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## **A690R, A694 & A691R SPRING STEEL/FOAM REPLACEMENT INSTRUCTIONS**

4/20/01

To replace spring steel/foam assembly in Rotary Shear Cutters, complete the following recommended steps:

1. Remove screws from both ends of aluminum track. Then slide hand cutter completely out of track.
2. Using needle nose pliers, grasp either end of old spring steel/foam assembly and pull out of track.
3. Assembly is designed to fit tightly in aluminum track. To make installation easier, lubricate with petroleum jelly or similar lubricant. To insert new assembly, attach a flexible wire through hole at either end of new steel/foam assembly. Wire has to be long enough to completely extend through length of track. The wire will be used to pull the assembly through track, but be sure that the assembly is properly inserted into track (See drawing on Page 2). The spring steel must be inserted in slot at bottom of track.
4. Slide the new spring steel/foam assembly into the aluminum track and center on the track.
5. Slide hand cutter back into track.
6. Rotary Shear Cutter can now be put back into production.

**NOTE:** When not in use, slide hand cutter to either end of track. This will avoid unnecessary pressure on foam strip which could shorten life of foam.

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## ROTARY HEAD REPLACEMENT

1. DISASSEMBLE ONE END OF THE CUTTER TO REMOVE THE OLD CUTTING HEAD.
2. REPLACE WITH NEW CUTTING HEAD AND REASSEMBLE CUTTER.  
 MAKE SURE BLADE FITS BETWEEN HARDENED BLUE STEEL BLADE AND ALUMINUM TRACK AND DOESN'T RIDE ON FOAM.
3. LOOSEN CAP NUTS TO ADJUST KNIFE HEIGHT FOR MATERIAL THICKNESS.  
 THERE SHOULD BE A GAP BETWEEN THE BLACK RUBBER WHEELS AND ALUMINUM TRACK.

FOR ILLUSTRATION PURPOSES  
 SOME FEATURES ARE NOT SHOWN.

THE BEARINGS ARE GLUED IN PLACE.  
 THE BEARINGS ARE NOT SERVICEABLE.

DESCRIPTION	PART NO.
ROTARY HEAD COMPLETE	69022
ROTARY HOUSING ASSEMBLY	69019
ROTARY KNIFE ASSEMBLY	69015
CAP NUT(2-REQ'D)	69005
AXLE(2-REQ'D)	69002
5/16 FLAT WASHER(4-REQ'D)	1008
A690R & A691R FOAM & BLADE ASSEMBLY SIZES	
24"	364244
36"	364255
48"	364266
60"	364261
A692 FOAM & BLADE ASSEMBLY	69233

