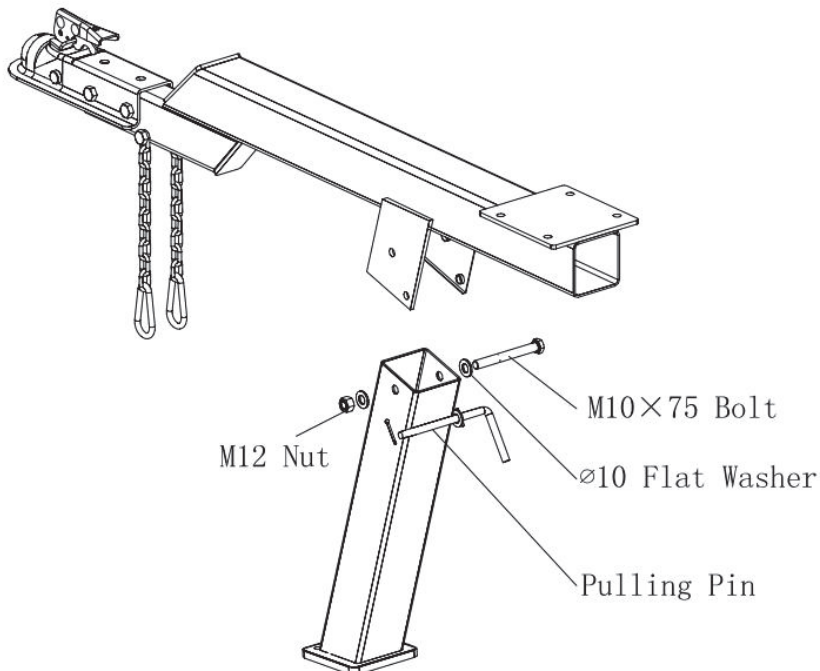
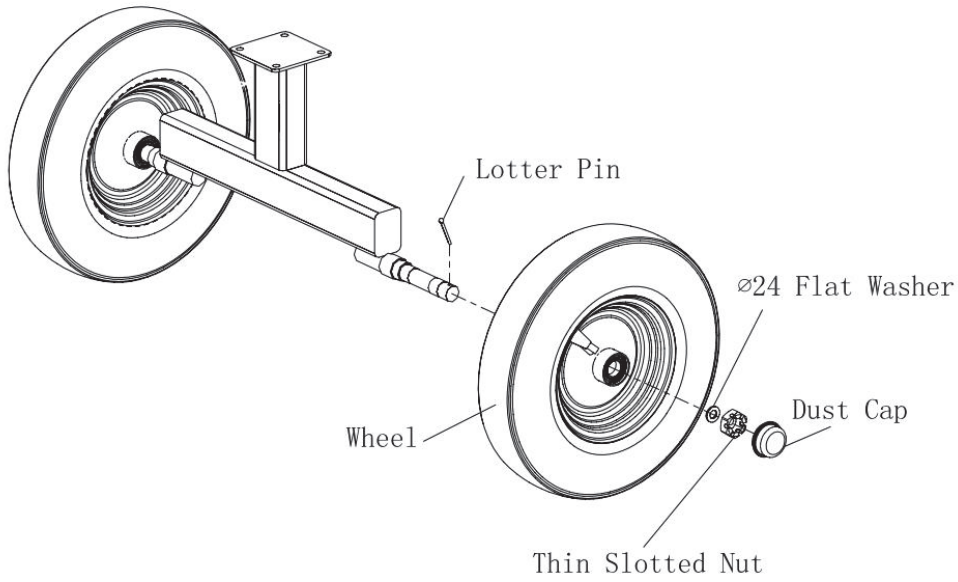


Rack returning very slow or not going all the way back.	<input type="checkbox"/> Return spring is unhooked or damaged. Reconnect or replace as needed. <input type="checkbox"/> Machine wedge end too low. Must be almost level or wedge end slightly higher.
Operator Lever Snapping out of gear or not staying in gear.	<input type="checkbox"/> Lever not all the way forward when rack comes under full load. Push lever quicker and more forcefully into the full forward position. <input type="checkbox"/> Ram has been overloaded at lower part of face. Check rack gear for straightness.
Rack slamming back too fast.	<input type="checkbox"/> Wedge end of machine too high. Must be almost level with ram end or just slightly higher. <input type="checkbox"/> Springs not operating properly. Fix or replace as needed.
Machine does not seem to have full splitting power.	<input type="checkbox"/> The belts may be too loose and slipping. Adjust or replace belts as needed. <input type="checkbox"/> Check Torque Specs of ABS system bolts. 5-6ft lbs.
Operator Lever not engaging rack with pinion gear.	<input type="checkbox"/> Clean wood chips or other debris from under rack. <input type="checkbox"/> Clean accumulated dirt from frame where carriage assembly rests against rubber bumpers.

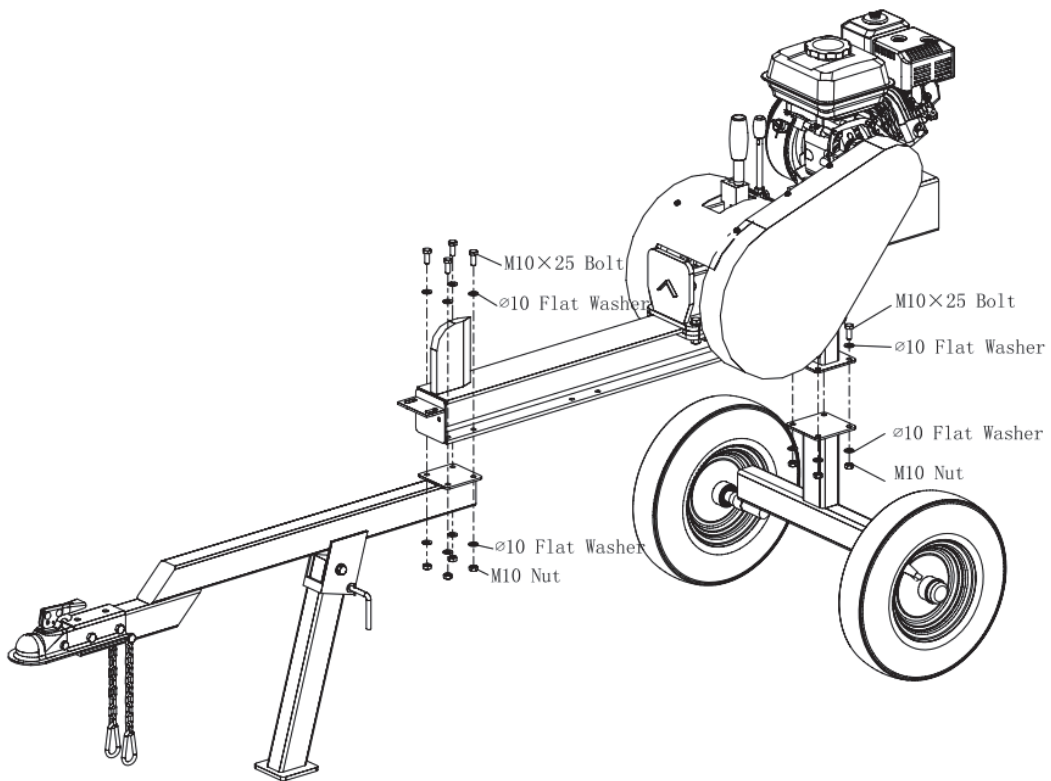
Assembly



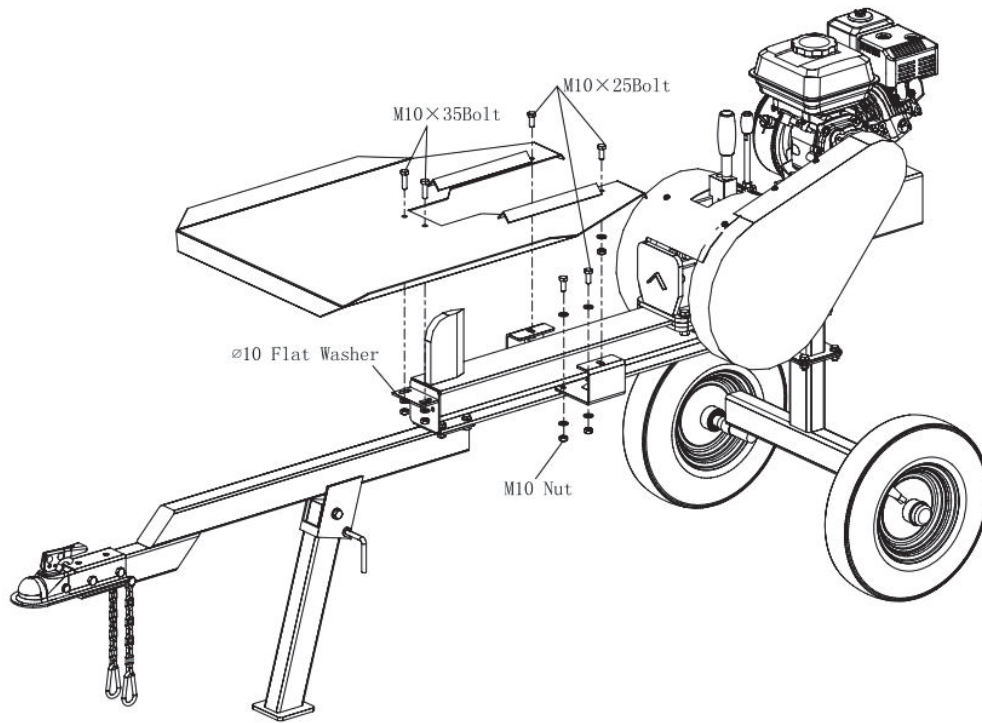
Step 1



Step 2

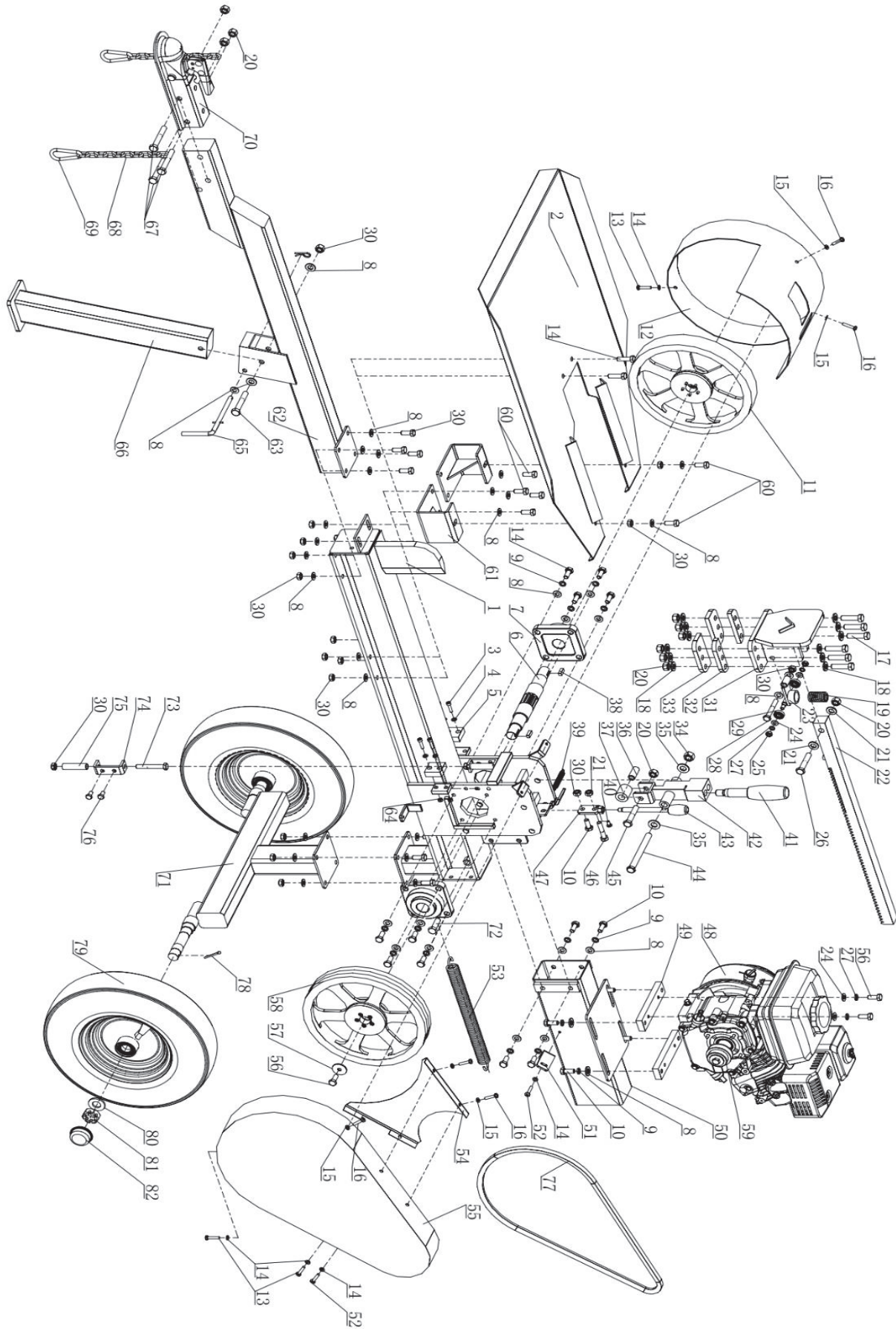


Step 3



Step 4

Exploded View



Parts List

No.	Description	Qty	No.	Description	Qty
1	Body	1	35	Washer ϕ 14	2
2	Table	1	36	Sleeve	1
3	Hex Bolt M6x30	4	37	Roller	1
4	Flat washer ϕ 8	9	38	Key 8x7	2
5	Damping block	2	39	Safety tension spring	1
6	Gear shaft	1	40	Cross recessed pan head bolt M6x10	1
7	Bearing housing	2	41	Operating handle	1
8	Washer ϕ 10	37	42	Operating pressure block	1
9	Spring washer M10	16	43	Safety handle	1
10	Hex Bolt M10x25	9	44	Hex Bolt M4x140	1
11	Flywheel	1	45	Hex Bolt M12x60	1
12	Flywheel cover	1	46	Hex Bolt M10x75	1
13	Hex Bolt M6x12	3	47	Safety block	1
14	Hex Bolt M10x30	10	48	Engine	1
15	Washer ϕ 6 Big	5	49	Engine seat	2
16	Hexagon socket head bolt M6x10	5	50	Engine tailstock	1
17	Hex Bolt M12x45	6	51	Wheel cover fixing plate	1
18	Washer ϕ 12	14	52	Hex Bolt M6x16	2
19	Return spring	1	53	Return spring	2
20	Non-metallic insert locking nut M12	11	54	Safety Cover	1
21	Hexagon nut M10	1	55	Pulley cover	1
22	Rack	1	56	Hex Bolt M8x25	7
23	Reset seat	1	57	Washer ϕ 8x30x3	3
24	Washer ϕ 8	6	58	Pulley	1
25	Non-metallic insert locking nut M8	2	59	Engine pulley	1
26	Hex Bolt M12x70	1	60	Hex Bolt M10x25	6
27	Spring washer M8	6	61	Seat	2
28	Hex Bolt M10x70	1	62	Tow pole	1
29	Bearing 609-2Z	2	63	Hex Bolt M10x80	1
30	Non-metallic insert locking nut M10	19	64	Non-metallic insert locking nut M6	4
31	Propeller	1	65	Pin	1

32	Track liner	2		66	Support leg	1
33	Track plate	2		67	Hex Bolt M12x75	3
34	Non-metallic insert locking nut M14	1		68	Chain	2
69	Chain Cufflinks	2				
70	Trailer cover	1				
71	Wheel carrier	1				
72	Hex Bolt M12x16	2				
73	Hex Bolt M10x90	2				
74	Side roller seat	2				
75	Side roller	2				
76	Hex Bolt M8x16	4				
77	Triangle belt	2				
78	Cotter pin	2				
79	Wheel	2				
80	Washer M24	2				
81	Slotted nut M24	2				
82	Wheel cover	2				