

**Bulletin #: V011311-01** 

Issue Date: January 13, 2011

#### How to Change the Carriage to 350% Prestretch

1. Unhook spring off of dancer bar to relieve pressure.

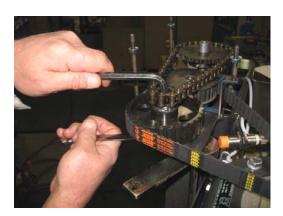


2. Loosen motor bracket hardware to relieve tension off of belt.





3. Loosen hardware on sprocket pulley.



Orion Packaging Systems \* A division of Pro Mach 4750 County Road 13 NE Alexandria, MN 56308 (800) 333-6556 \* www.support.orionpackaging.com



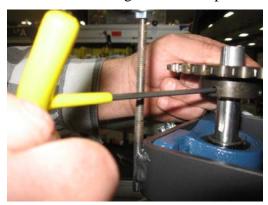
Bulletin #: V011311-01

Issue Date: January 13, 2011

4. Remove chain link and chain.



5. Take off existing outer 260% prestretch sprocket.



6. Replace with new 350% prestretch sprocket provided in kit.



Orion Packaging Systems \* A division of Pro Mach 4750 County Road 13 NE Alexandria, MN 56308 (800) 333-6556 \* www.support.orionpackaging.com



Bulletin #: V011311-01

Issue Date: January 13, 2011

7. Check that the sprockets are level.



8. Add new chain with an additional  $\frac{1}{2}$  link and connecting link onto the sprocket and sprocket pulley.





**Bulletin #: V011311-01** 

Issue Date: January 13, 2011

9. Tighten chain with flat bar and re-tighten sprocket pulley so that the chain is tight.



Check Tension



10. Pull outward on the motor end bracket to tighten up the belt and re-tighten motor

bracket hardware. (See illustration with step #2)



Check Tension



11. Rehook spring up to the dancer bar. (See illustration with step #1)