

S32060

ENGINEERING CONTROLLED
MANUFACTURER: YES

CHANGE DETAIL: NEW

INSTALLATION INSTRUCTION COVER PAGE;

PRINT THE FOLLOWING PAGES: 2 - 12

- FINAL PRINT FORM TO BE 8.5 X 11, DOUBLE SIDE.
- FOR INSTRUCTIONS OF MORE THAN 1 DOUBLE SIDED PAGE
STAPLE IN UPPER LEFT CORNER

Notes:

1. The cover page shows the total number of pages while the subsequent pages count only the actual pages that will be printed as the Instructions.
2. The full LE print border only appears on the cover page.
3. See the master file for information on maintaining this cover page as landscape and the subsequent pages as portrait along with how the header and footer differences are maintained.

The cover page contains a "SECTION BREAK" that must remain on this page to keep the subsequent pages as portrait while keeping this page landscape. To see the "section break" toggle the Show/Hide paragraph marks and other hidden formatting symbols command. Also the header and footer for all pages are linked to each other except for the cover page. This allows the cover page to have a unique header and footer compared to the rest of the pages in the document. This master file is saved with the Show/Hide command in the Show setting and this reference note can be deleted before saving the final document

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MANUFACTURING TOLERANCE PER E2056 UNLESS OTHERWISE SPECIFIED TOLERANCE: ON 2 PLACE DECIMALS IS ±.02 ON 3 PLACE DECIMALS IS ±.002 ON ALL ANGLES IS ±.5 OF A DEGREE MATERIAL TOLERANCE ("I") TO AGREE WITH PUBLISHED STANDARDS.	CONTROL: CLEVELAND	REFERENCE:	EQUIPMENT TYPE: WIRE FEEDER			Page 1 of 12		
	DRAWN BY: S. Reid		SCALE:	SUBJECT: INSTALLATION INSTRUCTIONS			DOCUMENT NUMBER:	DOCUMENT REVISION:
	ENGINEER: A. Mehlman	NA		MATERIAL DISPOSITION:	APPROVAL DATE:	PROJECT NUMBER:	S32060	A
	APPROVED: DAD			NA	11-4-2016	CRM52662		

Installation Instruction for Flex Feed™ 74HT, Flex Feed™ 84 and the Power Feed® 84 to the K305 Flux Tank

*Note: -In order to install the wire feeders listed above, you must have the Heavy Duty Wire Reel Stand installed on the wire feeder.

-If your wire feeder is feeding from the left side of the machine, you will first need to switch wire feeding to the right side before it can be installed to the flux tank.

-Illustrations do not show a full model of the flux tank or the wire feeder that would be attached to the heavy duty wire reel stand. You do not need to remove the wire feeder from the wire reel stand to install the bracket.

TOOLS REQUIRED:

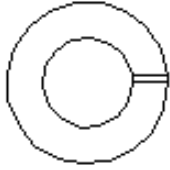
-Two 3/8" wrenches or one 3/8" wrench and one 3/8" socket

-Two 1/2" wrenches or one 1/2" wrench and one 1/2" socket

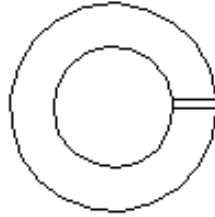
-Two 5/16" wrenches or one 5/16" wrench and one 5/16" socket

MOUNTING HARDWARE:

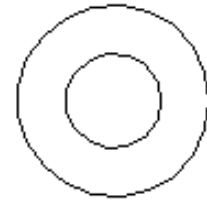
AA- 2 pc.
3/8" Lock Washer



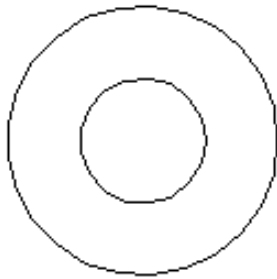
BB- 2 pc.
1/2" Lock Washer



CC- 4 pc.
3/8" Washer



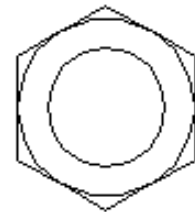
DD- 4 pc.
1/2" Washer



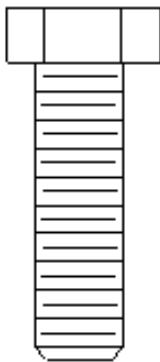
EE- 2 pc.
3/8" Hex Nut



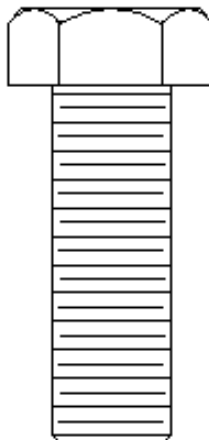
FF- 2 pc.
1/2" Hex Nut



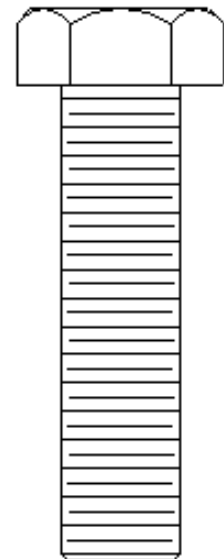
GG- 2 pc.
3/8" x 1.25" Hex Head Bolt



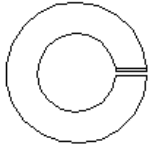
HH- 1 pc.
1/2" x 1.5" Hex Head Bolt



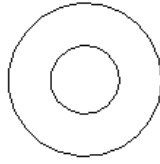
JJ- 1 pc.
1/2" x 2" Hex Head Bolt



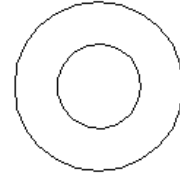
KK- 2 pc.
5/16" Lockwasher



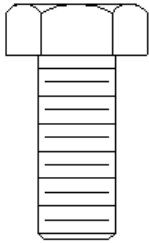
LL- 2 pc.
1/4" Flat Washer



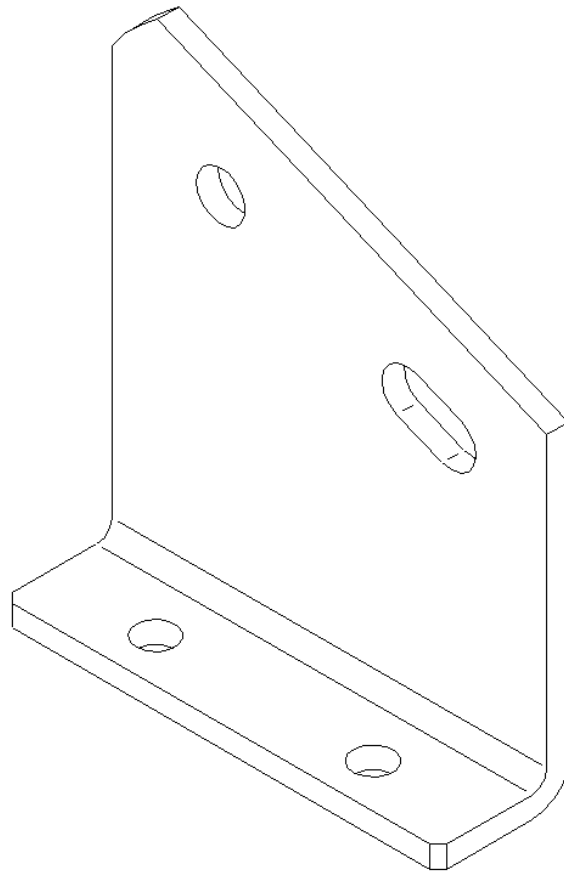
MM- 2 pc.
5/16" Flat Washer



NN- 2 pc.
5/16" x 3/4" Hex Head Bolt



PP- 1 pc.
M26044 Flux Tank Stabilizer Bracket



STEPS:

Removing the Wire Reel Stand

1. In order to remove the Wire Reel Stand, you must make sure to flip the rear flux tank hopper support leg and place a block underneath it to stabilize the assembly from tipping backwards. (See Figures 1A and 1B for details)



Figure 1A

Rear flux tank support leg before being flipped to stabilize assembly for removal of the wire spool reel.



Figure 1B

Rear flux tank support leg after being flipped and stabilized with a block underneath. The assembly is now safe for wire spool reel removal.

2. Remove fasteners holding the flux tank arm to the wire reel stand as seen in Figure 2.

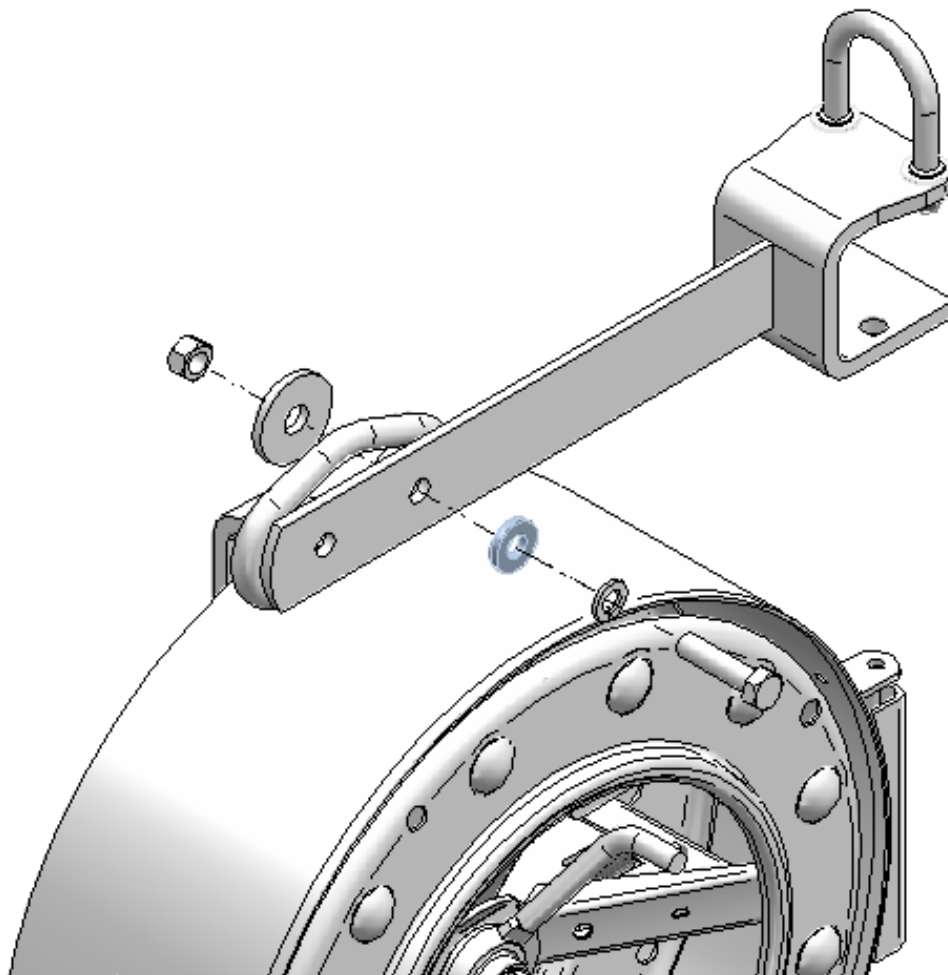


Figure 2

3. Remove fasteners that are holding down the wire reel stand to the frame as seen in Figure 3. After removal, the Wire Reel Stand may be discarded.

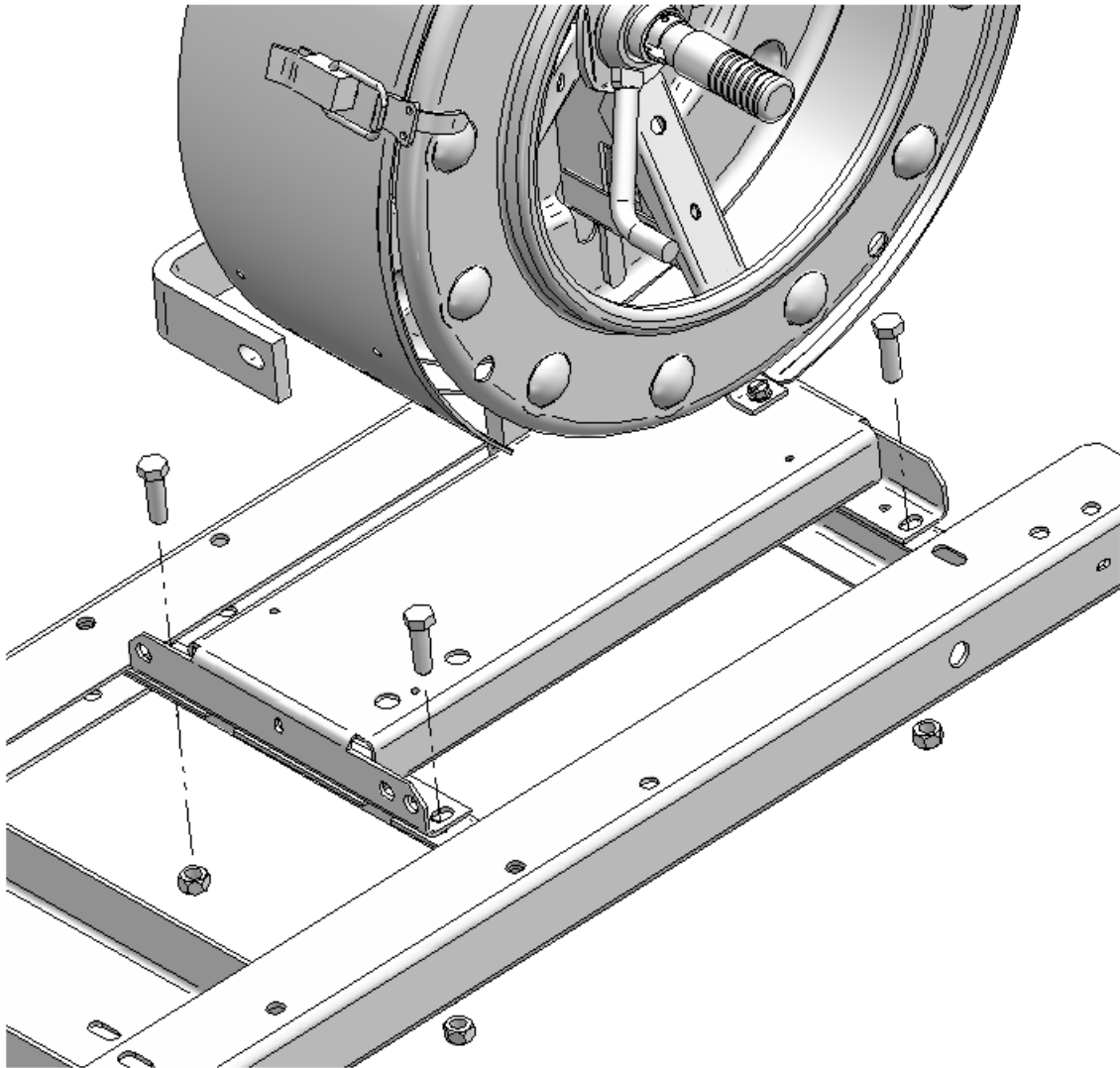


Figure 3

4. Install your Flex Feed™ 74HT, Flex Feed™ 84 or a Power Feed® 84 to your undercarriage per L16570 Installation Instructions, included with this kit.
5. Remove the bale hook from the bale as shown in Figure 4. Save the insulated washers and the insulated inserts to be used later in the installation.

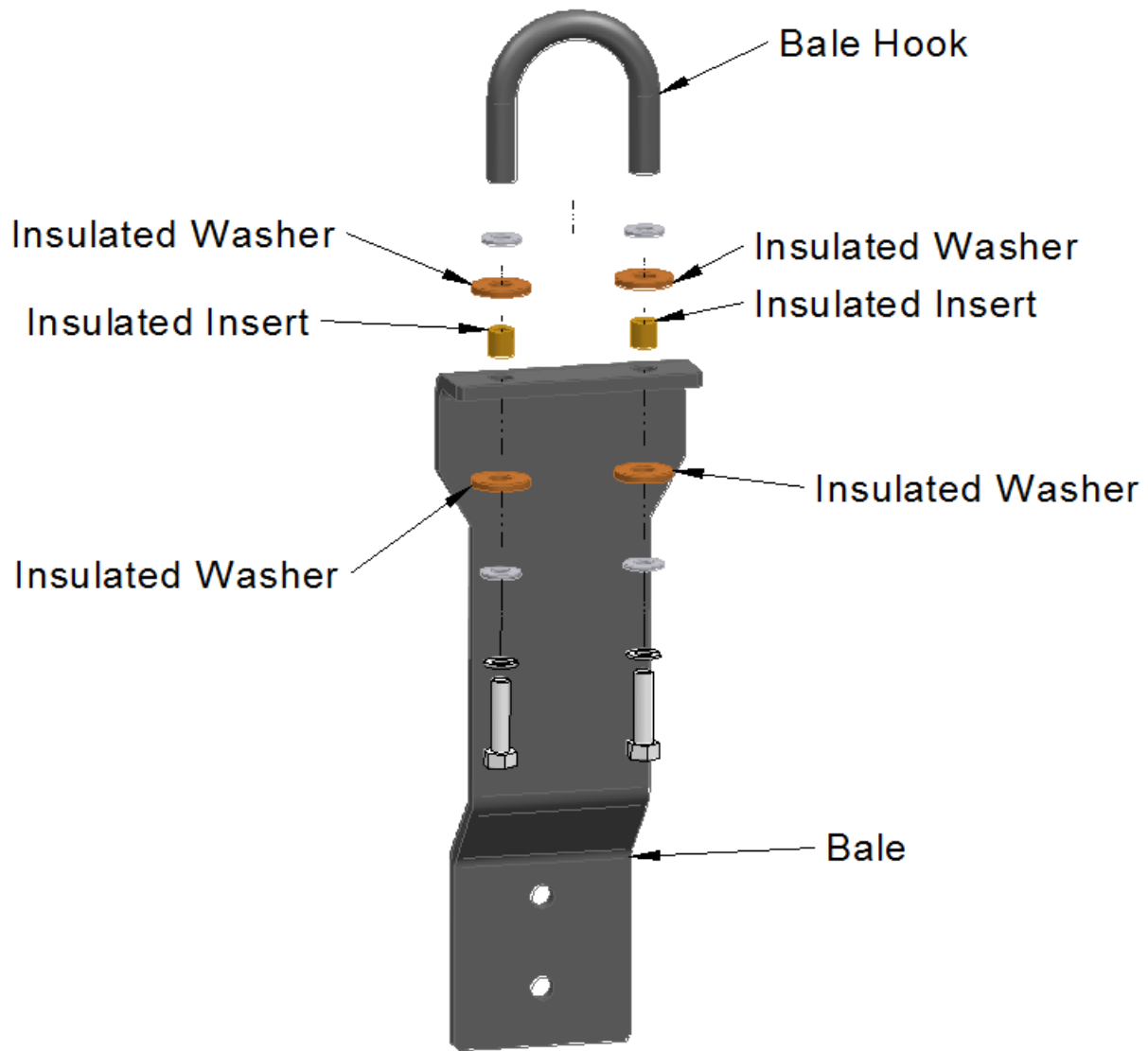


Figure 4
Removal of the bale hook from the bale

6. Remove the bale from the heavy duty wire reel stand and flip it to the other side. Once flipped, bolt it back together using the same hardware you removed. This can be seen in Figures 5A, 5B and 5C below.

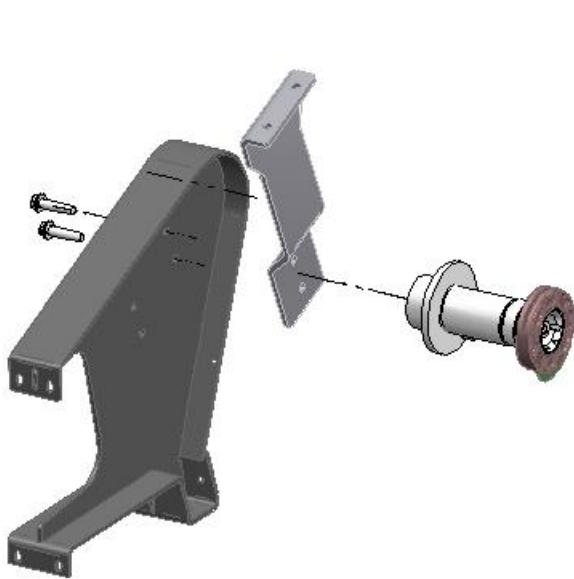


Figure 5A

Removing the bale from the wire reel stand

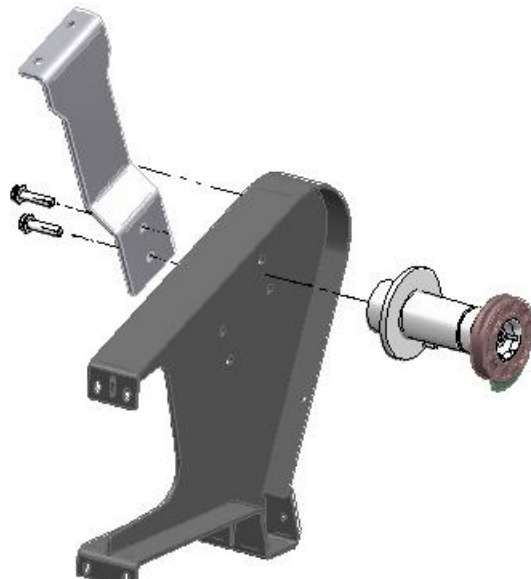


Figure 5B

Flipping bale to other side of wire reel stand



Figure 5C
Completed Assembly

7. Install M26044 flux tank stabilizer bracket to the bale as shown below in Figure 6. Use the insulators you saved from step 5.

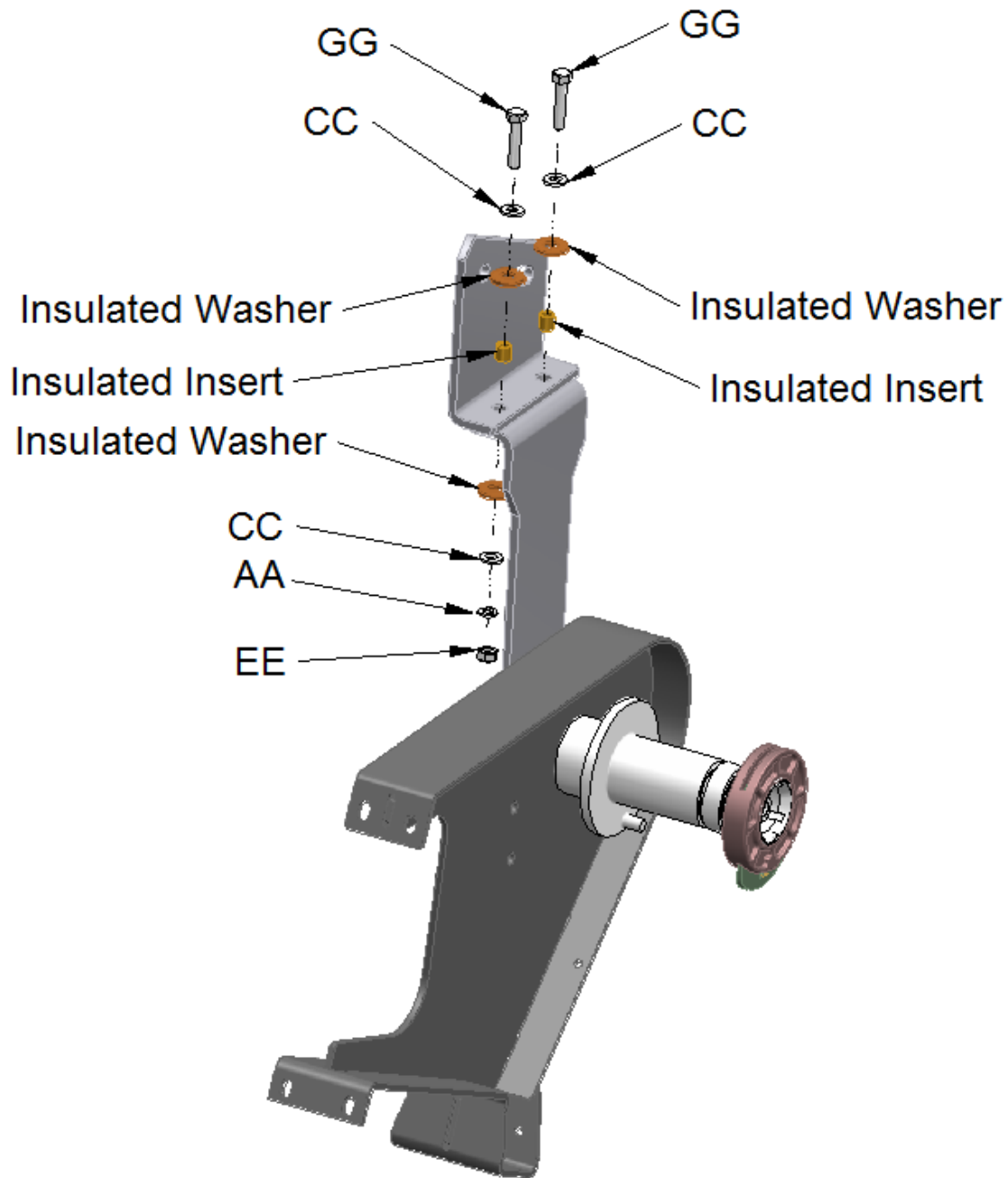


Figure 6
Bolting KK (M26044) to the bale

8. Bolt the M26044 Stabilizer Bracket to the flux tank as shown in Figure 7.

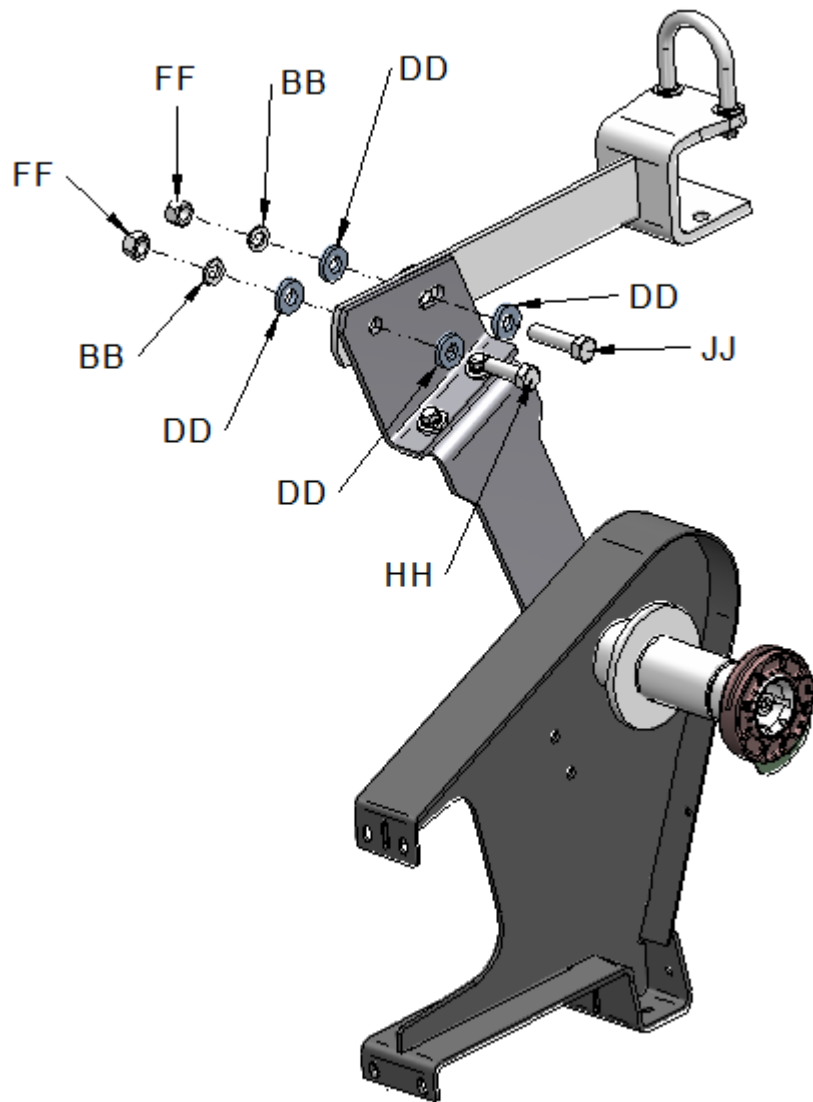


Figure 7

Completed Assembly

