

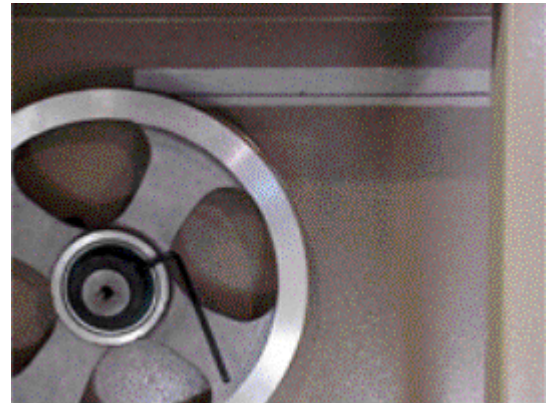
Roots-Tech Preheater Instructions - Fine Wire Assembly with Telescopic Guide

General - This assembly replaces the existing top preheater sheave for use in preheating 18 - 32 AWG conductors at low speeds. The assembly reduces heat loss at the top sheave and in the path to the cross-head. The assembly can be added or removed as needed.

Installation - This process includes the removal of the existing top sheave, addition of the fine wire sheave assembly, and the telescopic guide tube assembly.

Steps follow:

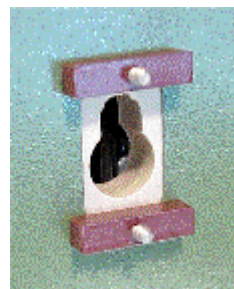
1. Keep the conductor in the preheater.
2. Remove the pinchpoint shield using a 7/32" Allens wrench.
3. With conductor in place, mark the wire path as shown.
4. Remove conductor from unit.
5. Remove shaft collar using 4 mm Allens wrench, and slide off top sheave.
6. Install Fine Wire assembly as shown using 5 mm Allens wrench. Align to marked wire path and center on inductor tubes.
7. Replace pinchpoint shield.
8. The Telescopic Guide tube assembly is mounted to the exit side of the preheater using the mounting bracket and nut plates as shown using a 3/16" Allens wrench.
9. Position the telescopic guides as shown, slots at bottom.
10. Preheater is now ready for operation.



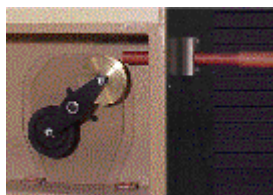
Marked wire path and Allens wrench in shaft collar, ready for removal.



Fine Wire assembly aligned to marked wire path. Shown with right - to-left wire direction.



Nut plates viewed from inside.



Complete assembly shown for right-to-left operation.