



INSTRUCTION SHEET

Facer Extension Kit for 65" Pipe

A6513001

Overview

Use of drill jig to drill and tap blade holders allowing installation of blade holder extensions at each blade. In conjunction with new blades, allows facing of 65" OD pipe.

Tools Required

Electric handheld drill, tap handle or wrench, 7/16 wrenches or sockets, 1/4 Allen wrench

Contents of Kit

<u>Item</u>	<u>Part No.</u>	<u>Qty</u>	<u>Description</u>
1	MAB00005	1	1/4-20NCx1-1/4LG HHCS
2	MAC00077	16	5/16-18NCx1-1/2LG HHCS
3	MBA00005	1	1/4-20NC Finish Hex Nut Steel Plated
4	MBE00005	1	1/4 Regular Split Lock Washer Steel Plated
5	MBE00006	16	5/16 Regular Split Lock Washer Steel Plated
6	MJL00062	1	1/8" drill bit
7	MJL00063	1	5/16-18NC Tap
8	MNC00012	2	.257x1/2x1/2LG Drill Bushing
9	3615716	1	Shortened 36/48/65 Facer Blade Set
10	6512803	1	Blade Holder Extension Jig
11	6512804	8	Blade Holder Extension
12	6512901	1	Blade Holder Extension Drill Jig Bracket

Procedure

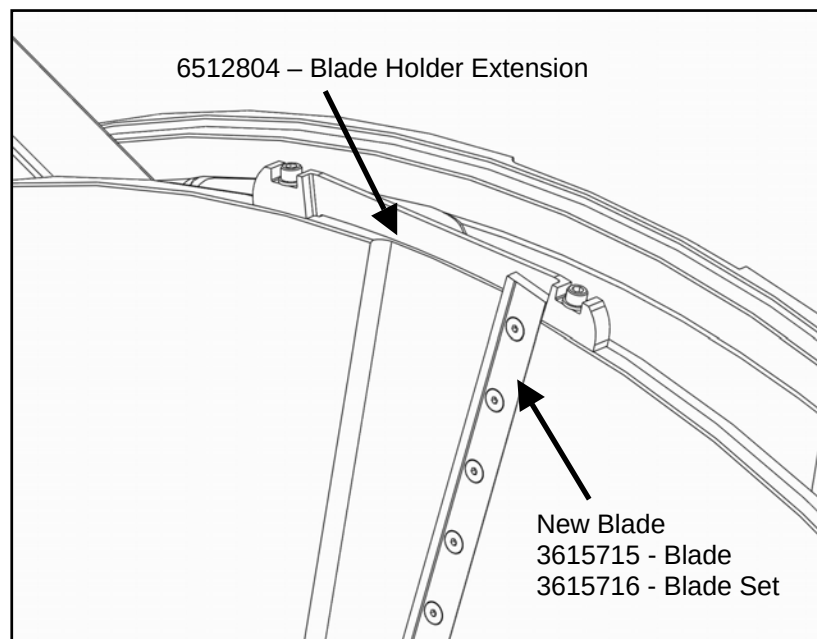
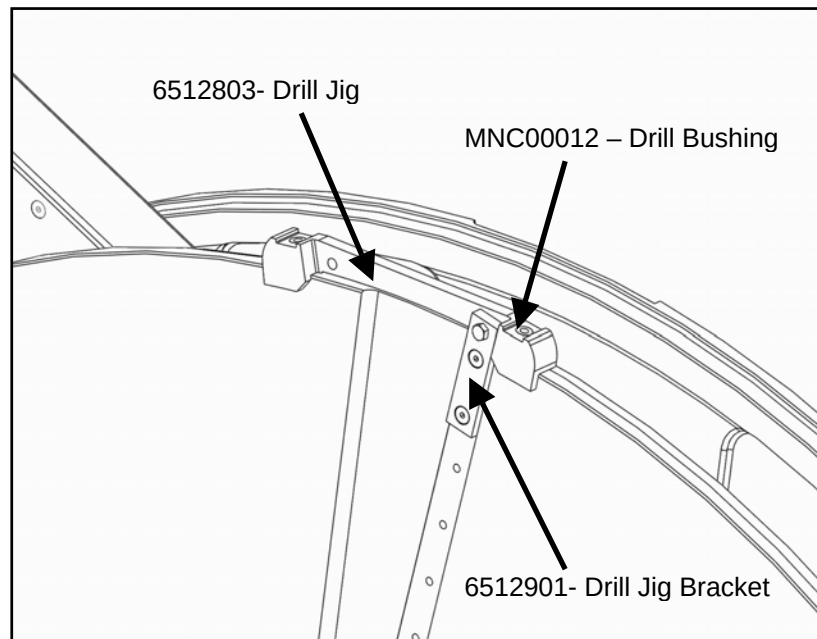
1. Press MNC00012 drill bushings into 6512803 jig.
2. Remove existing blades from facer.
3. Attach 6512901 drill jig bracket as shown below using 2 blade screws.
4. Attach 6512803 drill jig to the bracket as shown using provided 1/4-20NC hardware.
5. Use 1/8" (Ø.257) drill provided to drill through the jig into the blade holder 1" deep.
6. Remove the jig and use 5/16-18NC tap provided to tap the holes you have drilled.
7. Install new shortened blade provided in the kit hanging the end off the blade holder.
8. Slide 6512804 blade holder extension up to the back of the blade and attach to the blade holder with 5/16 hardware provided.



INSTRUCTION SHEET

Facer Extension Kit for 65" Pipe

A6513001



DRAWING REVISION HISTORY LISTING

PART NO: 651300101

DESCRIPTION: FACER EXTENSION KIT FOR 65" PIPE INSTRUCTION SHEET

<u>APPR.</u>	<u>REV</u>	<u>DATE</u>	<u>BY</u>	<u>DESCRIPTION OF REVISION</u>
SRB	A	5/4/09	RLE	ON SHEET 2, SECOND ILLUSTRATION, CORRECTED 6512803-DRILL JIG TO 6512804-BLADE HOLDER EXTENSION.