

6330527 FRONT TOOLING EXTENSION KIT ASSEMBLY INSTRUCTIONS AND PARTS LIST

These instructions explain the process of mounting an EXTENSION PLATE to the FRONT TOOLING of the Model 633 and 653 to accommodate cutting units with 3.5" diameter reels. Be sure to read and understand all instructions before attempting to install this kit.

ASSEMBLY INSTRUCTIONS

These instructions explain how to attach the EXTENSION PLATE to the existing FRONT TOOLING PLATE. Before proceeding with the assembly instructions review and identify the parts contained in the assembly kit (parts list).

1. Remove any cutting unit from the FRONT TOOLING.
2. Verify that the TOP PLATE of the FRONT TOOLING has four threaded $\frac{1}{4}$ -20 holes. (Old versions of the TOP PLATE do not have the threaded holes for mounting the FRONT TOOLING EXTENSION PLATE).
3. Align the four holes of the FRONT TOOLING EXTENSION (6339226) to the FRONT TOOLING TOP PLATE, as shown in FIG. 1.
4. Insert four SPLIT LOCK WASHERS (K371501) and four BUTTON HEAD SCREWS (B251216) from the top of the FRONT TOOLING EXTENSION into the TOP PLATE.
5. Use a torque wrench to tighten each screw to 120 inch/pounds (13.5 N/m). Do not use thread locking compound (Loctite).

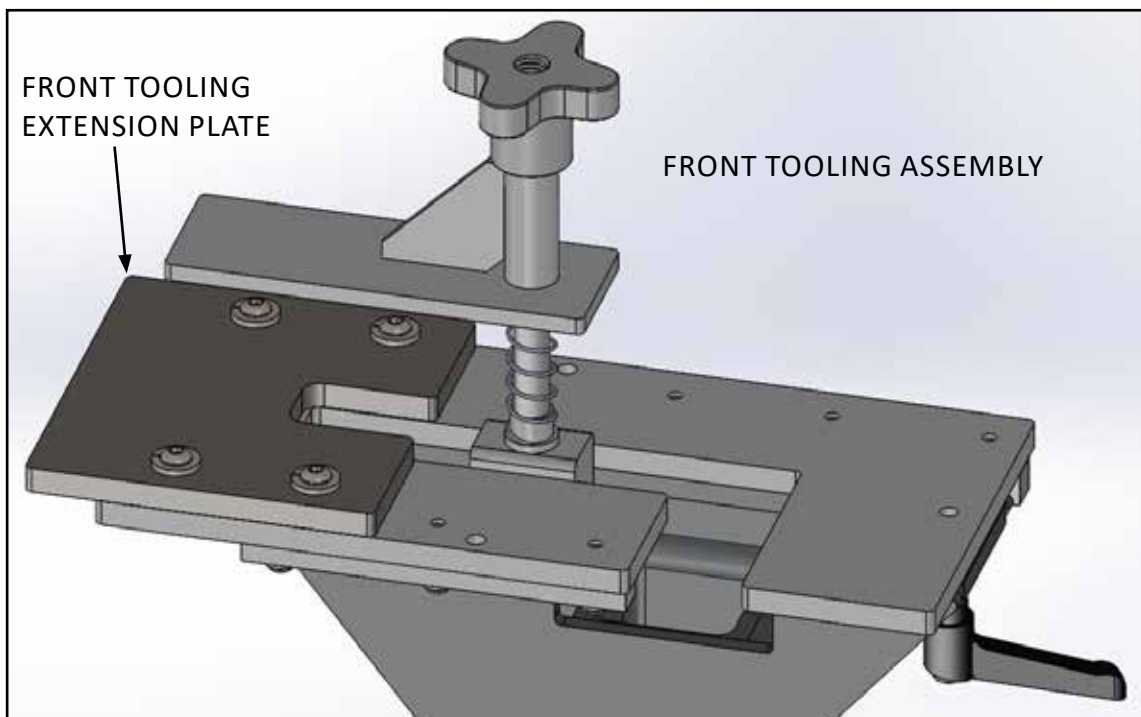


FIG 1: FRONT TOOLING EXTENSION PLATE mounted to FRONT TOOLING ASSEMBLY.

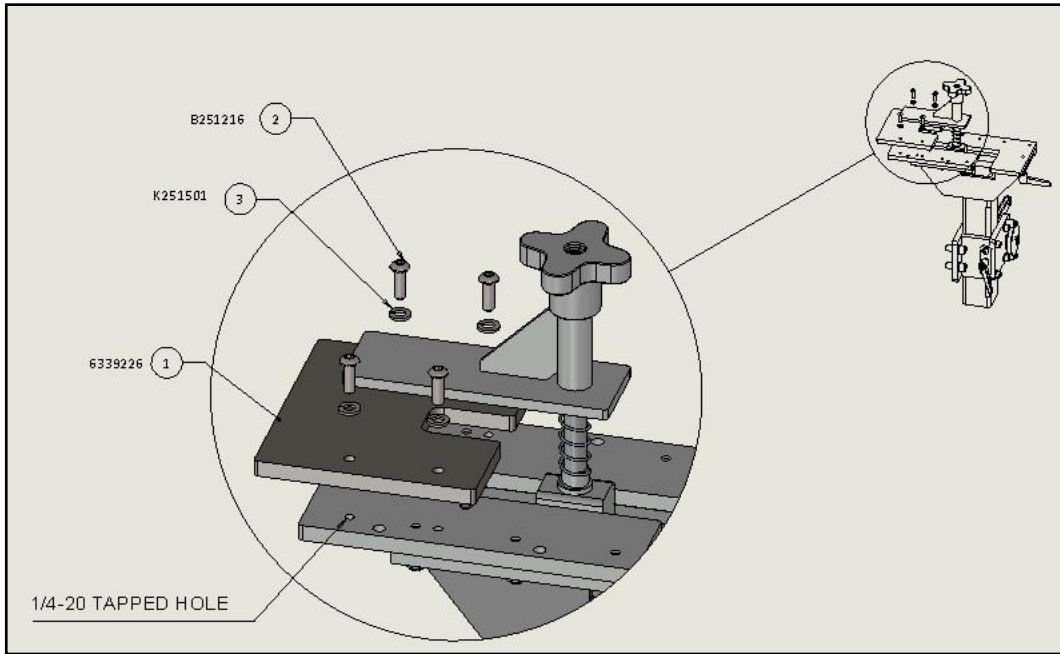


FIG 2: Exploded view of the FRONT TOOLING EXTENSION and FRONT TOOLING ASSEMBLY

PARTS LIST

DIA. NO.....	PART NO.	DESCRIPTION	QTY.
1.....	6339226	FRONT TOOLING EXTENSION.....	1
2.....	B251216.....	1/4-20 X 3/4 BUTTON HEAD SOCKET CAP SCREW ...	4
3.....	K251501	3/8 LOCKWASHER SPLIT.....	4