

Installation Instructions for new Inbound Table, Roller Out Bound Table and Veneer Gage.

Recommended Tool List

Welder and all associated supplies and protective gear
Mechanical Lift such as a small hoist or tractor with lifting straps
Cutting Torch
4" side grinder
Green spray paint (John Deere Green)
Tape Measure
Soapstone or other type of marker
4ft level
2 pound hammer
Round 3/8 in punch
Small bottle jack
Pliers
Wrenches
2 Nylon lifting straps

Bill of Materials

1.5 x 6 welded end veneer cylinder	39-20010	1
2.0 x 8 tie rod IBT cylinder	39-20020	2
Chris Cutter IBT spring	60-10327	3
Spring Perch Bar		1
3ft wide split roller IBT	A20449	1
Roller OBT with 4-12" veneer	A20503	1
IBT spring mount	A21095	3
Welded leg assembly	A21171	1
IBT cylinder lower mount	A21172	2
Gusset	A21178	4
Key, Pivot Bar	A40842	1
Mount Leg	A40846	2
Pivot Bar	A40852	1
Roll Pins		2
T-Nut	A40988	2
Pivot Bearing Housing	A40989	2
(Already welded to the welded leg assembly)		

A

1. Start by removing the exiting Outbound Table. It is held in place by 4 nuts and bolts. Remove the 4 fasteners and lift the table off of its support brackets and set out of the way. This table is heavy and will require two people to lift off or some type of mechanical lift.
2. Remove the Veneer Gage Cylinder. This will be located on the outbound side of the cutter with one end attached to a cylinder mount bracket welded to the bottom beam of the Chris Cutter frame and the other end attached to the Veneer Gage. Remove the two hydraulic hoses attached to the Veneer Gage Cylinder. Be certain to cap the ends of the hoses to prevent any debris from entering the hydraulic system. Next, use pliers to remove the cotter pins from the top and bottom clevis pins. There are two cotter pins in each clevis pin but only one has to be removed. Using a hammer and punch, drive both clevis pins through the clevis mounted on each end of the Veneer Gage Cylinder.

CAUTION: The Veneer Gage Cylinder may be supporting the veneer gage and when it is removed, the veneer gage may fall down. Take precautions to support the veneer gage if necessary.

3. Remove the veneer gage assembly by supporting it on the outbound side of the cutter and removing the two pivot bolts located on either end of the inbound side of the cutter. Pull the veneer gage assembly through the outbound end and set to the side.
4. Remove the two Inbound Table Cylinders. These are located on the inbound side of the cutter. There is one on either side of the inbound table. Just like with the Veneer Gage Cylinder, the hydraulic lines must be removed and capped to prevent debris from entering the hydraulic system. These cylinders have a formed hitch pin in the clevis pin that must be removed. Once they are removed then the clevis pins on both ends of each cylinder can be removed and then the cylinder can be removed. These cylinders may be reused for the new Inbound Table if they are in good condition.
5. The Inbound Table is now held in place by two pivot bolts located at the end of the table farthest from the cutter. Support the Inbound Table with some kind of mechanical lift. Once supported, remove the two pivot bolts and lift the table out of the way. There are some springs supporting the table but they are not mechanically attached to the Inbound Table and should not hinder the removal of the Inbound Table.
6. Remove the Inbound Table Springs.

B

1. Using the cutting torch, remove the bottom Veneer Gage Cylinder mount bracket located on the outbound side of the cutter. It is welded to the bottom beam of the Chris Cutter Frame. Grind this area smooth after removing the bracket.
2. Using the cutting torch, remove the Outbound Table support brackets and grind smooth.

Outbound Table Support Bracket



3. Using the cutting torch, remove the old Inbound Table support frame, the Inbound Table Cylinder mount brackets, the Inbound Table Spring perches and the veneer gage mounts. Grind these areas smooth.

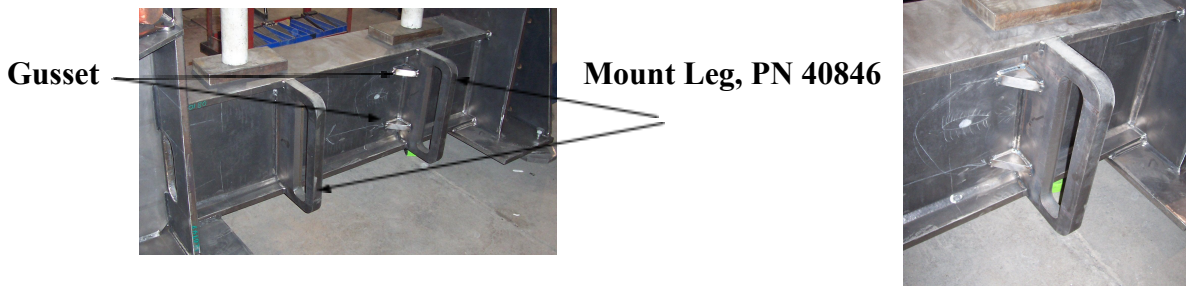
Inbound Table Cylinder Mount Bracket



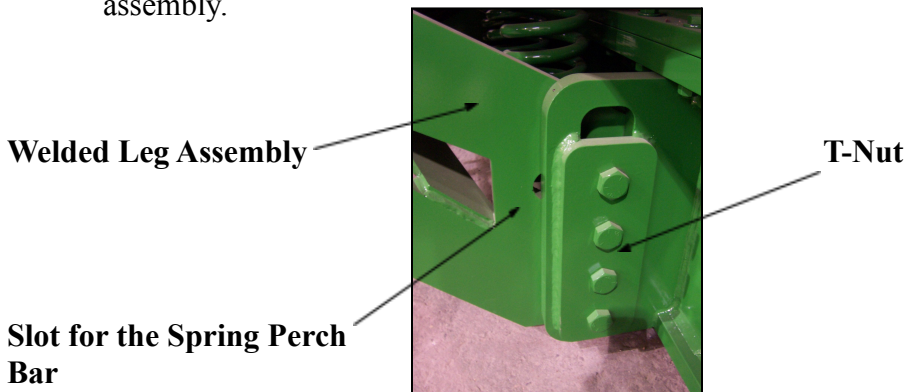
Inbound Table Support Frame

C

1. Using the tape measure and soap stone, put a vertical line on the bottom beam in the center of the beam. Now measure out $17 - 17/32$ inches on either side of center line and place another vertical line. The distance between the two outer vertical lines should be $35 - 1/16$ inches. Take the Mount Leg, P/N 40846, and align the inside edge with the vertical line and tack in place. Do not fully weld yet. Do the same on the other side. Measure the outside of the welded leg assembly and be certain that it will fit between the two Mount Leg brackets welded to the bottom beam. If not absolutely certain of the fit, lift the weldment into place to verify fit. Once the locations of the Mount Leg brackets have been verified, and then fully weld it in place. There are also 4 gussets, 2 per Mount Leg bracket, that get welded to the inside of each one. They are located 4 inches from the top and bottom. This location is not critical. When complete, it should look similar to the photos below.



2. Using the nylon lifting straps and the mechanical lift, lift the Welded Leg Assembly into position. Fasten to the Mount Leg using the two T-Nuts, P/N A40988, and associated bolts. Do not tighten the bolts yet. There is some movement in this assembly to allow for fine tuning the position of the final assembly.



3. The Spring Perch Bar is a weldment made of two flame cut bars of steel that fit into the slots on the Welded Leg Assembly and hold the Inbound Table Springs. Do not weld this in place yet.

4. Using the two nylon straps and the mechanical lift, move the Inbound Table into position. Align the pivot point on the Inbound Table with the Pivot Bearing on the Welded Leg Assembly. Slide the Pivot Bar through the Inbound Table and the Pivot Bearing on either side of the table. Do not install the roll pins in the pivot bar yet. Raise the Inbound table and install the three springs on the Spring Perch Bar. Do not weld the bar in place yet. Lower the table back down onto the springs or the tooth bar, whatever the inbound table hits first.



Note that the Inbound table is cut at an angle to match the tooth bar. If the machine has an older square tooth bar either the table or the tooth bar or both may need to be ground to allow the inbound table to drop down completely.

5. The Inbound table must be aligned with the tooth bar. It should be centered on the tooth bar and as straight as possible. Use a large pry bar to move the table as needed. Be certain that that the bolts in step 2 above did not get tightened too tight or the table will not move. If they are too loose then the table will not stay in place. Once the table is where it should be, all 8 bolts connecting the Welded Leg Assembly to the Mount Leg can be tightened.

6. Lift the Outbound table and veneer gage assembly into position and bolt in place with 4 bolts and nuts on either end.

Outbound table and veneer gage assembly

4 fastening bolts and nuts



7. Place a small bottle jack under the Spring Perch Bar and raise the Spring Perch Bar until the entire Inbound and Outbound table assembly starts to raise. Place a 4ft level on the Inbound table rollers and let the edge of the level touch the teeth. Use a tooth that is not worn to set the level of the Inbound table. Continue to raise the Spring Perch Bar until the Inbound table rollers are $\frac{1}{4}$ in below the top of a new chisel. Now weld the Spring Perch Bar into the Welded Leg Assembly. The roll pins may now also be put into the pivot bar .

Spring Perch Bar

Place bottle jack here

Note: The table for a 5ft cutter has 3 springs not two as shown here.



8. Attach the two 2 x 8 in tie rod cylinder to the Outbound table with the chrome shafts pointed down. Be certain that the cylinder is fully extended. Raise the table assembly mechanically and lay the level across the rollers so that it can be determined when the rollers are $\frac{1}{2}$ inch above a new bottom tooth fully extended. At this point hold the table assembly in place. Attach the IBT cylinder lower mounts to both cylinders and set against the bottom beam of the Chris Cutter. Be certain that the cylinder is hanging straight and the IBT Cylinder lower mount is square to the frame. Weld in place on both sides.

Cylinder

IBT Cylinder lower mount



9. Weld the T-Nuts in place to prevent movement