



#650 SR STRAIGHTENER

Replacement Rundown Jackscrew
Link Kit Installation

The purpose of this kit is to replace/upgrade the User's existing rundown link pins from .407" diameter with retaining rings to .500" diameter hardened shoulder screws and locknuts.

This change will offer improved link pin life and better control over material flatness.

To install the new shoulder screws in the links, the jackscrew and upper roll bank bracket holes need to be re-sized to larger diameters.

Kit #335780 consists of the following parts:

(8) .500" diameter / 1.75" long link pins with 3/8"-16 thread size
(Part # 204616).

(10) 3/8"-16 locknuts (Part #PS225774).

(1) Drill/Reamer guide (Part #335778).

(1) Pre-Drill – 12.5 mm diameter (Part #335777).

(1) Reamer - .500" diameter (Part #335779).

(1) Guide pin – .407" to 12.5mm (Part #339574)

(1) Guide pin – 12.5mm to .500" (Part #339575)

REFER TO ILLUSTRATION ON THE NEXT PAGE

LITTELL #650 SR Stra. - Link Pin Conversion Kit

8 Link Pin - Screws / Locknuts



.500" Reamer



12.5mm Drill



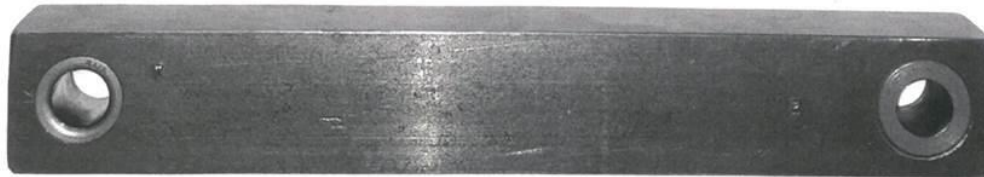
Guide Pin (#339574)



Guide Pin (#339575)



Guide Block (#335778)

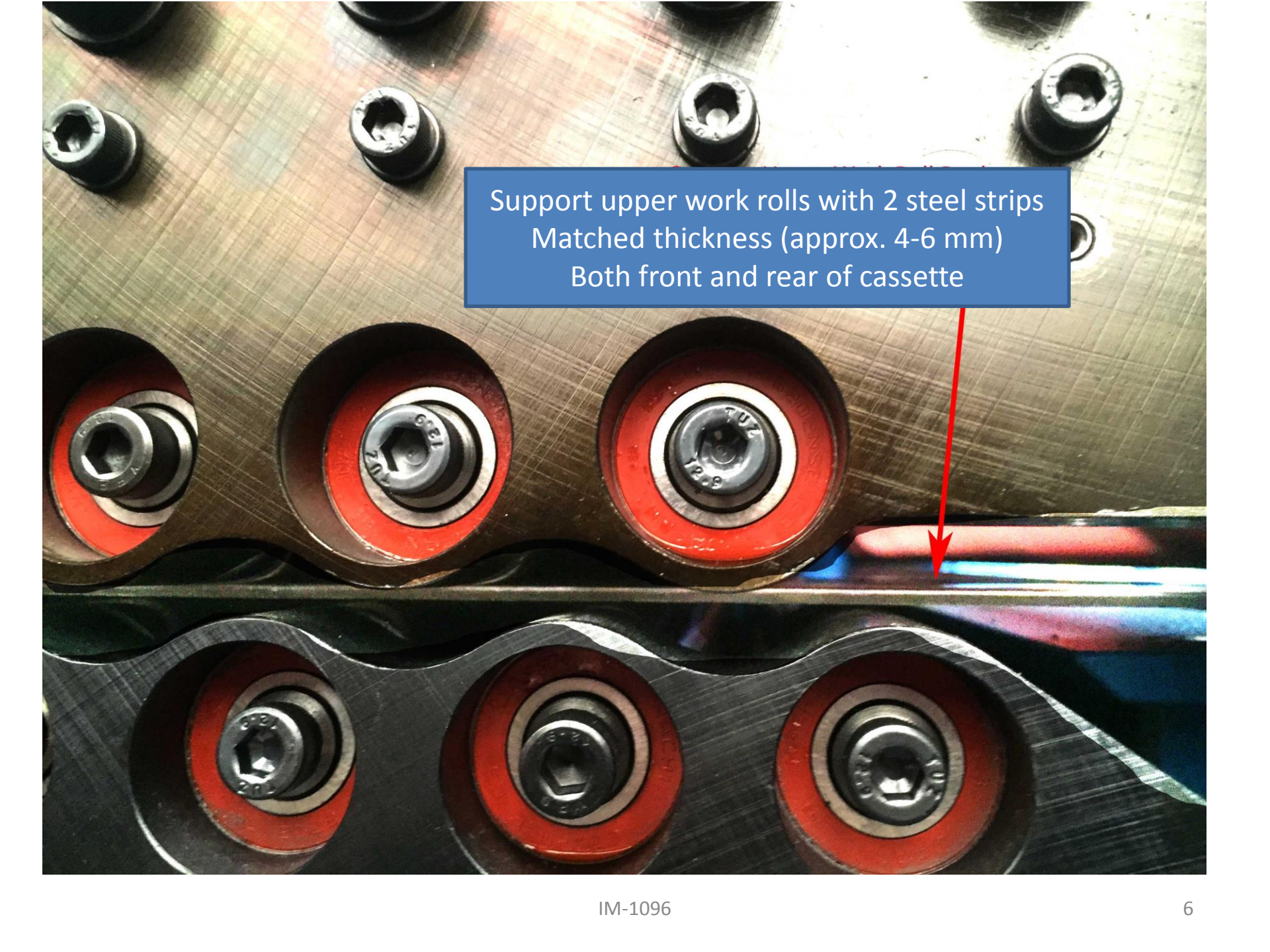


The following steps should be used in replacing the link pins:

1. Open the straightener roll bank and insert at least two pieces of precision bar stock meeting the following specifications:
 - Matched thicknesses, between 4 mm and 6 mm
 - Width between 25 mm and 100 mm
 - Length approximately 610 mm

The bar stock pieces should be positioned at both the front and back side of the head.

REFER TO ILLUSTRATION ON THE NEXT PAGE



Support upper work rolls with 2 steel strips
Matched thickness (approx. 4-6 mm)
Both front and rear of cassette

2. Slowly lower the upper work roll bank until the work rolls touch the bar stock material. Lockout the machine using both the emergency stop button at the straightener and operator's console.

Alternatively, if required by local safety code, turn off power before working on the machine.

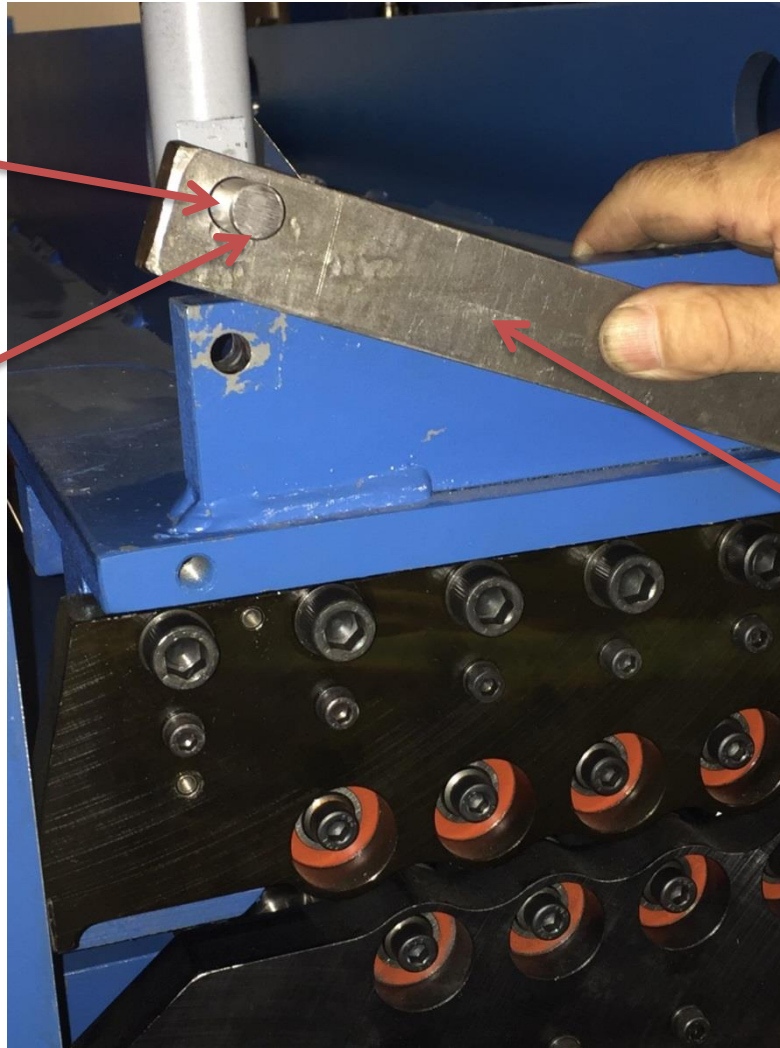
- Using c-clip pliers, remove the retaining rings on all link pins. Remove all 8 link pins and 16 links from the straightener head.



4. Mount the supplied drill/reamer guide (Part # 335778) against the upper straightener roll bracket using pin #339574 as a guide. Make sure the 12.5mm drill bushing is used, NOT the .500" bushing.

Pin #339574
.406" to 12.5mm

12.5mm hole on
guide



Guide #335778

5. Clamp the guide to the upper straightener roll bracket ensuring that the link pin hole is aligned.



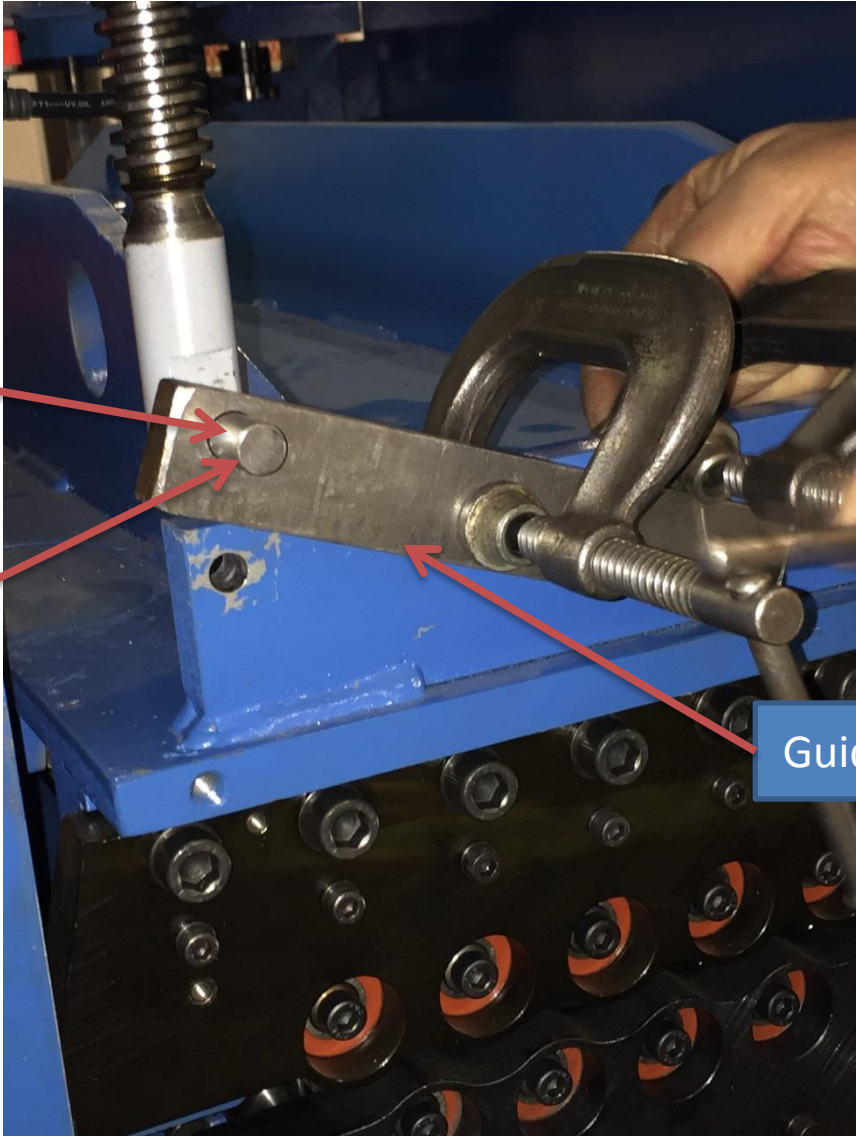
6. Remove the guide pin and lock the 12.5 mm drill into a suitable drill motor. Drill through the link pin hole. The use of cutting oil is recommended.



7. Unclamp the guide block, flip the block to use the other bushing, and reclamp using pin #339575 as a guide in the .500" hole. Remove the guide pin.

Pin #339575
12.5mm to .500"

.500" hole on
guide



Guide #335778

8. Replace the 12.5 mm drill with the supplied .500" reamer. Ream out the link pin hole in one quick pass to avoid possibly enlarging the pin clearance hole any more than necessary. The use of cutting oil is recommended.

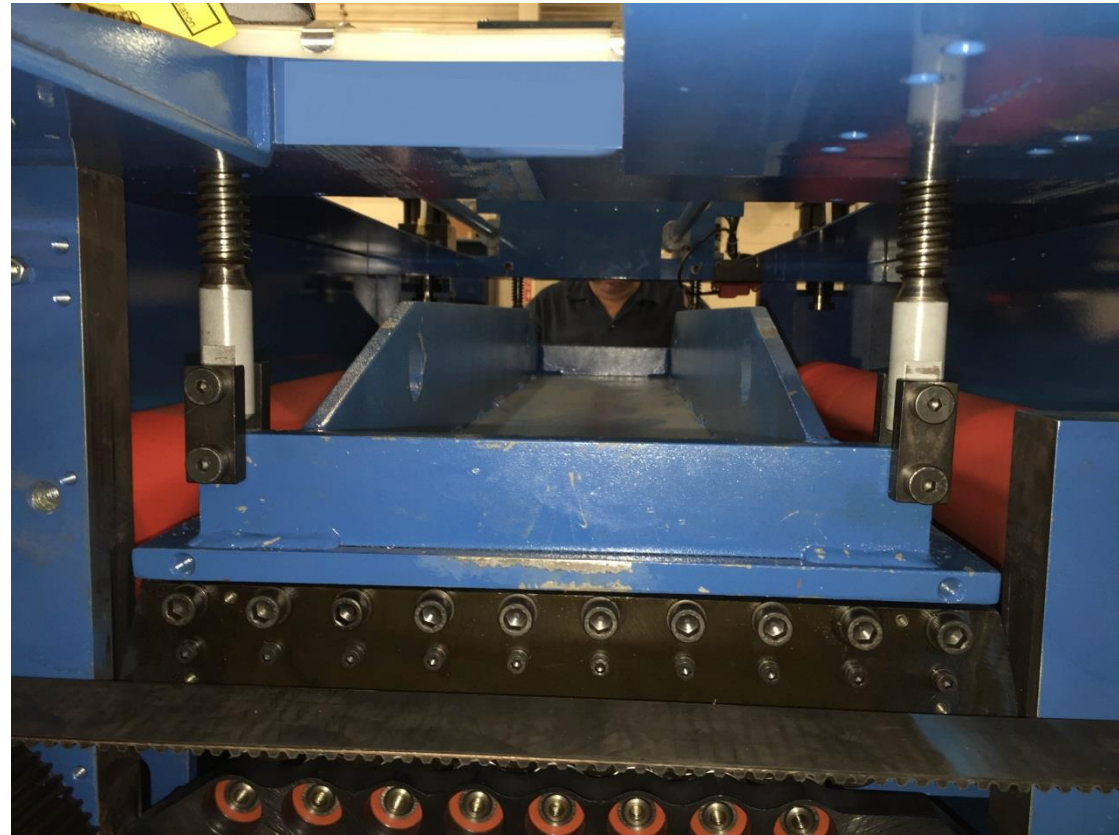


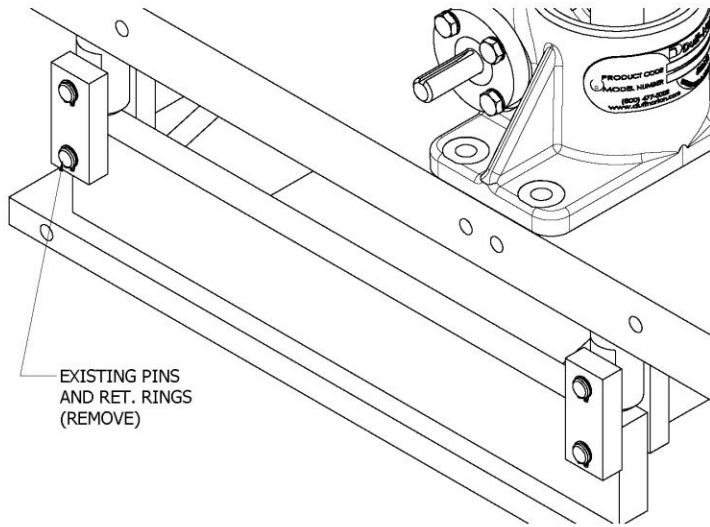
- Repeat the same operation on the link pin holes on the upper straightener roll bracket using the drill/reamer guide.



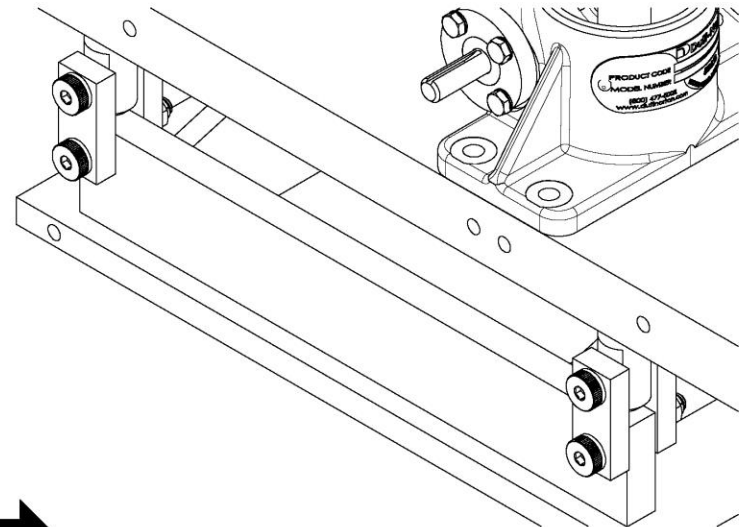
- The links (total of 8 pieces) can be re-sized on a drill press using the drill/reamer supplied in this kit.

11. Reassemble the links to the jackscrew and straightener cassette using the new link pins and locknuts.

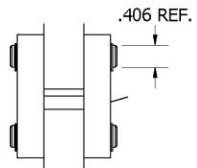




STRAIGHTENER PINS
BEFORE MODIFICATION
SCALE 1 : 2



STRAIGHTENER PINS
AFTER MODIFICATION
SCALE 1 : 2



| PARTS LIST | | | | |
|------------|-----|-------------|--|--|
| ITEM | QTY | PART NUMBER | DESCRIPTION | |
| 1 | 4 | 319524 | LINK | |
| 2 | 4 | 204616 | BOLT-MFG-STD"-.500 DIA X 1.75 LG | |
| 3 | 4 | PS225774 | NUT "FLEXLOC" FULL RH .375-16 20FA 616 | |

