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Kit Instruction—

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K11 0002DN
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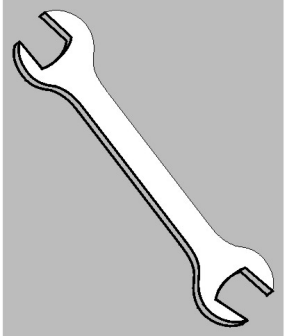
K11 0002N
K13 0001
K13 0001H
K13 0001R
K13 0001S



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This manual may contain references to "yellow pages." Although the pages containing troubleshooting procedures are no longer printed on yellow paper, troubleshooting instructions, if any, will be contained in the easily located "Troubleshooting" chapter or section. See the table of contents.

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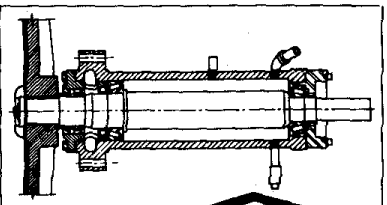

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MAINTENANCE BULLETIN B22MB84006
October 21, 1983

RE: PROPER BELT TENSIONING

Gentlemen:

Proper belt tensioning is important not only to the service life of the belts themselves but also motor and bearing life. Of course, the service life of V belts depends on other normal maintenance functions.

Upon installation, the pulleys should be checked for alignment and that the pulleys are not cocked, chipped or damaged in any way. Also, be sure there is no foreign matter build up inside the grooves.

New V belts will stretch their most during their first 6 to 8 weeks of operation. Therefore, after proper installation, tension should be checked after the first 6 to 8 weeks of operation and at least once a year thereafter. And most certainly if a squeal is detected.

Finally, V belts must be kept relatively clean. This means a periodic check and cleaning by blower, vacuum, etc. of the belts dust, lint, etc. which settle from the air. Liquids of any type (water or oil) should be kept away from belts.

In this regard we are pleased to provide the attached instructions for checking and adjusting V belt tension on MILNOR washer-extractors. These instructions are provided in four different sections, each containing tension tables for various size machines. Only one copy of each is attached but we will provide more upon request at no charge. It is suggested that you order one complete set for each mechanic.

The belt tension tester, mentioned in the instructions, is available from MILNOR under our part number 30T001. Please check with our Parts Department for price.

We are happy to offer these instructions and if there are any questions, please contact anyone in our Service Engineering Department.

Very truly yours,

PELLERIN MILNOR CORPORATION

Leroy J. Trevigne
Supervisor, Service Engineering

LJT/kf

Attachment

V-BELT TENSION ADJUSTMENTS FOR 30" AND 36" B-TYPE MACHINES AND 42" Q-TYPE MACHINES

This instruction is to be used for adjusting the belt tension on the following machine modes:

30016BWE	42026QHE
36021BWE	42026QTG
360326QWE	42026QTH
42026QWE	

A belt tension testing device (Milnor® part number 30T001) and a straight edge are required when using these instructions.

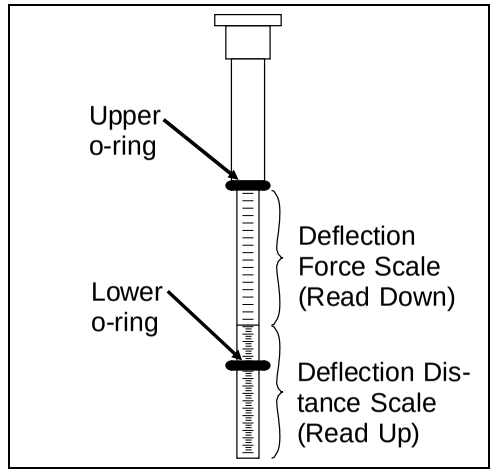

FIGURE 1 (MSSM0204AE)
Tension Tester Scales

Tension Settings

Set the o-rings on the tension testing device (see FIGURE 1) as follows:

1. Move the upper o-ring to the topmost position, resting against the bottom edge of the cap.
2. Find the proper belt deflection setting (by machine model and belt function) in the appropriate table below.
3. Move the lower o-ring on the tension tester to this deflection setting on the inches scale.

NOTE 1: The tension testing device is marked on the one side in inches and pounds and on the other side in centimeters and kilograms. All values in the tables are marked.

NOTE 2: The instruction sheet provided with the tension testing device should not be used. Use only the instructions provided herein.

NOTE 3: The reference (ref.) codes shown in the tables are for factory use only.

Belt Tension Measurements

1. Place a straight edge along the top edge of the belt to be tested so that it spans both pulleys. Place the tension tester in the center of the belt and press and down on the cap until the lower o-ring is in line with the straight edge, as shown.
2. Read the setting of the upper o-ring on the LBS scale of the tension tester.
3. Compare this value with the acceptable range in the appropriate table. If the belt is brand new (has never been run), use the range in the Initial Tension column. If the belt is not brand new, locate the acceptable range in the Final Tension column.

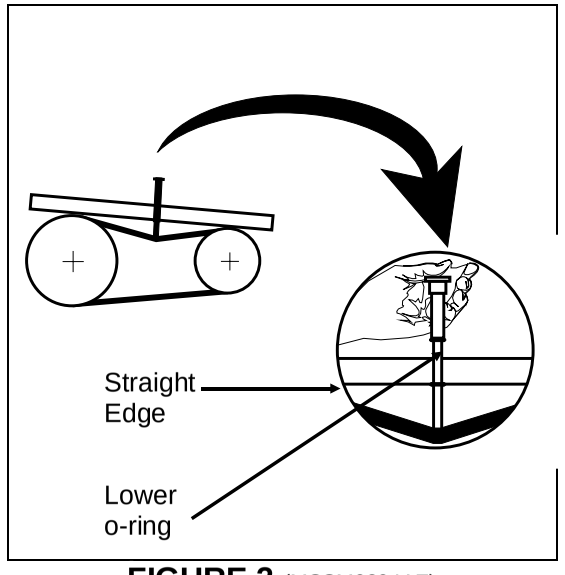

FIGURE 2 (MSSM0204AE)
Taking Measurements with the Tension Tester

4. If the reading on the tension tester is less than the range shown in the table, the belt is too loose and must be tightened. If the reading is greater than the range shown in the table, the belt is too tight and must be loosened. Adjust the belt until the reading falls within the acceptable range in the table.

30016BWE

		Belt Deflect. (inches)	Initial Tension (lbs.)	(ref.)	Initial Tension (lbs.)	(ref.)
WASH/ 2 SPEED WASH	50C	5/16	6.6 – 9.2	KP3	5.1 – 7.1	KN
	60C	11/32	2.4 – 2.84	DP2	2.0 – 2.4	DN
DRAIN	50C	5/16	9.6 – 13.0	MP3	7.4 – 10.0	MN
	60C	11/32	2.8 – 4.0	EP2	2.4 – 3.37	EN
HIGH SPEED EXTRACT	50C	25/64	10.5 – 14.3	NP3	8.1 – 11.0	NN
	60C	25/64	8.0 – 11.0	LP3	6.2 – 8.5	LN
LOW SPEED EXTRACT	50C	11/64	9.0 – 13.0	MP3	7.4 – 10.0	MN
	60C	5/32				

36021BWE

		Belt Deflect (IN)	Initial Tension (lbs.)	(ref.)	Initial Tension (lbs.)	(ref.)
WASH/ 2 SPEED WASH	50C	13/32	2.4 – 2.8	DP2	2 – 2.4	DN
	60C	13/32	2.4 – 2.8	DP2	2 – 2.4	DN
DRAIN	50C	25/64	9.6 – 13.0	MP3	7.4 – 10.0	MN
	60C	23/64	2.8 – 4.0	EP2	2.4 – 3.4	EN
HIGH SPEED EXTRACT	50C	27/64	10.5 – 14.3	NP3	8.1 – 11.0	NN
	60C	27/64	9.6 – 13.0	MP3	7.4 – 10.0	MN
LOW SPEED EXTRACT	50C	11/64	6.6 – 9.2	KP3	5.1 – 7.1	KN
	60C	11/64				

36026QWE

		Belt Deflect. (inches)	Initial Tension (lbs.)	(ref.)	Initial Tension (lbs.) (ref.)	
WASH/ 2 SPEED WASH	50C	13/32	2.4 – 2.84	DP2	2.0 – 2.4	DN
	60C	13/32				
DRAIN	50C	25/64	9.6 – 13.0	MP3	7.4 – 10.0	MN
	60C	13/32	2.8 – 4.0	EP2	2.4 – 3.34	EN
HIGH SPEED EXTRACT	50C	7/16	9.6 – 13.0	MP3	7.4 – 10.0	MN
	60C	7/16	8.0 – 11.0	LP3	6.2 – 8.5	LN
LOW SPEED EXTRACT	50C	3/16	9.6 – 13.0	MP3	7.4 – 10.0	MN
	60C	3/16				

42026QWE

		Belt Deflect (IN)	Initial Tension (lbs.)	(ref.)	Initial Tension (lbs.)	(ref.)
WASH/ 2 SPEED WASH	50C	11/32	9.6 – 13.0	MP3	7.4 – 10.0	MN
	60C	23/64	2.8 – 4.0			
DRAIN	50C	23/64		EP2	2.4 – 3.4	EN
	60C	23/64	10.5 – 14.3			
HIGH SPEED EXTRACT	50C	7/16	9.6 – 13.0	NP3	8.1 – 11.0	NN
	60C	7/16	9.6 – 13.0	MP3	7.4 – 10.0	MN
LOW SPEED EXTRACT	50C	1/4	6.6 – 9.2	MP3	7.4 – 10.0	MN
	60C	1/4		KP3	5.1 – 7.1	KN

42026QHE, QTG, QTH

		Belt Defl. (inches)	Initial Tension (lbs.)	(ref.)	Final Tension (lbs.)	(ref.)
WASH/ 2 SPEED WASH		19/64	9.62 – 13.0	MP3	7.4 – 10.0	MN
DRAIN		5/32	10.5 – 14.3		8.1 – 11.0	
MAIN	50C	31/64	10.5 – 14.3	NP3	8.1 – 11.0	NN
	60C	15/32				
OPTIONAL LOW SPEED EXRACT		19/64	8.0 – 11.0	LP3	6.2 – 8.5	LN

V-BELT TENSION ADJUSTMENTS

This instruction is to be used for adjusting the belt tension on the following machine models:

42031WE2	42031SG2	42031WE3	42031SG3
42044WE2	42044SG2	42044WE3	42044SG3

A belt tension testing device (Milnor® part number 30T001) and a straight edge are required when using these instructions.

Tension Settings

Set the o-rings on the tension testing device (FIGURE 1) as follows:

1. Move the upper o-ring to the topmost position, resting against the bottom edge of the cap.

2. Find the proper Belt Deflection setting (by machine model and belt function) in the appropriate table in this section.

3. Move the lower o-ring on the tension tester to this deflection setting on the inches scale.

NOTE 1: The tension testing device is marked on one side in inches and pounds and on the other side in centimeters and kilograms. All values in the tables are in inches (in) and pounds (lbs).

NOTE 2: The instruction sheet provided with the tension testing device should not be used. Use only the instructions provided herein.

NOTE 3: The reference (ref) codes shown in the tables are for factory use only.

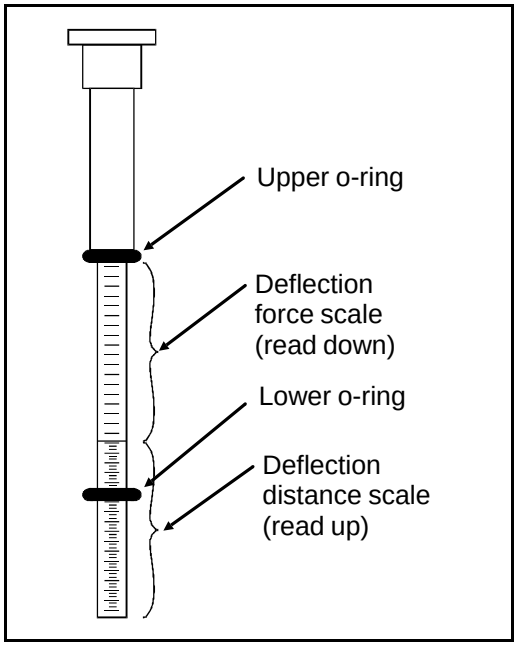

FIGURE 1 (MSSM0301AE)
Tension Tester Scales

Belt Tension Measurements

1. Place a straight edge along the top edge of the belt to be tested so that it spans both pulleys. Place the tension tester in the center of the belt and press down on the cap until the lower o-ring is in line with the straight edge, as shown.
2. Read the setting of the upper o-ring on the lbs scale of the tension tester.
3. Compare this value with the acceptable range in the appropriate table. If the belt is brand new (has never been run), use the range in the Initial Tension column. If the belt is not brand new, locate the acceptable range in the Final Tension column.

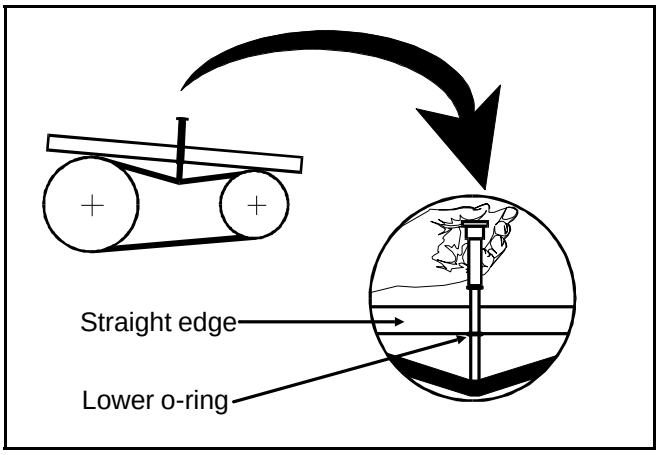

FIGURE 2 (MSSM0301AE)
Taking Measurements with the Tension Tester

4. If the reading on the tension tester is *less* than the range shown in the table, the belt is *too loose* and must be tightened. If the reading is *greater* than the range shown in the table, the belt is *too tight* and must be loosened. Adjust the belt until the reading falls within the acceptable range in the table.

42031WE2/WE3 and 42044WE2/WE3 Belt Tension Measurements

		Belt Deflection (inches)	Initial Tension		Final Tension	
			(LBS)	(REF)	(LBS)	(REF)
Wash/2-Speed Wash		11/64	9.6-13.0	MP3	7.4-10.0	MN
Drain		3/8	8.0-11.0	LP3	6.2-8.5	LN
Main	50Hz	9/16	10.5-14.3	NP3	8.1-11.0	NN
	60Hz	37/64				

42031SG2/SG3 and 42044SG2/SG3 Belt Tension Measurements

		Belt Deflection (inches)	Initial Tension		Final Tension	
			(LBS)	(REF)	(LBS)	(REF)
Wash/2-Speed Wash		11/64	9.6-13.0	MP3	7.4-10.0	MN
Drain		3/8	8.0-11.0	LP3	6.2-8.5	LN
E1 (optional)		11/32	9.6-13.0	MP3	7.4-10.0	MN
Upper Jackshaft to Lower Jackshaft	50Hz	13/16	10.5-14.3	NP3	8.1-11.0	NN
	60Hz	13/16				

V-BELT TENSION ADJUSTMENTS FOR 48", 52", 60" AND 72" WASHER-EXTRACTORS

This instruction is to be used for adjusting the belt tension on the following machine models:

48032BHE	48032BTG	48032BTH	48036QHE	48036QTG	48036QTH		
52038WE1	52038WTF	52038WTB	52038WTG	52038WTH			
60036WE2	60036WE3	60036SG2	60036SG3	60044WE2	60044WE3	60044SG2	60044SG3
72044SG2	72044SG3	72044WE2	72044WE3	72044WTB	72044WTG	72044WTH	

A belt tension testing device (Milnor® part number 30T001) and a straight edge are required when tensioning unbanded belts.

Tension Settings—Unbanded Belts

Set the o-rings on the tension testing device (see FIGURE 1) as follows:

1. Move the upper o-ring to the topmost position, resting against the bottom edge of the cap.
2. Find the proper belt deflection setting (by machine model and belt function) in the appropriate table below.
3. Move the lower o-ring on the tension tester to this deflection setting on the inches scale.

NOTE 1: The tension testing device is marked on one side in inches and pounds and on the other side in centimeters and kilograms. All values in the tables are in inches (in.) and pounds (lbs.).

NOTE 2: The instruction sheet provided with the tension testing device should not be used. Use only the instructions provided herein.

NOTE 3: The reference (ref.) code shown in the tables are for factory use only.

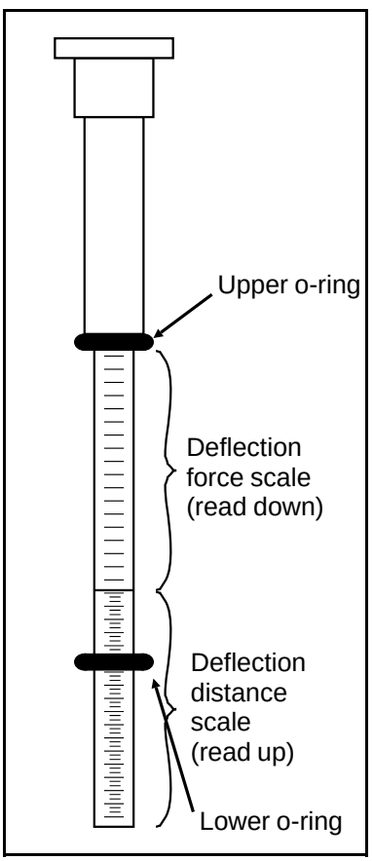

FIGURE 1 (MSSMA405AE)
Tension Settings

Belt Tension Measurements

Unbanded Belts

1. Place a straight edge along the top edge of the belt to be tested so that it spans both pulleys. Place the tension tester in the center of the belt and press down on the cap until the lower o-ring is in line with the straight edge, as shown.

2. Read the setting of the upper o-ring on the lbs scale of the tension tester.

3. Compare this value with the acceptable range in the appropriate table. If the belt is brand new (has never been run), use the range in the Initial Tension column. If the belt is not brand new, locate the acceptable range in the Final Tension column.

4. If the reading on the tension tester is *less* than the range shown in the table, the belt is *too loose* and must be tightened. If the reading is *greater* than the range shown in the table, the belt is *too tight* and must be loosened. Adjust the belt until the reading falls within the acceptable range in the table.

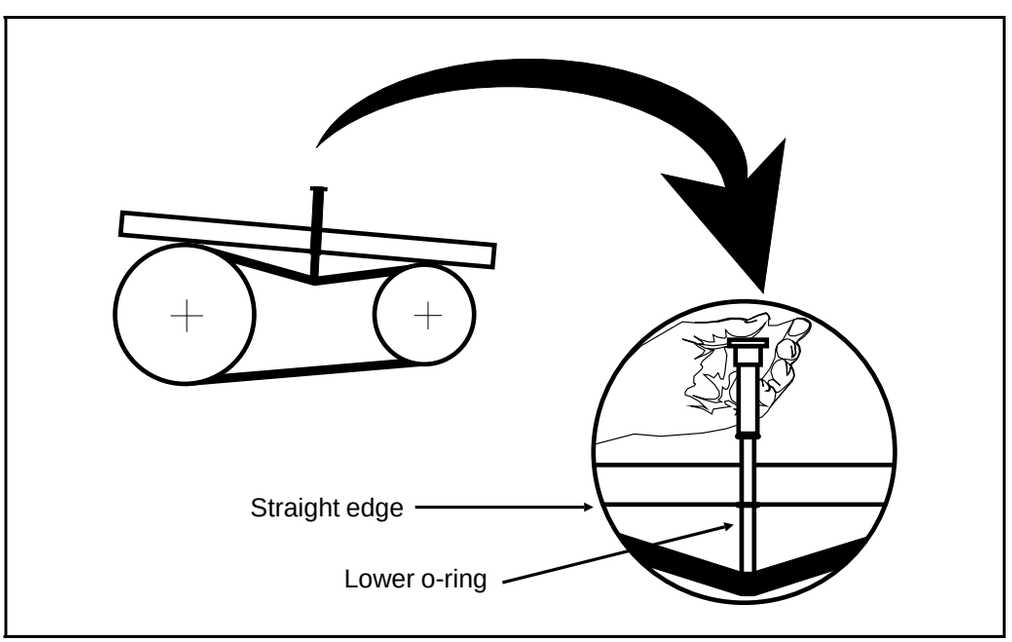

FIGURE 2 (MSSMA405AE)
Measuring Belt Tension

Tensioning Banded Belts

48032BHE, BTG, BTH

	Belt Deflect. (inches)	Initial Tension (lbs.)	(ref.)	Initial Tension (lbs.)	(ref.)
WASH/ 2 SPEED WASH	9/32	6.6 - 9.2	KP3	5.1 - 7.1	KN
DRAIN	5/32	5.7 - 7.6	JP3	4.4 - 5.9	JN
MAIN 50C	35/64	10.5 - 14.3	NP3	8.1 - 11.0	NN
MAIN 60C	17/32				
LOW SPEED EXTRACT	13/64	6.6 - 9.2	KP3	5.1 - 7.1	KN

48036QHE, QTG, QT

Belt Deflect (in.)	Initial Tension (lbs.)	(ref.)	Initial Tension (lbs.)	(ref.)
5/16	5.7 - 7.6	JP3	4.4 - 5.9	JN
5/32	6.6 - 9.2	KP3	5.1 - 7.1	KN
17/32	10.5 - 14.3	NP3	8.1 - 11.0	NN
17/32				
3/16	9.62 - 13.0	MP3	7.4 - 10.0	MN

52038WE1, WTF, WTB, WTG, WTH

	Belt Deflect. (inches)	Initial Tension (lbs.)	(ref.)	Initial Tension (lbs.)	(ref.)
WASH/ 2 SPEED WASH	25/64	10.5 - 14.3	NP3	8.1 - 11.0	NN
DRAIN	5/32	10.5 - 14.3	NP3	8.1 - 11.0	NN
E1	1/4	6.6 - 9.2	KP3	5.1 - 7.1	KN
E2	1/2	6.6 - 9.2	KP3	5.1 - 7.1	KN
MAIN 50C	11/16	18.2 - 26.0	SP3	14.0 - 20.0	SN
MAIN 60C	23/32	16.9 - 20.8	RP3	13.0 -16.0	RN

60036 + 60044WE2 + WE3

Belt Deflect (in.)	Initial Tension (lbs.)	(ref.)	Initial Tension (lbs.)	(ref.)
3/16	5.7 - 7.6	JP3	4.4 - 5.9	JN
13/32	6.6 - 9.2	KP3	5.1 - 7.1	KN
17/64	6.6 - 9.2	KP3	5.1 - 7.1	KN
11/32	6.6 - 9.2	KP3	5.1 - 7.1	KN
43/64	16.9 - 20.8	RP3	13.0 - 16.0	RN
45/64				

48032BHE, BTG, BTH

	Belt Deflect. (inches)	Initial Tension (lbs.)	(ref.)	Initial Tension (lbs.)	(ref.)
WASH/ 2 SPEED WASH	1/4	5.7 - 7.6	JP3	4.4 - 5.9	JN
DRAIN	3/64	6.6 - 9.2	KP3	5.1 - 7.1	KN
E-1	9/32	6.6 - 9.2	KP3	5.1 - 7.1	KN
E-2	39/64	6.6 - 9.2	KP3	5.1 - 7.1	KN
UPPER JACK TO LOWER JACK LOWER JACK TO UPPER JACK	BANDED BELTS NEED SPECIAL INSTRUCTIONS				

48036QHE, QTG, QT

	Belt Deflect (in.)	Initial Tension (lbs.)	(ref.)	Initial Tension (lbs.)	(ref.)
WASH/ 2 SPEED WASH	17/64	5.7 - 7.6	JP3	4.4 - 5.9	JN
DRAIN	33/64	6.6 - 9.2	KP3	5.1 - 7.1	KN
E-1	17/64	6.6 - 9.2	KP3	5.1 - 7.1	KN
E-2	5/8	6.6 - 9.2	KP3	5.1 - 7.1	KN
UPPER JACK TO LOWER JACK LOWER JACK TO UPPER JACK	BANDED BELTS NEED SPECIAL INSTRUCTIONS				

52038WE1, WTF, WTB, WTG, WTH

		Belt Deflect. (inches)	Initial Tension (lbs.)	(ref.)	Initial Tension (lbs.)	(ref.)
WASH/ 2 SPEED WASH		15/64	5.7 - 7.6	JP3	4.4 - 5.9	JN
DRAIN		13/32	6.6 - 9.2	KP3	5.1 - 7.1	KN
E1		17/64	6.6 - 9.2	KP3	5.1 - 7.1	KN
E2		5/16	6.6 - 9.2	KP3	5.1 - 7.1	KN
MAIN	50C	45/64	16.9 - 20.8	RP3	13.0 -16.0	RN
	60C	11/16	16.9 - 20.8	RP3	13.0 -16.0	RN

60036 + 60044WE2 + WE3

		Belt Deflect (in.)	Initial Tension (lbs.)	(ref.)	Initial Tension (lbs.)	(ref.)
WASH/ 2 SPEED WASH		15/64	5.7 - 7.6	JP3	4.4 - 5.9	JN
DRAIN		25/64	6.6 - 9.2	KP3	5.1 - 7.1	KN
E1		17/64	6.6 - 9.2	KP3	5.1 - 7.1	KN
E2		5/16	6.6 - 9.2	KP3	5.1 - 7.1	KN
MAIN	50C	3/4	16.9 - 20.8	RP3	13.0 - 16.0	RN
	60C	23/32	16.9 - 20.8	RP3	13.0 - 16.0	RN

GUIDELINES FOR CHANGING 36" & 42" QWE REMANUFACTURED BEARING HOUSINGS

In addition to the usual procedure for changing a 36" & 42" QWE bearing housing, the guidelines below should be followed. These guidelines are primarily to prevent stripping the threads in the bearing housing mounting holes.

1. Rear bearing housing support plate must be removed first. Do Not merely remove rear bearing housing bolts & leave plate in machine bolted to the side and top. Remove it!

2. Remove bearing housing from machine.
3. Be sure all threaded holes in remanufactured bearing housing are clean. Blow out with air or run tap in holes to clean if necessary.
*4. Try a bolt in each hole, by hand, before installing remanufactured bearing housing, to be sure bolts go in each hole easily, meaning threads are clean & in good condition.

***NOTE: This step may not be necessary as remanufactured bearing housings are shipped with bolts in all mounting holes.**

5. Install new bearing housing in machine without rear support.
6. Be sure holes in front flange of bearing housing line up with holes in shell back by first installing all bolts by hand.
7. Do not tighten any bolts until all front flange bolts have been started into the bearing housing about 3/4 of the way.
8. Tighten all front flange bolts in a diagonal pattern to draw housing into shell back evenly.
9. At this point all front flange bolts should now be torqued to proper specifications.

NOTE: Only after all above steps have been taken should you proceed with the following steps to install the rear bearing housing support plate.

10. Before installing rear support plate, drop a bolt into each hole to insure the bolts fit cleanly through the holes. Also, the head of the bolt fits "flush" against the support plate. If not, open the hole slightly with a drill and bit to insure the bolt head does fit flush against the support plate.
11. Install bearing housing rear support plate by installing bolts through center hole circle into bearing housing. Do Not install side or top support bolts at this time!
12. Install all rear bearing housing bolts into rear of bearing housing, through rear support plate by hand about 3/4 of the way.
13. Tighten all rear bearing housing support plate bolts in a diagonal pattern until all are tight.
14. At this point, all rear bearing housing support plate bolts on the center circle should now be torqued to proper specifications.
15. Install, tighten and torque all side and top, rear bearing housing support bolts to proper specifications.
16. Complete the remainder of the change as usual.

Litho In U.S.A.

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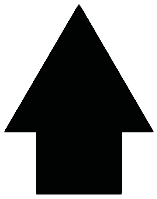
ATTENTION:

WHEN RETURNING BEARING HOUSING TO PELLERIN MILNOR CORPORATION, PLEASE INSURE THAT IT IS PACKED ACCORDING TO THIS ILLUSTRATION.

DO NOT NAIL SHUT – USE CLIPS PROVIDED.

BE SURE ARROWS ON BOX WALLS ARE POINTING UP WHEN BOX IS REASSEMBLED (ALL 4 SIDES).



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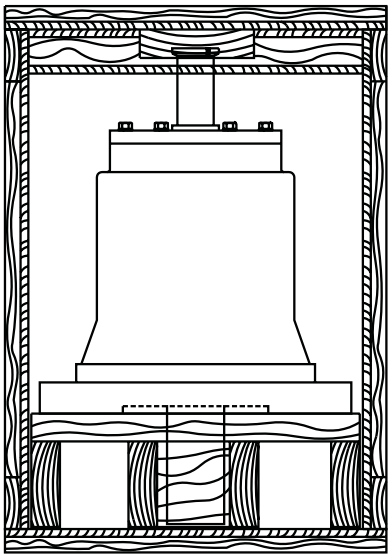

BEARING HOUSING RETURN KIT
FOR 36 & 42 BEARINGS

B2TAG82072/95312A

LUBRICATION INSTRUCTIONS

There are few lubrication points on your MILNOR Washer-Extractor. Those that are provided are there for a specific purpose, and must be faithfully serviced as recomended.

1. GEAR REDUCER: Check level before operating, refilling if necessary. After the initial 100 hours operation, drain gear reducer and refill with oil as specified on nameplate. Be sure to clean off magnetic drain plug before replacing. Check and refill every 6 months. Drain and replenish oil yearly.

2. MAIN BEARINGS AND SEALS: Proper lubrication here is mandatory. The main bearings and seals in this machine are esigned for grease lubr ation, and are arranged as shown in the main assembly drawings shown elsewhere herein. There are three grease fittings on each housing, two for the bearings, and one for the seal. The proper lubrication of both bearings and seals is mandatory for satisfactory life from the machin . The following instructions must be adhered to carefully.

   A. All grease lubricated bearing housings are factory pre-lubricated for the first 30 days of operation.

   B. Use Shell Alvania EP #2 grease.

   C. Pump grease in SLOWLY - not faster than 5 strokes per minute. Work grease gun lever slowly - TAKE AT LEAST 10-12 SECONDS TO COMPLETE EACH STROKE OF THE LEVER. A grease gun can build up extremely high pressures which will force the seals out of position and cause them to leak, even though the seal cavity is provided with a bleed-off.

   D. RUN WASHER CYLINDER AT EITHER WASH OR DRAIN SPEED DURING GREASING, AND FOR ONE MINUTE THEREAFTER.

   E. EVERY 200 OPERATING HOURS, OR EVERY 30 DAYS - WHICHEVER OCCURS FIRST:

      PUMP 2 STROKES INTO EACH BEARING GREASE FITTING.

      PUMP 1 STROKE INTO EACH SEAL CAVITY GREASE FITTING.

NOTE: It is possible, when the seals are lubricated, for a small amount of grease to work its way through the seals and into the shell. A hot water bath should be run in the machine before the first wash load after lubrication. This will prevent grease balls from forming on the wash. (This condition will not occur when the bearings are greased.) Do not pump more grease into the seal cavity than is called for above.

(Continued)

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The grease is forced into the bearing housing in such a way as to push the new grease into and through the bearings. It collects in the large central cavity.

CAUTION: MAKE SURE YOUR GREASE GUN IS WORKING AND THAT YOU GET A FULL CHARGE OF GREASE WITH EVERY STROKE. However, never pump the grease gun quickly - even if it is air bound - for damaging excessive pressures can easily be built up if this is done.

CAUTION: Be careful to keep grease from dropping on the brake drum. This will reduce the braking action considerably.

3. Lubricate door interlock plunger with a few drops of light machine oil weekly.

4. Lubricate motor bearings in accordance with motor manufacturer's recommendations Always open bearing relief plug before forcing grease into motor bearings. Remember that more motors are ruined by over-lubrication, which forces grease into the motor windings, than fail due to lack of lubrication.

5. Miltrol motor clutch, timer cylinder shaft, and chart drag spring assembly require lubrication in accordance with instructions on Miltrol Parts drawing elsewhere herein.

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INSTRUCTIONS TO INSTALL QWE BEARING HOUSING

Refer to the drawing and instructions on page BMP750052-75492A.

1. Before installing the bearing housing in the machine, use the tube of Silastic sealant furnished with the kit and coat the rear side of the bearing housing flange which seats against the shell back. Coat this surface completely but sparingly--no thicker than 1/16". Do not use any other gasket material for this purpose!
2. Before installing the bearing housing in the shell back, use Locquic primer on the two surfaces indicated on the above drawing to clean it. Then apply the Loctite stud lock also mentioned in the drawing. Put grade 222 Loctite on the main bearing housing bolts. THESE BOLTS MUST BE PUT IN WITH A TORQUE WRENCH. Tighten the bolts to the torque foot pounds specified on the drawing. Do not over tighten the bolts--follow the instructions carefully. Do not use the old locking straps previously used to hold these bolts. Use instead the grade 9 flat washers furnished in the kit.
3. Before attaching the rear cross brace to the rear end of the main bearing housing, use the Locquic primer and the Loctite mentioned on the drawing on the surfaces indicated. Secure the rear cross brace to the rear end of the main bearing housing with the new socket head screws furnished.
4. Replace the shims and the washers on top of the cross brace as necessary and drop in the bolts, but do not tighten them at this time. It may be necessary to use a drift punch to line up the shims and washers with the holes in the top of the frame. Once this is accomplished, you can easily drop the bolts in the holes from the top. Do not tighte them up at this time. Refer to the drawing on the back side of this page which shows how to use wedges for proper cylinder alignment if necessary.
5. Attach the rear cross brace to the frame side of the machine with the two side angle irons. Use the new $\frac{1}{4}$" thick flat washers furnished to cover up the slotted holes in the angle irons. Do not use the old thin washers which may collapse across the slots. After you have these bolts in place and loosely set, you are now ready to install the cylinder on the front of the main bearing housing. Before installing the cylinder, clean off any excessive Silastic which may have been squeezed out between the bearing housing flange and the shell back liner. If this is allowed to stay inside the machine, it could cause laundering problems when the machine is first put into use.
6. Once the cylinder is secured to the main shaft, install the shell front.
7. Check the opening of the shell front with the opening of the cylinder to see if they are in alignment. If the misalignment is excessive, it could cause the cylinder to strike the door. To align the cylinder, go to the rear of the machine and use wedges as shown on the drawing BMP740118R. If the cylinder is too low, drive in a wedge at point "A" shown on the drawing. If the cylinder is too far on the left, drive a wedge in between the cross brace and the base side sheet of the machine at point "B" shown on the drawing. Once the cylinder is in proper alignment, tighten up all 8 bolts, $\frac{1}{4}$" thick flat washers and lock washers to secure the cross brace in the proper place. At the same time, you are now ready to tighten the 5 bolts in the top of the rear cross brace.
8. Be sure to follow the instructions with regard to the proper tightening by foot pounds of torque shown on the installation drawing. Do not deviate from any of these instructions.

(See Reverse)

SERVICE DEPARTMENT

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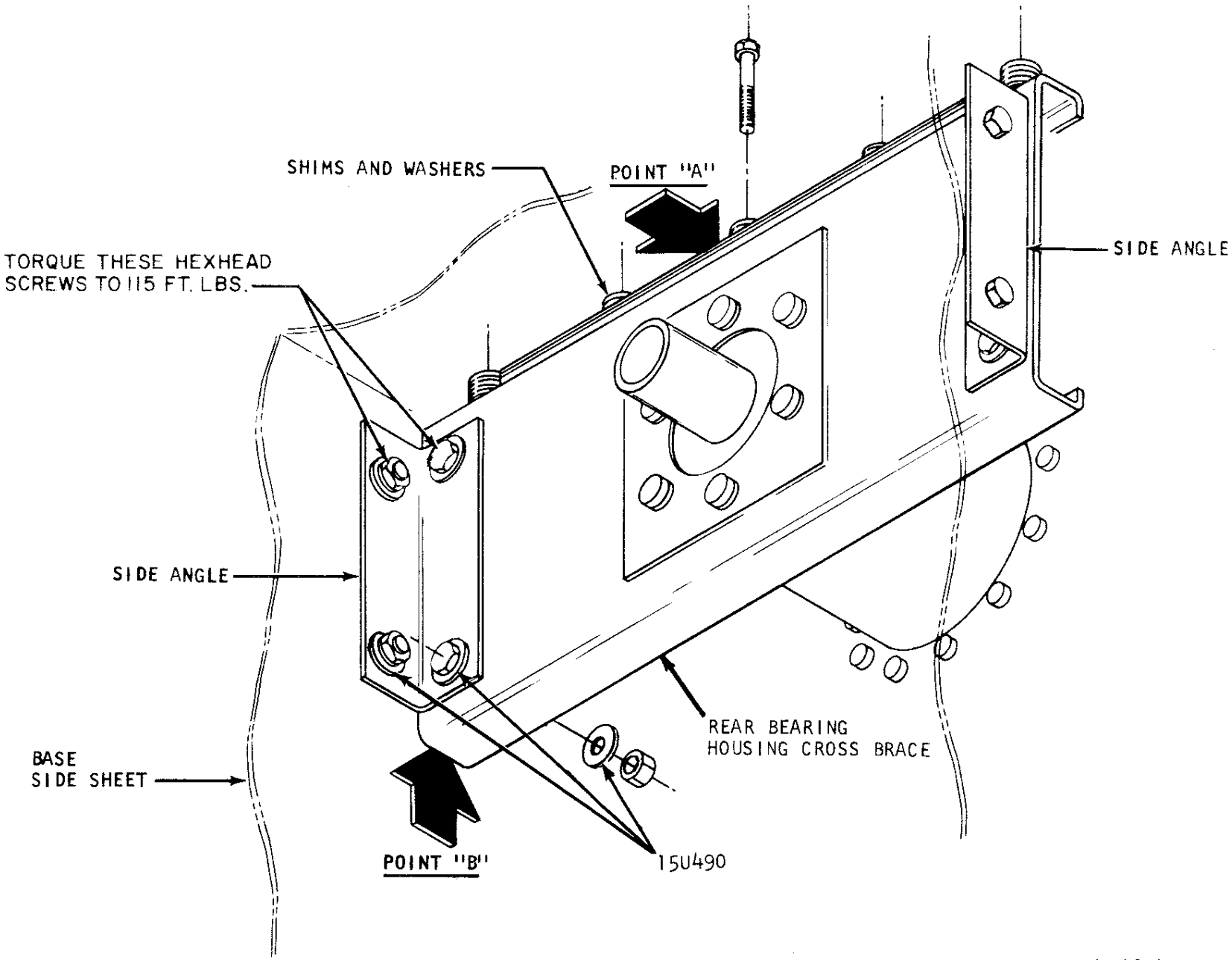
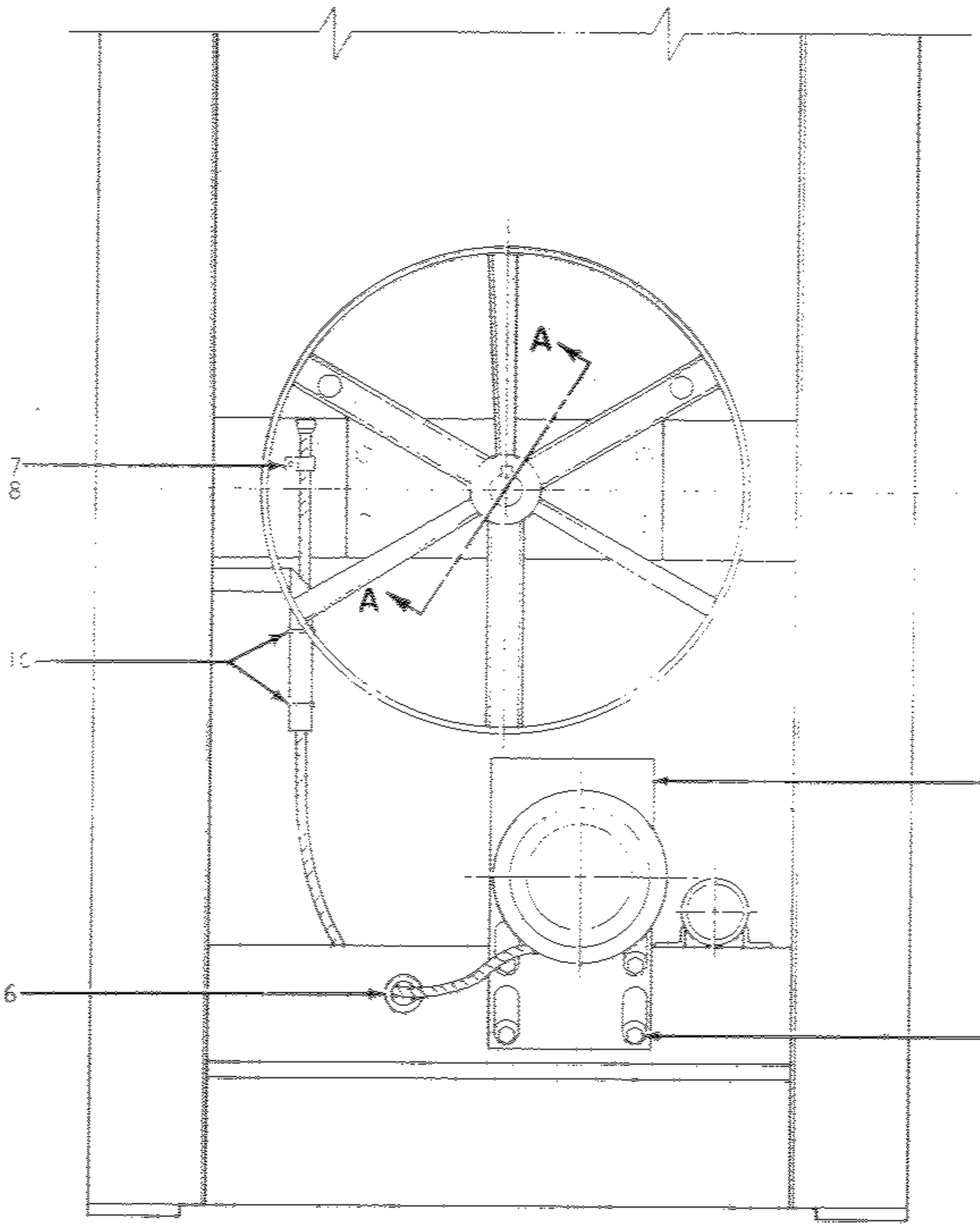
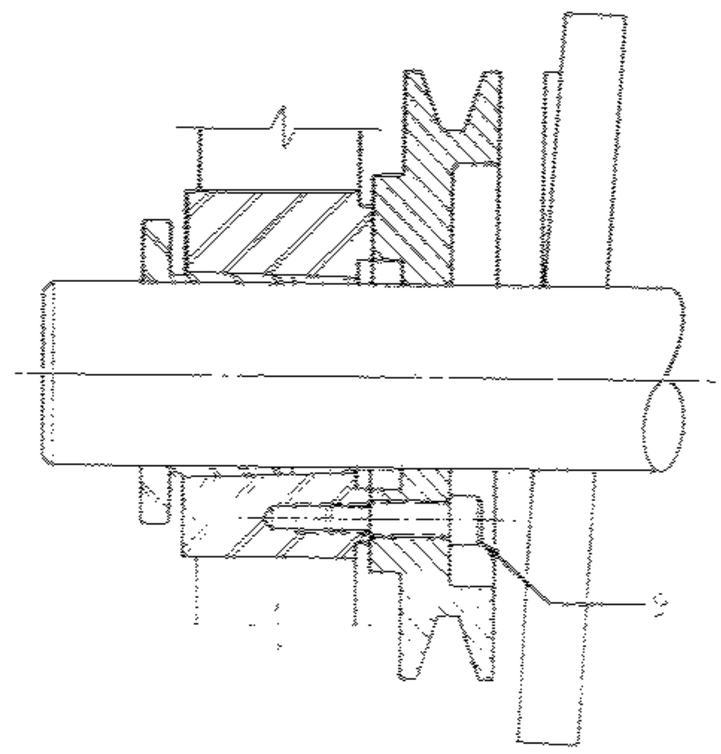


REFER TO PAGE BMP750052 FOR ADDITIONAL TORQUE INFORMATION





SECTION A-A

TIMING PULLEY & CENTRIFUGAL SWITCH ASSEMBLY

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