

**MR-SDC-1 (Belt Replacement)**  
old and new styles, M-825 and M-800 Series

- ▶ Remove infeed table attached to slitter, look under infeed table mounted to slitter.
- ▶ Remove 1/4"-28 socket head bolts (4 pieces) using 3/16" Allen wrench
- ▶ Note: Older style slitters may require tables were mounted with 1/4"-28 Hex Head bolts
  
- ▶ Remove 3/8"-24 Hex Head bolts and 1-1/4" end caps attaching cutting rolls, slitter knife blades (part # 4573), to slitter assembly
- ▶ Remove cutting rolls
- ▶ Note: Behind cutting rolls will be shims using a micrometer or calipers (verniers) measure thickness of shims behind cutting rolls. Be sure to reinstall the same amount of shims behind the top and the bottom of cutting rolls when reinstalling. Also, there will be shims behind the 1-1/4" end cap.
- ▶ Measure thickness. Be sure to use the same amount when reinstalling
- ▶ Remove 3/8"-24 Hex Head bolts attaching slitter housing to power
- ▶ Take off side plate (gear side) #35 as per assembly drawings #2.
- ▶ Remove only the bolts at infeed end of slitter assembly (2 pieces)
- ▶ Next remove 3/8"-24 Hex Head tap bolts #45 as per drawing (2 pieces)
- ▶ Hold slitter housing assembly, pull assembly away from slitter, this will allow gear belt pulley to hang freely. Lay aside housing assembly. Remove gear belt pulley
  
- ▶ Remove 3/8"-24 Hex Head bolt attaching slitter to head assembly (roll former)
- ▶ Remove only the bolt on left side of spreader - head rail #5 as per drawing #1
  
- ▶ Loosen 1/4"-20 set screw, hold set collar in place.
- ▶ Slide set collar #18 as per drawing #1 and drive gear #9 away from power
- ▶ Take off side plate (gear side).
- ▶ Remove 1/4" key stock from power
- ▶ Take off shaft #6 per print #1
- ▶ Remove 3/8"-24 Hex Head bolt #23. Slide power take off shaft to right side of machine
- ▶ To remove power take off shaft from power take off side plate (non gear side) swing side plate (non gear side) in up position.
- ▶ Remove worn belt, replace with new belt

Reverse these steps to reassemble

Note: To reinstall gear belt pulley on slitter housing assembly:

Install gear belt pulley in belt position pulley slide upper knife shaft through conveyor side plate into pulley. Install 3/8"-24 bolts, tighten.  
Be careful not to stretch or pry on belt when reinstalling.

Loosen Bolts in shaft 5  
To align Slitter Side  
Plate Straight with Roll  
Form Side Plate

13 1/2" Long Infeed  
Table Conveyor

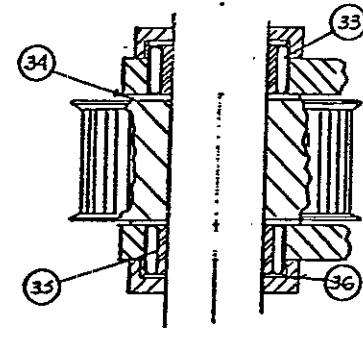
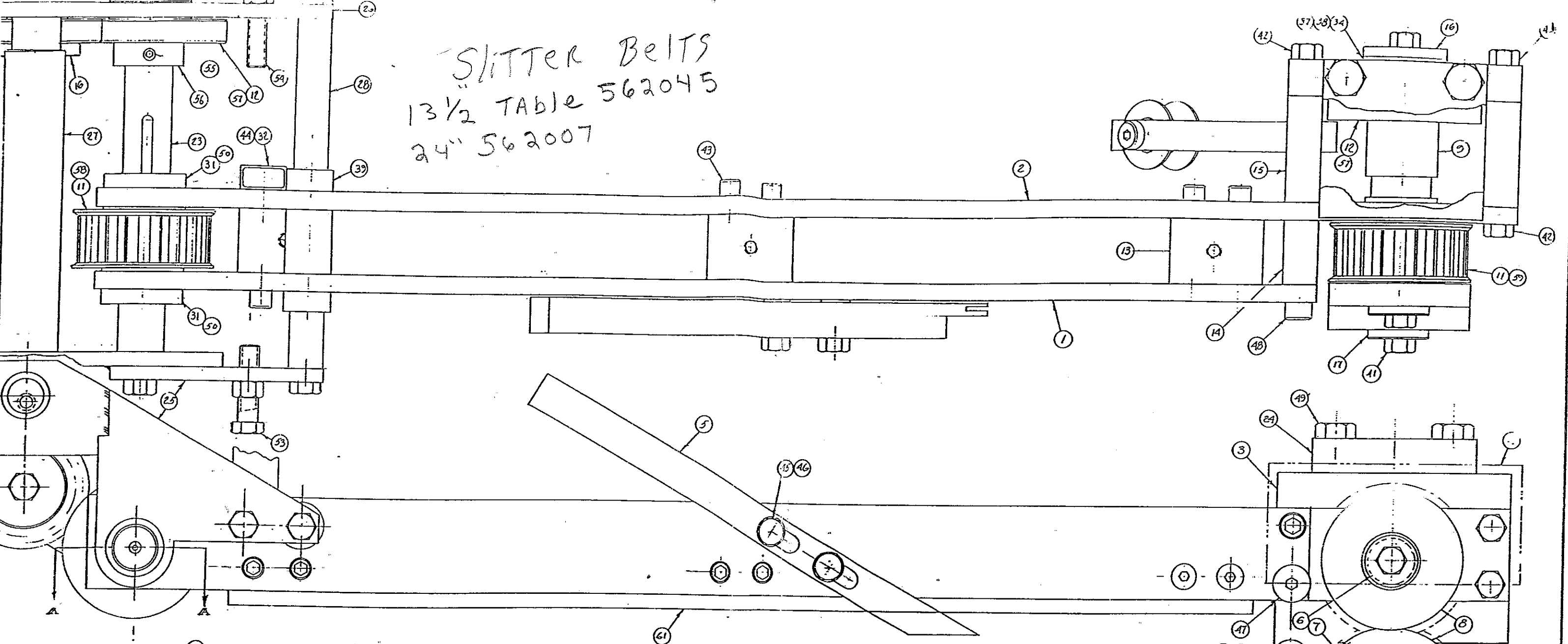
Loosen Two 3/8 Bolts and Rotate  
Shaft 5 to Raise or Lower Slitter  
and Retighten 3/8 Bolts

Slitter Wheel  
over LAP  
5/16"

SECTION A-A

27	1		X	1/4-20 CUP POINT SET SCREW 1/4 LG.
26	2		X	3/8-24 HEX NUT
25	1		X	↑ ↑ ↑ ↑ ↑ x 3" LG.
24	1		X	↑ ↑ ↑ ↑ ↑ x 1" LG.
23	4		X	3/8-24 HEX HD. BOLT x 3/4 LG.
22	1	C-250	X	BUSHINGS (1mm x 2)
21	4		X	AMPLEX - THRUST RACE
20	1	B-166	X	↑ ↑ ↑ ↑ ↑
19	2	B-166	X	TORRINGTON NEEDLE BEARING
18	1	SC-1	X	BROWNING SET COLLAR
17	2	CL-3-HK2T	X	CARR-LANE HAND KNOB ASSY
16				
15	1	4587	X	COVER - POWER TAKE-OFF
14	1	4582-1	X	SO. KEY 1/4 x 1/4 x 1/2 LG.
13	2	4219-8	X	END CAP WASHER
12	1	4564	X	CLAMP BAR - INFEED GUIDE
11	1	4563	X	INFEED GUIDE BAR
10	1	46L2	X	INFEED TABLE ASSY
9	1	4561	X	DRIVE GEAR
8	1	4560	X	IDLER GEAR
7	1	4559	X	SHAFT - IDLER GEAR
6	1	4553	X	SHAFT - POWER TAKE-OFF DRIVE SHAFT
5	1	4557	X	SPREADER - HEAD RAIL
4	1	4556	X	SPREADER - SIDE PLATE
3	1	4555	X	POWER TAKE-OFF SIDE PLATE (NON-GEAR SIDE)
2	1	4554	X	POWER TAKE-OFF SIDE PLATE (GEAR SIDE)
1	1	4553	X	SLITTER CONVEYOR ASSY

Slitter Belts  
 13 1/2 TABLE 562045  
 24" 562007



61	1	X	BAR MAGNETIC 22" LG
60	1	X	BROWNING DOUBLE GP. BELT
59	1	X	4582 1/2 LG
58	1	X	1 LG
57	3	X	4553-1 1/2 LG
56	1	X	COLLAR
55	1	X	SET SCW
54	1	X	1 LG
53	1	X	3/8-24 HEX HD. BOLT 1 LG
52	4	X	3/8-24 HEX NUT
51	2	X	3/8-24 HEX HD. BOLT 4" LG.
50	1	X	10-32 FLAT HD. MACH. SCW 5/8 LG.
49	4	X	1/2-20 HEX HD. BOLT 1 1/2 LG.
48	1	X	3/8-24 SOC. HD. CAP SCW 3/4 LG.
47	1	X	3/8-24 FLAT HD. SCW 3/4 LG.
46	4	X	35 WASHER
45	2	X	3/8-24 HEX HD. BOLT 1 1/4 LG
44	2	X	1 LG
43	9	X	5/16-24 SOC. HD. CAP SCW 3/4 LG
42	12	X	1 LG
41	6	X	3/8-24 HEX HD. BOLT 3/4 LG
40	2	X	4624 BEARING BLOCK SPREADER
39	1	X	E-259 BUNTING BEARING
38	4	X	1R-1612 TORRINGTON INNER RACE
37	2	X	B-2012 TORRINGTON NEEDLE BEG.
36	2	X	BUNTING THRUST RACE
35	2	X	TORRINGTON INNER RACE .510 LG.
34	C	X	BUNTING THRUST RACE
33	4	X	B-208 TORRINGTON NEEDLE BAG.

32	1	X	1698 HANDLE
31	2	X	4745 BEARING CAP
30	1	X	4539 IDLER GEAR SHAFT
29	1	X	4560 IDLER GEAR
28	1	X	4556 SPREADER POWER TAKE OFF
27	1	X	4557 EXCENTRIC SPREADER
26	1	X	4554 SIDE PLATE-POWER TAKEOFF-AFT
25	1	X	4555 SIDE PLATE-POWER TAKEOFF-FOR
24	2	X	4702 ADJUSTING PLATE
23	1	X	4558 DRIVE SHAFT-POWER TAKE OFF
22	1	X	516-18 JAM NUT
21	1	X	SHOULDER SCW 8B MAX 1 1/4 LG
20	2	X	BRASS WASHER .05TX 3/8ID 3/4OD
19	1	X	OMIT
18	1	X	4585 NICK UP ARM V PULLY
17	2	X	4213-1 NICK UP ARM ASSY.
16	4	X	4219-B END CAP WASHER
15	5	X	4579 END CAP WASHER
14	2	X	4578 BEARING BLOCK SPREADER
13	3	X	4577 CONVEYOR SIDE PLATE SPREADER
12	3	X	4576 CONVEYOR SPREADER
11	2	X	4575 SLITTER HEAD GEAR DRIVE
10	1	X	4574-1 GEAR BELT PULLY 18-HQ-100
9	2	X	4574-2 SPACER SLITTER HEAD
8	2	X	4573 SPACER SLITTER HEAD
7	1	X	4572 SLITTER KNIFE
6	1	X	4571 LOWER KNIFE SHAFT
5	1	X	4570 UPPER KNIFE SHAFT

1	1	X	4569 EXTENDED BEARING BLOCK
3	1	X	4567 SLITTER HD. BEARING BLOCK
2	1	X	4566 CONVEYOR SIDE PLATE-AFT
1	1	X	4565 CONVEYOR SIDE PLATE-FOR

