

## Technical Bulletin

Bulletin No	10	2014-03	Issued: 022014	Revised:	Page 1 of 3
Equipment	1 Gallon Bail-O-Matic				
Topic	Retro-Fit Rear Hinge AUS .098" or 2.5mm Wire				

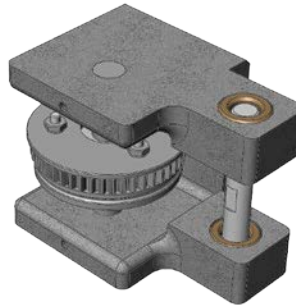
**Issues: Older Style Hinge required too much maintenance causing:**

1. Inconsistent Wire Drive/Straightness/Length.
2. Poor operation from excess wear of the older woodruff-key style Rear Hinge parts.
3. Excess repair time and costs maintaining the parts required for smooth operation.

**Solution:**

**A low-cost direct-fit replacement Retro-Fit Rear Hinge is available.**

**Assembly # 10.09.004**



**It comes with an easily-greasable hardened shaft, and needle bearing.**

It is a very important improvement to the wire feed system, that is economical, and greatly reduces the required maintenance to keep the wire drive, straightness, and length consistent.

We are recommending this upgrade to all our customers still operating the older woodruff-key style rear hinge, as it will improve the operation, longevity, and consistency of the wire feed, while greatly reducing the required maintenance.

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The older woodruff-key type idler roller and shaft in the rear hinge, also known as the rear feed roller, would wear and require replacing about twice a year. Replacement required changing the shaft, the key, often the bearings, and eventually the feed roller as well. When maintained properly, one could expect to get 3 or 4 idler shafts to one rear feed roller. However, when neglected, the feed roller required replacement every time.

### Retrofit Includes

- Hinge casting with Pivot Bushings and Pin Rear Feed Roller
- Gear
- Cover
- Needle Bearing with Integral Seals
- Fixed & Hardened Idler Shaft with Easy Access Grease fittings

### Key Benefits

- The Sealed Bearing and Greasable Hardened Shaft last much longer, with better performance.
- Fewer parts to maintain.
- There is no wear to the bore of the rear feed roller, which was the major cause of premature replacement of the older style roller.
- The shaft and bearing are much more easily changed.
- Can expect 1 to 2 years of improved operation, with monthly greasing of the shaft, before changing the bearing and the shaft.
- Direct replacement fit on any One-Gallon Bail-O-Matic.

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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	101078	BRACKET, WIRE FEED	1
2	101151	SHAFT	1
3	02356-01	PRESSURE ROLL	1
4	00850	DISC GEAR WIRE STRAIGHTENER	1
5	00678-01	GEAR PRESSURE ROLL	1
6	02468	BUSHING	2
7	101080-01	HEAVY DUTY NEEDLE BEARING	1
8	00673	SHAFT MOVABLE BRACKET WIRE FEED	1

ZONE	REV.	DESCRIPTION	DATE	BY
REVISIONS				
		NAME	DATE	
		BAH		
		ENG BY		
		CHECKED		
		ENG APPR.		
		DRAWN BY		
		BAH	03/06/13	
		COMMENTS		

UNLESS OTHERWISE SPECIFIED:	DIMENSIONS ARE IN INCHES TOLERANCES UNLESS OTHERWISE SPECIFIED: FRACTIONAL: .0005 DECIMAL: .0005 ANGULAR: .001 HOLE SIZE: .0015 HOLE POSITION: .0015 HOLE FACE: .0015 HOLE DEPTH: .0015
FORMERLY AN ORIGINAL DRAWING	DO NOT SCALE DRAWING
NEE FAST	USED ON
APPLICATION	

PRIMARY DIMENSIONAL TOLERANCES: DIMENSIONS ARE IN INCHES TOLERANCES UNLESS OTHERWISE SPECIFIED: FRACTIONAL: .0005 DECIMAL: .0005 ANGULAR: .001 HOLE SIZE: .0015 HOLE POSITION: .0015 HOLE FACE: .0015 HOLE DEPTH: .0015	REAR FEED ROLLER - NEEDLE BEARING .098 WIRE SIZE DWG. NO. <b>B 10.09.004</b> SCALE: 1:2 WEIGHT: SHEET 1 OF 1
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