

Wheel Upgrade Installation

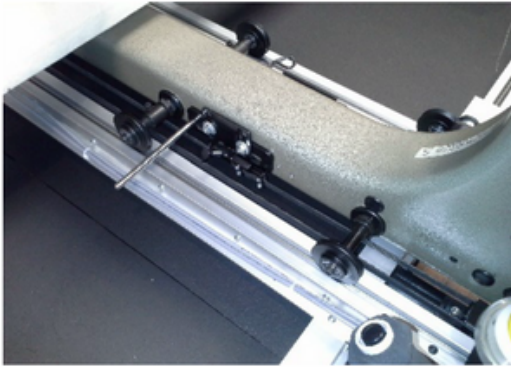


Fig. 1

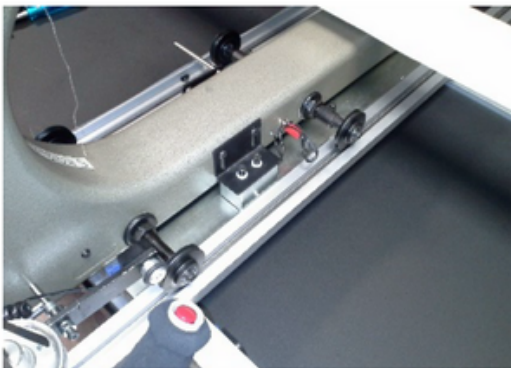
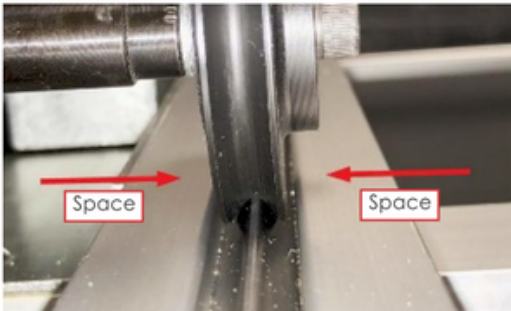


Fig. 2



All wheels are centered (using washers) so that they don't touch the aluminum track

Fig. 3

Hardware

In most cases the existing hardware on your machine can be re-used with the new wheels & no new hardware is needed. If some of your original hardware is missing, consult this list:

- #85689 - 1/4" x 3/4" Shoulder Screw (2 used on front of crosstrack)
- #85-4040 - Washer, 6mm Spring (up to 8 used to shim wheels for proper clearance)
- #85-0052 - 1/4-20 x 1" Hex Bolt (2 used for inner rear crosstrack wheels)
- #080-0307 - 1/4-20 x 1-1/4" Hex Bolt (2 used for outer rear crosstrack wheels)
- #080-0306 - M6-1.0 x 25mm Bolt

Machine Head

- All the wheels on the head will be replaced as shown in Fig.1 & 2.
- The wheels can be replaced one at a time using the 6M x 25mm cap screws. It is easiest to work on the rear axle then the front axle.
- Use the 6MM washers to shim the rear axle wheels. This will evenly space the wheels over the track (Fig. 3).
- Most, if not all of the shims should be installed on the left side of the head to give the channel lock magnet more clearance (if such a magnet is installed) (Fig. 4).
- Align the adjustable front axle to allow the machine to track straight and center the wheels over the track insert.

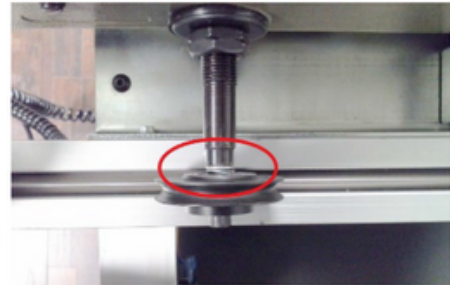


Fig. 4

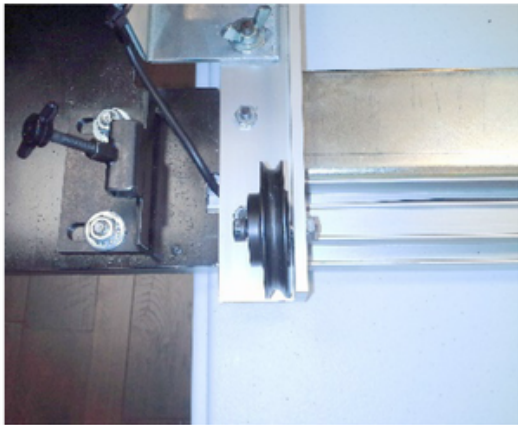


Fig. 5

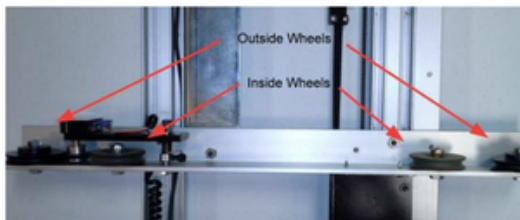


Fig. 6

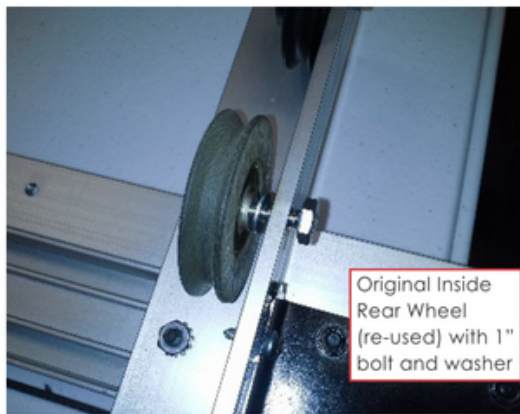


Fig. 7

Cross Track- Front Wheels

- Remove nut, then shoulder bolt. If bolt's shoulder measures under 3/4" long, replace bolts with #85689
- Discard old wheels and install new, oriented as shown in figure 5.

Wheels will be able to float on the shoulder bolts to self-align to the track.

Cross Track- Back End

- **Inside Rear Wheels** (if equipped) - Remove bolt and ensure it's a 1" bolt with 1 spacer washer under it (fig 7).
- **Outside Rear wheels** - Remove existing outside rear wheels and hardware. Put the 1-1/4" bolt thru the hole in the cross-track, then put on a spring washer, and then the wheel and nut (figs 6 and 8).

Re-Install Cross Track on Table

- Make sure the rear interior wheels do not "bind" on the cross track and the front wheels have enough travel on the shoulder bolts.
- Re-adjust vertical channel lock magnet. It must not touch the table surface but still be near enough to lock to it, regardless of machine position along the track. Use 3 business cards or 1 plastic hotel room key to set the gap.

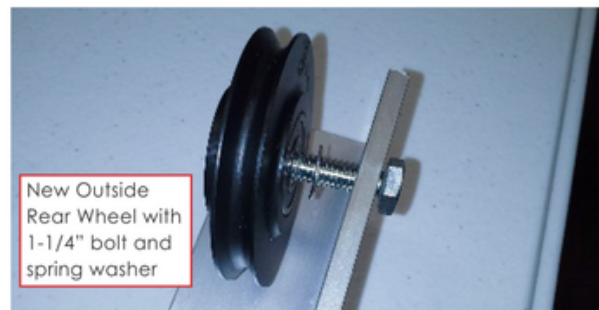


Fig. 8