

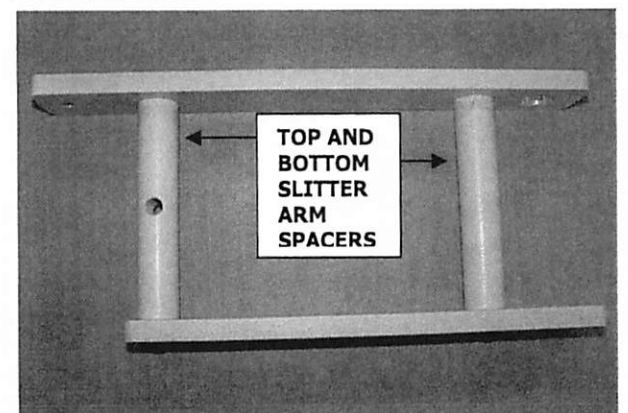
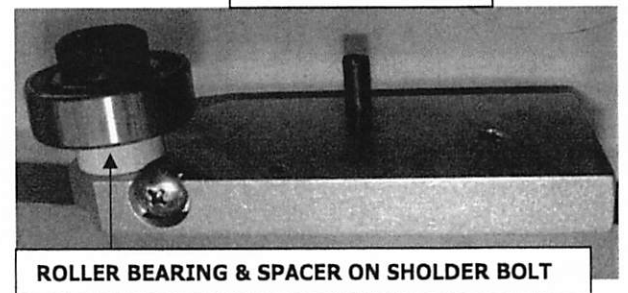
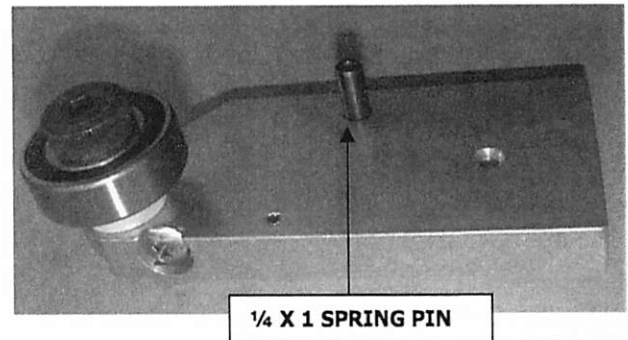
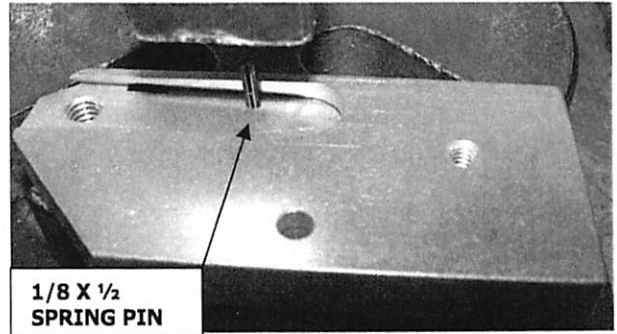
EHR SIGNMASTER PRE-FEED SLITTER

ASSEMBLY PROCEDURES

SEPTEMBER 2007

PREFEED SLITTER OPTION EHR SIGNMASTER

- 1) **PREPARE THE PREFEED SLITTER OPTION SLITTER KNIFE HOLDER (EP30 186.4) RACK 10 BY ARBOR PRESSING A $1/8 \times 1/2$ SPRING PIN INTO THE CHANNEL SIDE, FLUSH. FROM THE FLAT SIDE ARBOR PRESS A $1/4 \times 1$ SPRING PIN, FLUSH WITH CHANNEL SIDE.**
- 2) **PLACE A ROLLER BEARING (PRB052) RACK 8 ON A $1/2 \times 5/8$ SHOULDER BOLT AS13. FROM RACK 10 TAKE THE ENLARGED (AS OF 2014) SLITTER FOLLOWER SPACER (EP30 193.4). NEXT TO THE ROLLER BEARING, ADD THE SLITTER FOLLOWER SPACER. THREAD THE ASSEMBLED SHOULDER BOLT INTO THE SLITTER KNIFE HOLDER FROM THE $1/4 \times 1$ SPRING PIN SIDE. THE ROLLER BEARING WILL SPIN, THE SPACER WILL NOT SPIN. LOOSELY INSERT A 10-32 X $1/4$ TRUSSHEAD INTO THE THREADS ALONG THE SLITTER KNIFE HOLDER BY THE FOLLOWER SPACER.**
- 3) **FROM RACK 10 CONNECT THE LONGER LEFT SLITTER ARM (EP30 188.4L) TO THE SHORTER RIGHT SLITTER ARM (EP30 188.4R) THROUGH THE OPENINGS CLOSEST TO THE LARGER SLITTER SHAFT HOLES. CONNECT WITH THE BOTTOM SLITTER ARM SPACER (EP30 187.4B) LOOSELY WITH (2) $1/4$ -20 X $3/4$ BH, LOCTITE ON THREADS. LAY ON FLAT SURFACE TO ASSURE ALIGNED SIDES.**
- 4) **CONNECT THE SLITTER ARMS AT THE UNEVEN END WITH THE CENTER THREADED, TOP SLITTER ARM SPACER (EP30 187.4T) RACK 10. THE CENTER THREADS ON THE TOP SLITTER SPACER ALIGN OUTWARD AS PICTURED. USE (2) $1/4$ -20 X $3/4$ BH, WITH LOCTITE ON THREADS. TIGHTEN TOP AND BOTTOM SPACERS NOW.**



5) FROM RACK 10 THREAD A 10-32 X $\frac{3}{4}$ SET SCREW INTO A SLITTER WEIGHT (EP30 189.4). INSERT THE *UNTHREADED* END OF A SLITTER WEIGHT ARM (EP30 190.4) THROUGH THE SLITTER WEIGHT AND SNUG SET SCREW ON SLITTER WEIGHT ARM. THE SLITTER TENSION WILL BE ADJUSTABLE BY MOVING THE SLITTER WEIGHT UP AND DOWN THE SLITTER ARM USING THE SET SCREW.

6) LOCTITE THE END THREADS OF THE SLITTER WEIGHT ARM AND THREAD INTO THE TOP SLITTER ARM SPACER. ORIENT WITH THE LONGER LEFT SLITTER ARM ON THE LEFT, AS PICTURED. TIGHTEN WITH A WRENCH, BUT BE CAREFUL NOT TO SCRATCH THE SLITTER ARM WITH THE WRENCH.

7) LOCTITE THREADS ON A $\frac{1}{4}$ -20 X $\frac{3}{4}$ BH AND SECURE THE SLITTER KNIFE HOLDER ASSEMBLY TO THE OUTER LONGER LEFT SLITTER ARM. REST THE $\frac{1}{4}$ X 1 SPRING PIN ON THE SLITTER ARM, OPPOSITE THE SLITTER WEIGHT.

8) SLIDE A $\frac{3}{4}$ " SPLIT SHAFT COLLAR (PRC097A) RACK 8 ONTO AN EHR44 SLITTER SHAFT (EHR44 191.4) LOFT 2. SLIDE THE PREFEED SLITTER ARM ASSEMBLY ONTO THE SLITTER SHAFT, *KNIFE HOLDER FACING OUTWARD*, AND ANOTHER $\frac{3}{4}$ " SPLIT SHAFT COLLAR. CENTER THESE PIECES ON THE SLITTER SHAFT AND TIGHTEN THE $\frac{3}{4}$ " SPLIT SHAFT COLLARS.

9) SECURE THE (2) EHR44 SLITTER SHAFTS, WITH THE *ASSEMBLED SHAFT* TOWARD THE REAR, BETWEEN THE (2) SLITTER BRACKETS (EP30 185.4) RACK 10. USE THE HOLES CLOSER TOGETHER ON THE SLITTER BRACKET ENDS. THE ROLLER BEARING FACES THE EXCESS BRACKET SIDE. THE ASSEMBLED SLITTER SHAFT SECURES TO THE *CENTERED* HOLE, WITH THE UNASSEMBLED SLITTER SHAFT CLOSER TO THE EDGE OF THE SLITTER BRACKET, WHICH WILL BE THE FRONT. USE (4) $\frac{1}{4}$ -20 X $\frac{3}{4}$ BH WITH LOCTITE ON THREADS TO SECURE SLITTER SHAFTS.

