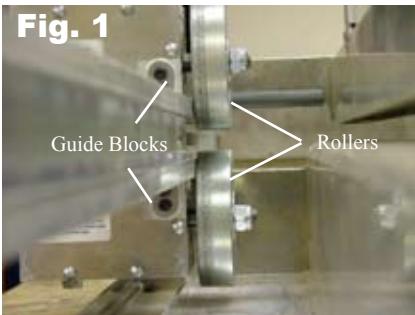


Upgrading the Lacer Head on the Roller Lacer®

(Serial Numbers 50,000+)



Step 1: Remove the old lacer head by first removing both rollers and then all four guide blocks. See Fig. 1.

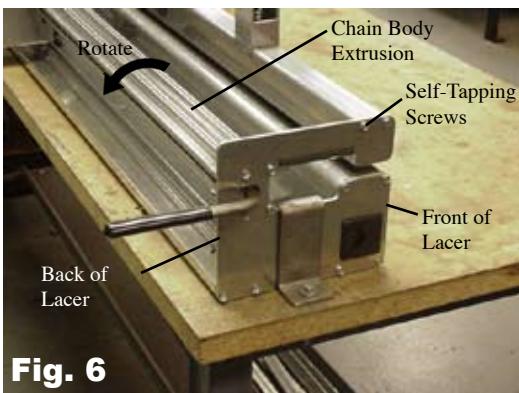
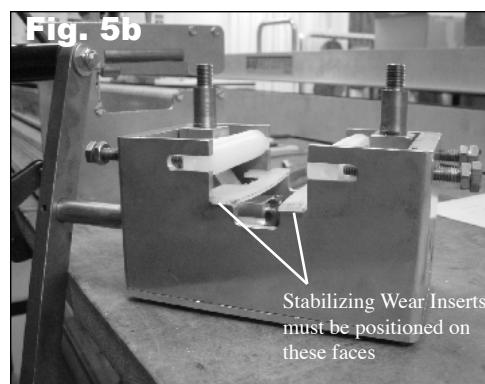
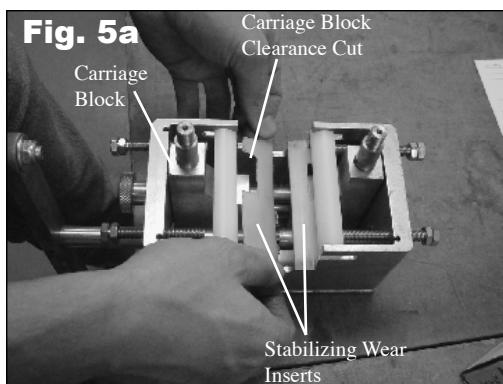
Step 2: Remove the bottom lacer tray by loosening and removing the four self tapping screws that secure the bottom pan to the side plates (two screws at each end). See Fig. 2.

Step 3: To detach the bottom tray place the Roller Lacer on its front face and then pull down on the bottom tray to remove from extrusion slot. See Fig. 3.

Step 4: To install the new, two-piece bottom tray assembly insert the black plastic tray into the slot located in the bottom main tube extrusion of the lacer. See Fig. 4. Next install the aluminum tray by inserting the plastic tray into the slot in the aluminum tray extrusion. See Fig. 4. Align the aluminum portion of the tray with the holes in the end plates and install the four self tapping screws.



Step 5: Insert the new guide blocks into the head, along with stabilizing wear inserts as shown in Fig. 5a. 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. 5b. **NOTE:** The flat surface of the guide block faces the carriage block.



Step 6: 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. 6.

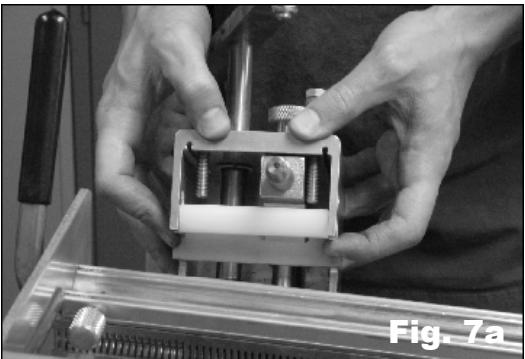


Fig. 7a

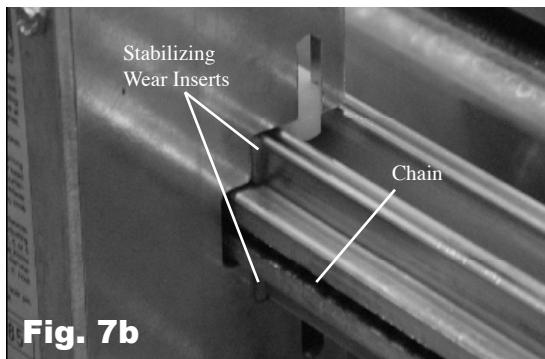


Fig. 7b

Step 7: Place the lacer head back onto the aluminum extrusion while holding stabilizing wear inserts in place. See Fig. 7a. 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. 7b.

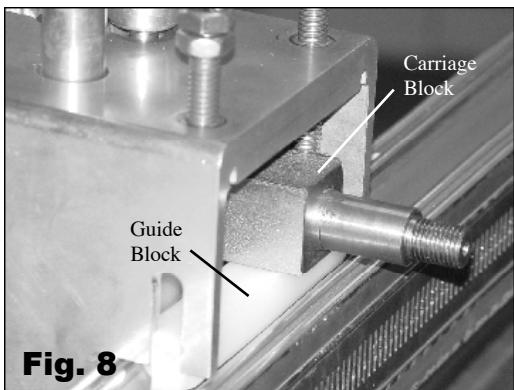


Fig. 8

Step 8: 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. 8.

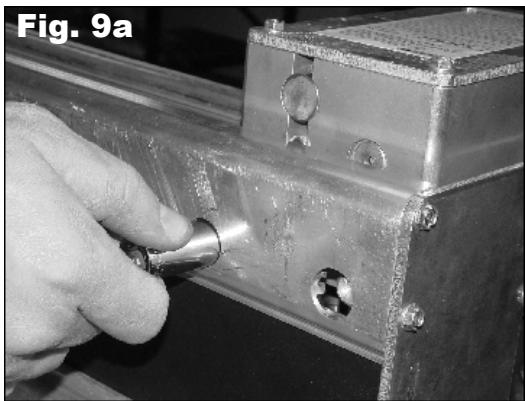


Fig. 9a

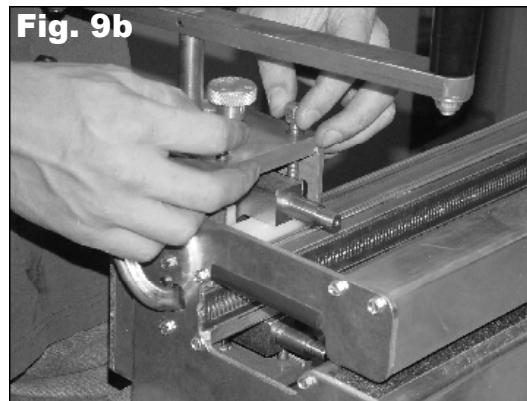
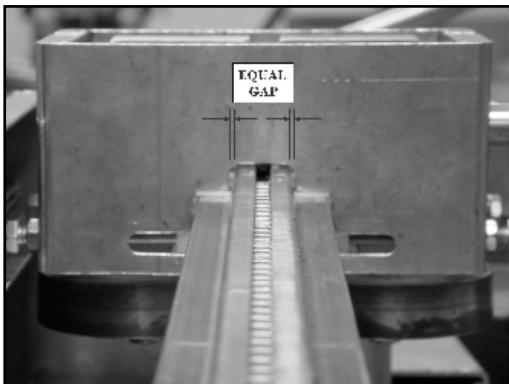


Fig. 9b



Step 10: 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. 10. 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.



Fig. 8

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

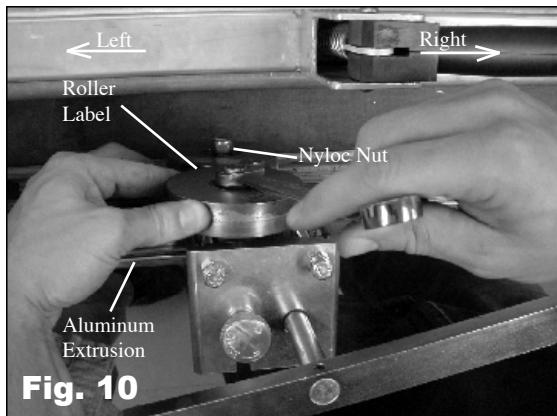


Fig. 10

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.



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