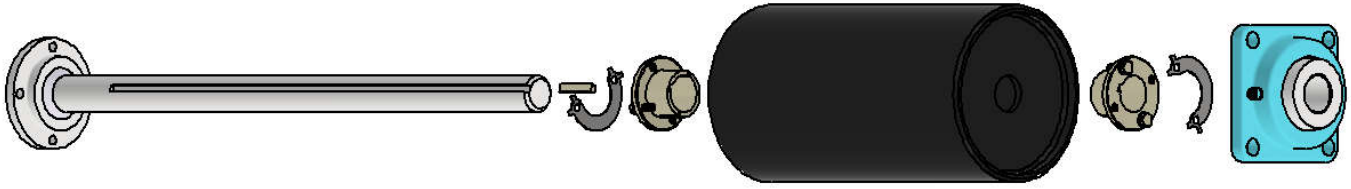


## XL-Saw Assembly - Roller Assembly



**DISASSEMBLE:** Remove existing rollers and shafts, leave gear box in place. See below caution about right angle gear boxes. If removing the upper F20-01 hangers and MP01-011 Idle Roller assemblies for additional space, take caution to mark orientation for re-installation. Once reinstalled confirm saw blade head pivots freely without obstruction by rollers. Reinstallation may cause board travel issues that will need to be recalibrated. See calibration manual for board travel instructions. Take note of your specific bearing placement and bearing adjuster plates. Not all machines are assembled the same. Dispose of used RC-0002 taper bushings, bushings and 1/4" bolts should not be re-used.

**INSPECT SHAFT KEYWAYS:** Begin with MP01-026 Shimpo Roller Shaft. Inspect keyway for play, replace shaft as needed.

Machines with right angle Motovario: (RI-0009 10:1 or 20:1) with through shaft in gear box. Take great care in removing shaft from gear box. Any hammering can destroy seals of gear box. It is recommended to cut the shaft at the gear box and press out the stub. Use anti-seize aluminum paste when reassembling with new RF-0003 1-1/4" x 36" KFL shaft.

Older machines with Shimpo gear boxes: have two piece MP01-016 Shimpo flange with additional RC-0002 taper bushing and key. These should be replaced with one piece Shimpo shaft.

**SLIP ROLLER AND TAPERS ON SHAFT, INSTALL ON GEARBOX:** Thread two RC-0002 taper lock bushings and MP01-010 roller on to MP01-026 shaft. Take care with orientation of bushing. Taper locks should move freely on shaft. Do not bolt in place. Attach shaft to RI-0008 Shimpo with M8-1.25x25mm SHCS (4 Each Hub) Use Red Loctite. Torque in star pattern.

**SHIM AS NEEDED:** Confirm far end of shaft is concentric in flange bearing opening on far end of shaft. Shim Shimpo gear box as needed with steel banding pieces at Shimpo gear box mounting bolts.

Once shimmed, install RA-0012 bearing on outside end of shaft. Bolt to F21-01 frame with 1/2-13" x 1-1/2" Hex Head & 1/2-13" Lock Nuts (4 Each Bearing) – Torque in place. Grease fitting faces toward inside of machine. Tighten set screw on bearing.

**ALIGN KEY AND ROLLER THEN TORQUE:** Align MP01-010 roller to desired position. Take caution to clear rollers on fence. Edge of roller should line up with edge of fence. Mark edge of bushing on shaft. Move roller and flanges aside on shaft. Insert provided key into keyway using provided Loctite 680 retaining compound. Key will stick out of RC-0002 bushing roughly 3/16". Dimple edge of shaft keyway into side of key using a punch. Only 1 side of roller will have key.

Loosely insert RC-0002 bushing into MP01-010 roller hub and pull both over the installed key. Slip opposing RC-0002 bushing into other end of MP01-010 Roller hub. Align MP01-023 locking clips and evenly snug using included 1/4" bolts. Alternate tightening each bolt roughly 1/4 turn at a time. Flanges are fragile. Do not bend tabs of MP01-023 locking clip until calibration is complete.

Confirm everything rotates smoothly and all bolts are torqued. Run 100" test in Calibration manual to reconfigure scale factors. Re-torque browning hubs after calibration and bend locking tabs over bolts.