

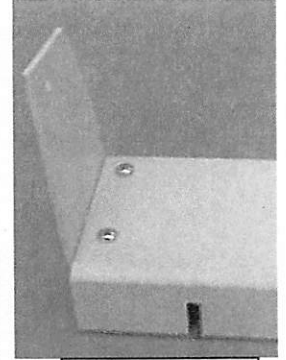
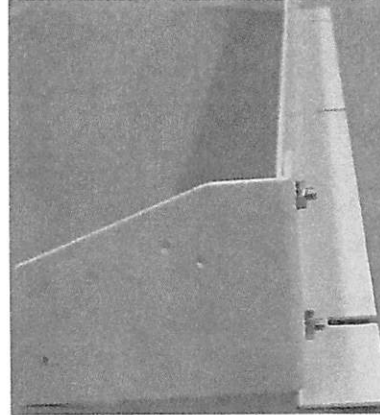
EP25 PRE-MASK PRE-FEED SLITTER

ASSEMBLY PROCEDURES

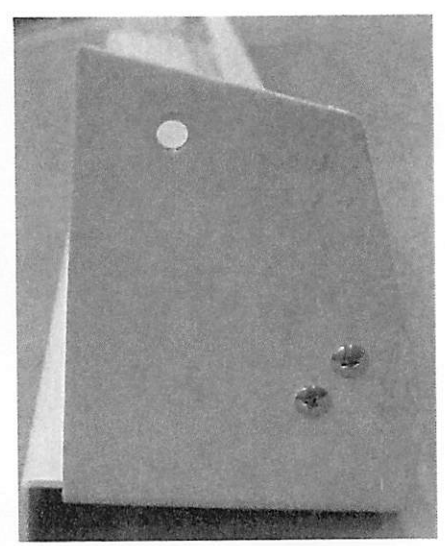
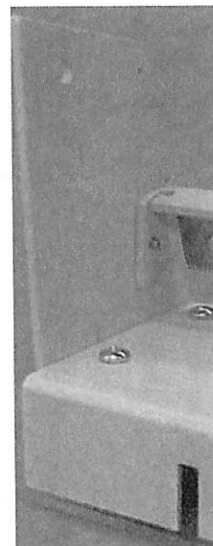
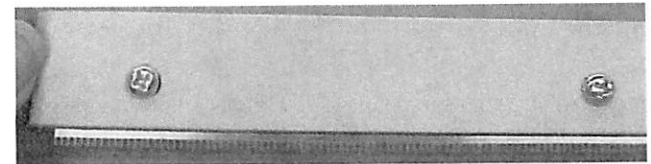
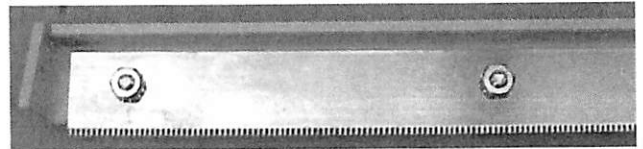
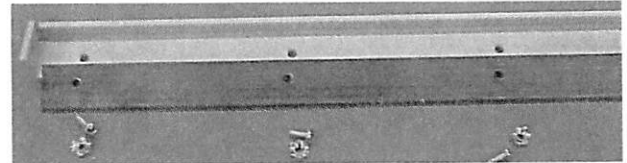
FEBRUARY 2012

PRE-MASK EP25 PRE-FEED SLITTER ASSEMBLY

- 1) ATTACH SLITTER ATTACHMENT RIGHT BRACKET C (EP25 103.4R) RACK 9 AND SLITTER ATTACHMENT LEFT BRACKET C (EP25 103.4L) RACK 9 TO EXIT TABLE C (EP25 102.4) AS05 USING (4) 10-32 X 3/8 RH AND (4) 10-32 KEPS HEX NUTS. THE STRAIGHT SIDE OF THE BRACKET GOES CLOSER TO BEND IN EXIT TABLE. RIGHT BRACKET HAS TWO #6 TAPPED HOLES ON ANGLED SIDE. KEPS NUTS GO UNDERNEATH EXIT TABLE INTO BEND OF BRACKETS.
- 2) **CAREFULLY** ATTACH CUT OFF BLADE C (0500 111.4) AS05, *WHICH IS VERY SHARP*, TO INSIDE AREA OF CUT OFF BRACKET COMPLETE AND PAINTED (0500 112.4) AS05 USING (6) 8-32 X 3/8 RH THROUGH CUT OFF BRACKET INTO CUT OFF BLADE AND (6) 8-32 KEPS HEX NUTS TIGHTENED ONTO BLADE. BE SURE HOLES LINE UP. ADD (1) 8-32 X 1 SHCS TO RIGHT END HOLE FROM BACK OF MACHINE AND TIGHTEN DOWN WITH 8-32 KEPS HEX NUT. THIS SCREW IS TO ATTACH TENSION SPRING LATER.
- 3) ATTACH ASSEMBLED CUT OFF BLADE C AND CUT OFF BRACKET COMPLETE TO RIGHT AND LEFT SLITTER ATTACHMENT BRACKETS. CUT OFF BLADE FACES DOWNWARD AND 8-32 X 1 SHCS WILL BE ON END HOLE RIGHT FROM MACHINE REAR. USE (4) 6-32 X 3/8 TH TO SECURE CUT OFF BLADE BRACKET TO SLITTER ATTACHMENT.
- 4) LINE UP HOLES ON PAINTED SLITTER LEVER POSITIONER (EP25 104.4) RACK 9 WITH TAPPED HOLES ON RIGHT SLITTER ATTACHMENT BRACKET. CAREFULLY SNAP SLITTER LEVER POSITIONER ONTO SLITTER ATTACHMENT BRACKET SO NOT TO SCRATCH PAINT. THE NOTCH IN LEVER POSITOINER SHOULD FACE UPWARD.

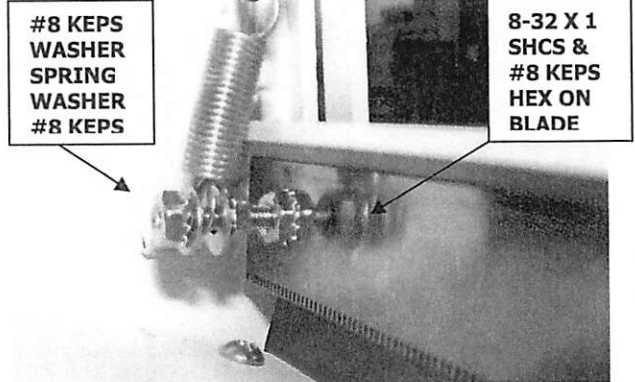


LEFT BRACKET



SECURE SLITTER LEVER POSITIONER WITH (2) 6-32 X 3/8 THMS. MAY RETAP.

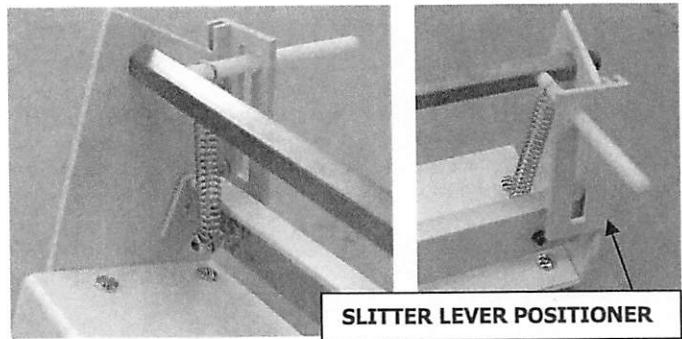
- 5) GENTLY ARBOR PRESS FLAT END OF WHITE PLASTIC SLITTER LIFTING LEVER (EP25 107.4) RACK 9 INTO DRILLED HOLE TOWARD END OF SLITTER BAR C (EP25 101.4) AS05.



#8 KEPS WASHER SPRING WASHER #8 KEPS

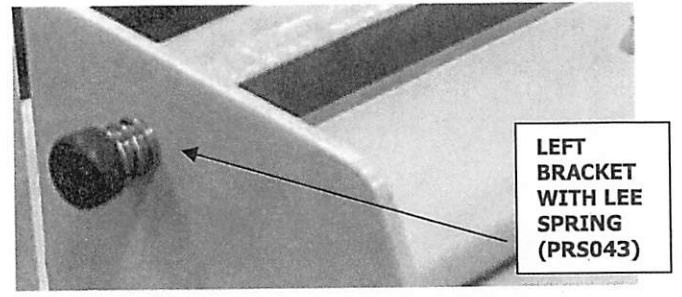
8-32 X 1 SHCS & #8 KEPS HEX ON BLADE

- 6) WITH THE 8-32 X 1 SHCS CUTTER BLADE SCREW UNDER THE LEVER POSITIONER, THREAD ANOTHER KEPS HEX NUT PART WAY UP SHCS THREADS, TEETH FACING OUTWARD. ADD #8 FLAT WASHER ONTO THREADS, THE LOOPED END OF EXTENSION SPRING (PRS302) RACK 9 AND SECOND #8 FLAT WASHER. SECURE EXTENSION SPRING BY ADDING A THIRD #8 KEPS NUT, TEETH INWARD. TIGHTEN KEPS NUT TEETH ONTO FLAT WASHERS. THE SPRING SHOULD FACES UPWARD TO CATCH SLITTER LIFTING LEVER.



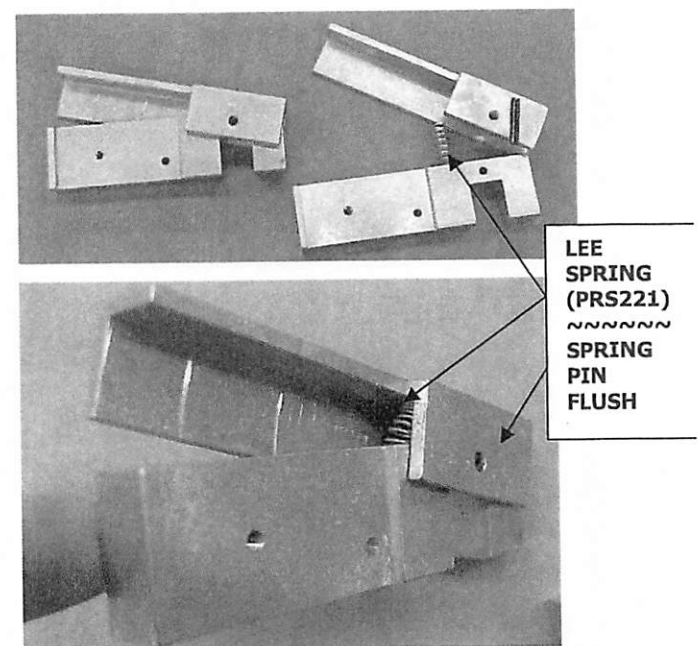
SLITTER LEVER POSITIONER

- 7) INSERT SLITTER LIFTING LEVER THROUGH REMAINING EXTENSION SPRING LOOP AND SECURE SLITTER BAR C TO RIGHT ATTACHMENT BARCKET WITH 1/4 X 5/16 SHOULDER BOLT. ATTACH LEFT END OF SLITTER BAR TO LEFT ATTACHMENT BRACKET WITH 1/4 X 3/8 SHOULDER BOLT THAT HAS LEE SPRING (PRS043) RACK 9 ADDED ONTO SHOULDER.



LEFT BRACKET WITH LEE SPRING (PRS043)

- 8) INSERT LEE SPRING (PRS221) RACK 12 INTO PROVIDED HOLE ON SLITTER KNIFE HOLDER (EP25 105.4) RACK 9. HOLD SLITTER SAFETY SHIELD (EP25 106.4) RACK 9 OVER SPRING, ALIGNING HOLES ON BOTH PIECES SO YOU CAN ARBOR PRESS IN A 1/8 X 3/4 SPRING PIN. BE CERTAIN THE LEE SPRING IS IN CORRECT ORIENTATION BEFORE ARBOR PRESSING. USE ENOUGH PRESSURE TO INSERT SPRING PIN BUT NOT ENOUGH TO BEND SAFETY SHIELD, AS THIS UNIT MUST EASILY SLIDE UP AND DOWN WITH USE OF SPRING.

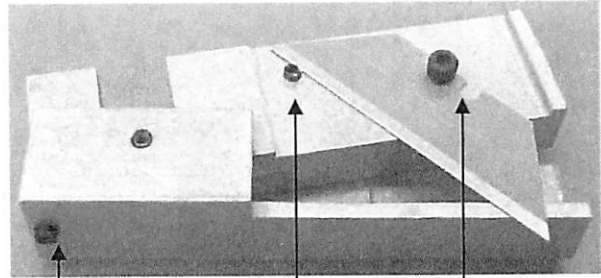


LEE SPRING (PRS221) ~~~~~ SPRING PIN FLUSH

- 9) INSERT 1/8 X 1/2 SPRING PIN INTO UNTHREADED HOLE IN RECTANGULAR RECESS OF SLITTER KNIFE HOLDER. THE SPRING PIN SHOULD BE FLUSH ON FLAT

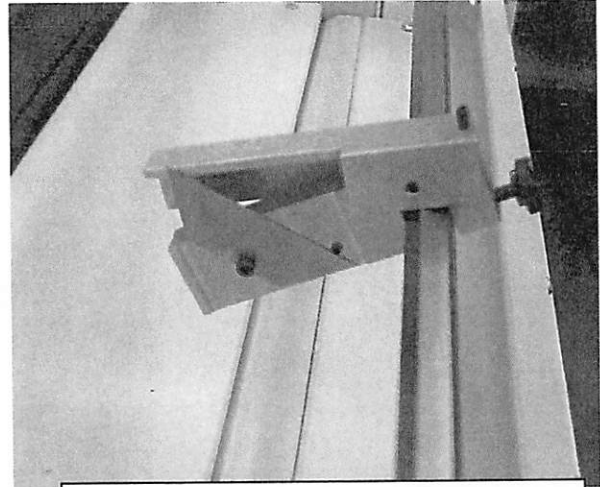
SIDE WITH EXPOSURE OF SPRING PIN ON RECESSED SIDE.

- 10) **INSERT SLITTER KNIFE BLADE (PRB032) CAB1 INTO RECTANGULAR RECESS OF SLITTER KNIFE HOLDER WITH SHARP EDGE RESTING ON SPRING PIN AND TIP STICKING PAST SAFETY SHIELD. SECURE SLITTER KNIFE BLADE WITH 6-32 X 1/4 SHCS.**



8-32 X 1/4 SS ~ 1/8 X 1/2 SPRING PIN ~ 6-32X1/4 SHCS

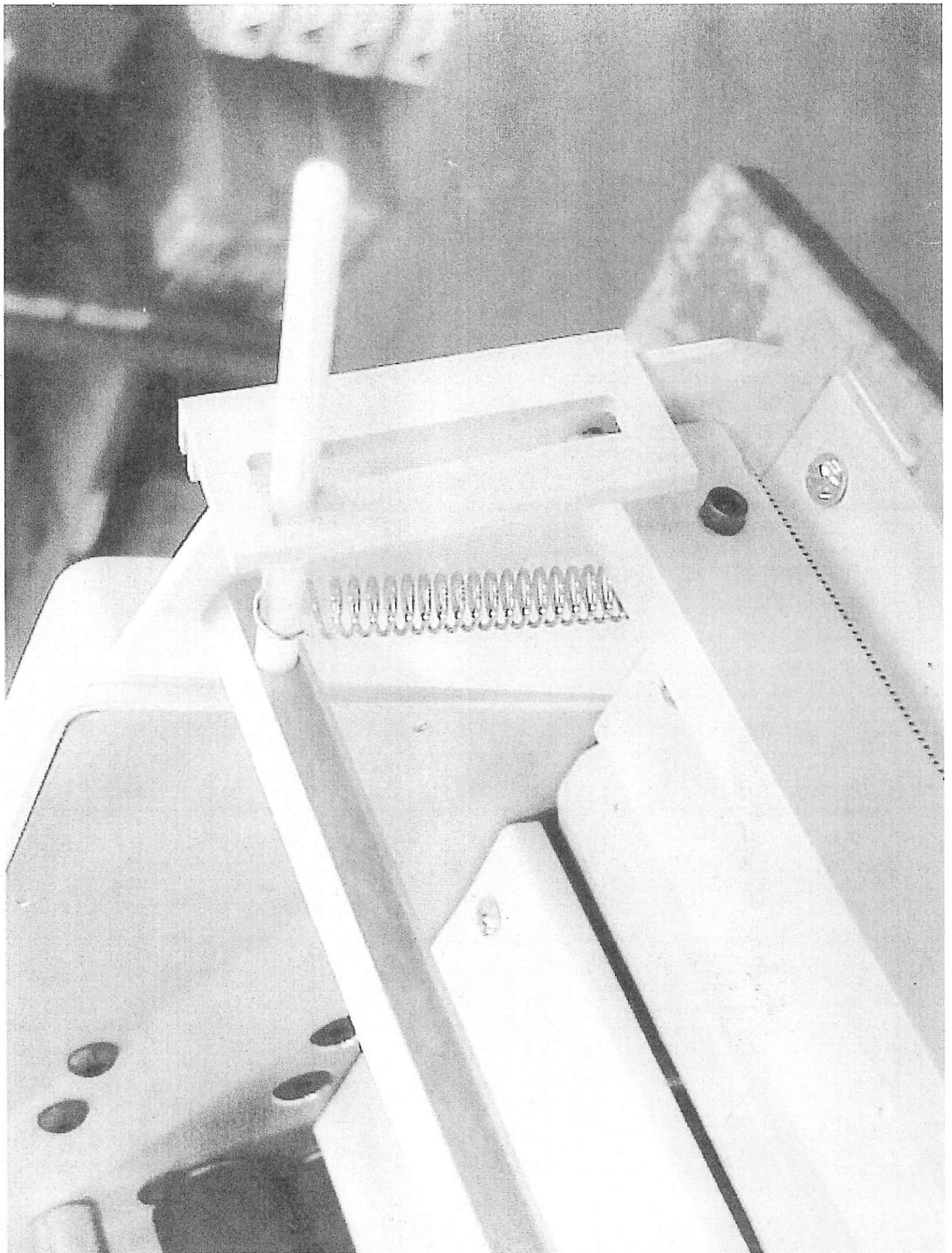
- 11) **ADD AN 8-32 X 1/4 SET SCREW TO END OF SLITTER KNIFE SAFETY SHIELD AND THREAD A SPI KNOB (PRK178) AS08 INTO TAPPED END OF SLITTER KNIFE HOLDER.**
- 12) **PLACE KNIFE HOLDER ASSEMBLY ON SLITTER KNIFE BAR C WITH POINT OF BLADE UPWARD BY SAFETY SHIELD. SECURE WITH SPI KNOB.**
- 13) **COMPLETE SLITTER ASSEMBLY IS ATTACHED TO BACK OF EP JR MACHINE WITH (3) SPI KNOBS (PRK177) AS08.**

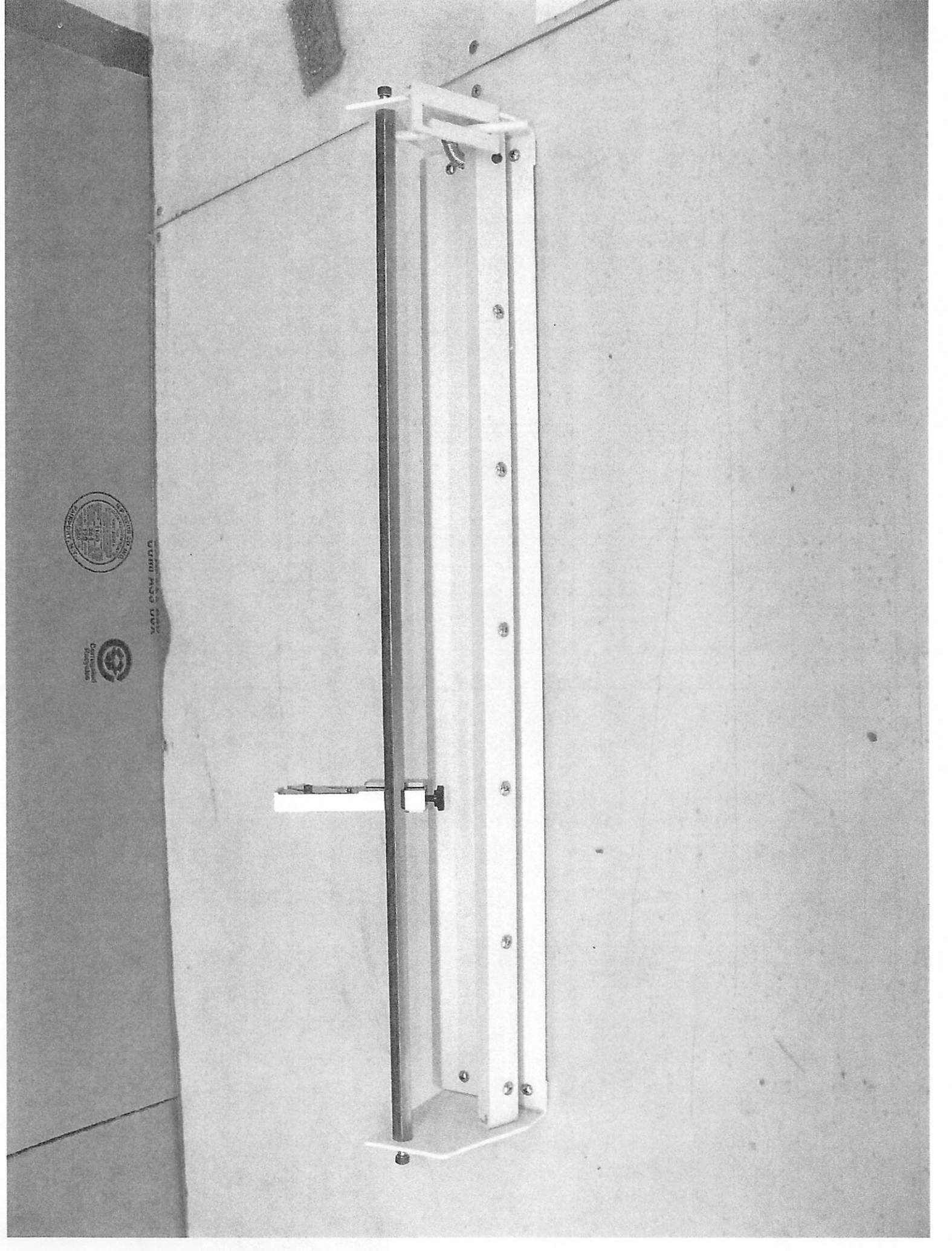


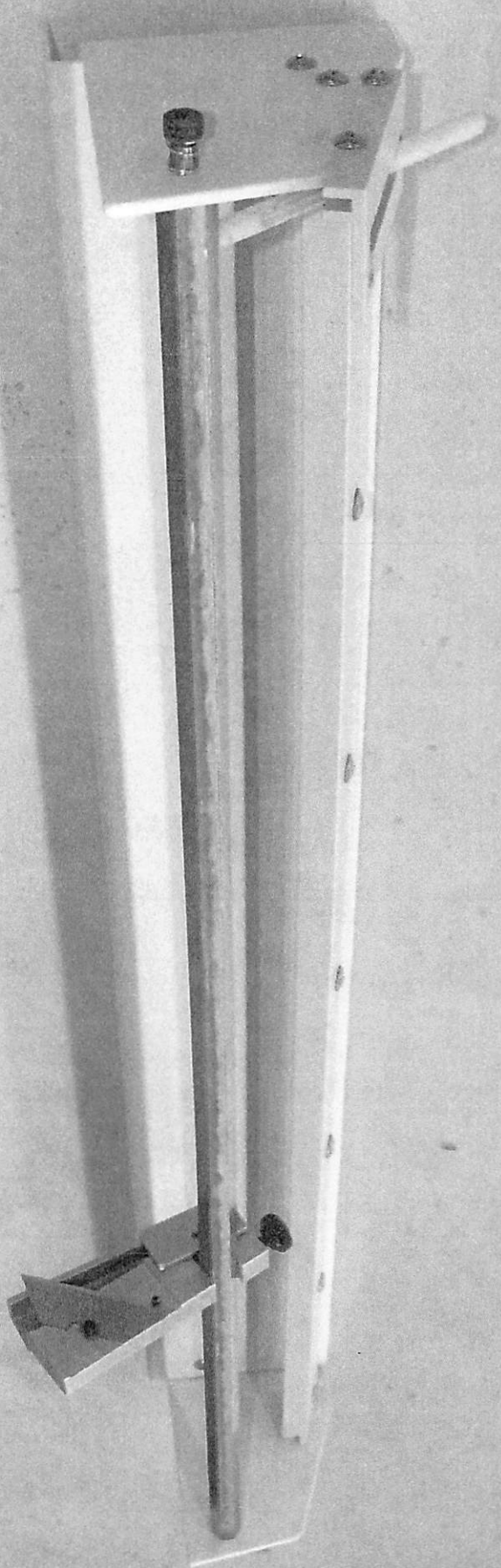
SLITTER KNIFE ASSEMBLY ON SLITTER BAR

EP25 JR
PRE-FEED
SLITTER
OPTION
INSTALLED



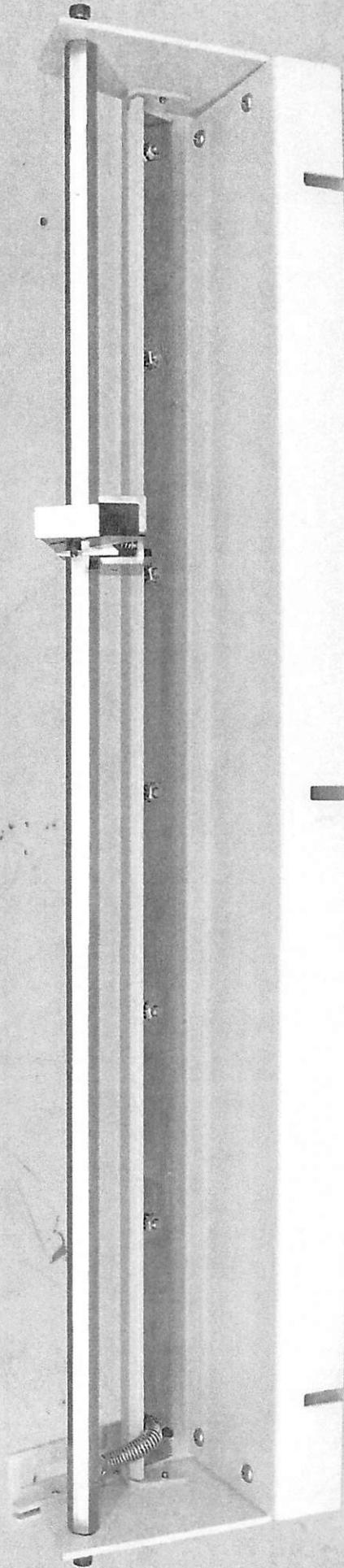


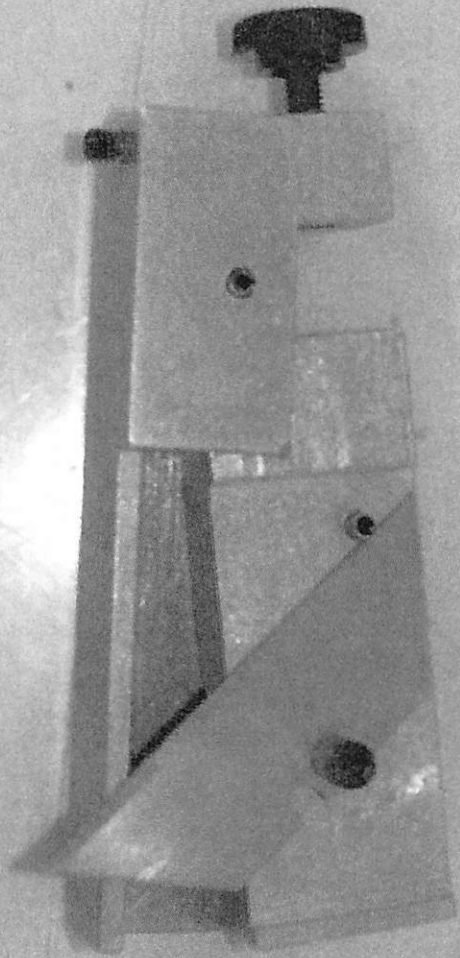






U.S. DEPARTMENT OF COMMERCE
BUREAU OF STANDARDS





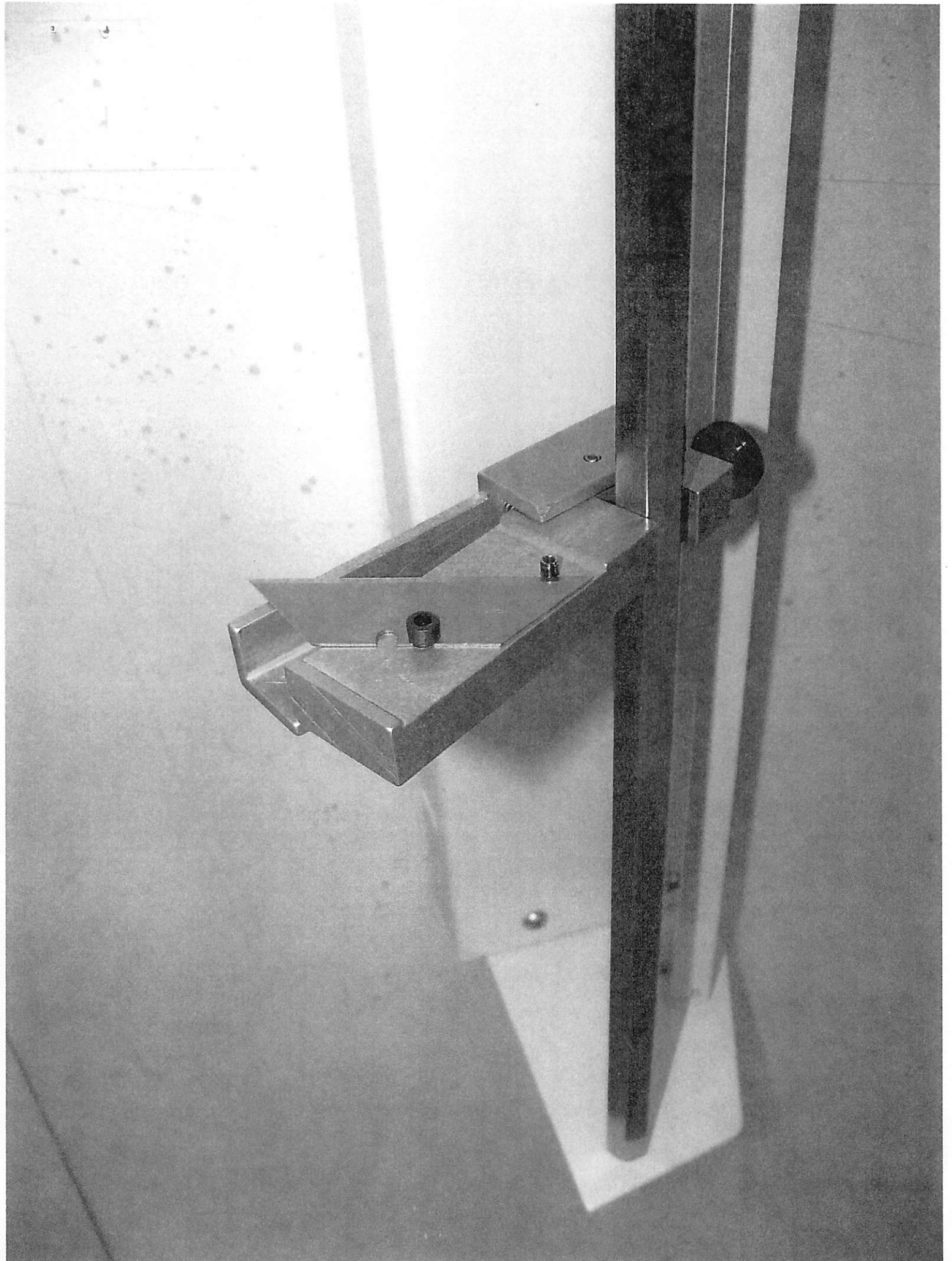
Job: A112478-000 Job Date: 02/14/12 Status: R Released
 Co-product Mix:
 Item: EP25 108.5 Released: 1.000
 EP25 PRE-FEED SLITTER ASSEMBLY
 Revision:
 Customer: Reference: I

Oper Ctrl	WC	Description	Move Hrs Pcs/LbrHr	Queue Hrs	Setup Hrs Pcs/MchHr	Start FixSchHrs	End OffsetHrs
10	407	R&D ASSEMBLY	0.00	0.00	0.00		
Yes			5.00	H	0.20	?	?

Type Item/Desc Qty/UM Per Reference

<i>ASOS</i>	M ✓	EP25 101.4 SLITTER BAR C	1.00000		EA	U	I
<i>ASOS</i>	M ✓	EP25 102.4 EXIT TABLE REV.A	1.00000		EA	U	I
<i>Pro. 9</i>	M ✓	EP25 103.4L SLITTER ATTACHMENT LEFT BRKT C	1.00000		EA	U	I
<i>Pro. 9</i>	M ✓	EP25 103.4R SLITTER ATTACHMENT RIGHT BRKT C	1.00000		EA	U	I
<i>RK 9</i>	M ✓	EP25 104.4 SLITTER LEVER POSITIONER	1.00000		EA	U	I
<i>RK 9</i>	M ✓	EP25 105.4 SLITTER KNIFE HOLDER	1.00000		EA	U	I
<i>RK 9</i>	M ✓	EP25 106.4 SLITTER SAFETY SHEILD	1.00000		EA	U	I
<i>ASOS</i>	M ✓	PRK177 SPI W/1/2" SCREW, #99-117-4	3.00000		EA	U	I
<i>ASOS</i>	M ✓	PRK178 SPI W/3/4" SCREW	1.00000		EA	U	I
<i>RK 9</i>	M ✓	PRS302 LE-039D-5-M EXTENSION SPRING	1.00000		EA	U	I
<i>RK 9</i>	M ✓	PRS043 LEE SPRING LC-022D-0 (EP SLITTER ASSY)	1.00000		EA	U	I
<i>RK 9</i>	M ✓	PRS221 ✓ LEE SPRING #LC-026C-10-M	1.00000		EA	U	I

**Rack 12*



4.00.02
JOB06-O

live

Ledco Corporation
JOB OPERATION LISTING

02/20/12 08:42:06
Page: 2

Job: A112478-000 Job Date: 02/14/12 Status: R Released
Co-product Mix: Item: EP25 108.5 Released: 1.000
EP25 PRE-FEED SLITTER ASSEMBLY
Revision: Customer: Reference: I

Type Item/Desc Qty/UM Per Reference

Rack 9

Type	Item/Desc	Qty/UM	Per	Reference
M ✓	EP25 107.4 SLITTER LIFTING LEVER	1.00000 EA	U	I
M	.125J0008 1/8 X 1/2 SPRING PIN	1.00000 EA	U	I
M	.138EBA06 6-32 X 3/8 TH PHIL M/S	6.00000 EA	U	I
M	.164CBA06 8-32 X 3/8 RH PHIL M/S	6.00000 EA	U	I
M	.164KKC01 #8 FLAT WASHER 2DNW8	2.00000 EA	U	I
M	.164L0L00 8-32 KEPS HEX NUT EXT. LOCK WASHER	6.00000 EA	U	I
M	.164MAA04 8-32 X 1/4 SH SET SCREW	1.00000 EA	U	P
M	.164PAA04 8-32 X 1/4 SHCS	1.00000 EA	U	I
M	.190CBB06 10-32 X 3/8 RH PHIL M/S	4.00000 EA	U	I
M	.250IAC05 1/4 X 5/16 SHOULDER BOLT	1.00000 EA	U	I
M	.250IAC06 1/4 X 3/8 SHOULDER BOLT	1.00000 EA	U	I
M	.190L0L00 10-32 KEPS NUT	4.00000 EA	U	P
M	.125J0012 1/8 X 3/4 SPRING PIN	1.00000 EA	U	I
M ✓	0500 111.4 CUT OFF BLADE C	1.00000 EA	U	I

ASOS

4.00.02 live
JOB06-0

Ledco Corporation
JOB OPERATION LISTING

02/20/12 08:42:06
Page: 3

Job: A112478-000 Job Date: 02/14/12 Status: R Released
Co-product Mix: Item: EP25 108.5 Released: 1.000
EP25 PRE-FEED SLITTER ASSEMBLY
Revision: Customer: Reference: I

Type	Item/Desc	Qty/UM	Per	Reference
AS05 M ✓	0500 112.4 CUT OFF BRACKET COMPLETE AND PAINTED	1.00000 EA	U I	
20 3 Yes	ASSEMBLY	0.00 0.00	0.00 0.00	0.00 ?

EP25 105.4 = 1 one Blade Holder
EP25 106.4