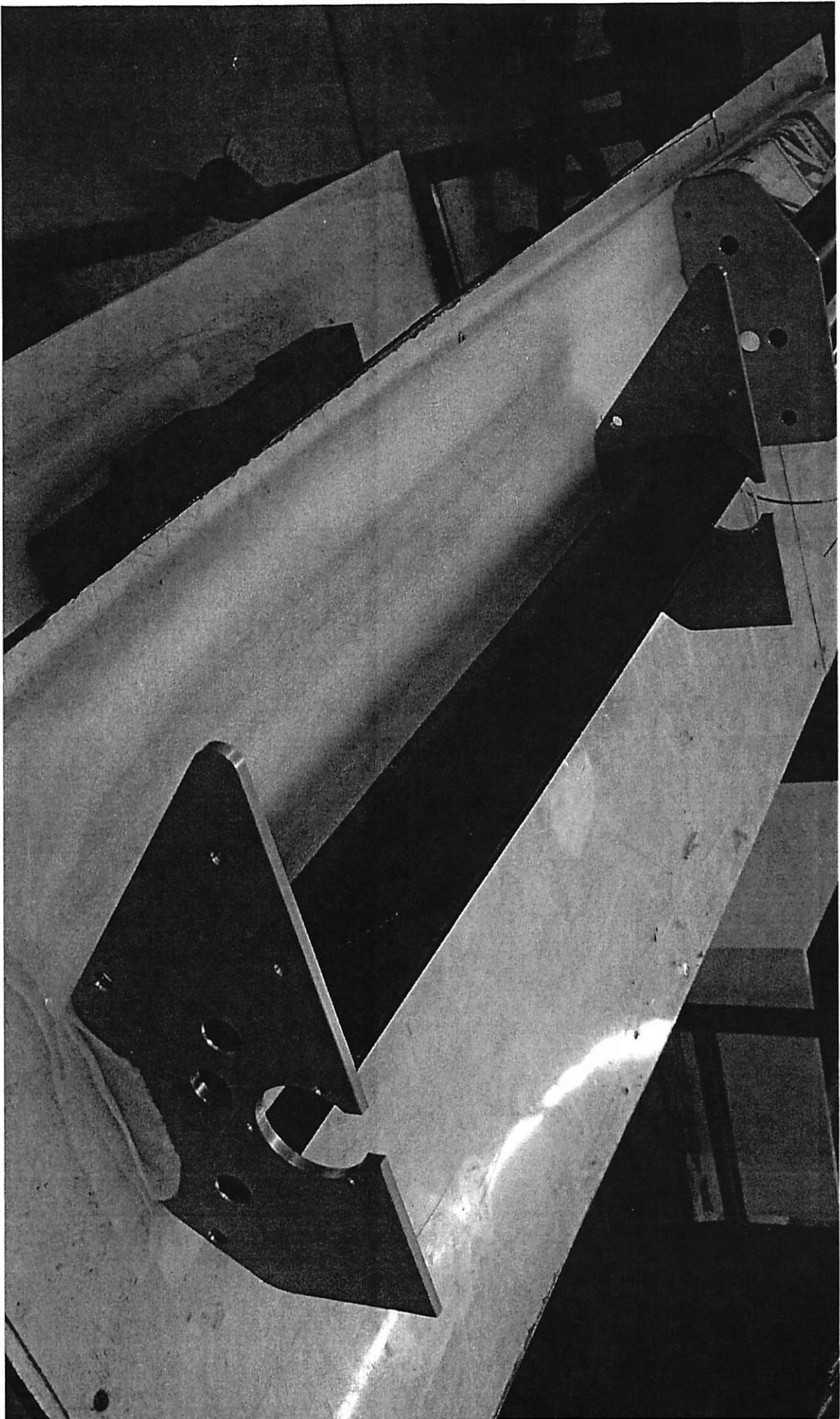


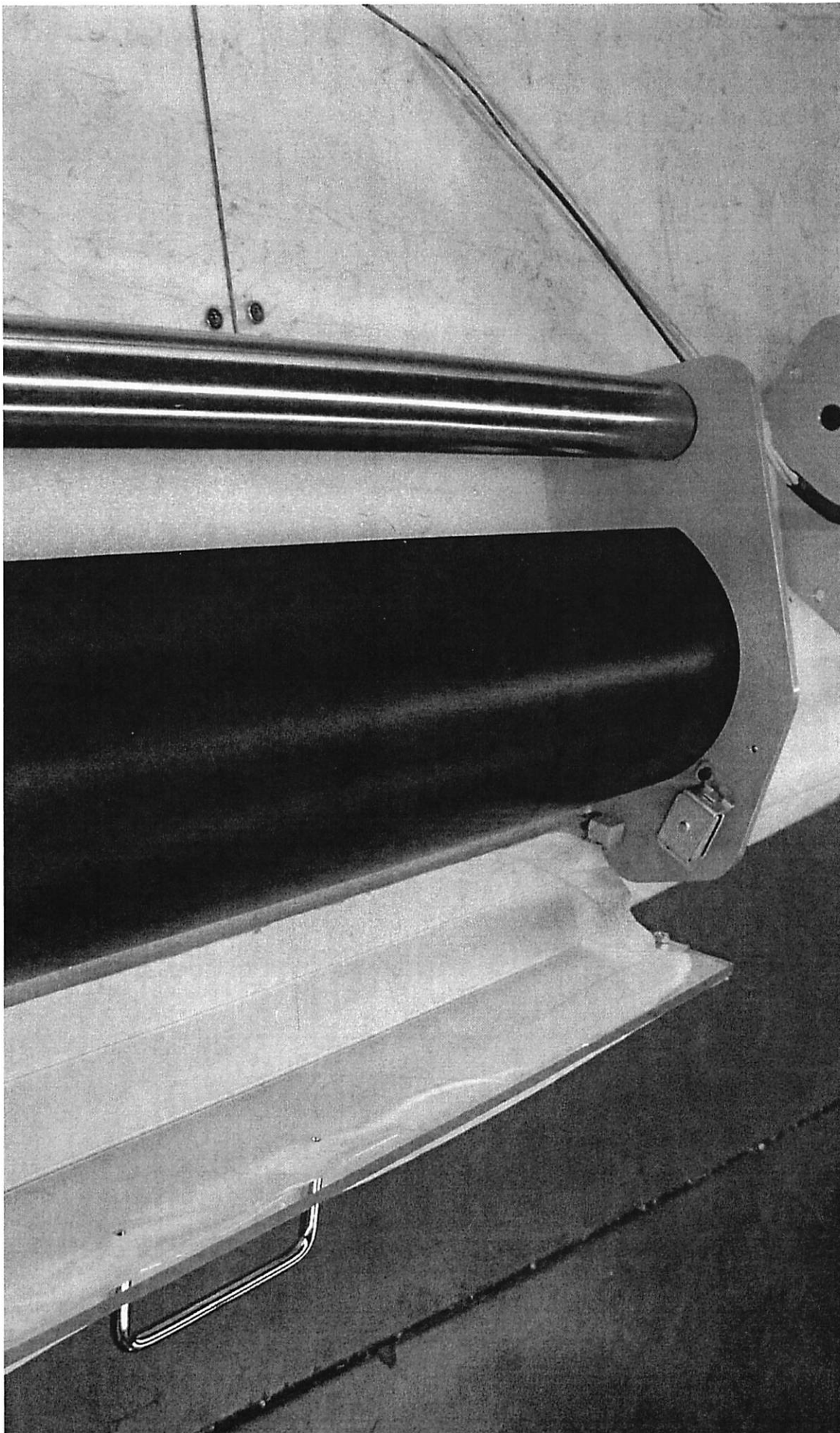
# **HRD44 *REAR* RELEASE LINER TAKE-UP WITH SLITTER**

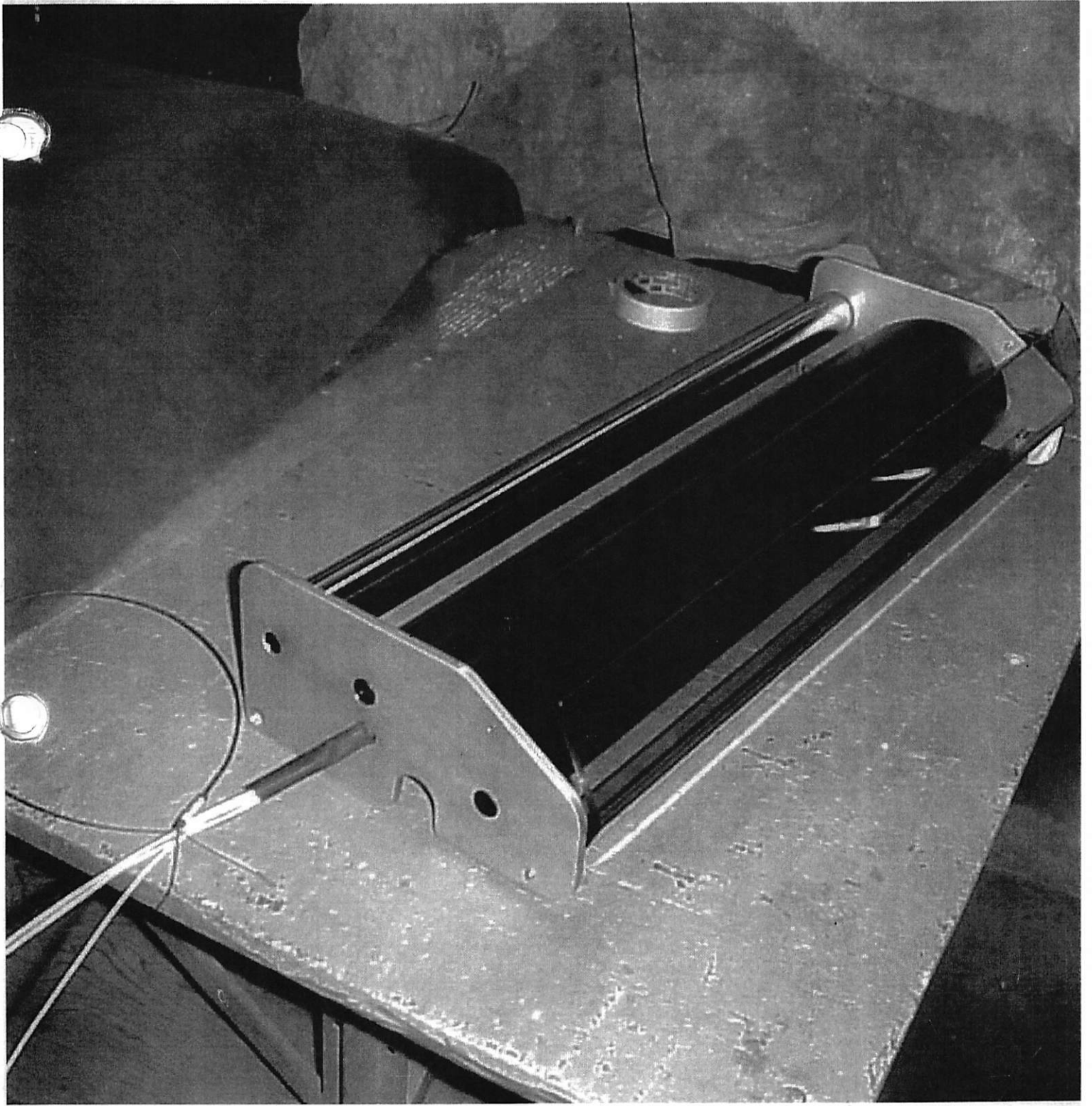
## **ASSEMBLY PROCEDURES**

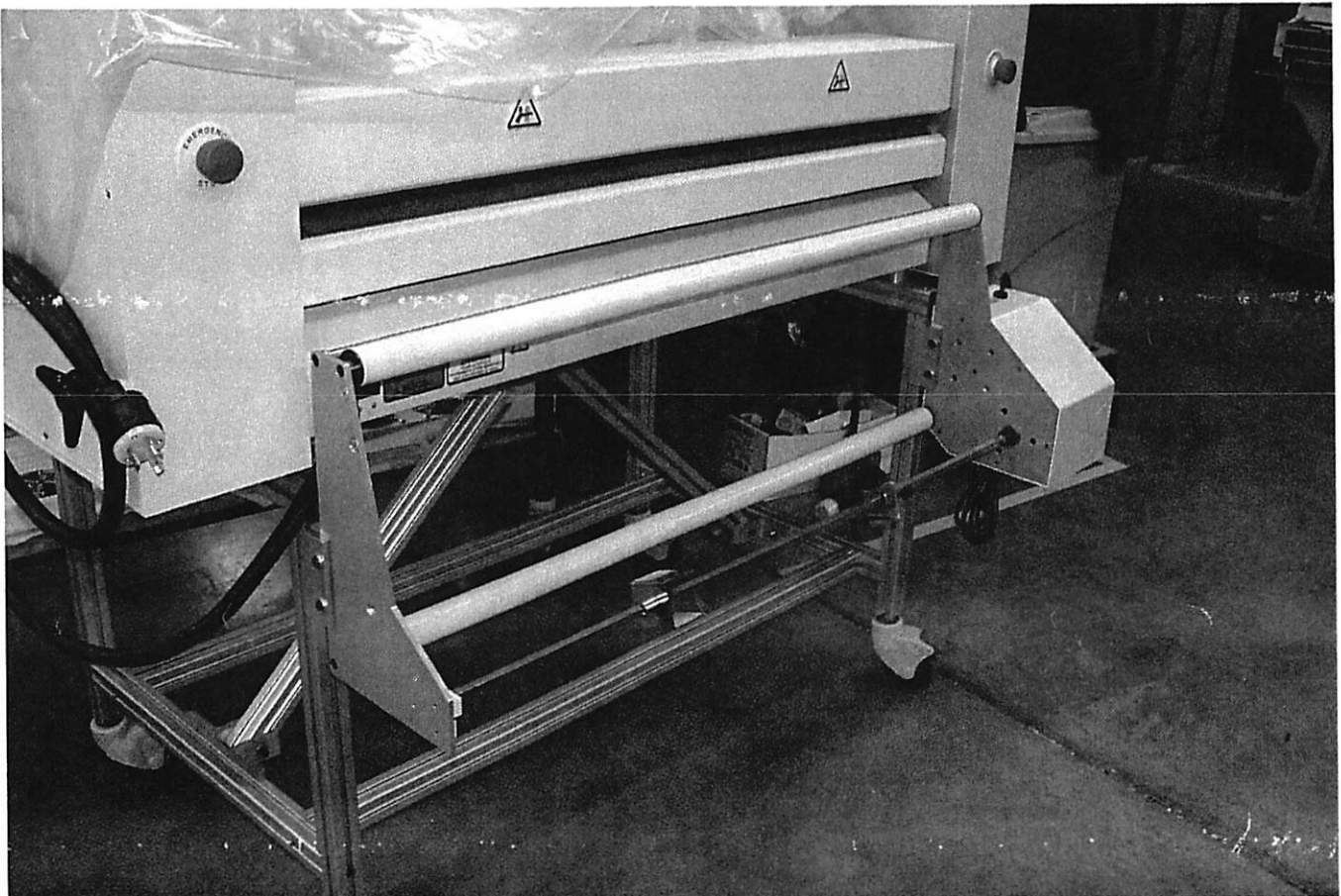
**August 2018**

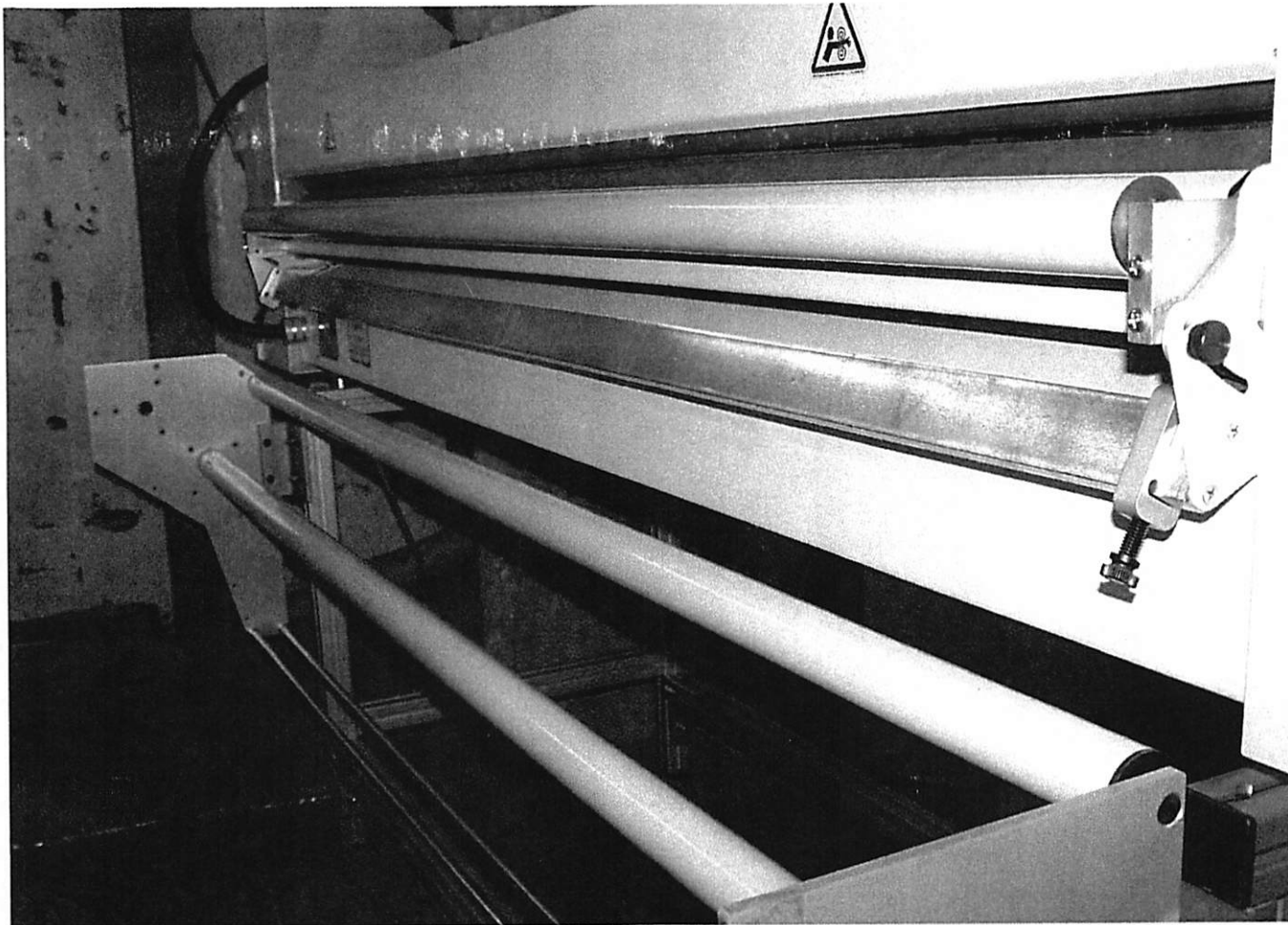


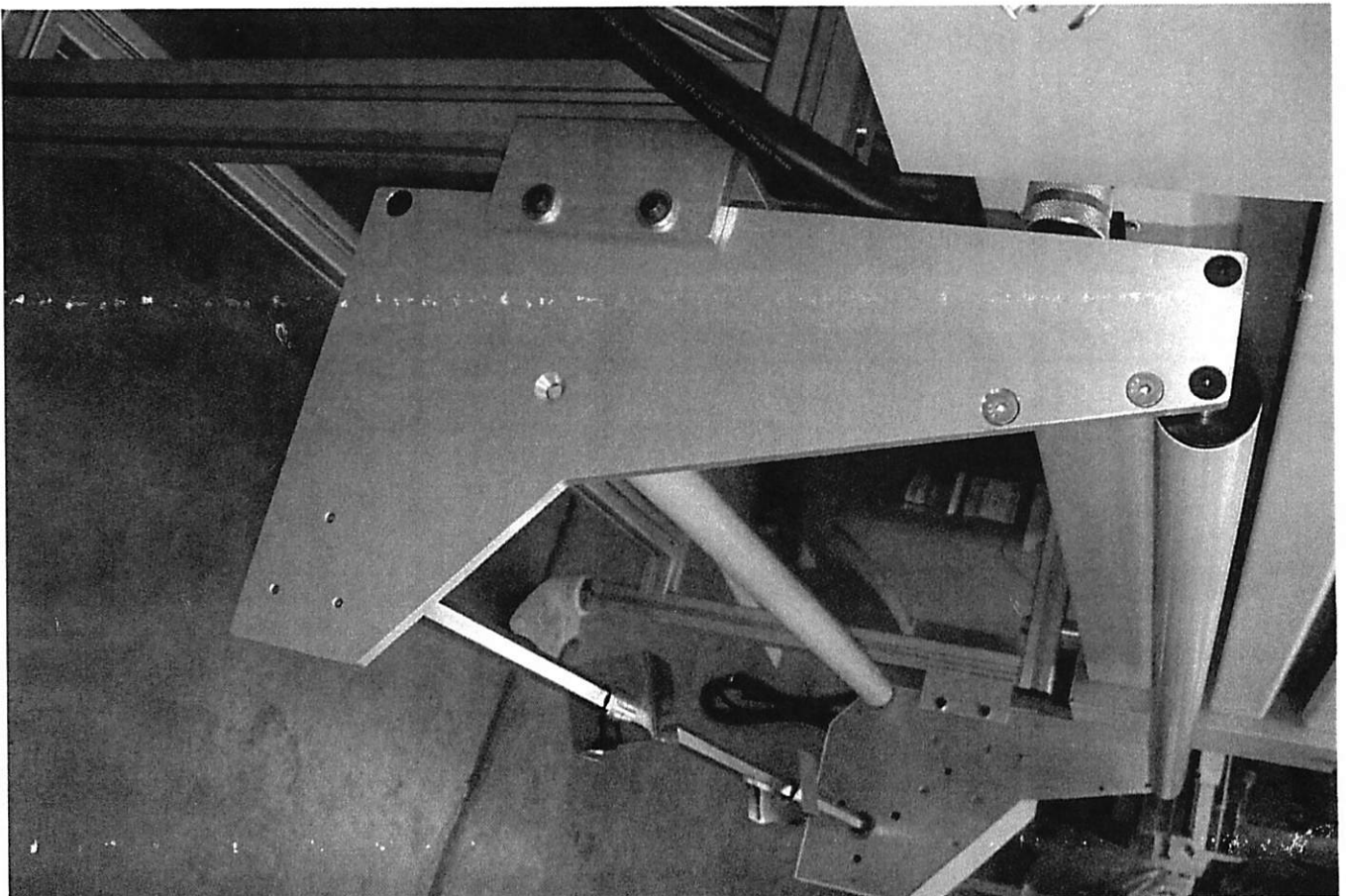
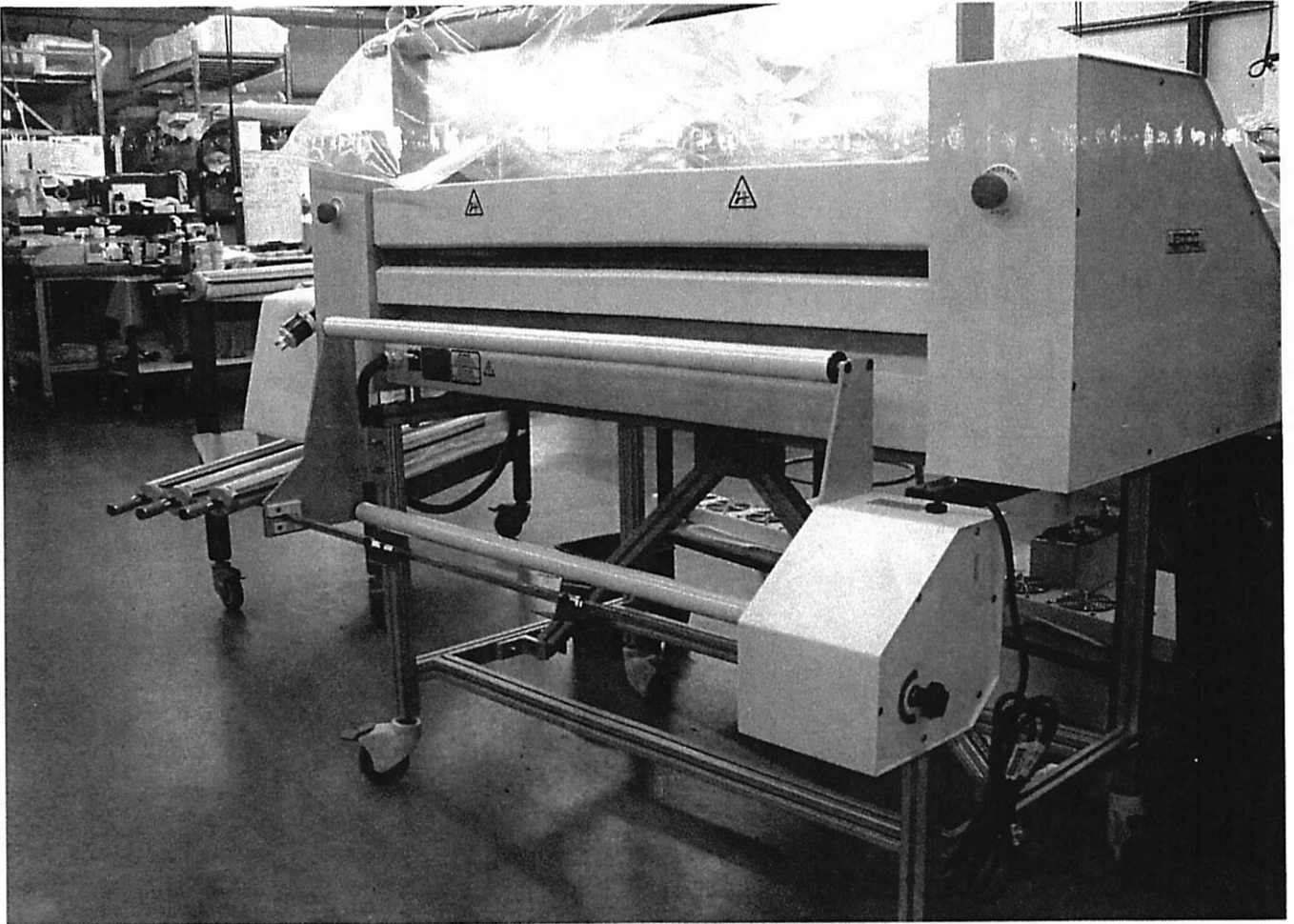




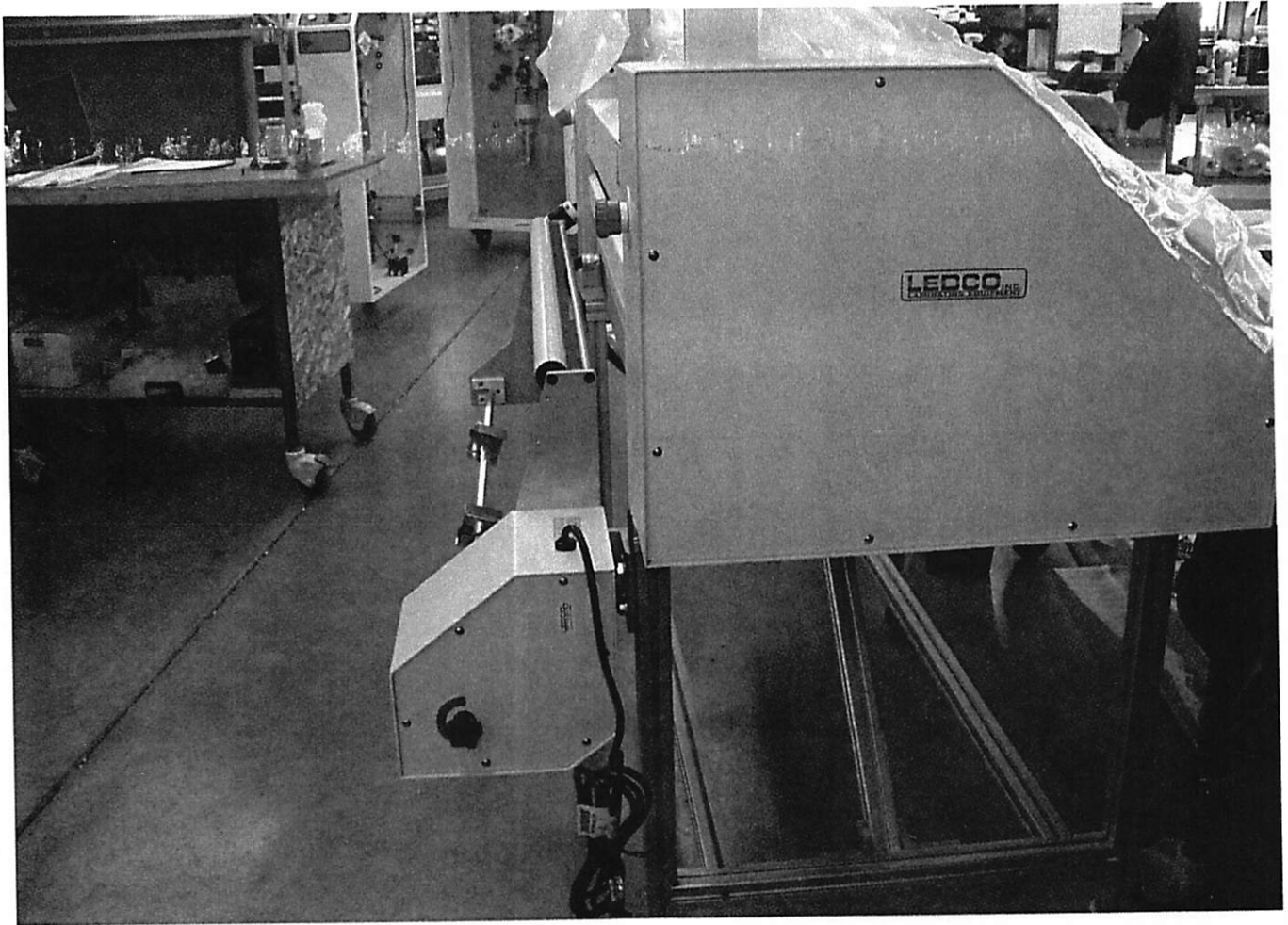


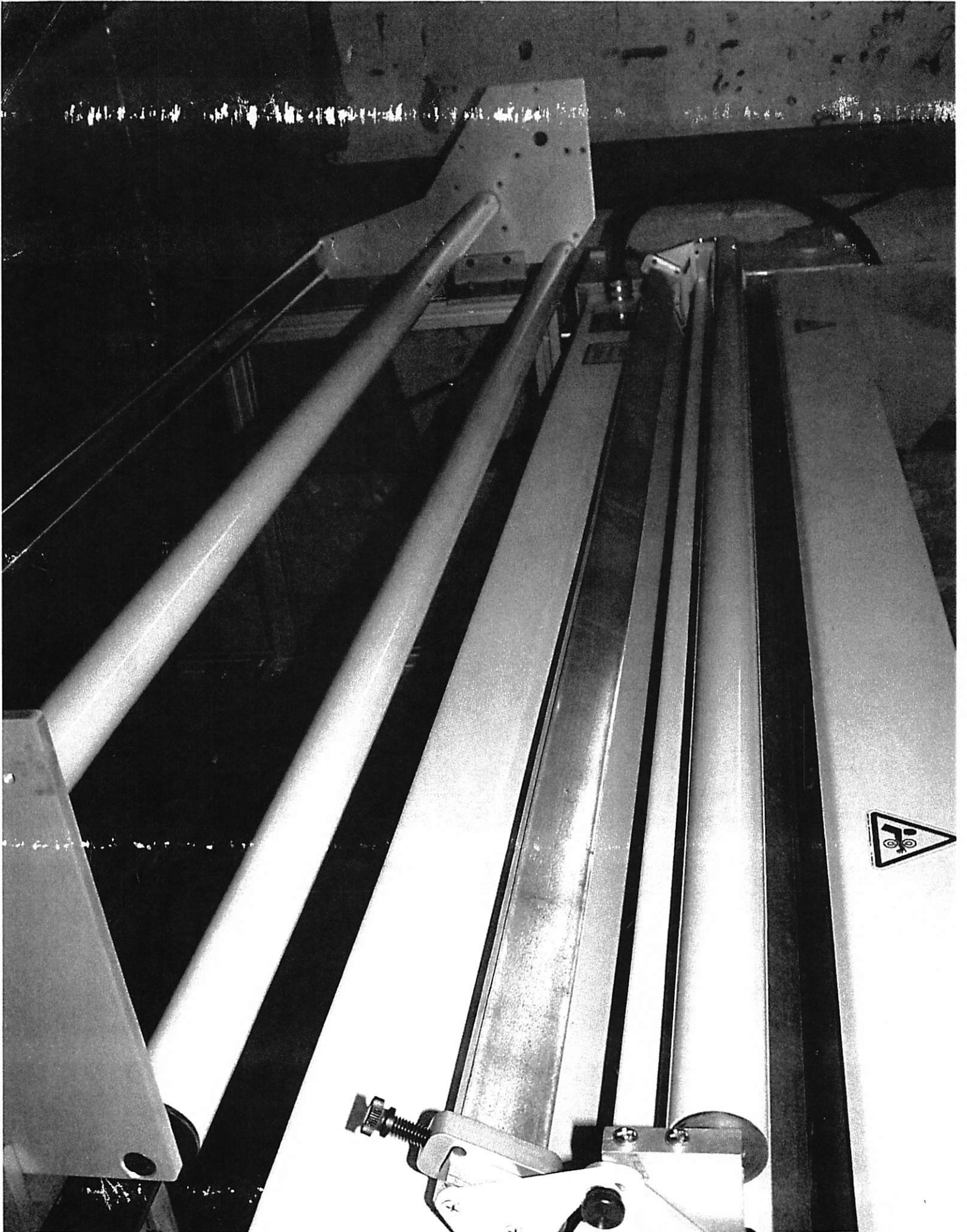






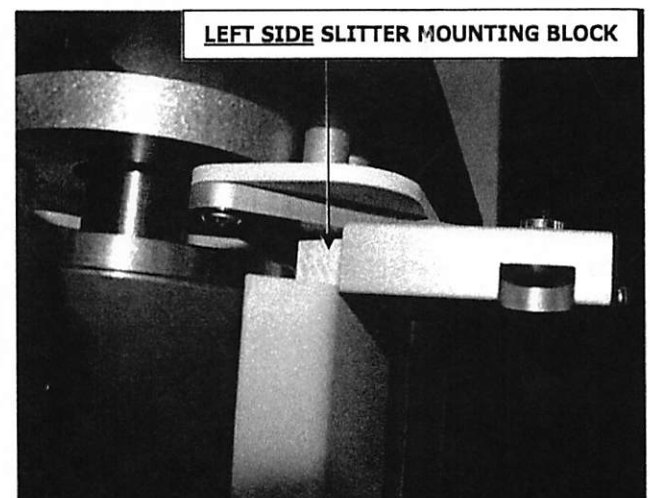
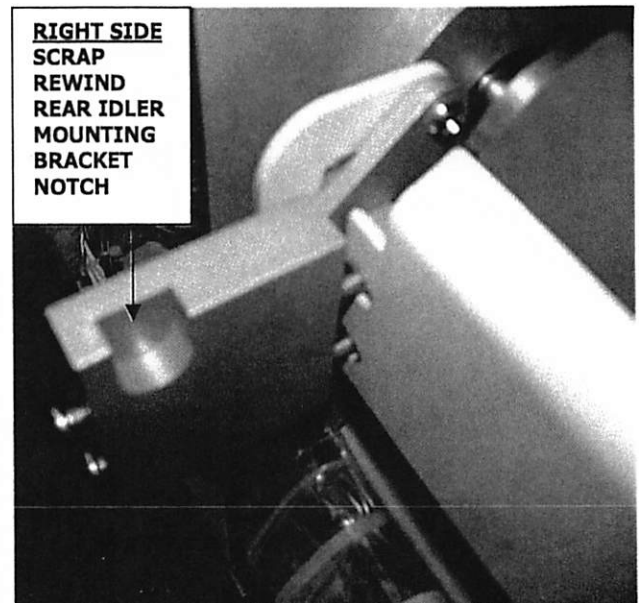
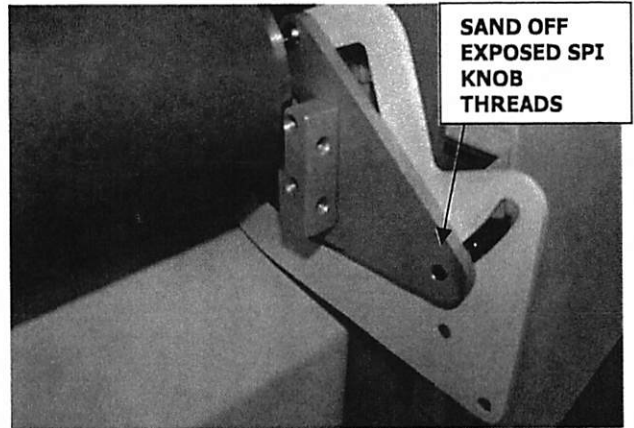






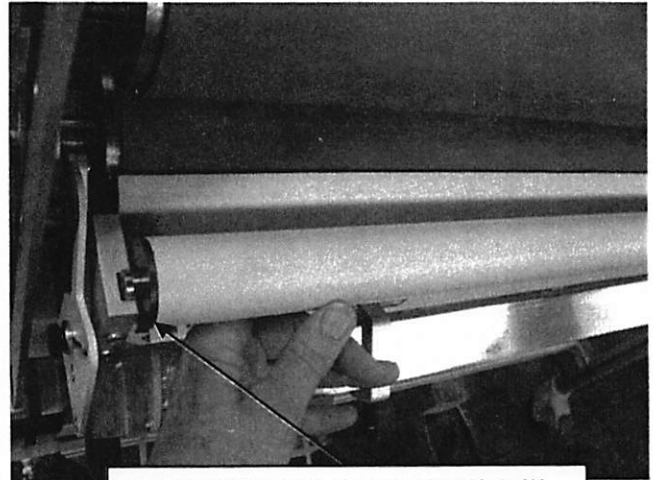
# HRD44 REAR RELEASE LINER TAKE UP WITH SLITTER

- 1) IF THE HRD44 HAS BOTH SLITTER AND REAR RELEASE LINER TAKE UP OPTIONS, AN ADDITIONAL IDLER TUBE MUST BE ADDED SO THE EXITING FILM DOES NOT CATCH ON SLITTER BAR. FOLLOW SLITTER OPTION ASSEMBLY PROCEDURES THROUGH NUMBER 5). \*\* SAND OFF ANY EXPOSED THREADS ON SPI KNOBS (PRK177). THE SCRAP REWIND MOUNTING BRACKET IS FLUSH TO INNER SLITTER MOUNTING BRACKET. REDUCE THREADS ON (2) SLITTER THUMB SCREWS (PRK184) TO 1/2". SEND CUSTOMER (2) EXTRA ALSO.
- 2) FROM AS22C TAKE A SCRAP REWIND REAR IDLER MOUNTING BRACKET LEFT (D105 209.4L) AND A SCRAP REWIND MOUNTING BRACKET RIGHT (D105 210.4R). \*\*REMEMBER THE LEFT GOES ON THE RIGHT SIDE AS YOU FACE THE REAR OF THE HRD44. ORIENT THE SCRAP REWIND MOUNTING BRACKET WITH THE NOTCH UPWARD AND AWAY FROM THE HRD44.
- 3) INSERT (2) 10-32 X 2 1/2 PHMS THROUGH THE SCRAP REWIND MOUNTING BRACKET, WITH THE ANTI-WRAP CHANNELS FITTING INWARD ON THE THREADS. START BOTH SCREWS INTO THE SLITTER MOUNTING BLOCK. THE CLEARANCE HOLES IN THE SCRAP REWIND MOUNTING BRACKET MAY NEED TO BE OPENED WITH A DRILL TO ALIGN WITH THE SLITTER MOUNTING BLOCK. TIGHTEN BOTH SCREWS ONCE THEY ARE STARTED.
- 4) THE MACHINE SHOP WILL NEED TO TRIM THE END OF AN EHR44 FEED TABLE IDLER TUBE (EHR44 054.4) AS15 SO 43 15/16" REMAIN AND TRIM OFF 1/8" ON AN EHR44 FEED TABLE IDLER SHAFT (EHR44 109.4) LOFT 2 TO FIT INTO THE NOTCHES ON THE SCRAP REWIND MOUNTING BRACKETS.
- 5) TAP A NYLATRON IDLER BEARING

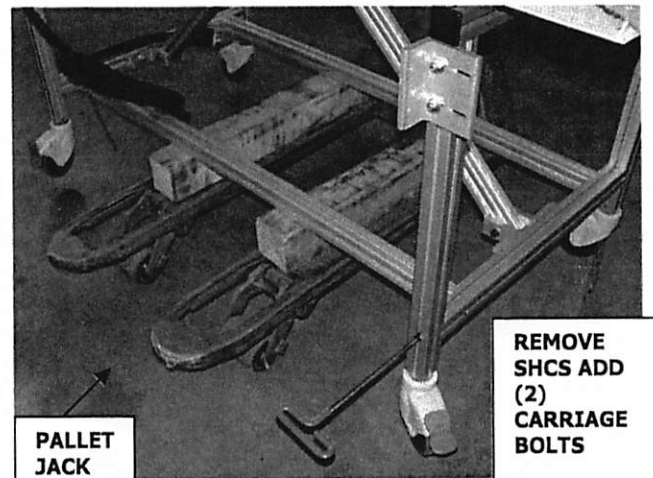


(PRB086A) AS09 INTO BOTH ENDS OF THE TRIMMED FEED TABLE IDLER TUBE. INSERT THE TRIMMED FEED TABLE IDLER SHAFT THROUGH THE NYLATRON IDLER BEARINGS. FIT THE EXPOSED IDLER SHAFT INTO THE SCRAP REWIND MOUNTING BRACKET NOTCHES. THE IDLER TUBE MUST SPIN FREELY.

- 6) TO ACCOMMODATE THE 42" REAR RELEASE LINER TAKE UP, (2) RELEASE LINER MOUNTING BRACKETS (EHR44 135.4B) LOFT 1 ARE ADDED TO THE REAR STAND LEGS. BOTH REAR RELEASE LINER MOUNTING BRACKETS FACE THE SAME DIRECTION. LIFT THE HRD44 WITH A PALLET JACK. PARTIALLY UNTHREAD REAR CASTERS. REMOVE THE 5/16-18 SOCKETHEAD HOLDING REAR THE LEG TO WIDTH SPANNER. SLIDE (2) 5/16-18 X 1 CARRIAGE BOLTS UP THE REAR LEG CHANNEL, ABOVE SHCS. REPLACE THE SHCS. ORIENT THE RLTU MOUNTING BRACKETS SO CHANNEL IS RIGHT OF CARRIAGE BOLTS. MEASURE AND SNUG BOLTS 2 5/8" BETWEEN TOP OF STAND AND TOP OF GUSSET/BACKET. USE A 5/16 FLAT WASHER AND 5/16-18 HEX NUTS.



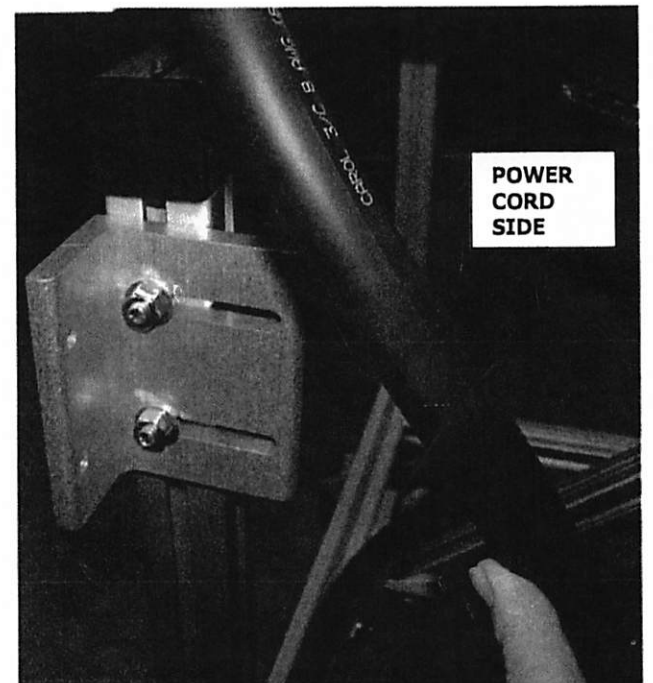
FIT EXCESS IDLER SHAFT INTO NOTCH



PALLET JACK

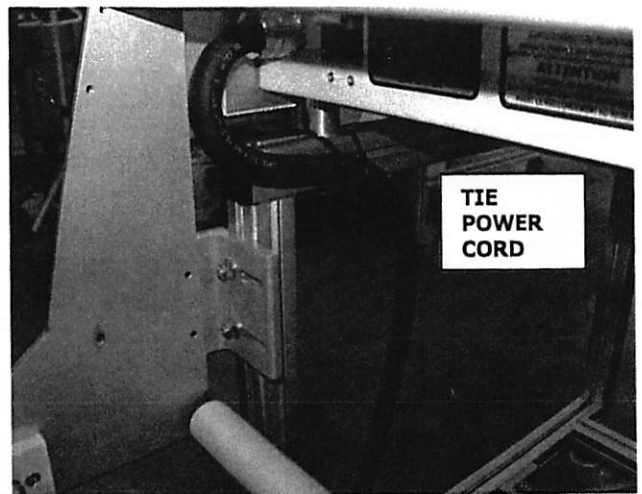
REMOVE SHCS ADD (2) CARRIAGE BOLTS

- 7) USING THE 42" RLTU FOR THE HRD44 REQUIRES IDLER TUBE AND SPREADER BAR RELOCATIONS. REMOVE THE IDLER TUBE, WITH SPREADER BAR AND (2) SPACERS LOCATED TOWARD THE MIDDLE OF THE RLTU PANELS. LEAVE THIS LOCATION EMPTY. THE 1/4-20 FHSB BEHIND THE RLTU MOTOR WILL NEED TO BE DREMELED OFF AND THE HEAD REMOVED FROM BEHIND THE MOTOR USING A MAGNET. REMOVE BOTH SPREADER BARS FROM THE SHORTER END OF THE RLTU PANELS. ADD THE IDLER TUBE TO THE SPREADER BAR WITH SPACERS AND LOCATE ON THE UPPER END OF THE SHORTER PANEL SIDE. THIS WILL FACE UPWARD WHEN ATTACHED.

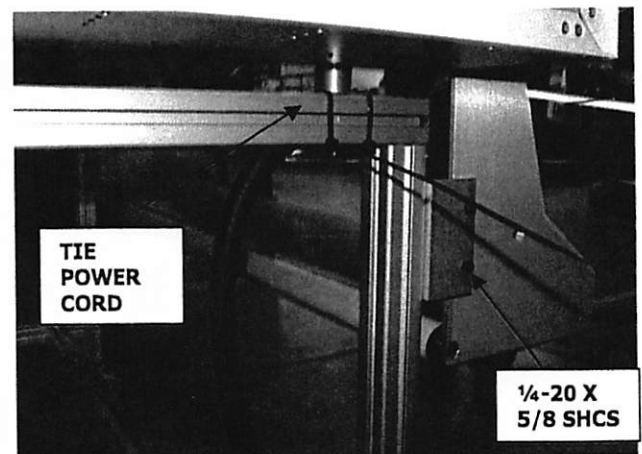


POWER CORD SIDE

8) THE HRD44 POWER CORD WILL LOCATE INWARD, BEHIND THE RLTU MOUNTING BRACKETS. USE (2) HEAVY CABLE TIES SHIPPING AND SECURE THE POWER CORD ON BOTH SIDES OF THE FOOT MOUNTING SHAFT EXTENSION. TRIM CABLE TIE ENDS.



9) IT TAKES (3) PEOPLE TO ADJUST THE REAR RELEASE LINER TAKE UP. THE SHORTER RLTU SIDE PANEL FACES UPWARD. WHILE (2) PEOPLE HOLD THE RLTU, THE THIRD PERSON ADJUSTS THE RLTU TO THE RLTU MOUNTING BRACKETS, ONE AT A TIME. INSERT (2) 1/4-20 X 5/8 SHCS THROUGH THE THROUGH THE RLTU MOUNTING BRACKETS INTO THE RLTU PANELS.



10) THE MACHINE SHOP MUST MODIFY THE RLTU SCRAP REWIND BRACKET BY COUNTERSINKING THE OPPOSITE SIDE FOR THE (3) 10-32 FHMS. THE SPI KNOB (PRK179) THREADS UPWARD FROM THE BOTTOM TO HOLD THE SHAFT IN PLACE.

11) WHEN THREADING THE FILM TO USE THE RLTU WITH REAR SLITTER, THE EXITING FILM LAYS OVER THE UPPER (2) IDLER TUBES AND UNDER THE LOWER IDLER TUBE, THEN SECURES TO THE SCRAP REWIND TUBE.

