

# Arbor Shaft Assembly and/or Bearing Replacement Instructions

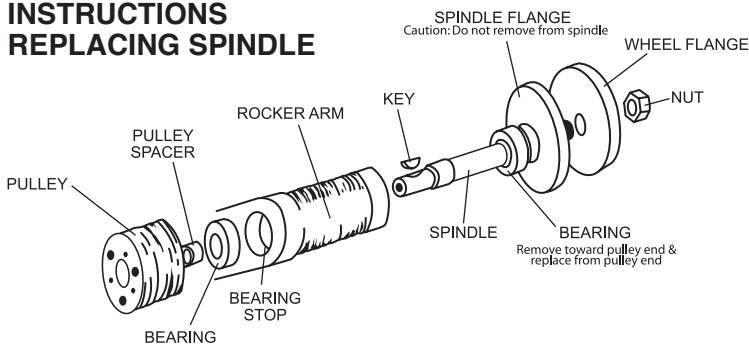
TO REMOVE ARBOR SHAFT & BEARINGS OBSERVE LOCKOUT – TAGOUT REQUIREMENTS.

1. Remove belt guard. Draw a line along the front of the motor base plate. This will serve as an alignment reference later. Loosen motor mounts and jackscrews. Remove belts.
2. Remove Pulley by:
  - a. Removing the 3 bolts in pulley bushing
  - b. Place these bolts in the tapped holes of the bushing and tighten evenly. This will push the pulley towards the rocker arm and off the taper lock bushing.
  - c. When the pulley is completely free of the bushing, remove the 3 bolts.
  - d. Remove the bushing by placing a screwdriver in the slot of the bushing and gently tap the screwdriver in until the bushing spreads open just enough to slide the bushing off of the arbor shaft, remove key.
  - e. Remove pulley spacer and save it.
  - f. Remove bearing keeper bolt located an flange side of the rocker arm (on 26" machine only).
3. Remove arbor shaft by driving left to right.

## TO INSTALL NEW ARBOR SHAFT & BEARINGS

1. Make sure rocker arm is free of abrasive dust, chips and other debris in the bearing seats and arbor area.
2. With a soft hammer or wood block to protect it, install new bearing in pulley side of rocker arm. Fit should be easy but not sloppy.
3. Again check that no contamination is in the bearing area and install arbor shaft, checking alignment when the shaft enters the opposite bearing.
4. With a soft hammer gently tap the arbor shaft (not flange) into the rocker arm partially.

## INSTRUCTIONS REPLACING SPINDLE



5. Place a pipe slightly larger than the arbor shaft, over the pulley end of the shaft and against the **inner race** of the bearing.
6. Have someone "buck" against the flange end of shaft while the bearing on the pulley side is being tapped in place. Using the pipe and a soft hammer, if necessary, tap the arbor shaft assembly back into the rocker arm.
7. Repeat Step 6 until arbor shaft is completely installed, with both bearings against the bearing stops. (Bearing stops on 26" shaft only).
8. Replace bearing keeper bolt (on 26" machine only).
9. Install pulley spacer against bearing and tighten set screw. Install key.

10. Place pulley bushing on arbor against pulley spacer. Mark the arbor shaft to indicate how far on the arbor the bushing must go to be against the pulley spacer. Accurately measuring the distance from pulley bushing to the end of the arbor shaft is another acceptable method to insure proper repositioning of the bushing. With contact between the inner race and the spacer, and the spacer and the pulley bushing, lock the arbor shaft in place preventing the shaft from moving left to right and helping maintain straight cuts.

11. Place pulley bushing into pulley. Install 3 bolts into "Clearance" holes of bushing and tapped holes of pulley. (This may be reversed on some machines, clearance in pulley, tapped holes in bushing).

12. Place pulley assembly onto arbor shaft. Be certain bushing is up to your mark on shaft and insure bushing is against spacer (or measured distance is arrived at again).

13. Remove screwdriver and evenly tighten bolts. As bolts are snugged:

- a. Place a straight edge against pulley and pick a reference point on motor pulley.
- b. Rotate arbor 1/3 turn and check with straight edge and reference.
- c. Repeat again another 1/3 revolution.
- d. Tighten appropriate bolts to true pulley with arbor shaft.

Proper approximate torque on pulley bolts.  
 Up to 20" Machine 9 FT/lbs.  
 26" Dry Machine 30 FT/lbs.  
 26" Wet Machines 60 FT/lbs.

14. Motor pulley and arbor pulley should now be running true with their respective shafts. Install belt(s).

15. Position motor so that a straight edge on arbor pulley is parallel with belts.

16. Using jackscrews, tension belt(s). Be certain pulleys remain parallel and use a straight edge to keep pulleys in the same plane so that the belt will track properly. The reference line drawn in Step 1 may be used as a "Guide" for belt tension and parallelism between arbor shaft & motor shaft. For "V" belts, tension should be measured as a deflection of about 1/64", times the center distance between the shafts, with a 2 1/2 pound force between centers **ON ONE BELT ONLY**.

17. Replace belt guard. Do not use bolts longer than 1/2 inch or belt(s) will be cut by bolt.

18. **Check belt tension after approximately 8 hours use.** Make sure belt(s) and pulley run true with motor and arbor shaft, and motor shaft and arbor shaft are parallel.

