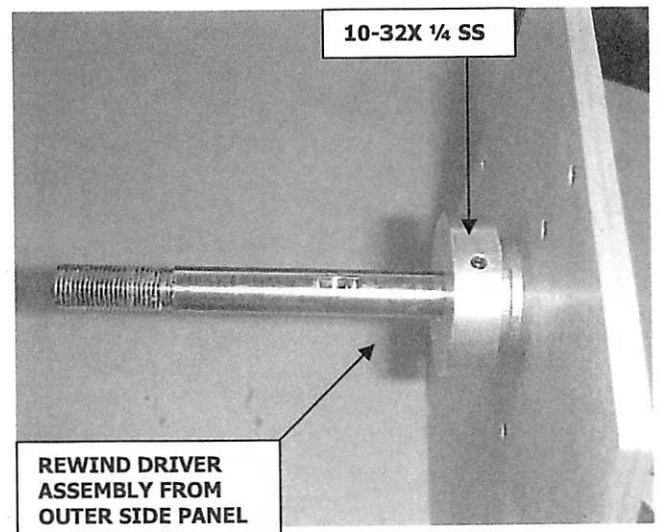
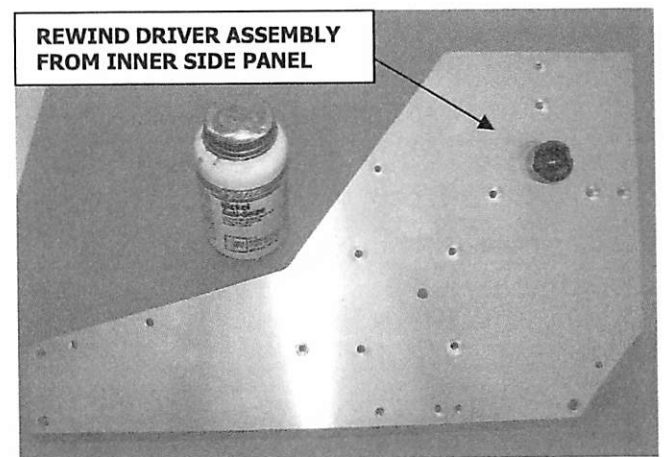
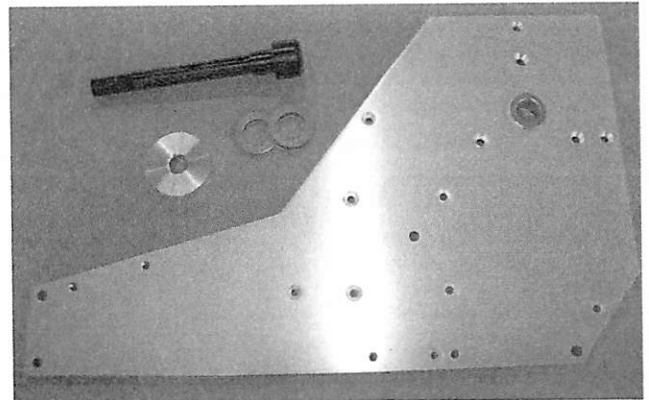
# DIGITAL 60 RELEASE LINER TAKE-UP LEFT SIDE PANEL ASSEMBLY

- 1) ATTACH REWIND ROLL BRACKET C (EP30 006.4) RACK 8 TO THE UPPER FRONT INSIDE OF THE SCRAP REWIND LEFT SIDE PANEL (D105 201.4) RACK 22. LOCTITE THREADS OF (3) 10-32 X  $\frac{3}{4}$  FH SCREWS, INSERT AND SECURE TO SIDE PANEL THROUGH COUNTERSUNK HOLES IN REWIND ROLL BRACKET.
- 2) STORE ASSEMBLED SCRAP REWIND LEFT SIDE PANEL UNTIL NEEDED.



# DI60 RELEASE LINER TAKE-UP RIGHT SIDE CLUTCH ASSEMBLY

- 1) ARBOR PRESS OILITE BEARING 1/8" FLANGE (PRB078) RACK 10 THROUGH INSIDE OF SCRAP REWIND RIGHT SIDE PANEL (D105 200.4) RACK 22. THE OILITE BEARING IS SURROUNDED BY (3) COUNTERSUNK HOLES.
- 2) TAP (2) OILITE WASHERS (PRW338) RACK 10 ONTO OILITE BEARING SHAFT EXTENDING ON OUTER RIGHT PANEL. STAKE WASHERS IN THREE PLACES.
- 3) REAM OUT OILITE BEARING AND WASHER ASSEMBLY.
- 4) BRUSH ANTI-SEIZE ON PORTION OF REWIND DRIVER ASSEMBLY C (EP30 045.6) RACK 8 RIDING ON OILITE BEARING.
- 5) INSERT REWIND DRIVER ASSEMBLY C FROM INNER SIDE PANEL THROUGH OILITE BEARING FLANGE.
- 6) THREAD A 10-32 X 3/4 SET SCREW INTO FIXED FRICTION PLATE C (EP30 007.4) RACK 8. WITH THINNER SIDE OF SET SCREW HOLE FACING OILITE WASHERS. SLIDE FIXED FRICTION PLATE OVER REWIND DRIVER AND SECURE WITH SET SCREW IN REWIND DRIVER HOLE. WHEN SEEDED INTO HOLE SET SCREW IS PAST FLUSH ON PLATE. TEST TO BE SURE REWIND DRIVER SPINS FREELY.
- 7) SLIDE A LEATHER WASHER (PRW336) RACK 22 ONTO REWIND DRIVER SHAFT.
- 8) ARBOR PRESS OILITE BEARING (PRB043) AS08 INTO 5/8" BORE 25B26 SPROCKET (PRS255A) RACK 8 WITH BEARING FLUSH ON TOOTH SIDE OF SPROCKET.
- 9) SLIDE SPROCKET, TOOTH SIDE INWARD NEXT TO LEATHER WASHER.
- 10) ADD ANOTHER LEATHER WASHER (PRW336) TO REWIND SHAFT.



11) INSERT HD SUPPLY ROLL KEY (PRX347) AS09 INTO REWIND SHAFT KEYWAY. SECURE KEY WITH FRICTION PRESSURE PLATE (H685 007.4A) RACK 8, SPRING DEPRESSION TOWARD OUTSIDE.

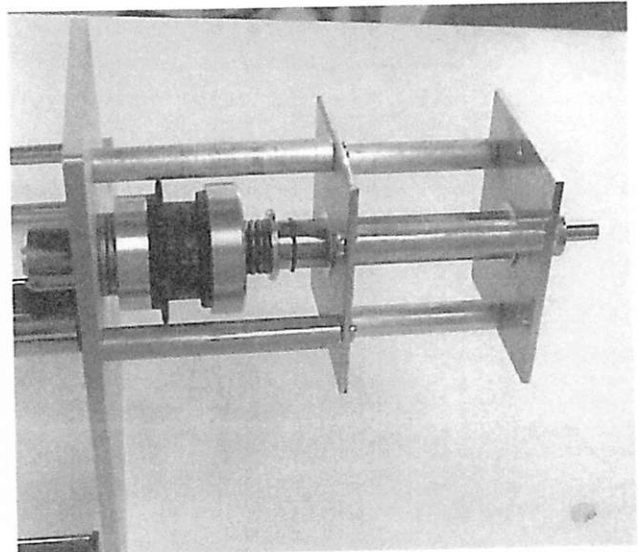
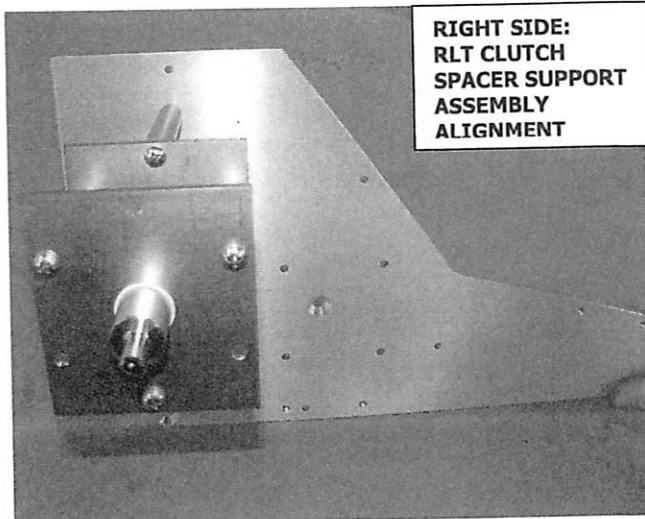
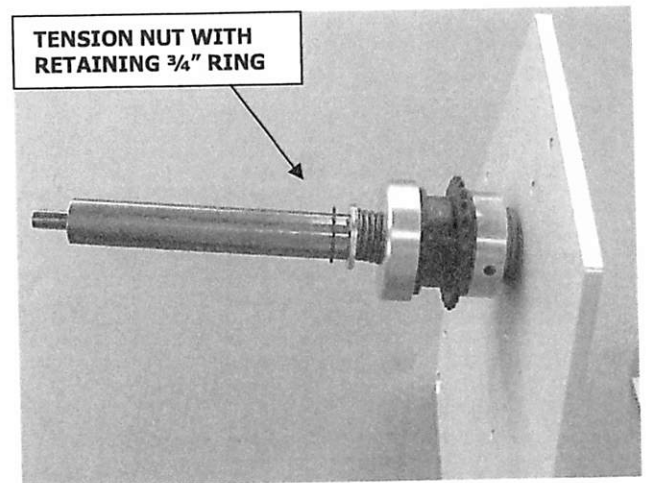
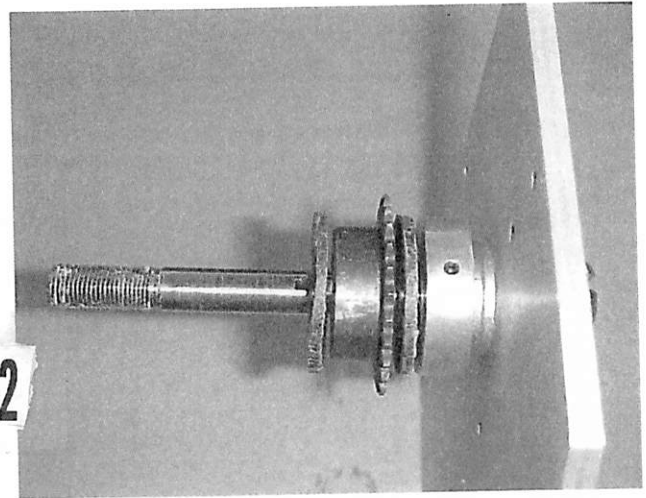
12) ADD EP REWIND SPRING (PRS226) RACK 10, FITTING INTO DEPRESSION IN PRESSURE PLATE.

13) SLIDE ON 1/2" FLAT WASHER SAE AS13.

14) SLIDE A 3/4" RETAINING RING (RACK 19) ONTO GROOVE IN TENSION NUT C (EP30 046.4) RACK 8.

15) BRUSH ANTI-SEIZE ONTO THREADS OF REWIND DRIVER ASSEMBLY AND TIGHTEN ON TENSION NUT. THIS IS A *LEFT HAND THREAD*. TIGHTEN TO FULL COMPRESSION OF SPRING, THEN BACK OFF.

16) SLIDE CLUTCH SPACER SUPPORT ASSEMBLY OVER TENSION NUT AND SECURE FROM INSIDE PANEL WITH (3) 10-32 X 3/4 FH. LOCTITE THREADS.

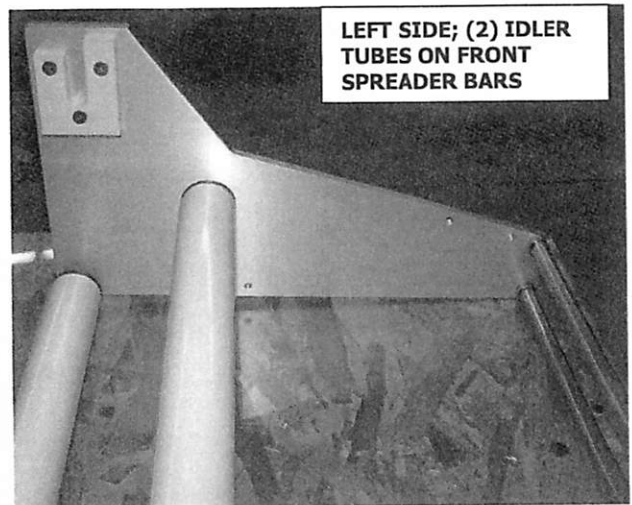
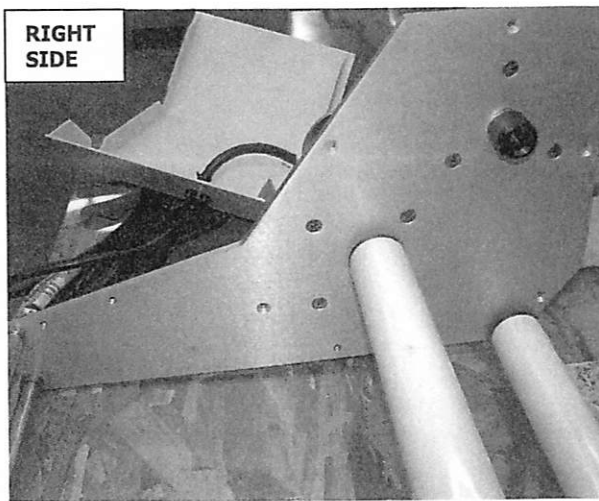
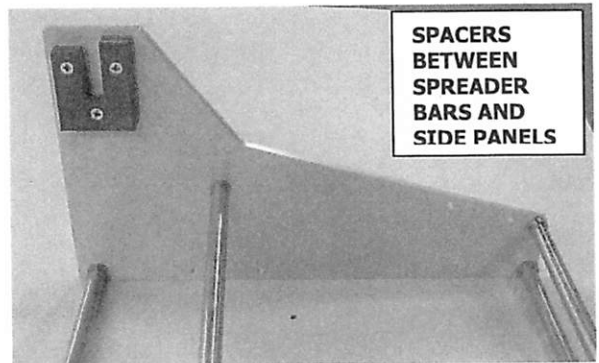
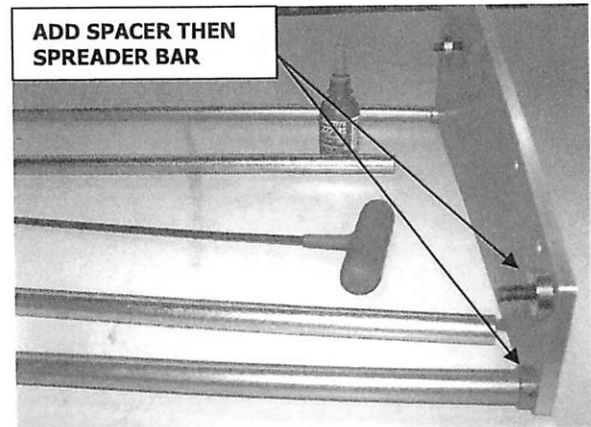


# DIGITAL 60 RELEASE LINER TAKE-UP SPREADER BARS & IDLER ASSEMBLY

- 1) INSERT (4) 1/4-20 X 1 FH SOCKET SCREWS, LOCTITE ON THREADS THROUGH PICTURED COUNTERSUNK HOLES ON OUTSIDE OF EITHER SIDE PANEL. LEFT SIDE IS PICTURED.
- 2) ON INSIDE, ADD (4) SCRAP REWIND LOCATING SPACERS (D105 202.4) RACK 22 TO SCREWS. THREAD ON (4) SPREADER BARS (D60 110.4) D60-01.
- 3) INSERT (4) BEARINGS IDLER-NYLATRON STYLE (PRB086A) AS13 INTO ENDS OF (2) IDLER TUBES (D60 052.4) D60-01.
- 4) SLIDE IDLER TUBES ONTO FRONT SPREADER BARS THAT ARE CLOSER TO REWIND BRACKET.
- 5) CONNECT ALL FOUR SPREADER BARS TO REMAINING SIDE PANEL BY FIRST ADDING (4) MORE SCRAP REWIND LOCATING SPACERS ONTO (4) 1/4-20 X 1 FH SOCKET SCREWS WITH LOCTITE ON THREADS AND TIGHTENING.

*no spacer on 50" RW*

*D105 052.4*

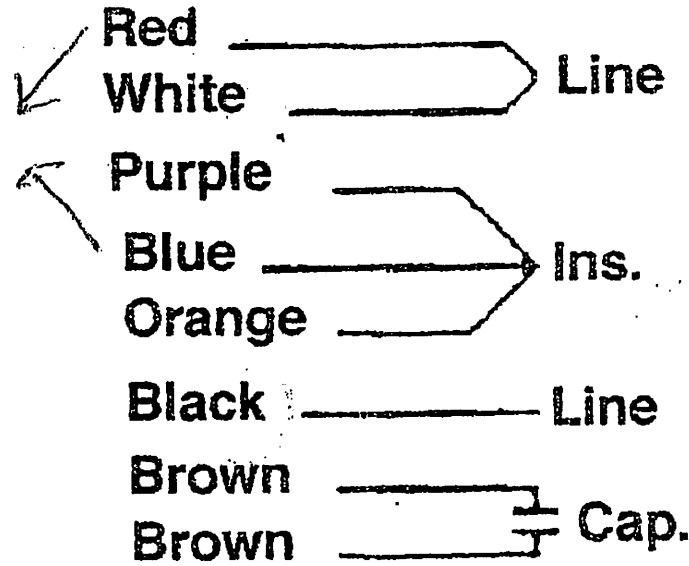
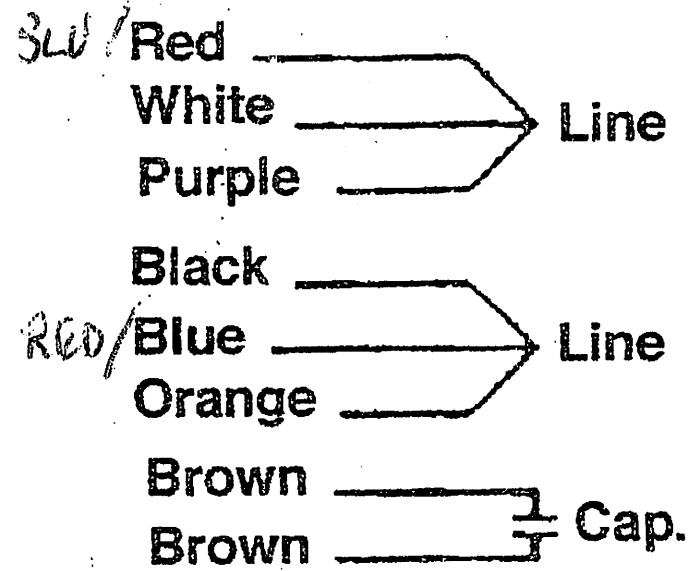


# Wiring Diagram

115 Volts

RET MOTOR  
DAYTON 12P08  
230 Volts

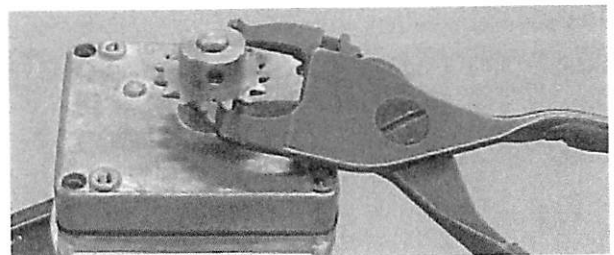
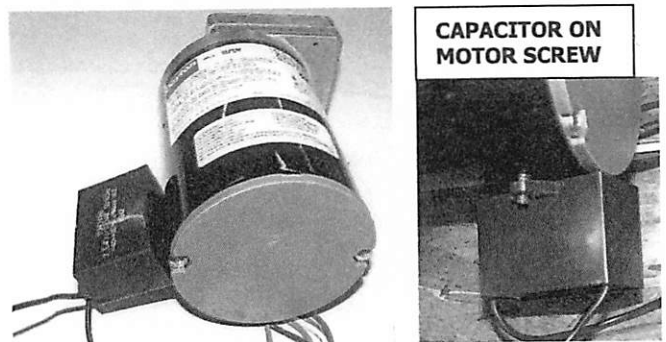
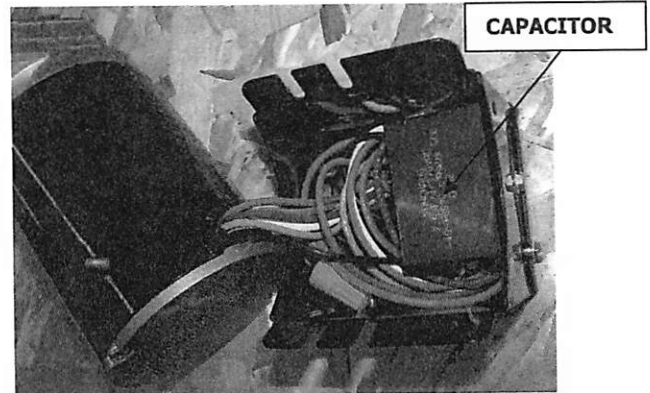
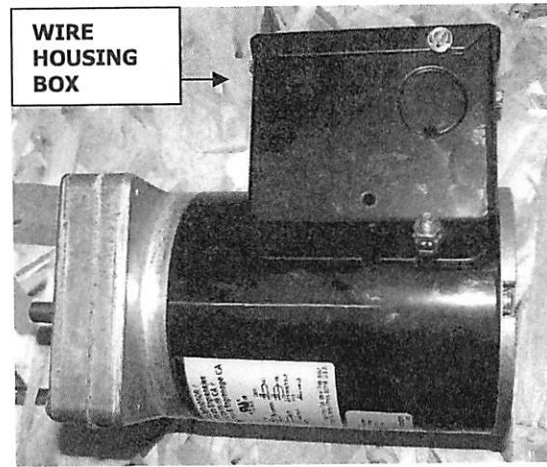
PRM 228A



To Reverse Rotation Interchange Red & Blue Motor Leads  
Capacitor Rating 7.5 MFD 370 Volts

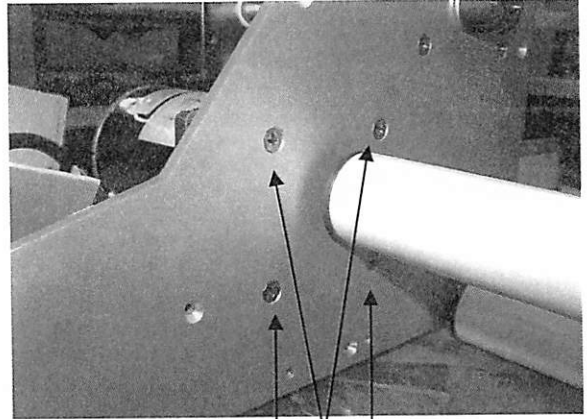
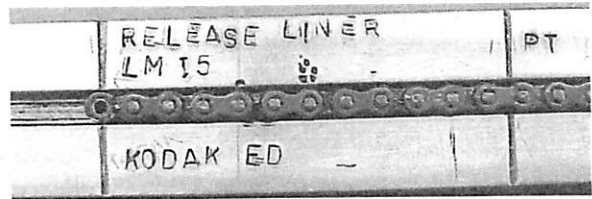
# DIGITAL 60 RELEASE LINER TAKE-UP MOTOR & ASSEMBLY

- 1) AS OF AUGUST 2008 THE RELEASE LINER TAKEUP WILL USE THE DAYTON 1LPUS MOTOR (PRM228A) AS01. THIS MOTOR ACCOMMODATES 110V AND 220V RELEASE LINER TAKEUPS. THE WIRE COMBINATIONS ARE DIFFERENT.
- 2) UNSCREW AND REMOVE THE DAYTON MOTOR WIRE HOUSING BOX CONTAINING WIRES AND CAPACITOR. RETAIN THE (2) KEPS HEX NUTS.
- 3) REMOVE THE CAPACITOR FROM THE HOUSING END PLATE, RETAINING SCREWS. GENTLY REMOVE THE MOTOR WIRES FROM HOUSING BOX.
- 4) UNSCREW THE CAPACITOR WIRE NUTS WHICH UNITE BLACK WIRES WITH BROWN AND BLUE WIRES. REPLACE THE WIRE NUTS WITH CLOSE CAPS (PRT289) LDW1. *DO NOT SEPARATE THE BROWN AND BLUE WIRES FROM THE BLACK CAPACITOR WIRES. CLEAR CAP EXACTLY AS THEY ARE UNITED.*
- 5) SECURE THE CAPACITOR TO THE MOTOR ORIENTED TO THE LOWER FRONT OF THE TAKEUP. USE THE SCREW THREADS ON THE MOTOR THAT HELD THE HOUSING BOX AND SECURE WITH THE KEPS HEX NUT THAT YOU RETAINED.
- 6) THREAD A 10-32 X ¼ SET SCREW INTO A 5/16 25B15 SPROCKET (PRS2455.1B) RACK 7.
- 7) SLIDE SPROCKET, *TOOTH SIDE INWARD*, ONTO MOTOR SHAFT. ALIGN SET SCREW ON FLAT OF MOTOR SHAFT. SNUG ENOUGH TO HOLD, AS THIS WILL BE READJUSTED LATER.
- 8) ADVANCE GEAR MOTOR SHAFT SO SET SCREW IS ALIGNED *UPWARD* WHEN MOTOR IS ON SIDE PANEL. THIS POSITION FACILITATES SETTING CHAIN.





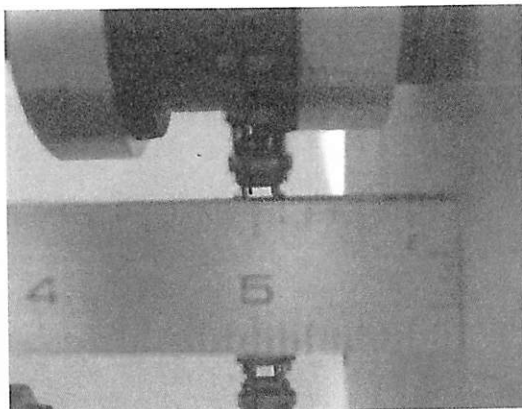
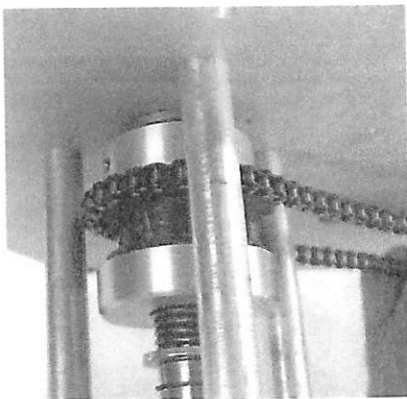
- 9) MEASURE #25 CHAIN (PRC083.1) CCT ON CHAIN GAUGE TO LINE LEFT OF MARKED "RELEASE LINER - LM 15." CUT CHAIN AND SET ASIDE.
- 10) INSERT (4) 10-32 X 2 FHMS INTO EQUIDISTANT COUNTERSUNK HOLES ON INNER RIGHT PANEL. SLIDE (4) SCRAP REWIND MOTOR STANDOFFS (D105 203.4) RACK 22 ONTO THREADS. SECURE MOTOR TO STANDOFFS *POSITIONED WITH WIRE BOX SCREWS DOWNWARD AND MOTOR MOUNTING OFFSET TOWARD REAR SPREADER BARS.*
- 11) LAY #25 CUT CHAIN OVER TEETH ON REWIND CLUTCH SPROCKET AND GEAR MOTOR SPROCKET. TWO STANDOFFS ARE *INSIDE* THE CHAIN CONNECTION. SECURE CHAIN WITH A #25 CHAIN CONNECTING LINK (PRC084) AS07.
- 12) MEASURE CHAIN DISTANCE FROM SIDE PANEL ON THE SCRAP REWIND SPROCKET. LOOSEN SET SCREW ON THE MOTOR SHAFT SPROCKET. ADJUST TO EVEN DISTANCE WITH REWIND SPROCKET TO THE SIDE PANEL. TIGHTEN SET SCREW ON FLAT OF MOTOR SHAFT.



MOTOR SCREW LOCATIONS



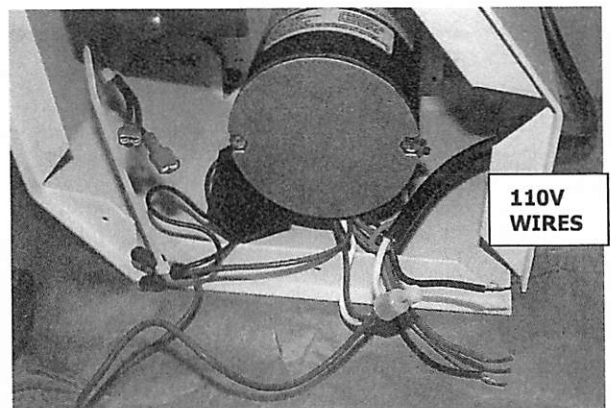
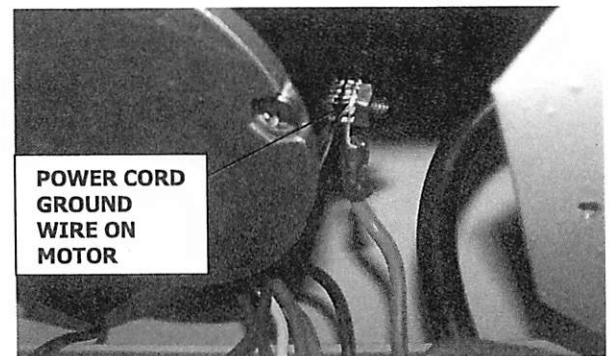
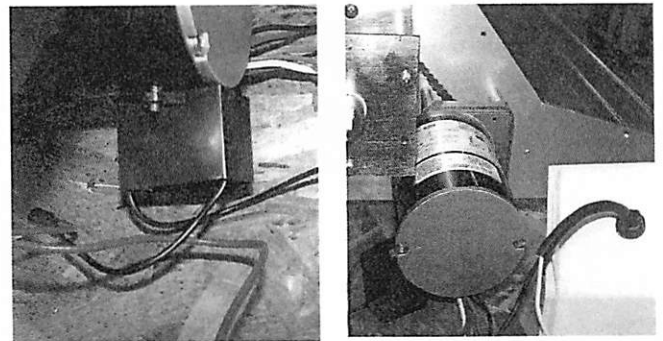
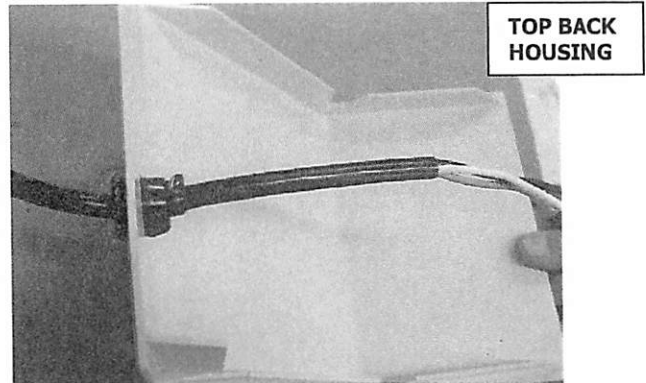
MOTOR MOUNTING OFFSET TO REAR



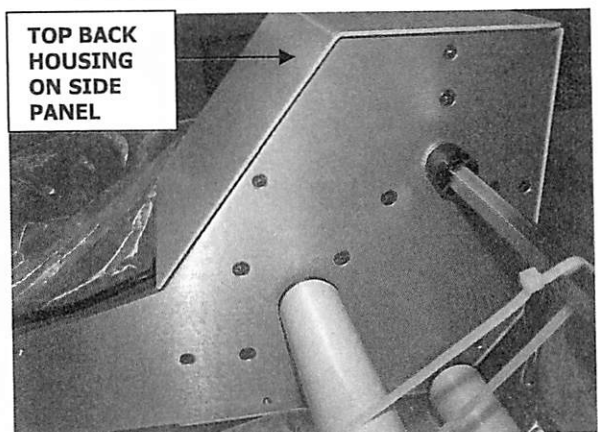
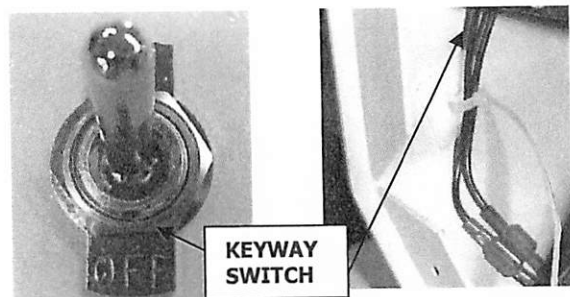
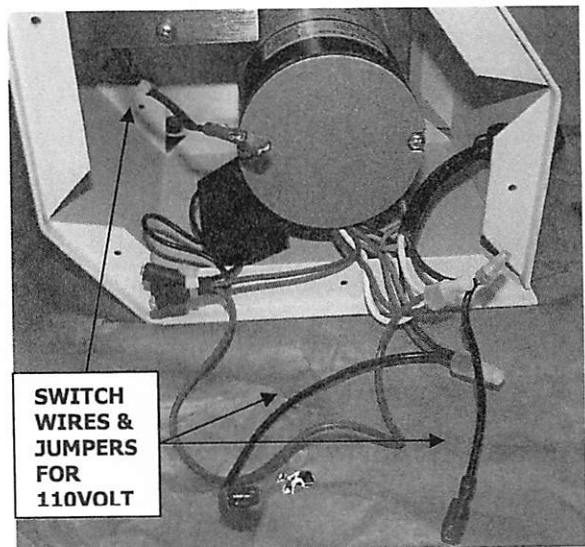
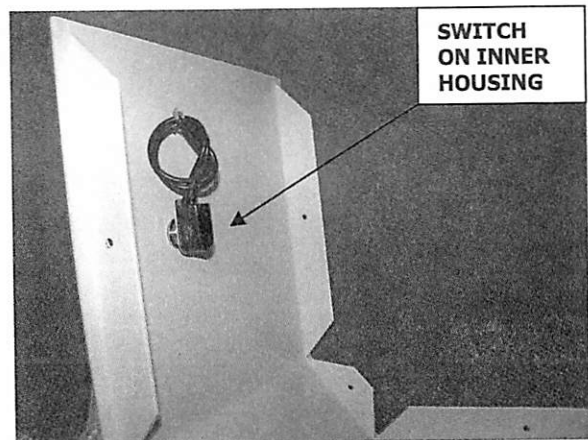
(4) SCRAP REWIND MOTOR STANDOFF

# DIGITAL 60 RELEASE LINER TAKE-UP WIRING 2016

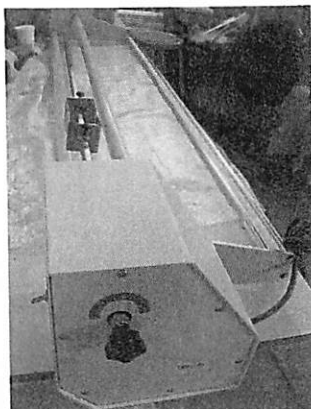
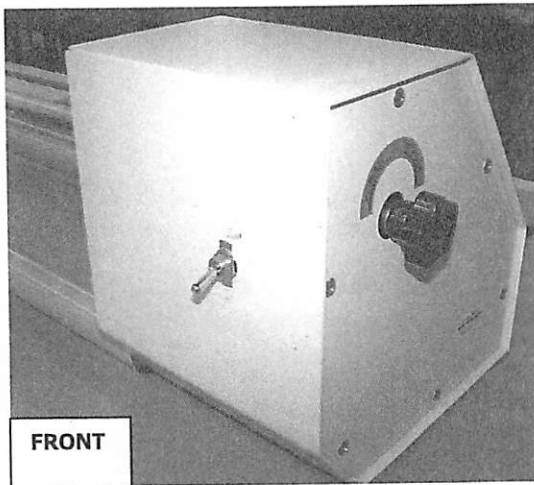
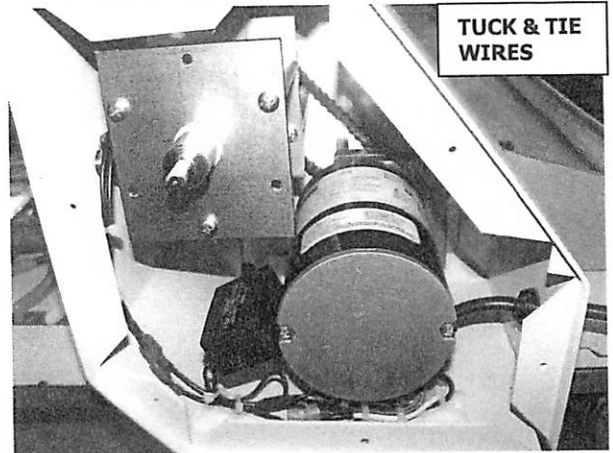
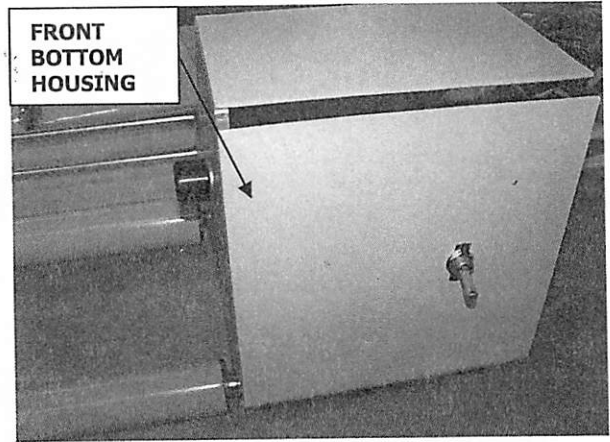
- 1) STRIP 3" OF PROTECTIVE SHEATHING OFF THE END OF A 16/3 POWER CORD 12' (PRC119) RACK 8. ADHERE BLACK ELECTRICAL TAPE AROUND SHEATHING 7" FROM END OF WIRES, TO INDICATE AREA WHERE STRAIN RELIEF BUSHING (PRB065) AS07 WILL SECURE POWER CORD INTO SCRAP REWIND TOP BACK HOUSING (D105 206.4) AS01. INSERT POWER CORD AND RELIEF BUSHING INTO TOP BACK HOUSING.
- 2) TERMINATE THE GREEN GROUND POWER CORD WIRE WITH A BLUE RING CONNECTOR (PRT294) LDW1. PLACE A #8 STAR WASHER ON THE REAR MOTOR HOUSING BOX SCREW. ADD THE GREEN GROUND WIRE RING CONNECTOR. SECURE GROUND WIRE TO MOTOR WITH THE #8 KEPS HEX NUT RETAINED WHEN THE HOUSING BOX WAS REMOVED.
- 3) DO NOT SECURE THE TOP BACK HOUSING AT THIS TIME. THE TOP BACK HOUSING CAN REST ON A WORKTABLE WHILE THE BLACK AND WHITE POWER CORD WIRES ARE TERMINATED.
- 4) STRAIGHTEN WIRES FROM MOTOR AND SEPARATE ACCORDING TO WIRING INSTRUCTIONS ON DAYTON MOTOR OR IN INSTRUCTION MANUAL *EXCEPT* THE RED AND BLUE WIRES ARE REVERSED, WHICH CHANGES THE MOTOR DIRECTION. THE MOTOR WIRING DIAGRAM INDICATES DIFFERENCE BETWEEN 220 VOLT AND 110 VOLT MACHINES. DIRECTIONS FOR 110 VOLT MACHINE FOLLOWS: USE CABLE TIES TO GROUP WIRES: *MOTOR WIRES*- PURPLE AND WHITE PLUS BLUE FROM THE *CAPACITOR*, CABLE TIE TOGETHER. STRIP THESE WIRES EVENLY AND ADD THE WHITE FROM THE *POWER CORD*. CLOSE CAP THESE FOUR WIRES WITH A (PRT290). *MOTOR WIRES*- BLACK, RED AND ORANGE PLUS A 6" BLACK JUMPER WHICH CONTINUES TO SWITCH. CLOSE CAP WITH (PRT290) THESE (4) WIRES.



- 5) THE BLACK POWER CORD WIRE IS CLOSE CAPPED (PRT289) WITH A 6" BLACK JUMPER WIRE.
- 6) TERMINATE BOTH BLACK JUMPER ENDS WITH A RED MALE FIM (PRT330) LDW1.
- 7) THREAD WASHER IN PACKET FOR SWITCH (PRS267) RACK 22 UP SWITCH STEM SO WHEN SWITCH IS INSERTED INTO SCRAP REWIND FRONT BOTTOM HOUSING (D105 205.4) AS01 ENOUGH THREADS SHOW ON THE OUTER FRONT BOTTOM HOUSING TO HOLD ON-OFF PLATE (PRS266) RACK 21 AND THE HEX NUT IN THE SWITCH PACKET.
- 8) TIGHTEN SWITCH WITH "OFF" SECTION OF THE ON/OFF PLATE *DOWNWARD* AND THE SWITCH *KEYWAY* *DOWNWARD* TOWARD BREAK IN HOUSING.
- 9) TERMINATE SWITCH WIRES WITH (2) FIF CONNECTORS (PRT331). CONNECT THE BLACK JUMPER WIRES WITH MALE CONNECTORS TO THE SWITCH WIRES.
- 10) ATTACH RLT TOP BACK HOUSING WITH POWER CORD TO RIGHT SIDE PANEL USING (3) 8-32 X 1/2 FH THROUGH INNER SIDE PANEL COUNTERSINKS.
- 11) PLACE ELECTRICAL TAPE OR INSULATION TUBING (PRI163) CAB1 OVER THE WIRE CLOSED CAP CONNECTIONS, INCLUDING THE CAPACITOR CONNECTIONS. HEAT SHRINK TUBING. USE PRESS CLIPS AND CABLE TIES TO SECURE WIRES.
- 12) SECURE RELEASE LINER TAKE UP FRONT BOTTOM HOUSING TO THE RIGHT SIDE PANEL THROUGH COUNTERSINKS USING (3) 8-32 X 1/2 FH. THE SWITCH IS POSITIONED OUTWARD WITH THE "ON" PLATE UPWARD.
- 13) CHECK THAT ALL WIRE CONNECTIONS ARE CAREFULLY FOLDED, TUCKED AND SECURED WITH PRESS CLIPS AND CABLE TIES. IT IS CRITICAL THAT NO WIRES BECOME DAMAGED BY MOVEMENT IN THE HOUSING.

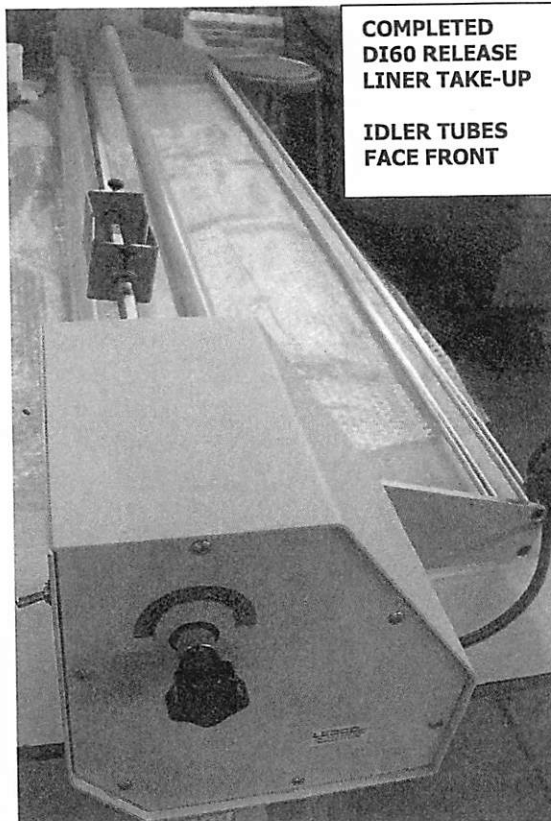
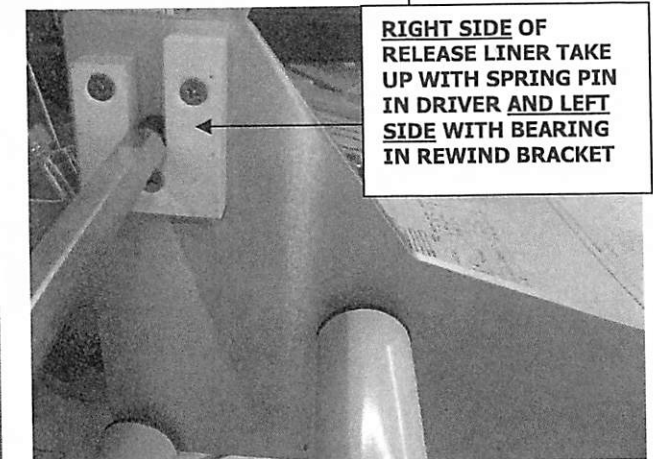
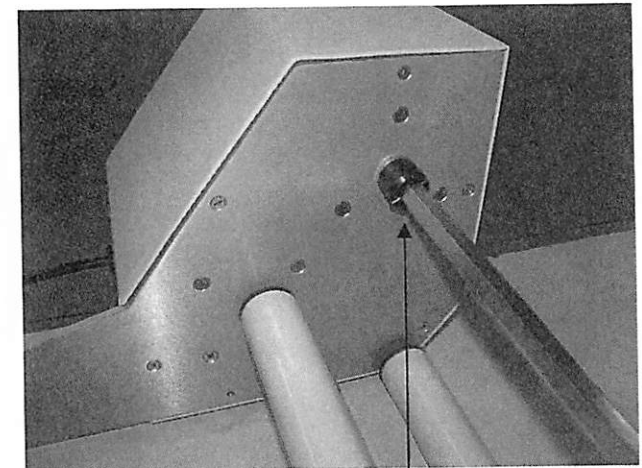
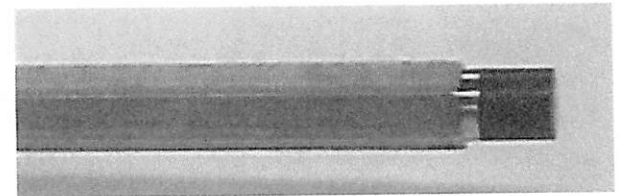
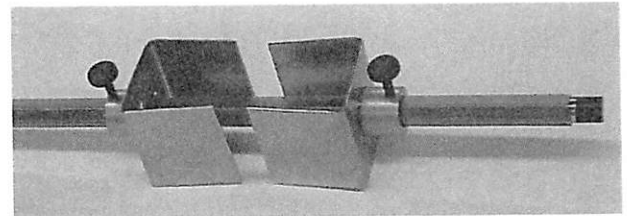
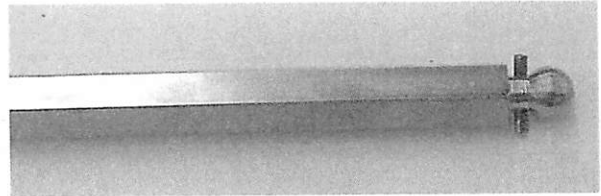


- 14) ON THE LOWER, REAR OUTER RELEASE LINER TAKE-UP HOUSING COVER (D105 207.4) RACK 22 ADHERE A SMALL LEDCO LOGO LABEL (LAB04) RACK 9.
- 15) ATTACH RLT HOUSING COVER TO TOP AND BOTTOM HOUSINGS WITH (6) 8-32 X 1/4 TH.
- 16) THREAD A 10-32 X 1/4 SET SCREW INTO A KNOB (PRK173) RACK 8. SLIDE KNOB ONTO FLAT OF TENSION NUT AND SECURE. TEST MANUAL FUNCTION OF REWIND.
- 17) ADHERE INCREASE/DECREASE LABEL (LAB42A) RACK 10 CENTERED OVER KNOB.
- 18) ADHERE THE SERIAL NUMBER LABEL WITH JOB ONTO THE REAR OF THE HOUSING, RIGHT OF THE POWER CORD.
- 19) PLUG IN RLT. SWITCH ON AND TEST DIRECTION AND REWIND. AFTER TESTING 220 VOLT RTL CUT OFF PLUG END.
- 20) FILL OUT RLTU INSPECTION TEST CARD.



# DI60 RELEASE LINER TAKE-UP SCRAP REWIND ASSEMBLY

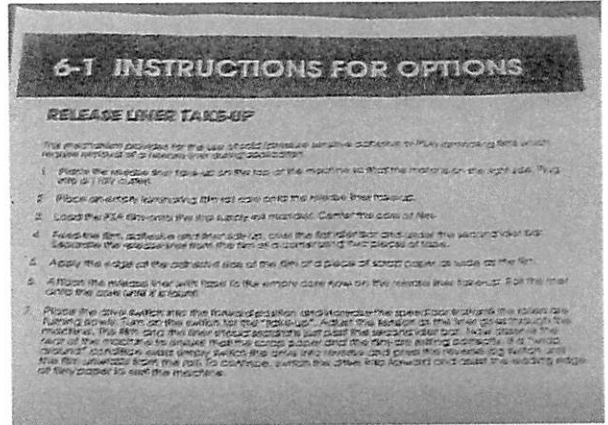
- 1) TAP OR ARBOR PRESS A 1/8 X 1 SPRING PIN INTO THE BALL END OF THE SCRAP REWIND SHAFT (D60 208.4) LOFT 2, LEAVING EQUAL AMOUNTS OF PIN SHOWING ON EITHER SIDE OF SHAFT.
- 2) TAP A BLACK PLASTIC BEARING (PRB071) RACK 8 ONTO THE OTHER END OF THE SCRAP REWIND SHAFT. IF THE BEARING IS TOO LOOSE, USE BLACK LOCTITE INSTANT ADHESIVE.
- 3) SLIDE (2) CORE GRIPPERS WITH HUBS (E850 207.6B) RACK 1 ONTO THE SHAFT WITH GRIPPERS FACING *INWARD* AND HUBS FACING *OUTWARD*. SECURE THE CORE GRIPPERS TO THE SHAFT WITH (2) SPI 3/4" SCREW KNOBS (PRK178) AS08.
- 4) INSERT THE SPRING PIN ON THE SHAFT INTO THE RIGHT SIDE REWIND DRIVER AND SLIDE THE PLASTIC BEARING ON THE SHAFT INTO THE REWIND BRACKET.



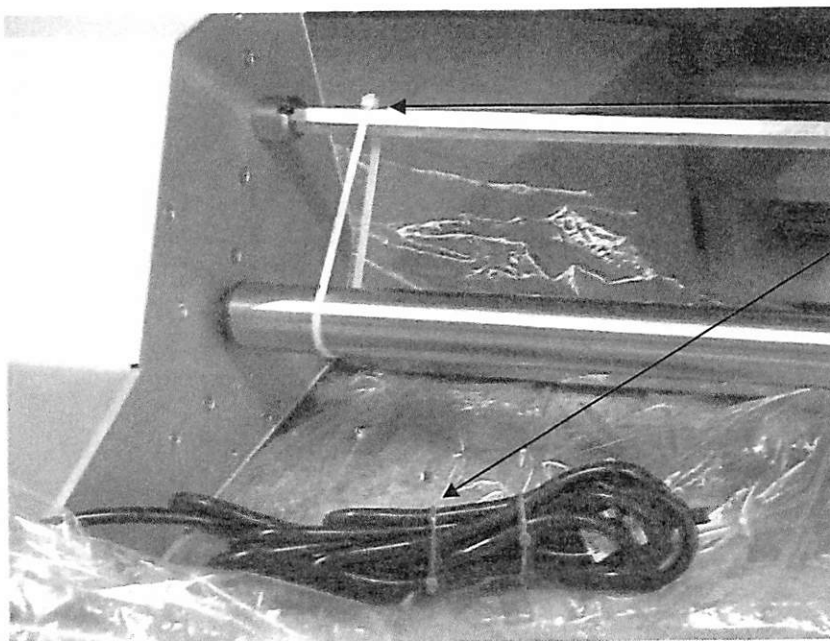
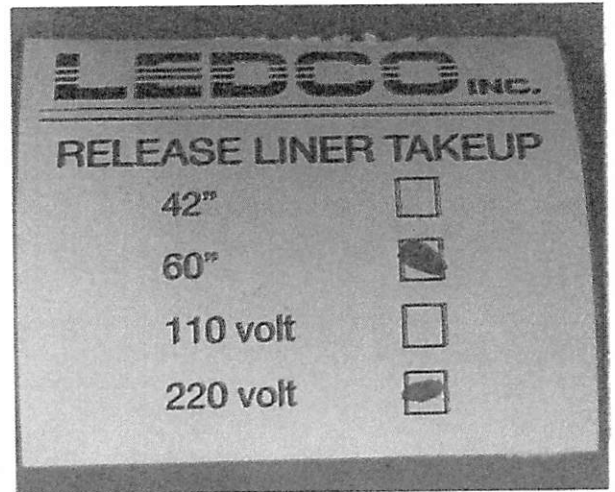
RIGHT SIDE OF  
RELEASE LINER TAKE  
UP WITH SPRING PIN  
IN DRIVER AND LEFT  
SIDE WITH BEARING  
IN REWIND BRACKET

# DI60 RELEASE LINER TAKE-UP SHIPPING PREPARATION

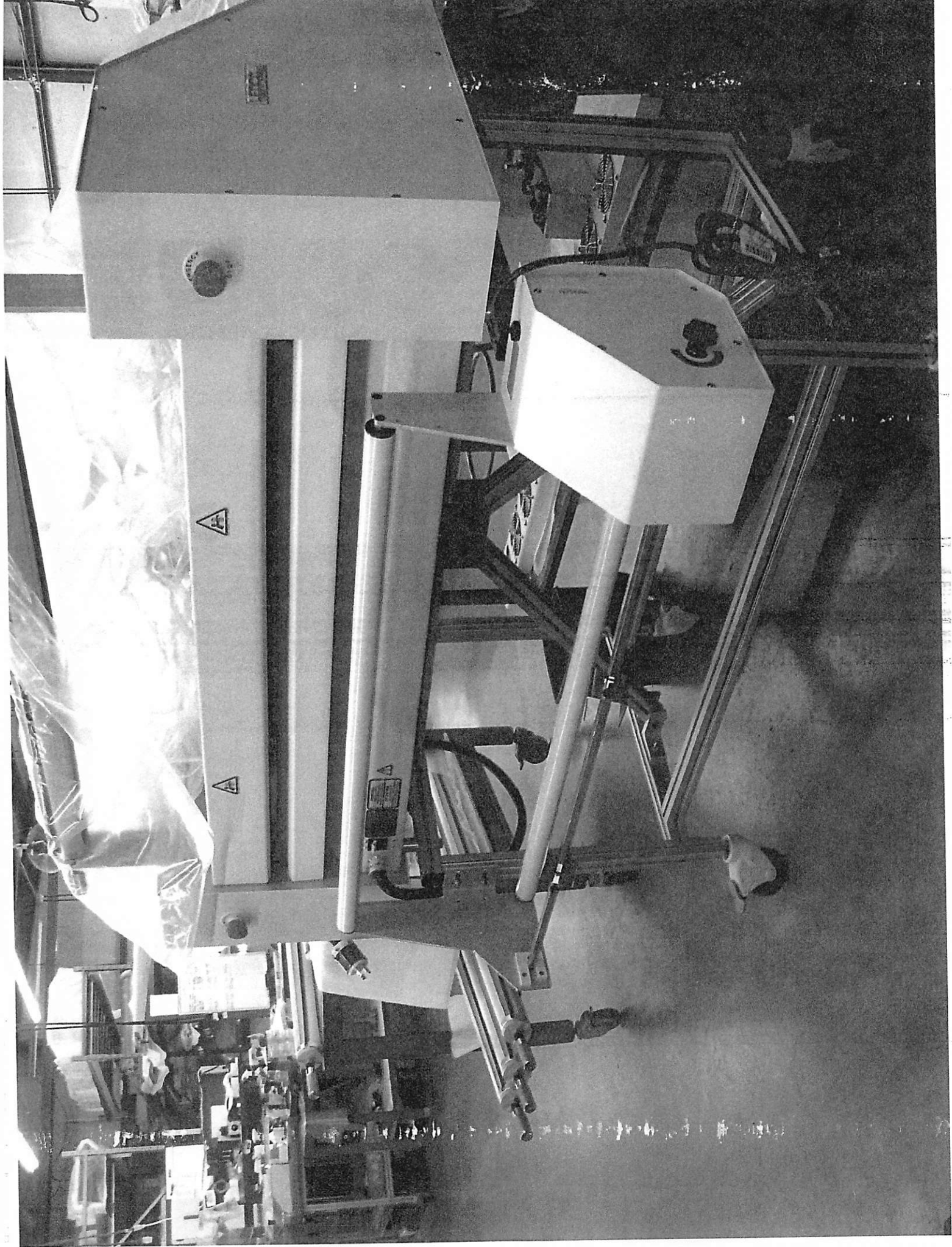
- 1) USING AN OILED CLOTH RUB IDLER TUBES AND SPREADER BARS.
- 2) USE CABLE TIES AND SECURE BOTH ENDS OF THE SCRAP REWIND SHAFT TO THE UPPER IDLER TUBE. USE CABLE TIES ALSO TO SECURE POWER CORD.
- 3) PLACE LARGE CLEAR PLASTIC BAG AROUND RELEASE LINER TAKE-UP AND INSERT INSTRUCTION SHEET IN BAG.
- 4) PREPARE (2) IDENTIFICATION LABELS.

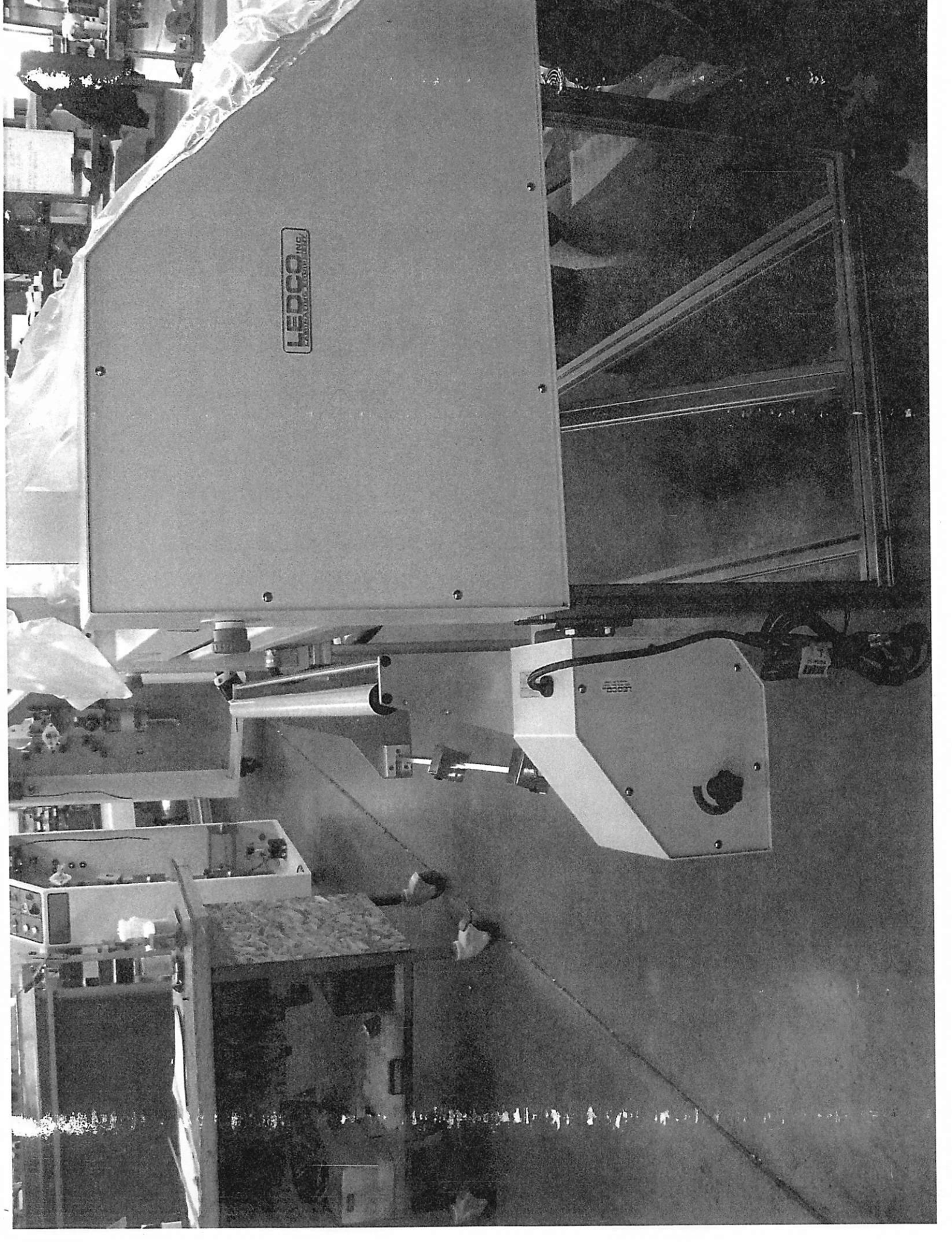


*LAB 500*

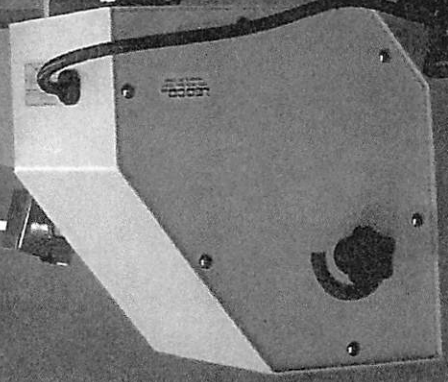


**CABLE TIE SECURING SCRAP REWIND BAR TO IDLER TUBE.**  
 ~~~~~  
**CABLE TIES ON POWER CORD.**

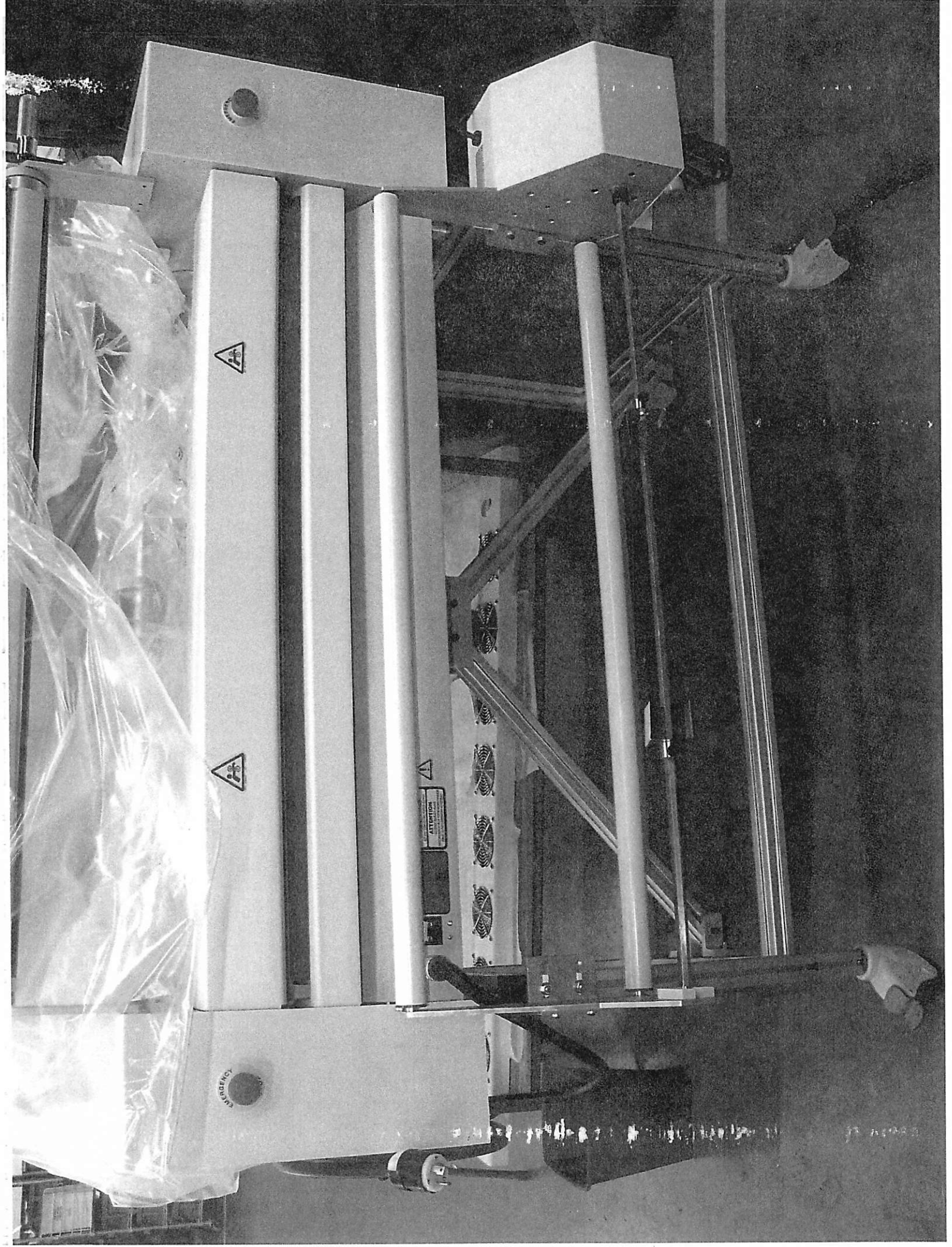




LEDSO  
CANADA'S FIRST COPY LINE







REAR

DANGER

DANGER

ATTENTION

REAR



