



Rack Repair Kit

2226 Directional Drill

Model No. 131-8953

Installation Instructions

Installing the Rack

Note: Use a minimum of 30 cm (12 inches) of rack for repair.

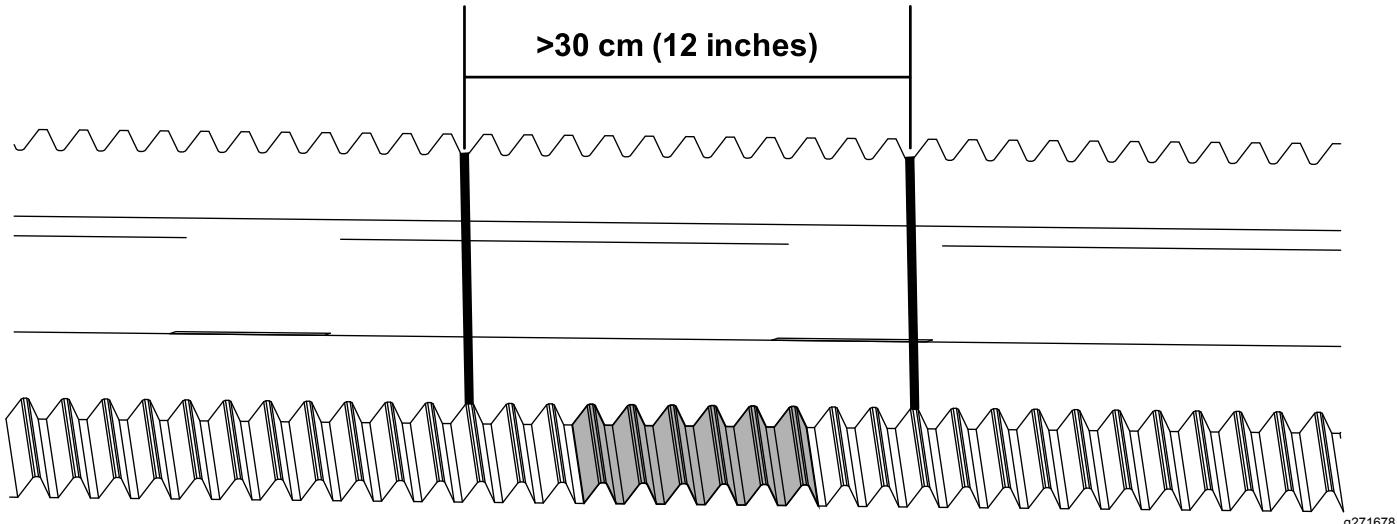


Figure 1

1. Move the machine to a level surface, shut off the engine, remove the key, turn the battery disconnect switch to the OFF position, and wait for the engine to cool; refer to the *Operator's Manual*.

Note: Remove the pipe box.



2. Use a square to line up the cut in the center of the valley of the tooth. Mark the area to be cut.

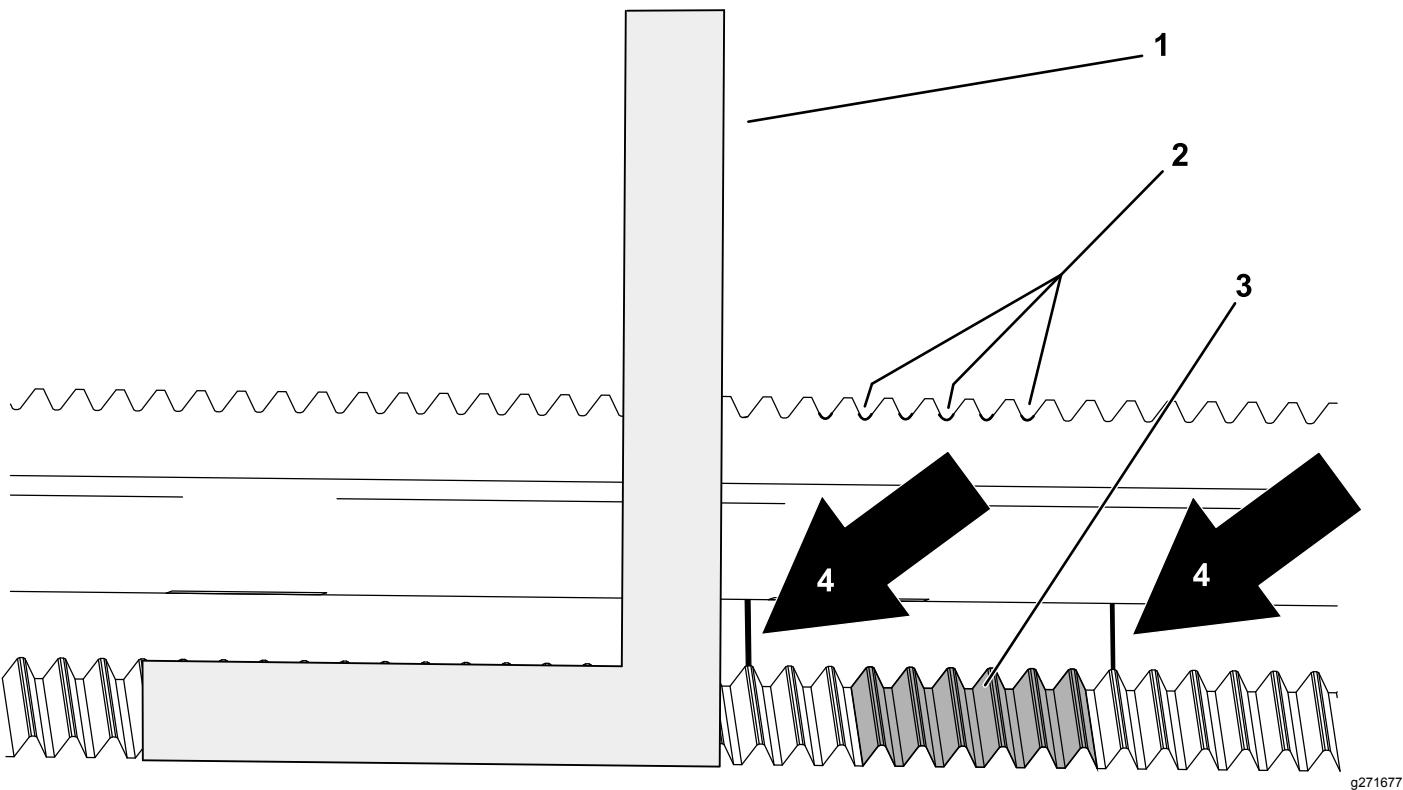


Figure 2

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1. Square

2. Valley of the teeth

3. Damaged teeth

4. Sample mark

3. Grind down the existing welds on the top and bottom of the damaged rack area.

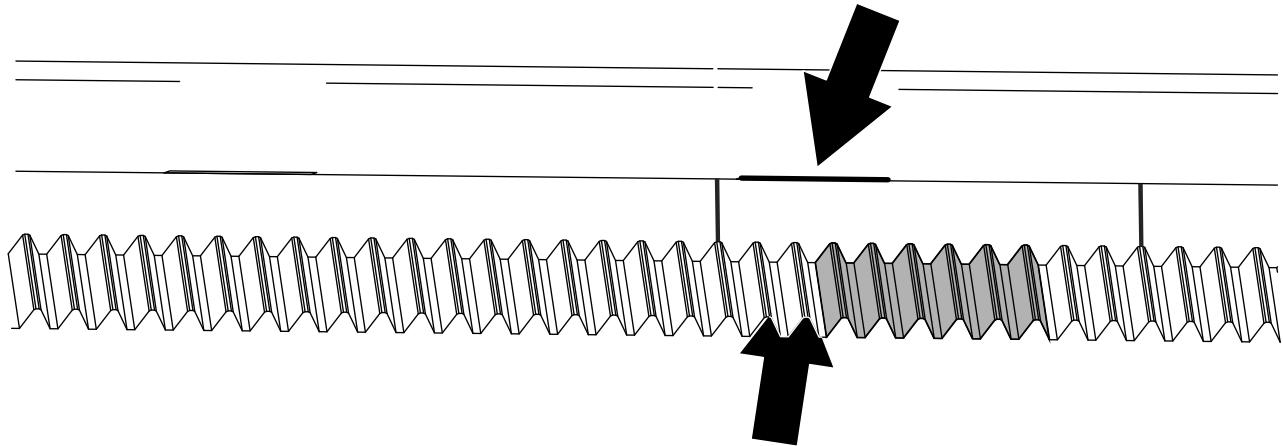


Figure 3

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4. Using a reciprocating or band saw to cut out the damaged rack.

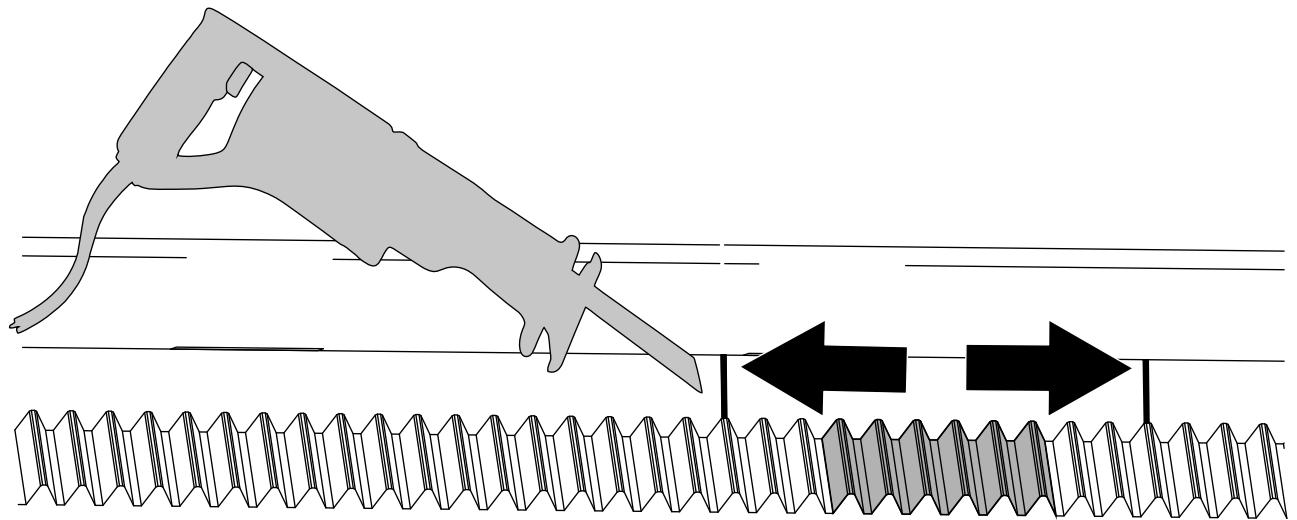


Figure 4

5. Use the cut out section to measure, mark, and cut out a new section of rack.
6. Use a piece of the cut out rack to align the new rack piece and the original rack.

Note: Grind down any damaged or bent teeth that does not allow proper alignment.

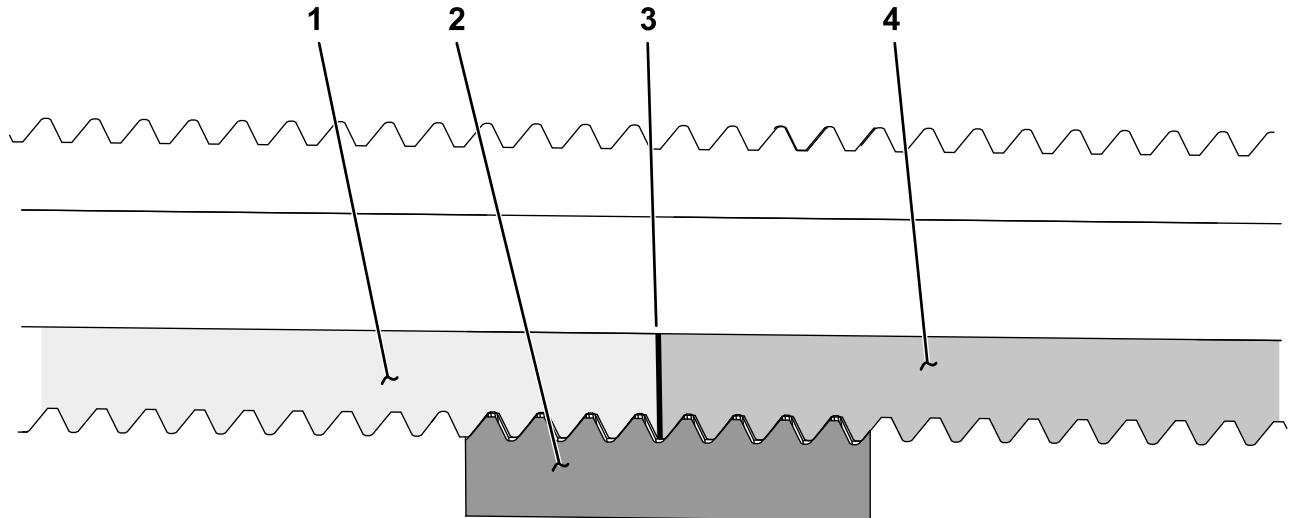


Figure 5

1. Original rack	3. Gap between the rack pieces
2. Damaged rack piece	4. New rack piece

7. Weld the rack pieces together. Weld the new rack piece to the frame. Grind down the weld areas to make it flush.

Important: Ensure that the welds and tooth root is flat or damage may occur to the rollers.

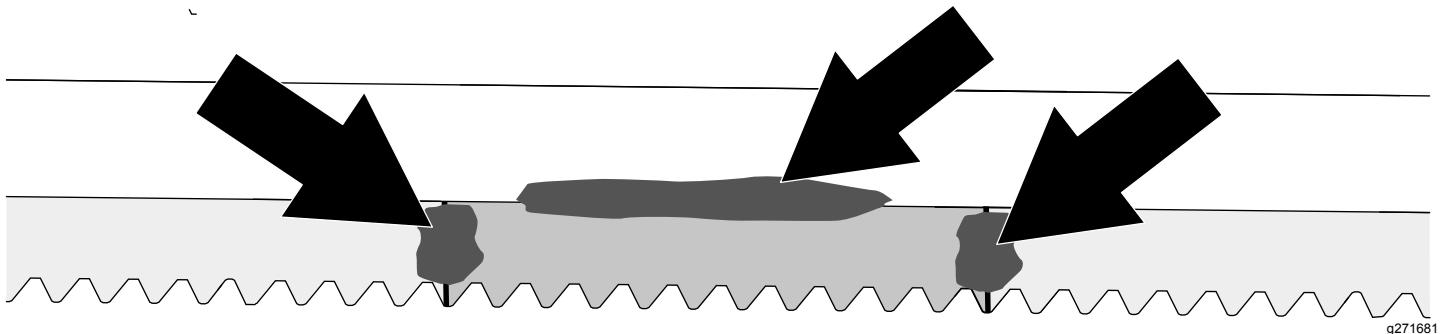


Figure 6

8. There will be a small gap at the joint of the rack pieces.

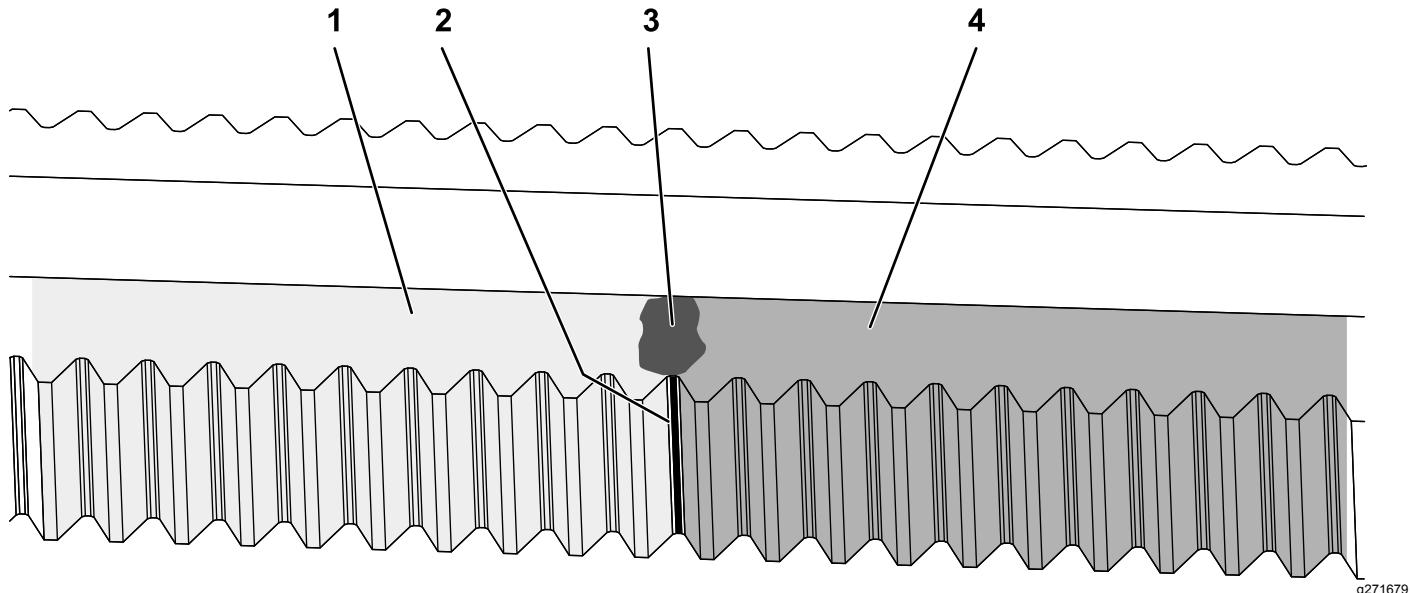


Figure 7

1. Original rack	3. Welded area
2. Gap	4. New rack piece