



Rack Repair Kit

2226 Directional Drill

Model No. 131-8953

Form No. 3427-372 Rev A

Installation Instructions

Installing the Rack

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

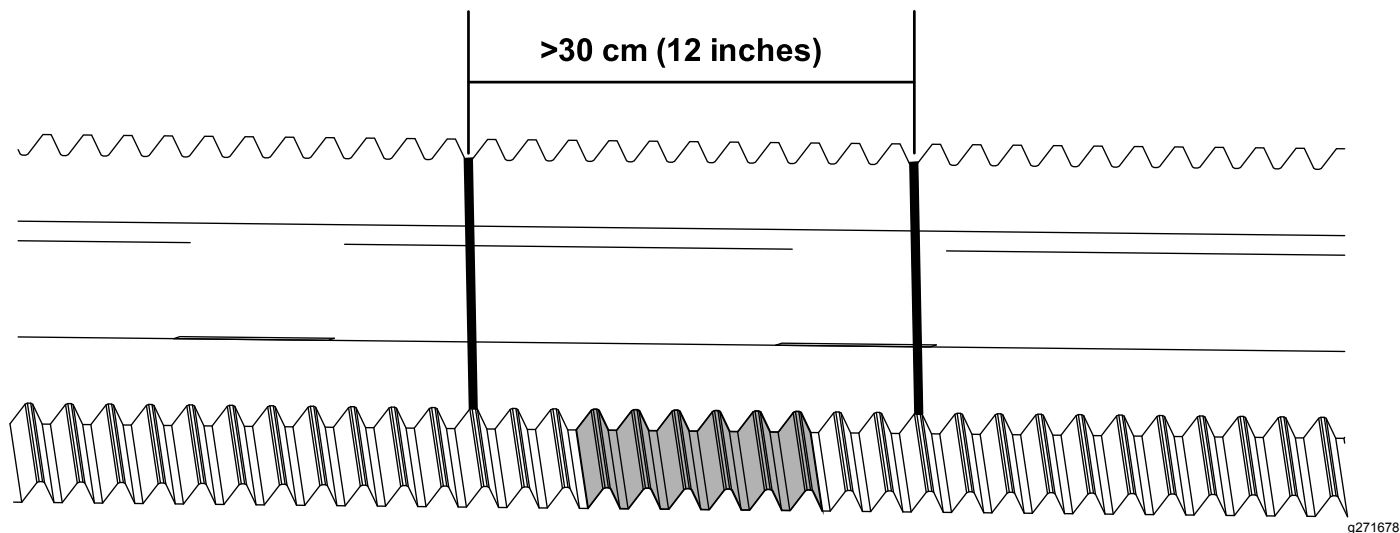


Figure 1

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.

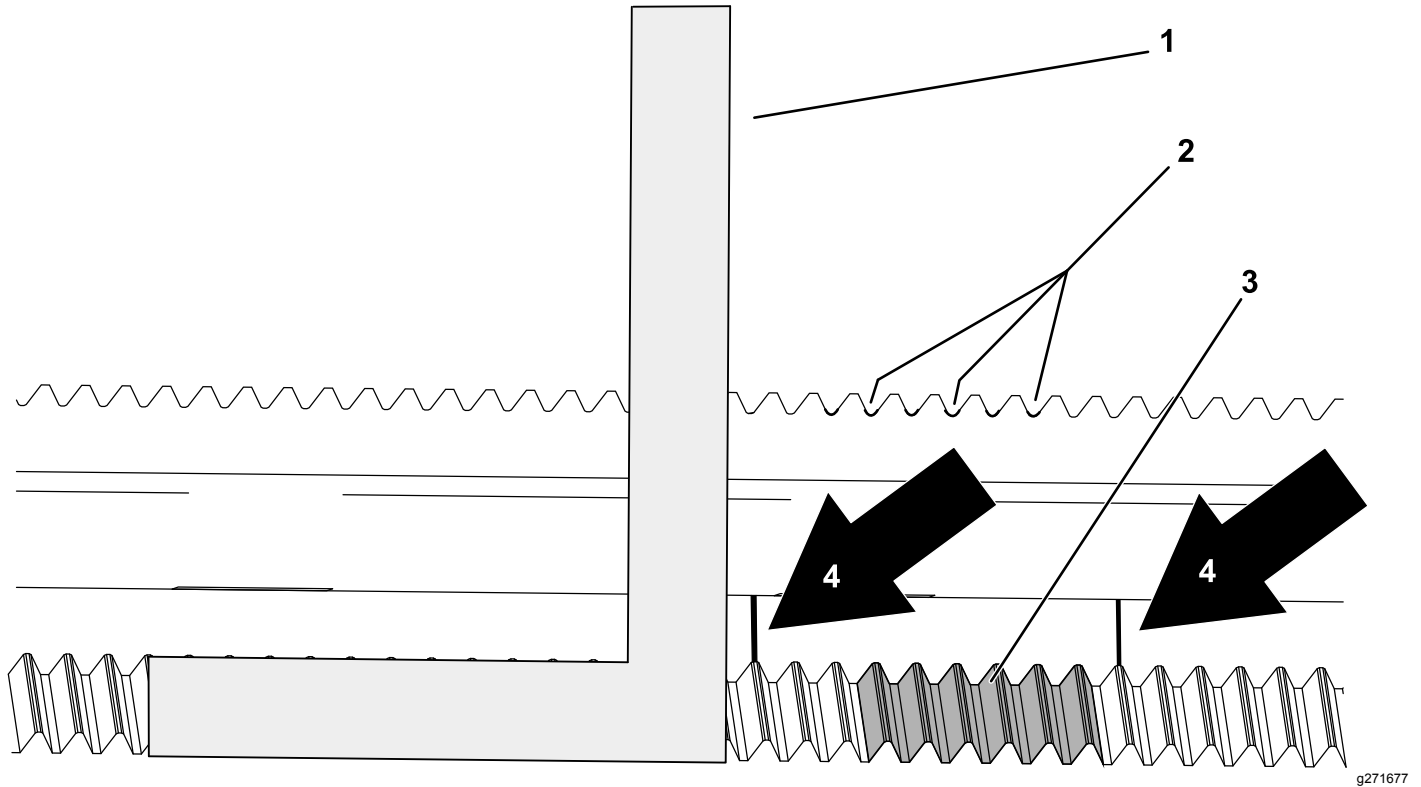


Figure 2

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|------------------------|------------------|
| 1. Square | 3. Damaged teeth |
| 2. Valley of the teeth | 4. Sample mark |

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

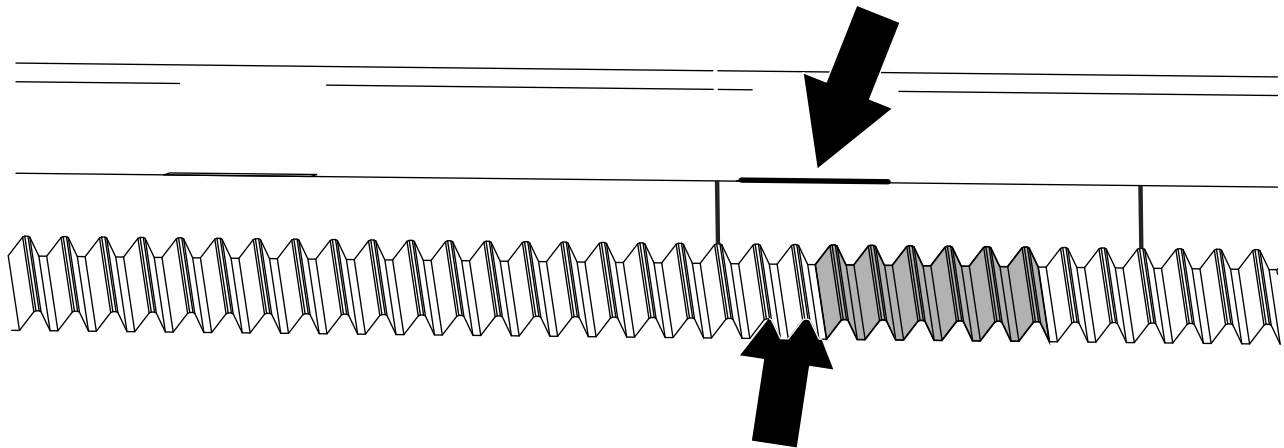


Figure 3

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

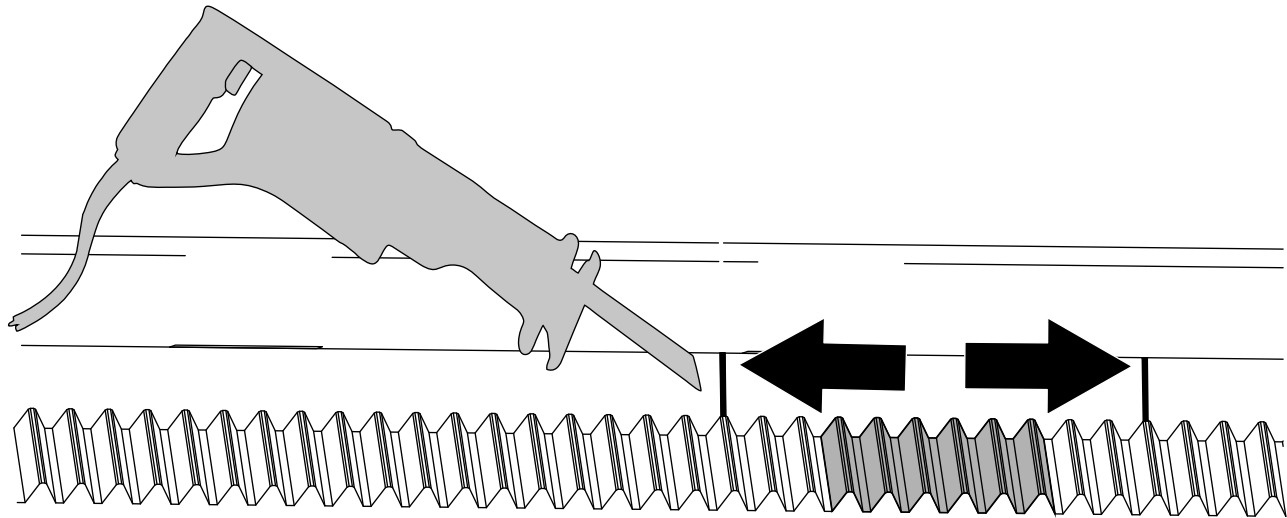


Figure 4

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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.

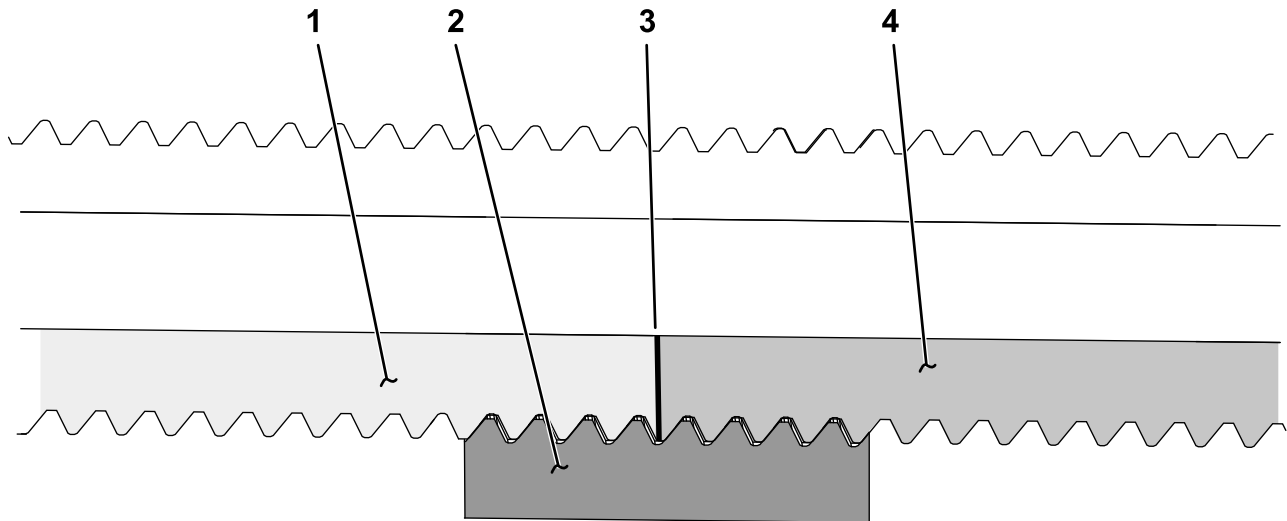


Figure 5

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|-----------------------|--------------------------------|
| 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.

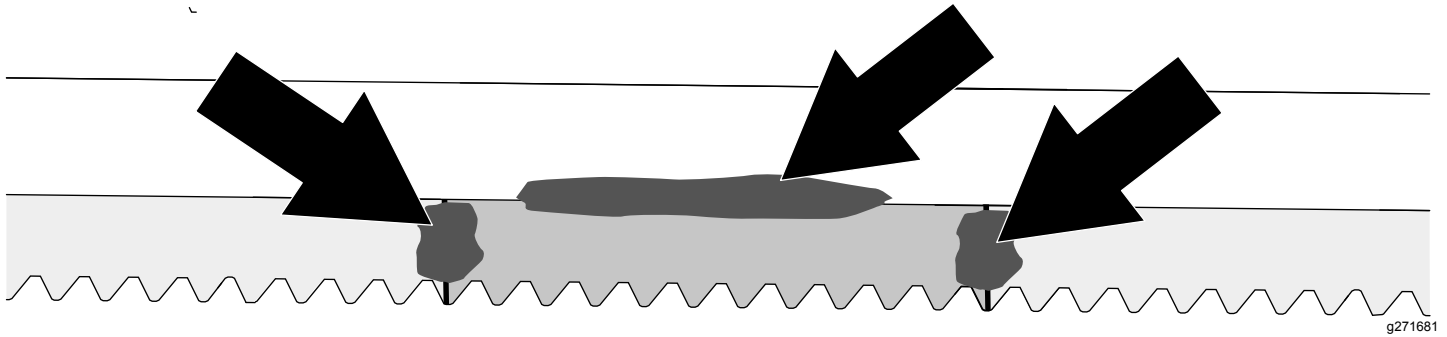


Figure 6

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

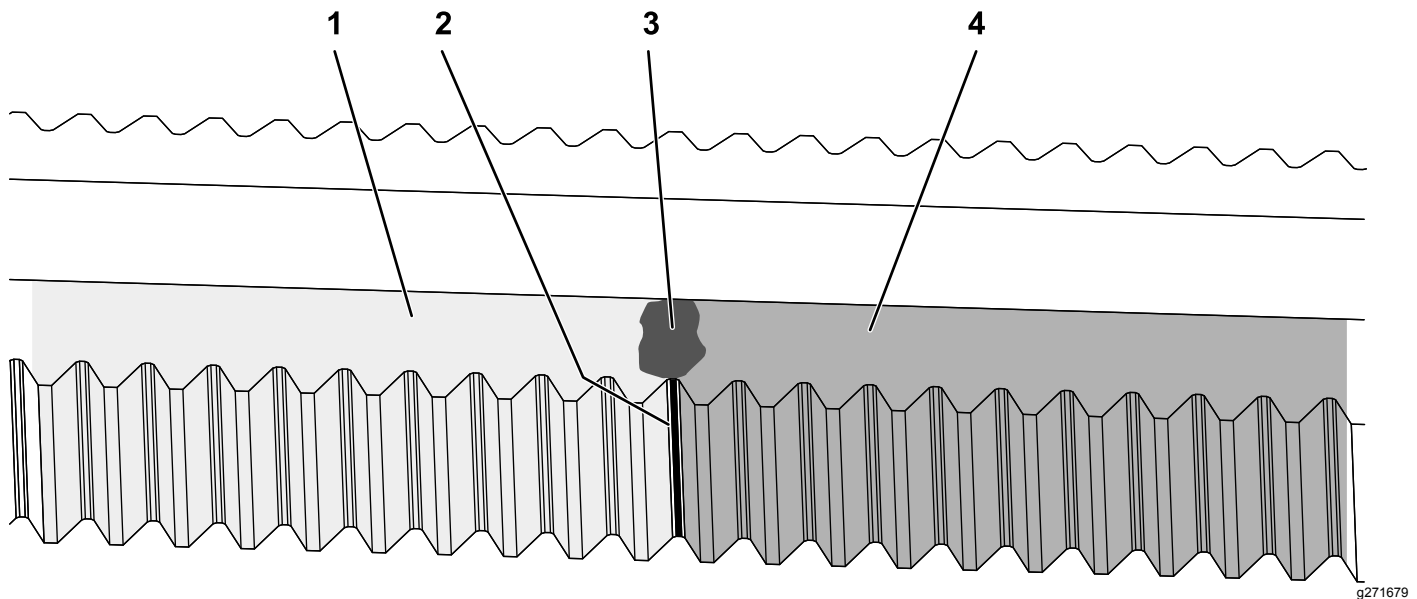


Figure 7

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