

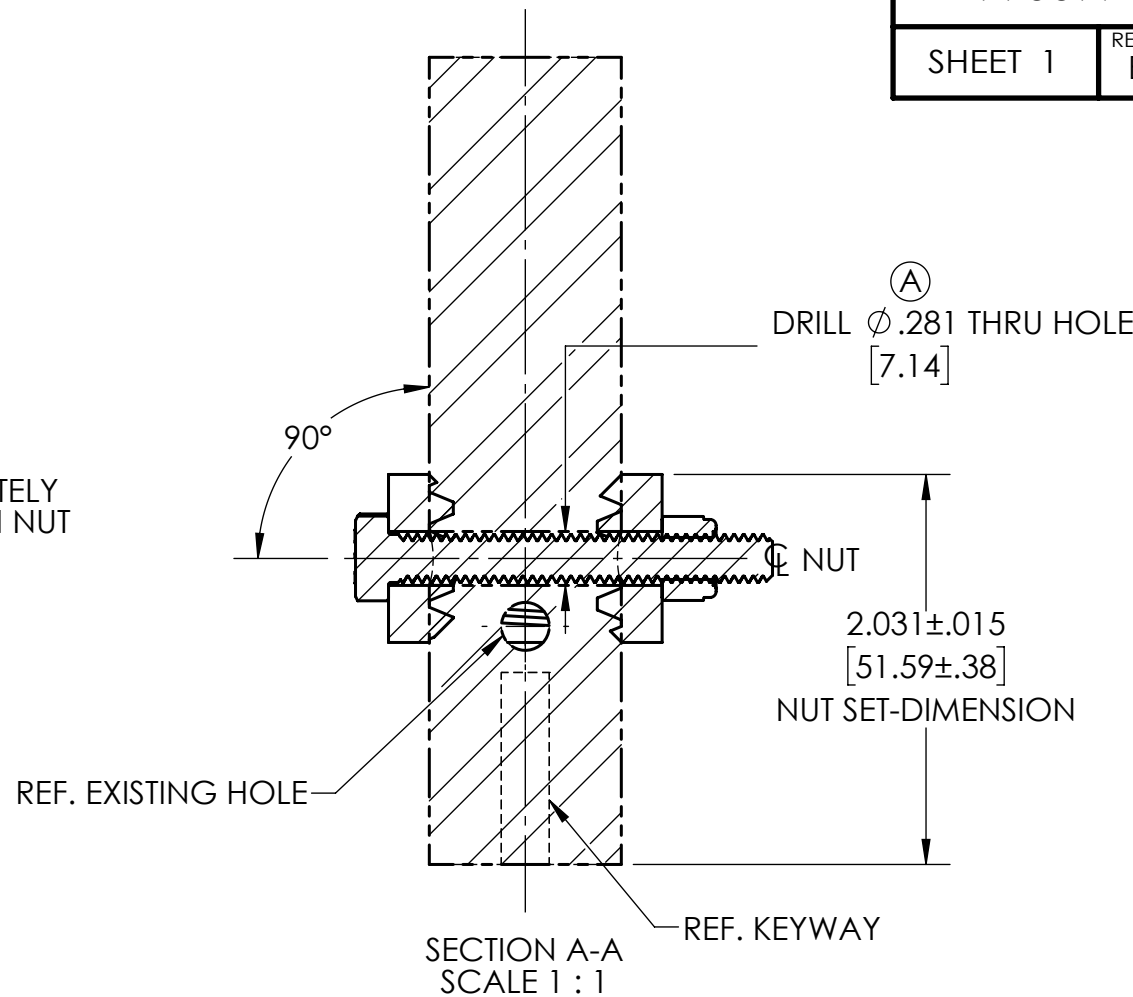
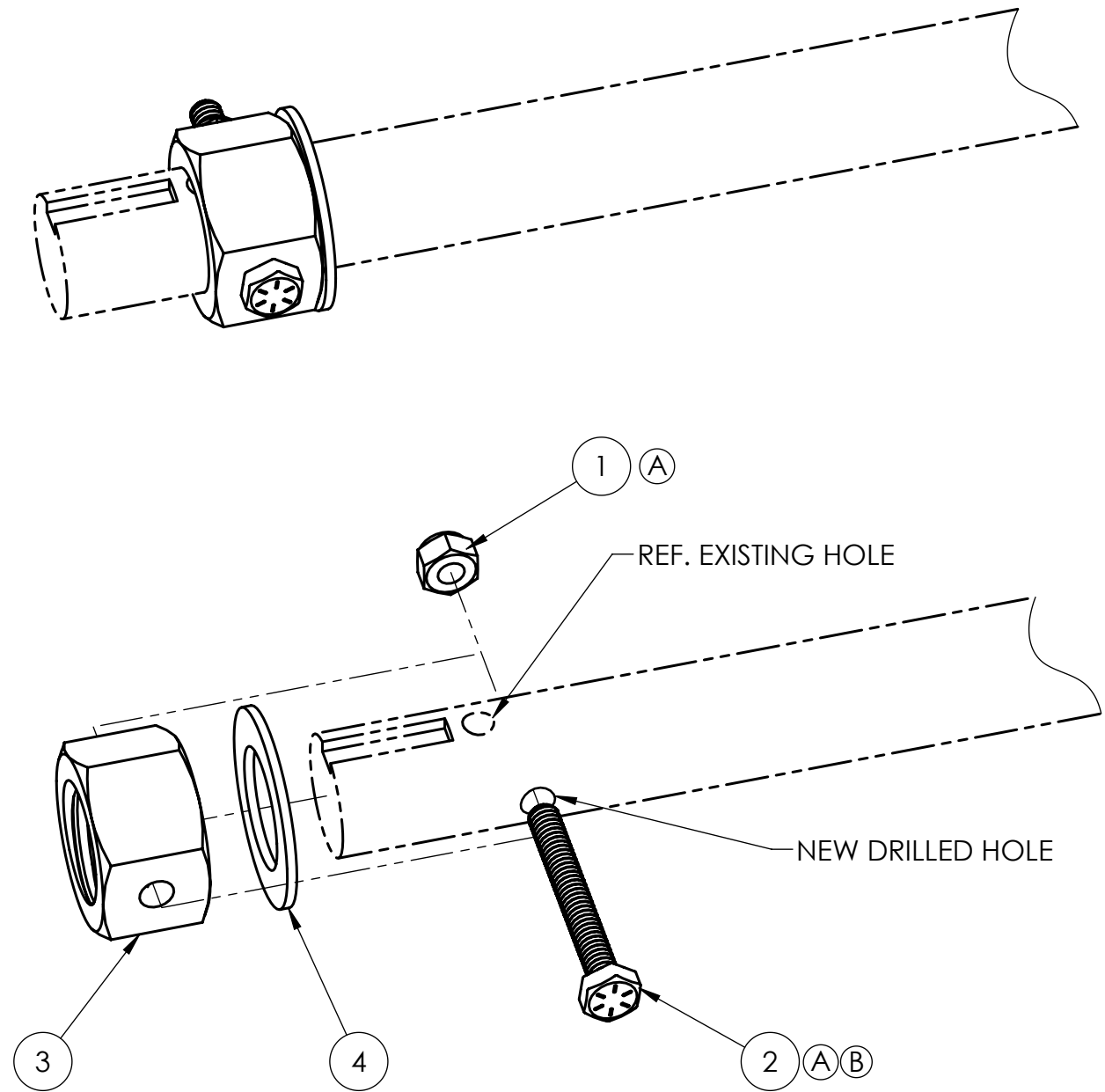
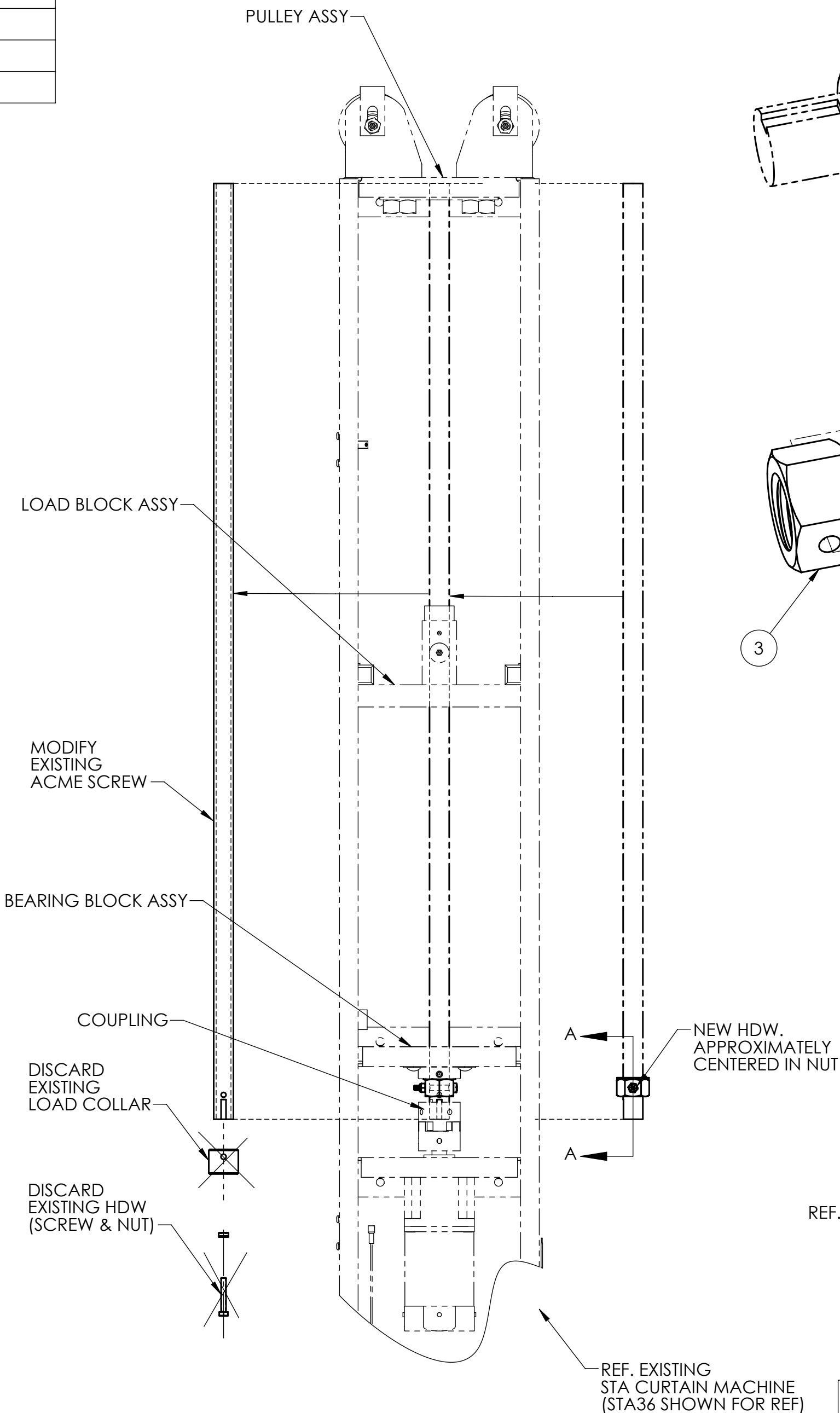
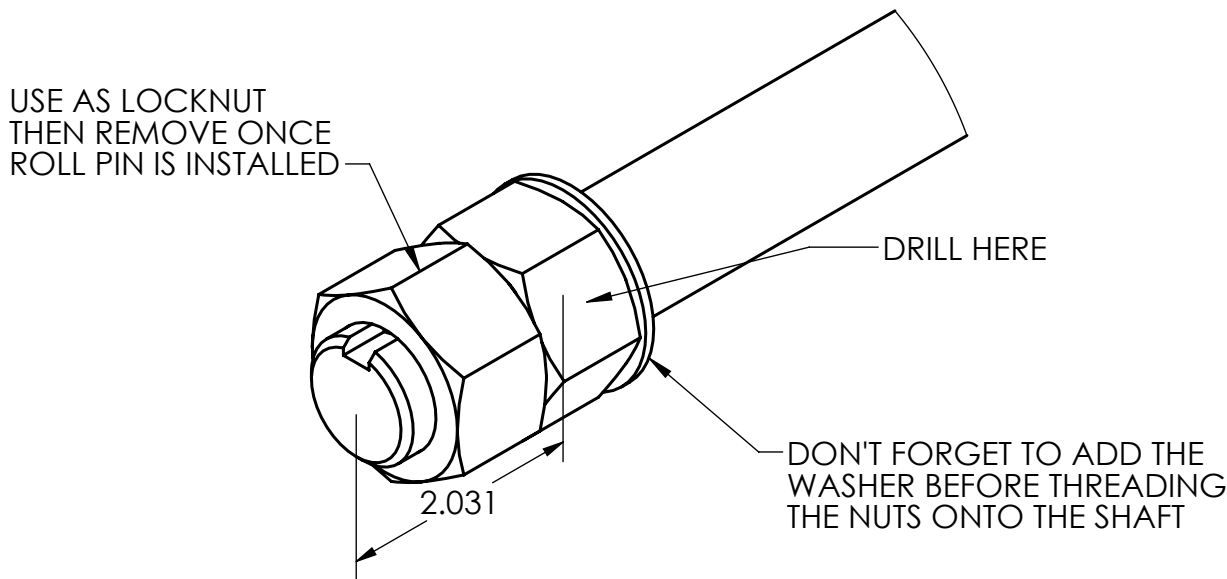
BILL OF MATERIALS			
ITEM #	PART #	QTY.	DESCRIPTION
1	00051194	1	NUT, HEX, NYLOCK, 1/4-20
2	690460	1	BOLT, HEX, 1/4-20 X 2"
3	970277	1	NUT, HEX, ACME, RH 1-5, PLAIN STL
4	970278	1	WASHER, FLAT, 1.00 ID X 1.63 OD

COLLAR REPLACEMENT INSTRUCTION

1. RUN CURTAIN MACHINE TO CENTER OF TRAVEL
2. REMOVE ELECTRICAL POWER FROM CURTAIN MACHINE BEFORE CONTINUING WITH THE FOLLOWING PROCEDURE
3. REMOVE LOAD FROM CURTAIN MACHINE
4. REMOVE PULLEY ASSEMBLY BY REMOVING (4) SCREWS AND (2) MOUNTING BOLTS
5. REMOVE (4) SCREWS AND (2) MOUNTING BOLTS FROM BEARING BLOCK ASSEMBLY
6. SLIDE BEARING BLOCK ASSEMBLY AND ACME SHAFT AWAY FROM THE MOTOR TO SEPARATE THE COUPLING
7. REMOVE THE COUPLING FROM THE ACME SHAFT
8. REMOVE SCREW, NUT AND LOAD COLLAR FROM ACME SHAFT
9. PLACE WASHER ON ACME SHAFT
10. THREAD ACME NUT ONTO THE SHAFT UNTIL THE 2-1/32" [51.59] DIMENSION SHOWN IS ACHIEVED (SEE SECTION A-A)
11. LOCK THE NUT IN PLACE TO PREVENT IT FROM MOVING DURING DRILLING (TIGHTENING 2 ACME NUTS TOGETHER WORKS WELL TO LOCK IT IN PLACE AS SHOWN BELOW)
12. CENTER PUNCH THE NUT BEFORE DRILLING
13. DRILL A 9/32" [7.14] HOLE THROUGH THE CENTER OF THE NUT AND THROUGH THE SHAFT, APPROXIMATELY PERPENDICULAR TO THE EXISTING HOLE, AS SHOWN.

NOTE: FOR STEP 13, DRILL A PILOT HOLE, USE METAL CUTTING OIL AND A SLOW DRILL SPEED FOR EASE OF DRILLING. BE SURE TO HOLD THE DRILL PERPENDICULAR TO THE DRILLING SURFACE TO PREVENT THE DRILL BIT FROM BREAKING DURING THE DRILLING PROCESS.

14. INSTALL NEW HDW SUPPLIED, INTO DRILLED HOLE, AS SHOWN.
15. UNDO LOCKING MECHANISM FROM STEP 11
16. INSTALL KEYWAY AND COUPLING ONTO THE ACME SHAFT
17. SLIDE BEARING BLOCK ASSEMBLY INTO PLACE CAREFULLY ENGAGING THE TWO COUPLING HALVE BACK TOGETHER AND THEN SECURE THE BEARING BLOCK ASSEMBLY WITH SCREWS
18. ADJUST COUPLING BACK SO THERE IS A SMALL AIR GAP BETWEEN THE TWO HALVES AND TIGHTEN SET SCREWS
19. INSTALL PULLEY ASSEMBLY AND SECURE WITH SCREWS
20. RE-ATTACH THE LOAD
21. APPLY ELECTRICAL POWER TO CURTAIN MACHINE
22. ADJUST LIMIT COLLARS AND CABLING TO ENSURE VENTILATION IS FUNCTIONING PROPERLY



990097	
SHEET 1	REV. B

B	16617	690460 WAS 970794	4/17/2024	CJH
A	12333	SPRING PIN (690349) WAS REPLACED BY SCREW & NUT; .281 DRILLED HOLE WAS .188 AND WAS PARALLEL TO EXISTING HOLE; MODIFIED INSTRUCTIONS	2/14/2014	RFM
REV	ECN#	DESCRIPTION	DATE	BY

UNSPECIFIED TOLERANCES 2 PLACE ±.060 3 PLACE ±.030 4 PLACE ±.010 HOLE DIA. ±.010 ANGULAR ± 1°	DIMENSINS ARE IN INCHES DIMENSIONS IN ( ) ARE MILLIMETERS UNLESS OTHERWISE SPECIFIED. DO NOT SCALE	DATE 01/21/14 DRAWN RFM CHECK _ WEIGHT .50 SCALE 3:16	DESCRIPTION 1 QUICKSHEET, ACME NUT REWORK DESCRIPTION 2 STA CURTAIN MACHINES	SHEET 1 OF 1	990097	REV. B
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VALCO COMPANIES, INC.

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