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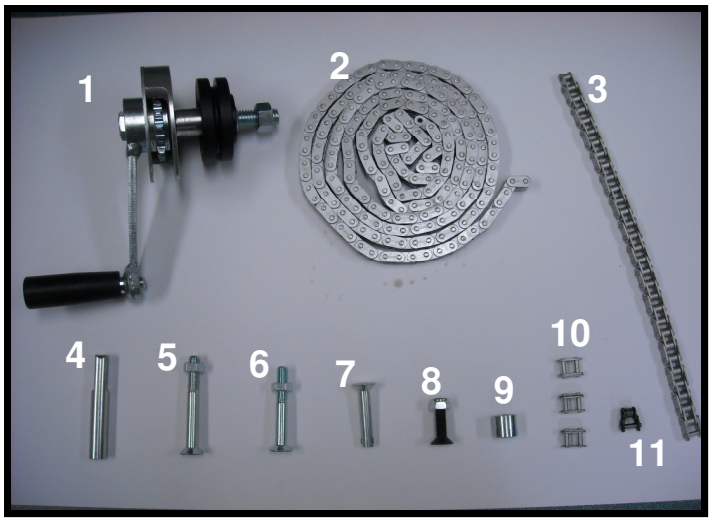
FITTING SIDE SHIFT WINDER

Machines Before Serial No: M827 606 5406 & M618 606 2335
Will Require a New Horizontal Ruler Gauge

ASSEMBLY KIT



EXTRAS

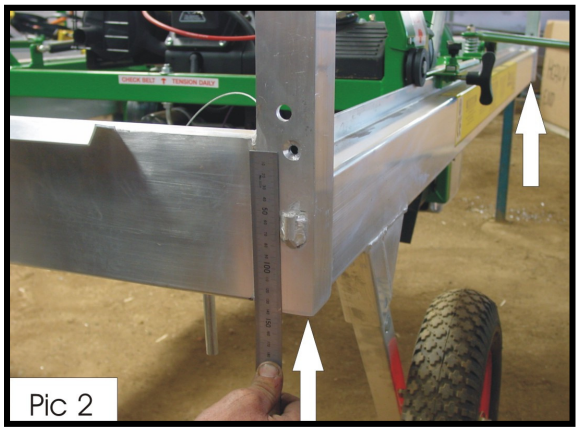
Repetitive Stop Bar
for older Model 8 mills

1	Side Shift Winder Assembly	6	M8 x 60 Flat Head socket cap screw (M6)
2	Long Chain	7	M8 x 45 Countersunk Head Pin
3	Short Chain	8	M8 x 25 Countersunk bolt
4	Chain Ferrule	9	Chain guide
5	M8 x 70 Flat Head socket cap screw (M8)	10	Joining link x 3

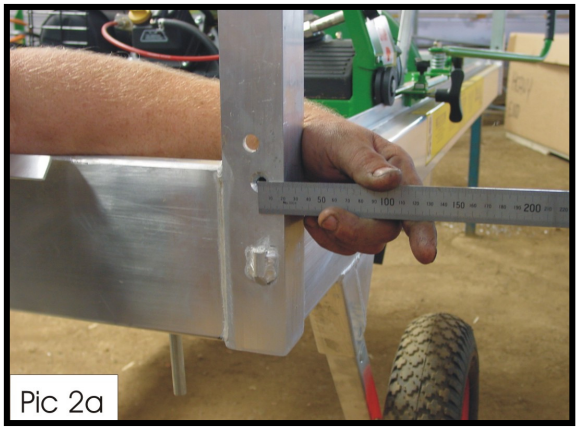
11 ***½LINK JOINER - SUPPLIED FOR STEEL TROLLEY ONLY ****

REMOVE 2 x Trolley Rollers from the trolley frame on the operator's side
MEASURE up 140mm & in 20mm on both ends of the ALUMINIUM trolley frame, **centre punch**
DRILL 8mm hole through angle & frame, then **countersink** holes with a 16mm drill bit
FIT **Head pin (7) needs to fit 1mm below the outer face of the aluminium angle**
DRILL 2 x 8mm drain holes in the underside of trolley frame at each end

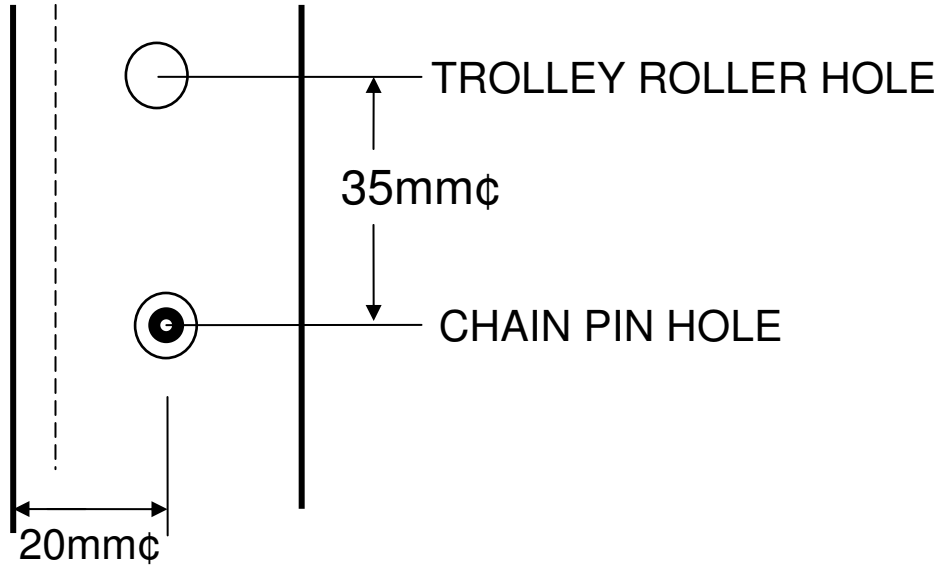
From operator's position
INSERT M8 x 45 Countersunk Head Pin (7) on **left** side
INSERT M8 x 60 (Model 6) / M8 x 70 (Model 8) flat head socket cap screw - **right** side through angle
FIT M8 nut to socket cap screw then fit the chain ferrule by 1 full turn of thread

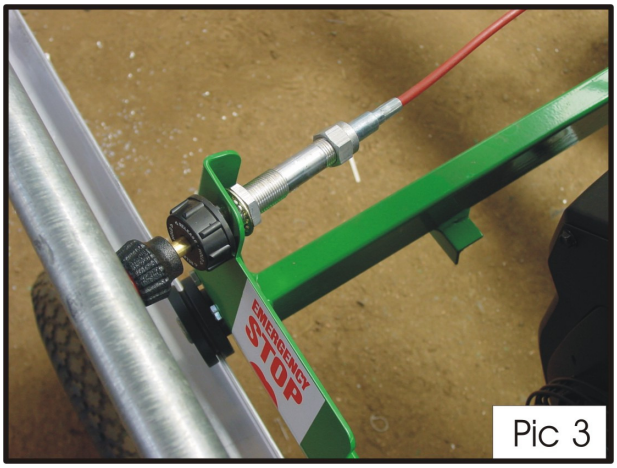

Pic 2

STEEL TROLLEY
MEASUREMENT FOR CHAIN HEAD PIN HOLE IS 35MM DOWN FROM TROLLEY ROLLER HOLE –
(see diagram on next page)


Pic 2a

END VIEW OF ANGLE ON STEEL FRAME





Pic 3

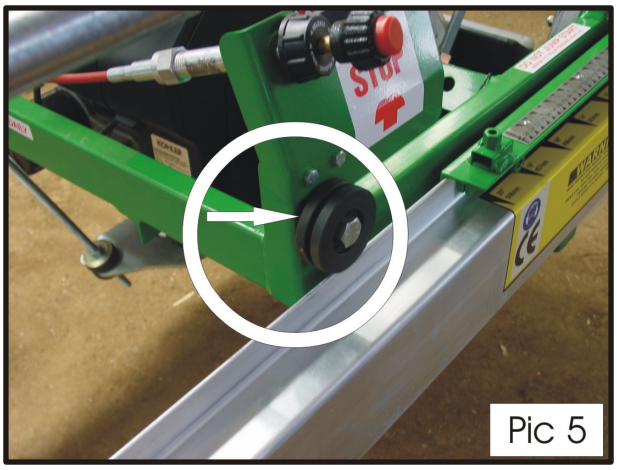
Loosen the Side Shift Brake & remove.

****Model 8 ONLY**
Loosen the throttle / emergency stop assembly then remove tacho & fuel tank.

Pic 4

IF REQUIRED, FIT A NEW
- **horizontal ruler gauge**
- **repetitive stop bar**

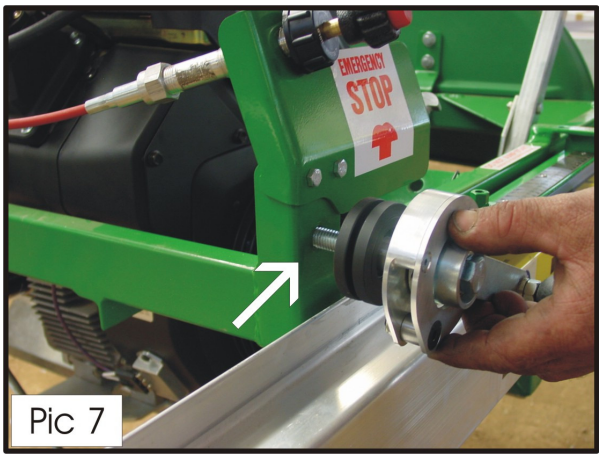
Lift the engine frame 30mm above the trolley.
Remove the old horizontal ruler gauge assembly & replace with new gauge



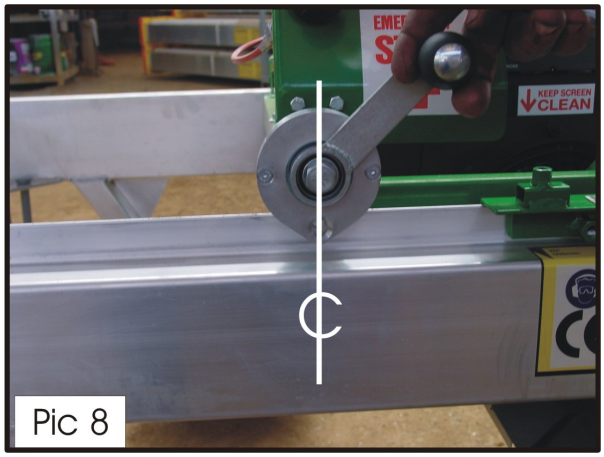
Pic 5

BEFORE lowering the engine frame onto the aluminium trolley
MEASURE BETWEEN THE ROLLER AND GREEN ENGINE FRAME

Make a note of the measurement
Remove the trolley roller



Pic 7



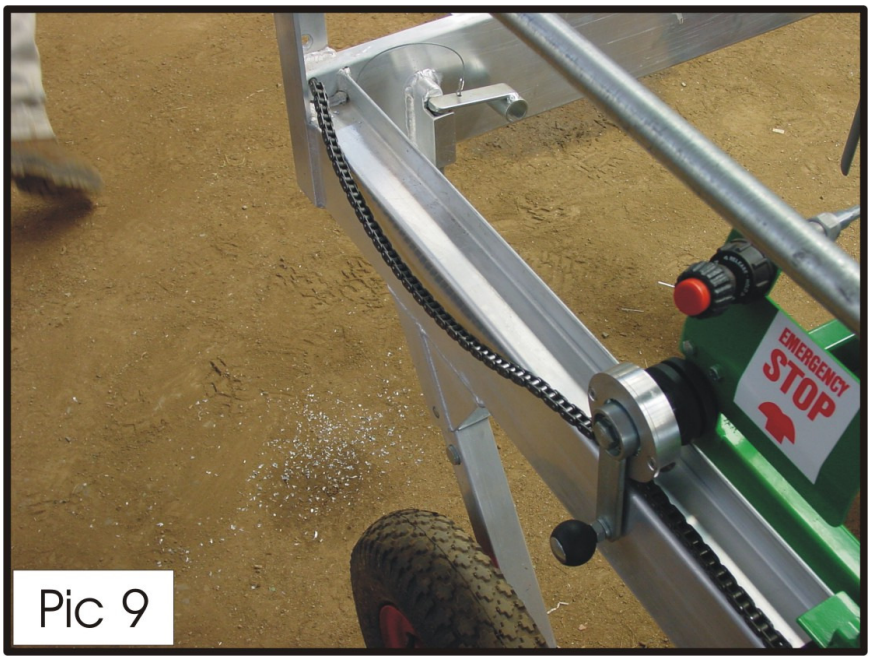
Pic 8

Fit Side Shift Winder assembly (1) into engine frame where trolley roller was removed

Chain guide hole in housing must point down (Pic7) & be centred vertically (Pic8)

NOTE: THE DIMENSION BETWEEN THE ROLLER AND GREEN ENGINE FRAME **MUST BE THE SAME** as Pic5 **BEFORE** doing the locknut up.

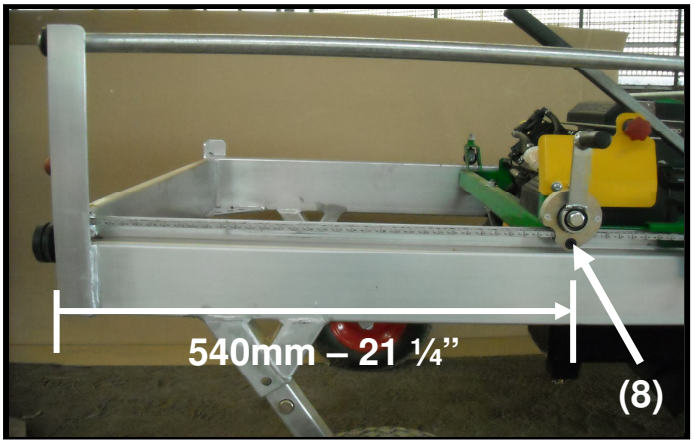
Lower engine frame back into position.



Pic 9

Model 6 – Use the Long Chain (2)
Model 8 – Join Long & Short Chain (2&3) together with joining link (10)
***** Keep short chain section to the right hand side of trolley *****
Slide chain through Side Shift Winder Assembly (1).
***** Add ½ link joiner to chain on steel mill trolley only *****

FIT chain to Countersunk Head pin (7) using joining link – left side
FIT chain to the chain ferrule (4) then tension chain & tighten lock nut to the ferrule– right side



BEFORE FITTING THE CHAIN GUIDE
TO THE SIDE WINDER ASSEMBLY

Side Shift Winder handle MUST
be in the vertical position
at 540mm – 21 ¼” from outside edge
of left side of trolley to centre of side winder

FIT the chain guide into lower part of the side winder assembly with M8x25 bolt (8)
& tighten nut

REFIT & TIGHTEN

Model 6 & 8

Side Shift Brake
2 Trolley Rollers

Model 8 ONLY

Fuel Tank
Tachometer
Emergency Stop/Throttle

Final position of horizontal ruler gauge,
chain & ‘T’ bolt