Instructions to Change Guide Blocks on Manual Roller Lacers®
(Serial Numbers 60,000+)

Step 1: Remove Roller Lacer Head.

Step 2: Position lacer head with tensioning bolts directly above lacer bottom pan holes.

Step 3: Loosen nut and remove rollers from roller shafts.

Step 4: Turn adjustment knob clockwise to open roller shafts to fully open position.

Step 5: Adjust tensioning bolts out until the bolt has cleared the slot that the guide block rests in.

Step 6: Simultaneously press top guide block up and bottom guide block down far enough to clear the extrusion while removing lacer head. See Fig. 1.

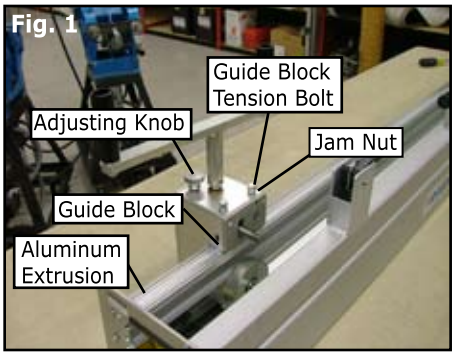
Step 7: Remove lacer head back plate by loosening and removing four screws. See Fig. 2.

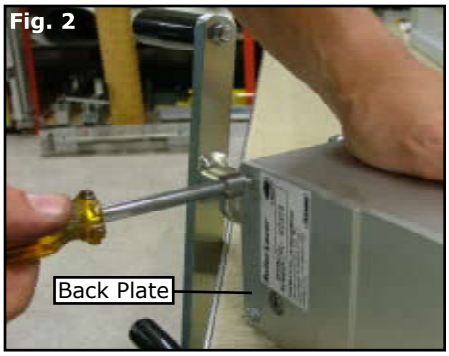
Step 8: Remove old guide blocks and stabilizing wear inserts.

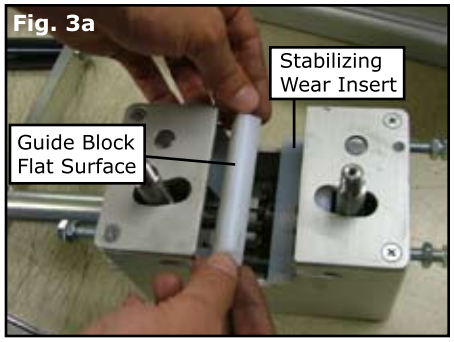
Step 9: Insert new guide blocks and stabilizing wear inserts into head (Fig. 3a). Ensure narrow side of stabilizing wear insert is aligned on roller shaft side. See Fig. 3b.

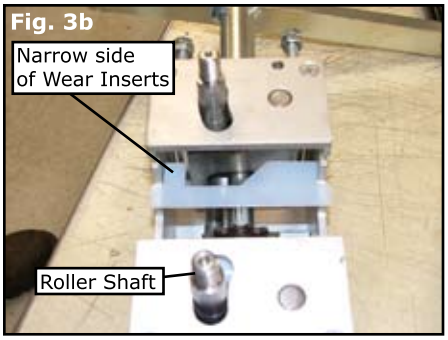
Step 10: Place lacer head on extrusion while holding stabilizing wear insert in place (Fig. 4a). Note: You may need to move head slightly from left to right while positioning it on the extrusion so that the sprocket teeth seat down into the chain.

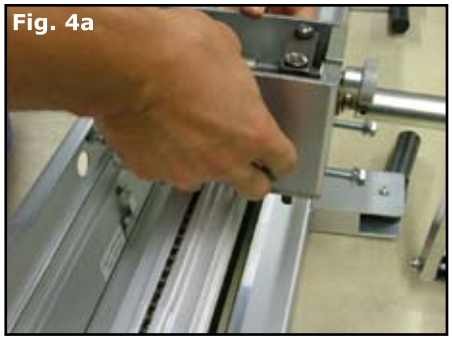
Step 11: Ensure stabilizing wear inserts are properly located between housing cutout and aluminum extrusion (Fig. 4b).

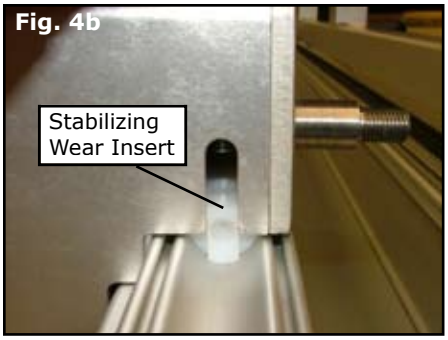




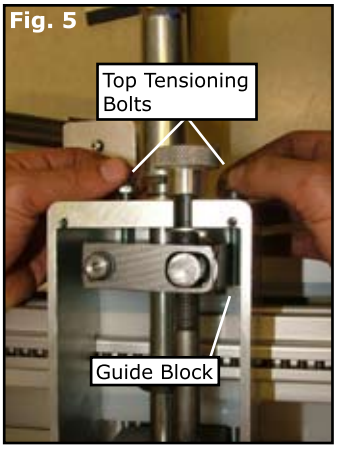








Step 12: Position head above bottom pan holes. Tighten top and Bottom tensioning bolts until guide blocks make contact with extrusion (Fig. 5).

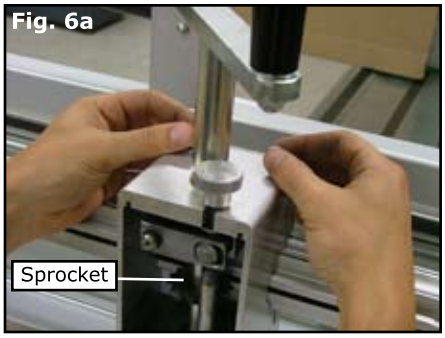


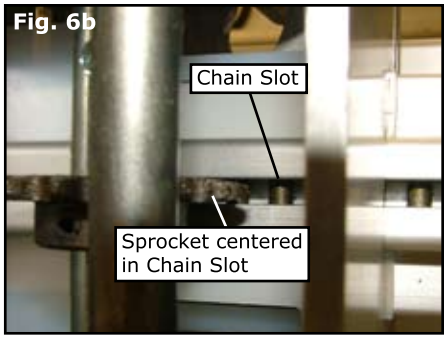
Step 13: Loosen bottom tensioning bolts one turn.

Step 14: Look through back of head and locate sprocket (Fig. 6a). Adjust tensioning bolts until sprocket is aligned in the center of chain slot (Fig. 6b).

Step 15: Adjust bottom tensioning bolts until they are just snug.

Step 16: Turning offset handle, move lacer head across the extrusion and ensure it moves freely. If sprocket interferes with chain slot, repeat steps 5-8 to properly center sprocket in chain slot.





Step 17: Install head back plate.

Step 18: Position rollers onto roller shafts until seated against aluminum extrusion. Note: Rollers are cut on a taper. Place the rollers on shaft so larger diameter of roller faces away from extrusion (label out); smaller diameter must face toward extrusion. Spin roller and tighten Nyloc nut until the roller makes light contact with extrusion. Next, loosen the Nyloc nut ¼ to ½ turn to allow roller to rotate freely. Repeat this procedure for other roller. See Fig. 7.

The Roller Lacer is now ready for service!

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