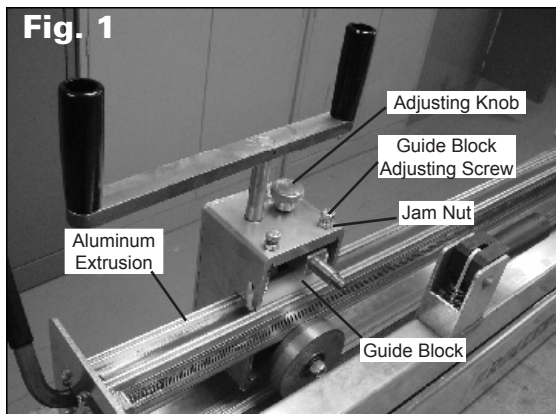


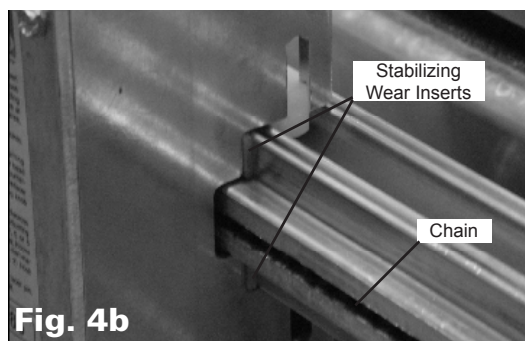
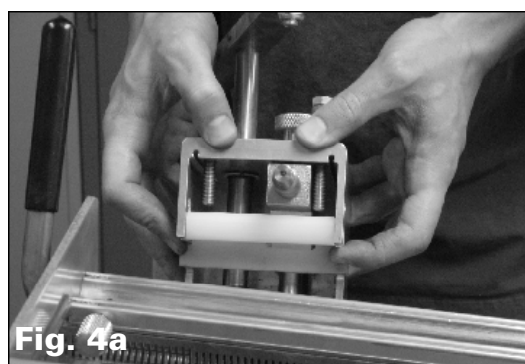
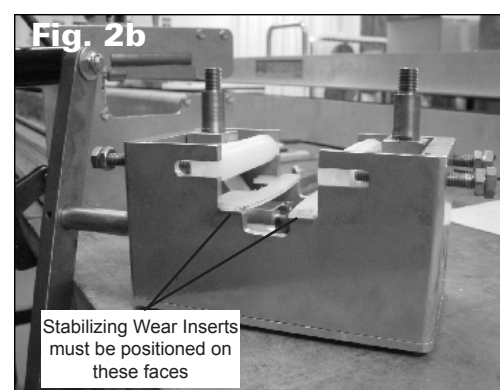
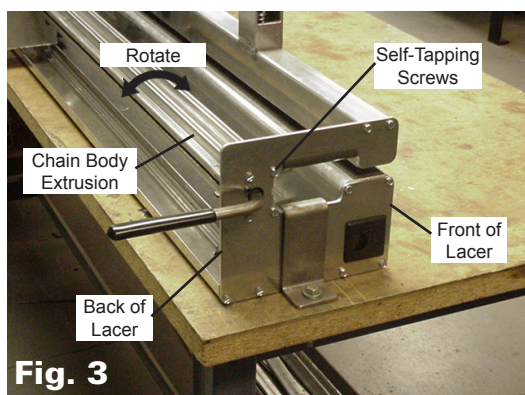
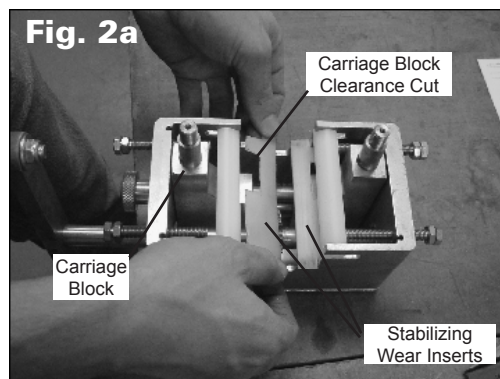
Changing Guide Blocks on the Roller Lacer®

(Serial Numbers 50,000+)



Step 1: Remove the Roller Lacer Head. Position the Roller Lacer head so that the bottom guide block adjusting bolts are directly above the holes located in the bottom pan of the lacer body. Remove the rollers from the roller shafts and adjust the roller shafts to the fully opened position by turning the adjustment knob clockwise. Next, loosen the jam nuts on the guide block tensioning bolts located at the top and bottom of the head. Adjust the tensioning bolts out until the bolt has cleared the slot that the guide blocks rest in. This will allow you to press the guide blocks up or down far enough to clear the extrusion while removing the lacer head. See Fig. 1.

Step 2: Remove the old guide blocks and insert the new ones, along with stabilizing wear inserts as shown in Fig. 2a. Ensure that the carriage block clearance cut on the stabilizing wear inserts is aligned with and facing the carriage blocks on the top and bottom. Also, make sure that the stabilizing wear inserts are located on the appropriate face of the housing cutout as shown in Fig. 2b. **NOTE:** The flat surface of the guide block faces the carriage block.



Step 3: To insure that the drive handle will clear the belt clamping handles while using the lacer do the following: First loosen the four self-tapping screws that attach the extrusion to the lacer. These screws are located at each end of the lacer. Now re-tighten the screws while twisting the extrusion towards the back of the lacer, removing all of the play in the holes. See Fig. 3.

Step 4: Place the lacer head back onto the aluminum extrusion while holding stabilizing wear inserts in place. See Fig. 4a. You may have to move the head slightly from side to side while positioning it on the extrusion so that the sprocket teeth seat down into the chain. The head should now be on the extrusion with the stabilizing wear inserts appropriately located between the housing cutout and the aluminum extrusion. See Fig. 4b.

Step 5: With the head positioned on the aluminum extrusion over the holes in the bottom tray, tighten the roller adjusting knob down all the way until closed. This will approximate the centering of the head vertically on the extrusion by clamping down on the guide blocks with the carriage blocks. See Fig. 5.

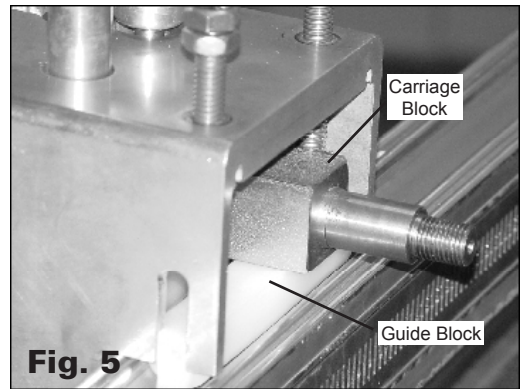
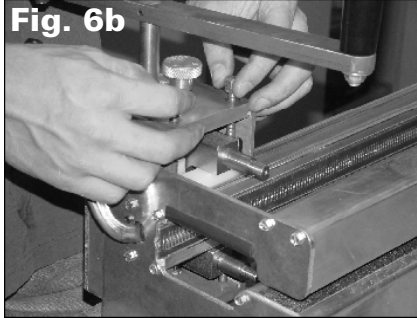


Fig. 6a

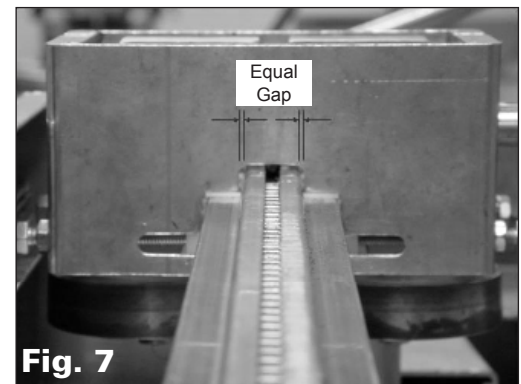


Fig. 6b



Step 6: Use a deep well socket or a nut driver to turn the guide block adjusting bolts on the bottom of the head down to just finger tight. Perform the same operation with the top adjusting bolts. See Fig. 6a & 6b.

Step 7: Visually verify that the amount of gap between the housing cutout and the aluminum extrusion is approximately equal on the two sides shown in Fig. 7. If the gap is not equal, open the rollers by turning the adjusting knob and loosen the adjusting screws on the wide side of the gap approximately $\frac{1}{4}$ to $\frac{1}{2}$ turn. Next take the adjusting screws on the opposite side to finger tight. Repeat this process until the amount of gap on each side of the extrusion is approximately equal.

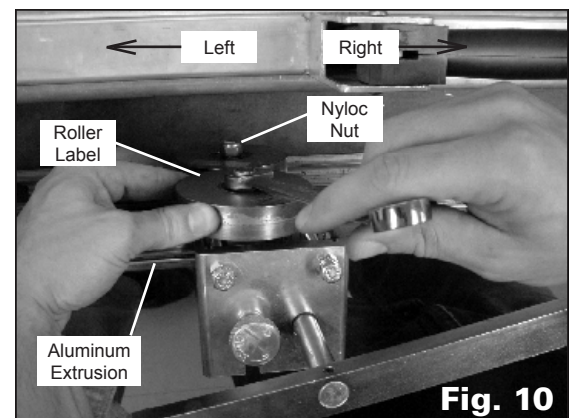


Step 8: Tighten the adjusting bolt jam nuts on both the top and bottom of the head. See Fig. 8.



Step 9: The head should now be securely attached to the lacer body. This means that the head will not move with respect to the aluminum extrusion when being rocked by hand in any direction. Run the head up and down the aluminum extrusion by turning the drive handle. The head should move with little effort. If the drive handle feels hard to turn, you may have to adjust the top guide block adjusting bolts out slightly to relieve some of the pressure. The correct amount of pressure is such that the head does not move with respect to the aluminum extrusion when being rocked by hand in any direction, but still operates with little effort when turning the drive handle.

Step 10: To finish, place the rollers back onto the roller shafts and pull them up against the aluminum extrusion. Make sure that the labels on the rollers are facing away from the aluminum extrusion. The rollers are cut on a taper. The larger diameter of the roller should be facing out (the side with the label) and the smaller diameter of the roller should be against the extrusion. While looking in a downward direction at the top of the head, push the roller all the way to the right when tightening the Nyloc hex nut. See Fig. 10. The Nyloc nut must be tightened until the roller makes light contact with the extrusion while spinning it. Next, the Nyloc nut needs to be loosened $\frac{1}{4}$ to $\frac{1}{2}$ turn to allow free rotation of the roller. Repeat this procedure for both of the rollers. The Roller Lacer is now ready for service.



2525 Wisconsin Avenue • Downers Grove, IL 60515-4200 • USA
Tel: (630) 971-0150 • Fax: (630) 971-1180 • E-mail: info@flexco.com

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