

LARGE REELS #14-04

REELMASTER® 335/3500-D/450/4500-D

March 6, 1995

REEL DRIVE PULLEY INSTALLATION PROCEDURES

PRODUCT: REELMASTER 335/3500-D and 450/4500-D Cutting Units

<u>UNITS AFFECTED:</u>	<u>MODEL NUMBERS:</u>	<u>SERIAL NUMBERS:</u>
	03752	ALL
	03753	ALL
	03754	ALL
	03756	ALL
	03741	ALL
	03751	ALL

SUBJECT: Reel Drive Pulley Installation Procedures.

SITUATION: The aluminum reel drive pulley is secured to the reel shaft with a cap screw and key. The cap screw is specially machined to provide a grease path for the reel bearing. If the cap screw becomes loose for any reason, retightening the cap screw may not be sufficient to retain the connection and could result in cutting unit damage. Specific installation procedures must be followed to prevent the cap screw from loosening during operation.

CORRECTION: If the retaining cap screw is loosened, perform the installation procedures shown on the back of this bulletin.

WARRANTY: Informative Bulletin Only. This bulletin documents installation procedures for routine maintenance and rebuilding purposes.

DISTRIBUTION: Copy the text and provide it to all customers with this equipment.



Customer Service Bulletin Commercial Business Group

Reelmaster® 335/3500-D and 450/4500-D Cutting Units

Model/Serial Range: **Model Numbers:** **Serial Numbers:**

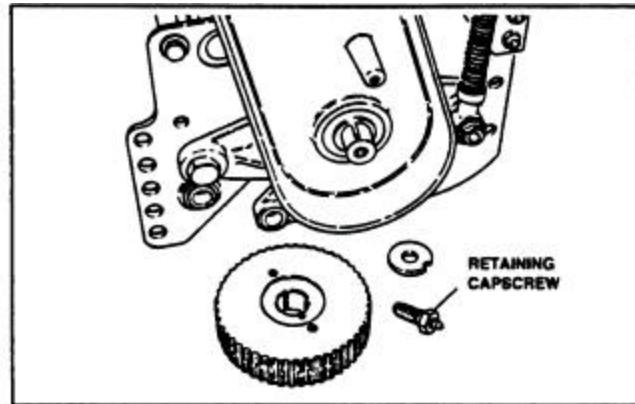
03752/03753/03754 00000-99999
03756/03741/03751 00000-00000

Subject: **Reel Drive Pulley installation Procedures.**

The following procedures should be used when installing The Reel Drive Pulley onto the Reel Shaft.

REEL DRIVE PULLEY INSTALLATION PROCEDURES for REELMASTER 335/3500-D and 450/4500-D Cutting Units

1. Disassemble the reel drive pulley from the reel shaft and inspect parts for damage.
2. Use Loctite® 755 (or equivalent) cleaning solvent to ensure that all grease is removed from the reel shaft and cap screw threads.
3. Assemble the reel drive pulley and key to the reel shaft. Use Loctite 271 or equivalent on the threads of the retaining cap screw. For an even stronger connection, apply RC 680 to the shaft and pulley mating surfaces.
4. Tighten the cap screw to 75 ft-lb (10.5 Kgm).
5. Install belt and adjust tension as stated in step 6 below. DO NOT use a bar between hose fittings on the motor to tighten the belt.
6. By hand, rotate the motor to tighten the belt until 1/8" (3 mm) deflection is achieved when 7 lbs. (3 Kg) of force is applied to the mid span of the belt. Tighten the reel motor mounting bolts to 25 ft-lb (4.7 Kgm). Too much tension on the belt can affect efficiency and lead to early seal failure of the reel motor.



NOTE:

Debris inside the belt housing can also cause problems and damage. Check to ensure the plug is installed in the inspection hole on the cover.

