

## Safety, Setup, Operation & Parts Manual

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**M28**  
**M48**  
**M68**

**Rev. A1.00+**  
**Rev. A1.00+**  
**Rev. A1.00+**

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**Safety is our #1 concern!** Read and understand all safety information and instructions before operating, setting up or maintaining this machine.

*April 2005*

*Form #740*

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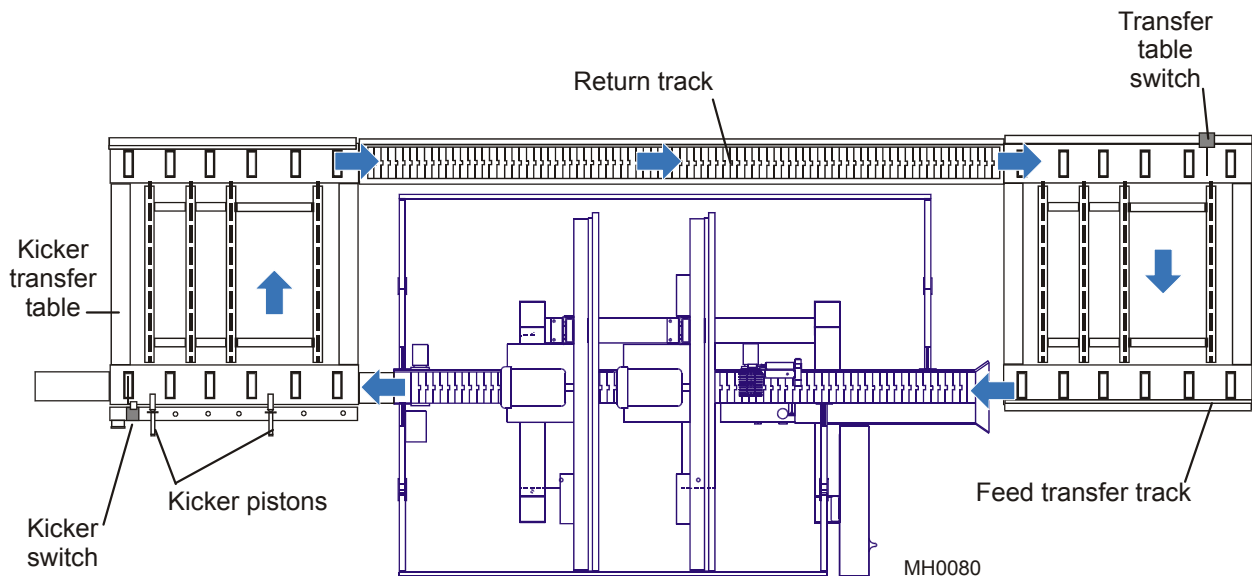
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## SECTION 1 OPERATION

### 1.1 Overview

See **Figure 1-1**. The Merry-Go-Round (MGR) handling system is designed to return unfinished cants to the feed end of the MultiHead. The system consists of two transfer tables and a return track. The standard length of each transfer table is 8' (2.44 m).

As cants exit the MultiHead they feed onto the kicker table.



**FIG. 1-1**

The table is adjusted so that cants of a specific height engage the kicker switch. Finished material moves under the kicker switch and can be off-loaded. If a cant engages the kicker switch, two air-driven pistons "kick" the cant onto the transfer chains. The cant is then routed to the return track back to the transfer table at the feed end of the MultiHead.

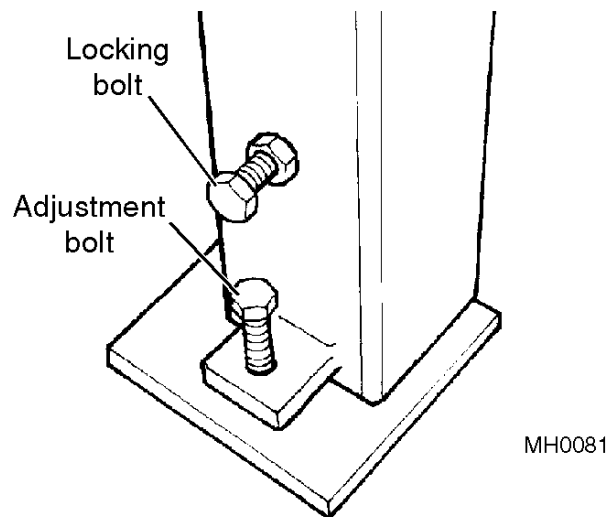
The cant activates a second switch which causes the transfer table to rise, transferring the cant from the return track to the feed table. Transfer chains then move the cant forward where it can then be reloaded onto the MultiHead feed track.

## 1.2 Merry-Go-Round Setup

See Figure 1-2.

1. Each merry-go-round (MGR) table has leg adjustments to help align the tables parallel to the MultiHead. Loosen the locking bolt and turn the adjusting bolt to raise or lower the leg. Sight down the table edge to determine if the table is aligned with the MultiHead feed track. Retighten the locking bolt to maintain the adjustment.

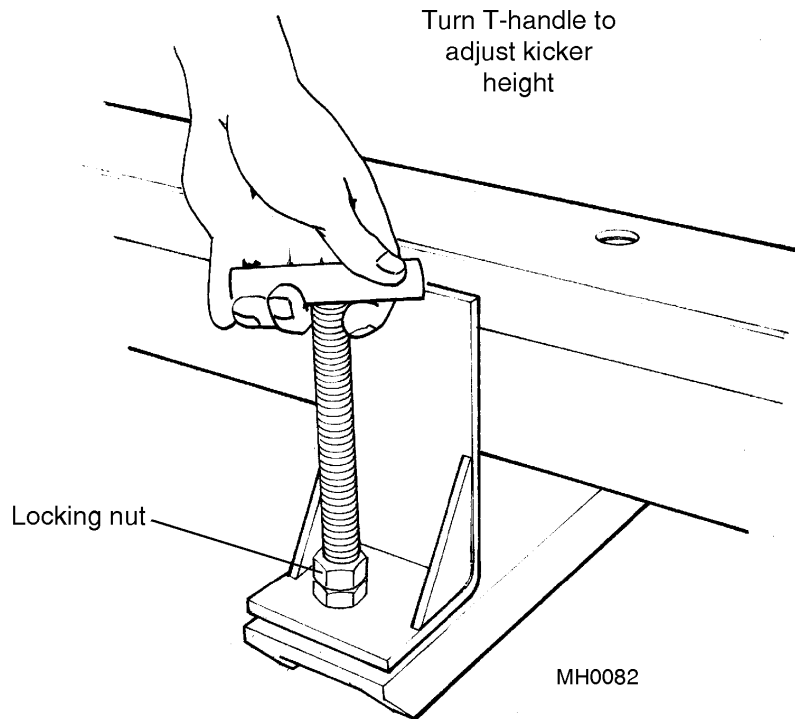
Avoid adjusting the legs so the table buckles, causing cants to contact the transfer chain before they are completely on the transfer table.



**FIG. 1-2**

See Figure 1-3.

2. Adjust the kicker table so that the desired height cant will contact the kicker switch. Loosen the locking nut and turn the T-handle to raise or lower the kicker table. Retighten the jam nut to maintain adjustment.



**FIG. 1-3**

# 1 Operation

## Merry-Go-Round Setup

See Figure 1-4.

3. Adjust the rear kicker to a position that will contact the rear of the cant. Different length cants will require readjustment of the rear kicker.

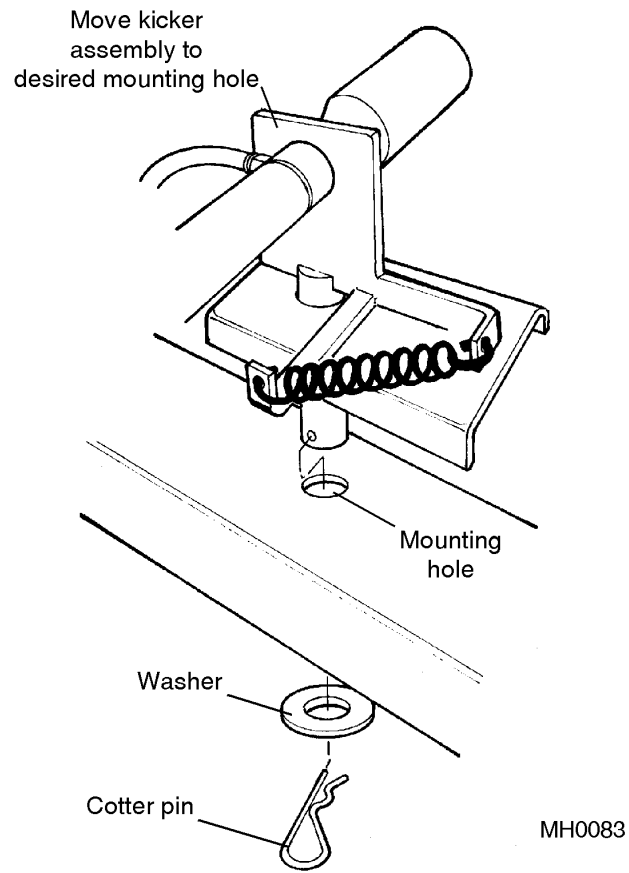


FIG. 1-4

See Figure 1-5.

4. Loosen the jam nuts and adjust the stop bolts on the return track fence so the fence opens to 1/4" more than the cant width to be cut. Retighten the jam nuts.

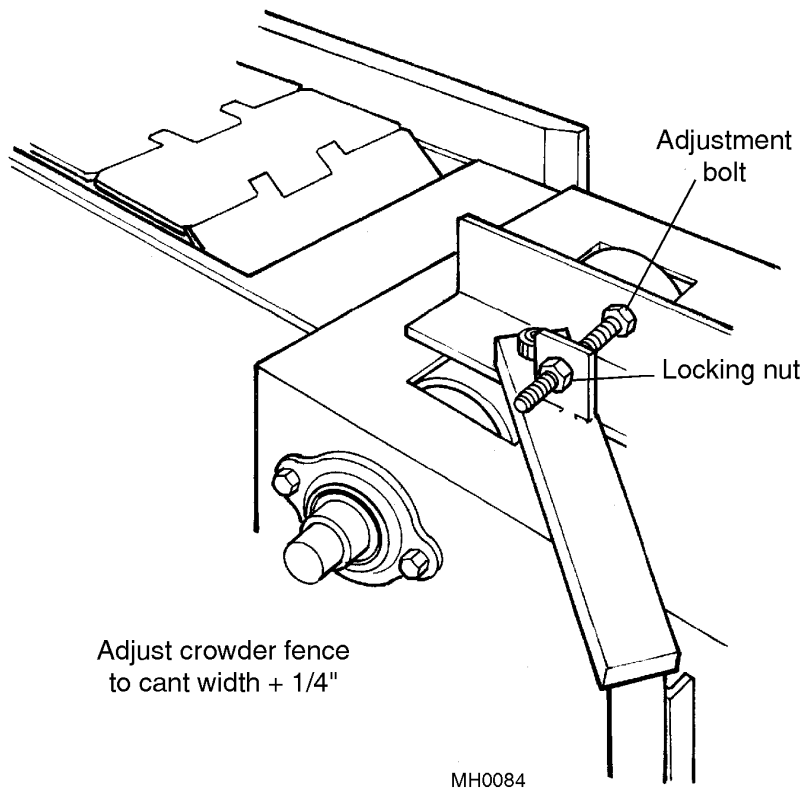


FIG. 1-5

# 1 Operation

## Merry-Go-Round Setup

See Figure 1-6.

5. Adjust the transfer table air switch so that the end of the cant contacts the switch once it has completely moved from the return track to the transfer table.

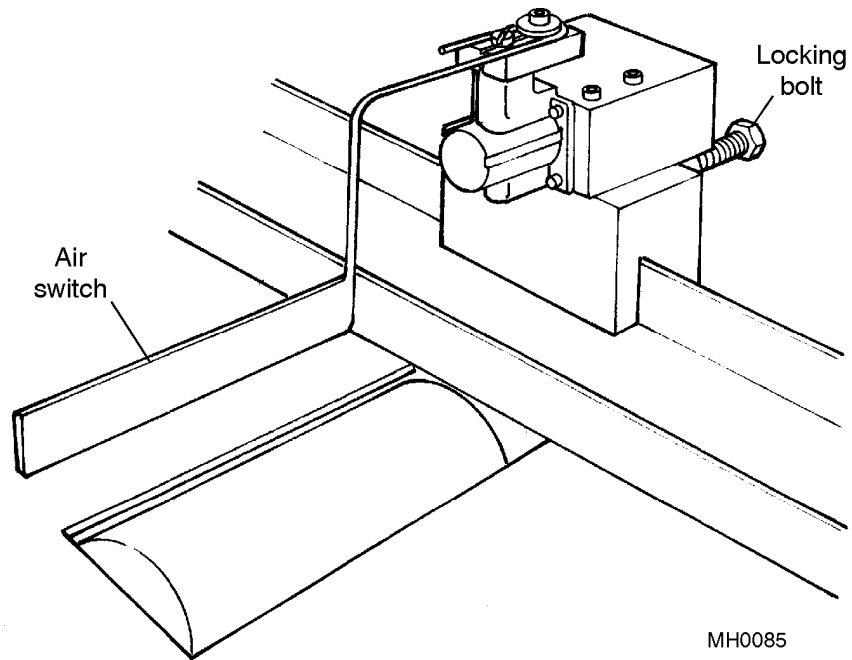


FIG. 1-6



## 1.3 Hydraulic Installation

### M28 & M48

1. At the MultiHead, remove the hose connecting the first feed roller motor to the filter on the hydraulic system.
2. At the MultiHead, remove the hose connecting the last feed roller motor to the track motor.

See Figure 1-7.

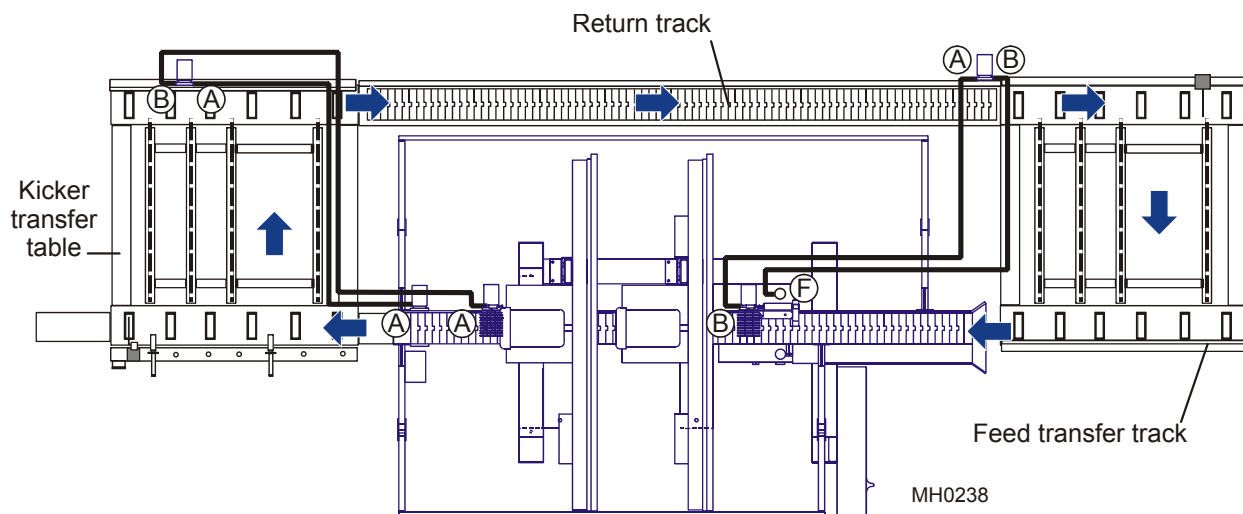


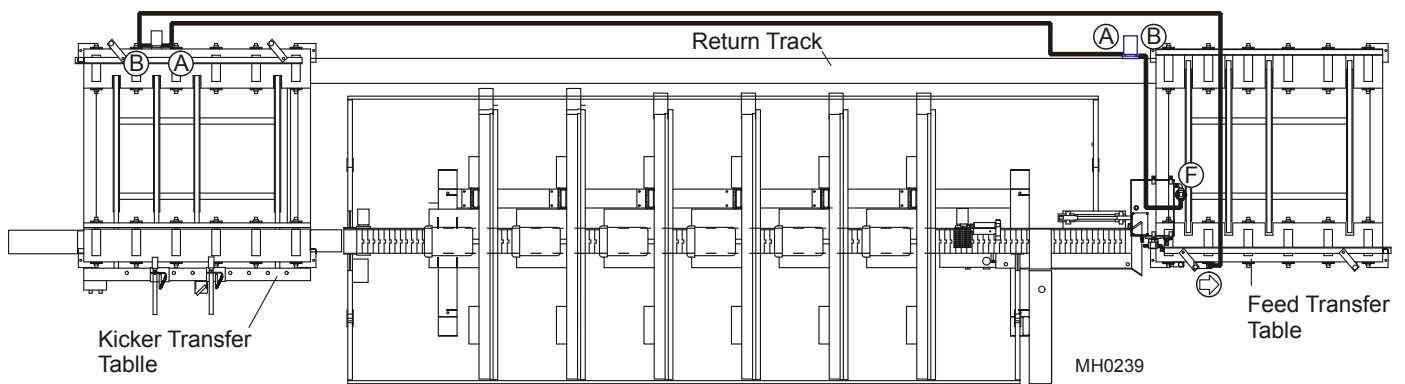
FIG. 1-7

3. Connect one of the supplied 11' hoses to port 'B' of the first feed roller motor. Connect the other end of the hose to port 'A' of the MGR return track motor.
4. Connect the other supplied 11' hose to port 'A' of the MGR return track motor. Connect the other end of the hose to the MultiHead hydraulic filter 'F'.
5. Connect a supplied 13' hose to port 'A' of the MultiHead track motor. Connect the other end of the hose to port 'B' of the MGR kicker table motor.
6. Connect the other supplied 13' hose to port 'A' of the last feed roller motor. Connect the other end of the hose to port 'A' of the MGR kicker table motor.

**M68**

See Figure 1-8.

1. Connect the longest hose to the open port of the flow meter (marked with an arrow). Connect the other end of the hose to port 'B' of the kicker table motor.
2. Connect the next longest hose to port 'A' of the kicker table motor. Connect the other end of the hose to port 'A' of the return track motor.
3. Connect the shortest hose to port 'B' of the return track motor. Connect the other end of the hose to the filter 'F' on the MGR hydraulic system.



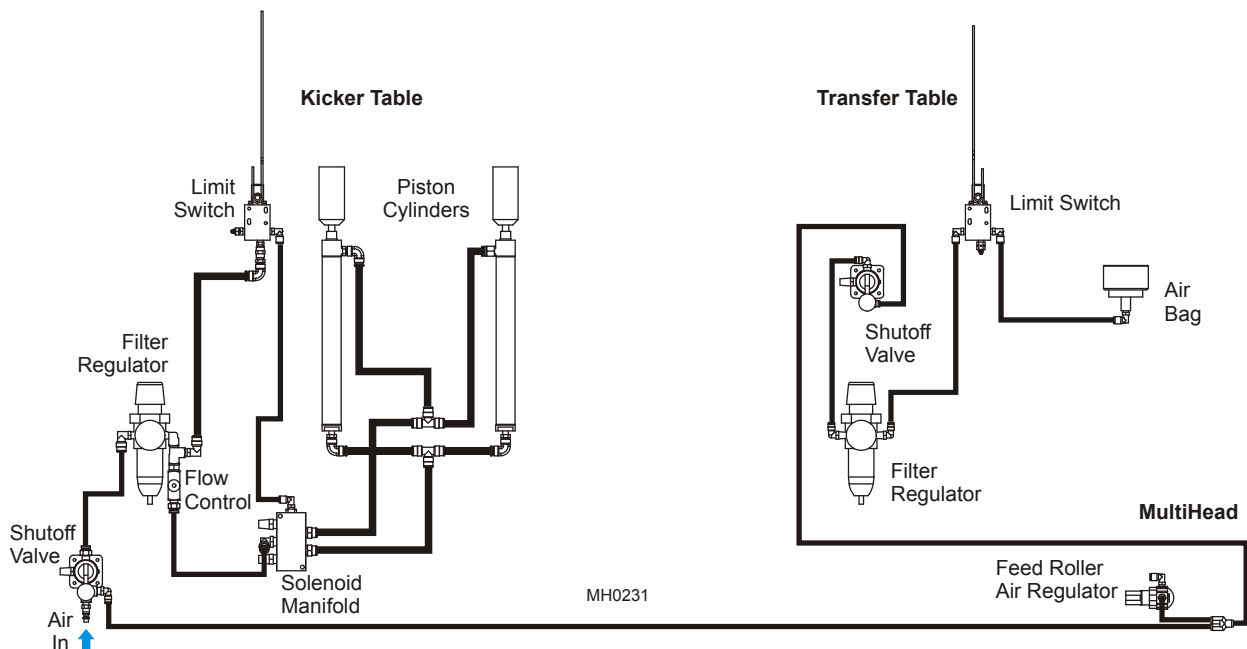
**FIG. 1-8**

## 1.4 Air Installation

The MGR air system consists of two valve assemblies; one operates the kickers and one operates the transfer table. Each valve assembly consists of a shutoff valve and an air regulator/filter with gauge. The kicker assembly also includes a solenoid valve and an air restriction valve to control the speed of the kickers.

**See Figure 1-9.** The air connection fitting may be located at either valve assembly. In the figure below, it is shown attached to the kicker valve assembly. To properly connect the air system:

1. Use a 1/4" NPT female fitting to connect the air line to the connection fitting.
2. Raise the shutoff valve handle on both air valve assemblies.
3. Turn both regulator valves until each gauge indicates 60 p.s.i. Turning the valve clockwise raises the air pressure; counterclockwise lowers the air pressure.
4. Activate the kicker switch and check the speed at which the kicker pistons operate. Adjust the flow control valve until the pistons move at the speed desired.



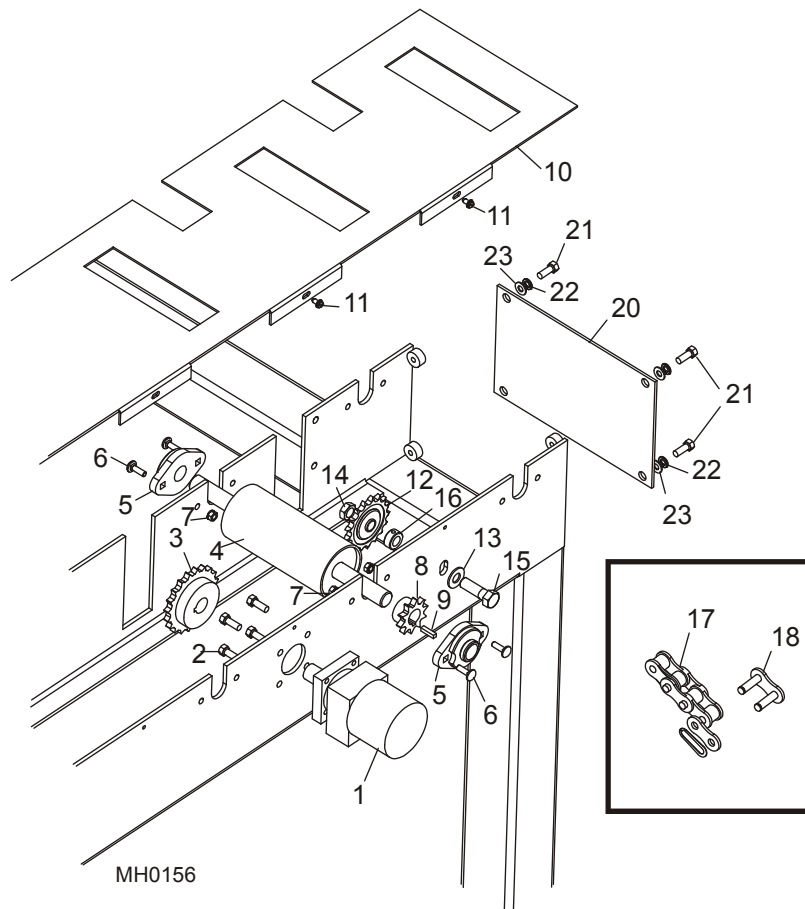
**FIG. 1-9**

# 2

## Merry-Go-Round Parts Kicker Table Drive Assembly

### SECTION 2 MERRY-GO-ROUND PARTS

#### 2.1 Kicker Table Drive Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	MOTOR, MG06-13-13AAAB HYDRAULIC	P21506	1	
2	BOLT, 3/8-16 X 1" HEX HEAD	F05007-7	4	
3	SPROCKET, 50BS20X1	P21129	1	
	ROLLER ASSEMBLY, MGR 15 1/4" TABLE	A21081	16 1/12 <sup>2</sup>	
4	Roller Weldment, MGR 15 1/4" Table	W21082	1	
	Bearing Assembly, 1" Flanged	A21621	2	
5	Bearing, 1" Flanged	P21490	1	◆
6	Bolt, 5/16-18 x 1" Carriage	F05006-9	2	
	Washer, 5/16" Split Lock	F05011-13 <sup>3</sup>	2	
	Washer, 5/16" SAE Flat	F05011-17 <sup>3</sup>	2	
7	Nut, 5/16-18 Self-Locking Hex	F05010-20	2	

	Instruction Sheet, 1" Flanged Bearing Replacement	A21621-384	1	
8	Sprocket, 50BS10X1	P21414	1	
9	Key, 1/4" Sq. X 1" Long	S21486	1	
10	COVER (DRIVE SIDE), 6' KICKER TABLE ROLLER	S21089 <sup>2</sup>	1	
	COVER (DRIVE SIDE), 8' KICKER TABLE ROLLER	S21608 <sup>1</sup>	1	
11	SCREW, 1/4-20 X 1/2" SLOTTED HEX HEAD	F05015-1	8 <sup>1/6</sup> <sup>2</sup>	
12	SPROCKET, 50BB17H X 5/8"	P21504	5 <sup>1/4</sup> <sup>2</sup>	
13	WASHER, 5/8" SAE FLAT	F05011-5	5 <sup>1/4</sup> <sup>2</sup>	
14	NUT, 5/8-11 HEX NYLON JAM	F05010-96	5 <sup>1/4</sup> <sup>2</sup>	
15	BOLT, 5/8-11 X 2" HEX HEAD GRADE 2	F05009-2	5 <sup>1/4</sup> <sup>2</sup>	
16	COLLAR, 5/8" I.D. LOCK	P05035	5 <sup>1/4</sup> <sup>2</sup>	
17	CHAIN, R50 X 86 PITCH ROLLER (8' TABLE ROLLER DRIVE EXTENSION)	P20207-86 <sup>4</sup>	1 <sup>1</sup>	
	CHAIN, R50 X 236 PITCH ROLLER (TABLE ROLLER DRIVE)	P20207-236	1	
18	Master Link, #50 Chain	P20208	1	
19	COVER, TABLE END	S21088	1	
20	BOLT, 3/8-16 X 1" HEX HEAD	F05007-7	4	
21	WASHER, 3/8" SPLIT LOCK	F05011-4	4	
22	WASHER, 3/8" SAE FLAT	F05011-3	4	

<sup>1</sup> Part numbers and quantities apply to MGR's with 8' capacity only

<sup>2</sup> Part numbers and quantities apply to MGR's with 6' capacity only.

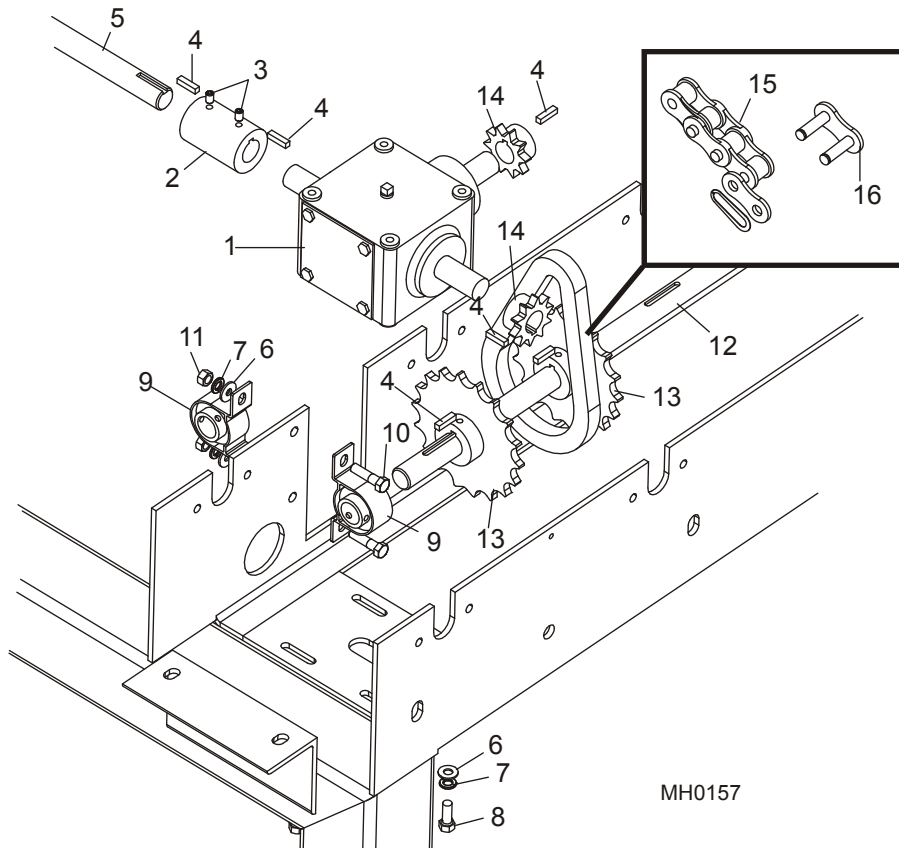
<sup>3</sup> Additional hardware to mount bearings to frames with tapped holes.

<sup>4</sup> Add to P20207-236 to create 322 pitch drive chain for MGR's With 8' capacity.

## 2 Merry-Go-Round Parts

### Kicker/Transfer Gear Box Assembly

## 2.2 Kicker/Transfer Gear Box Assembly



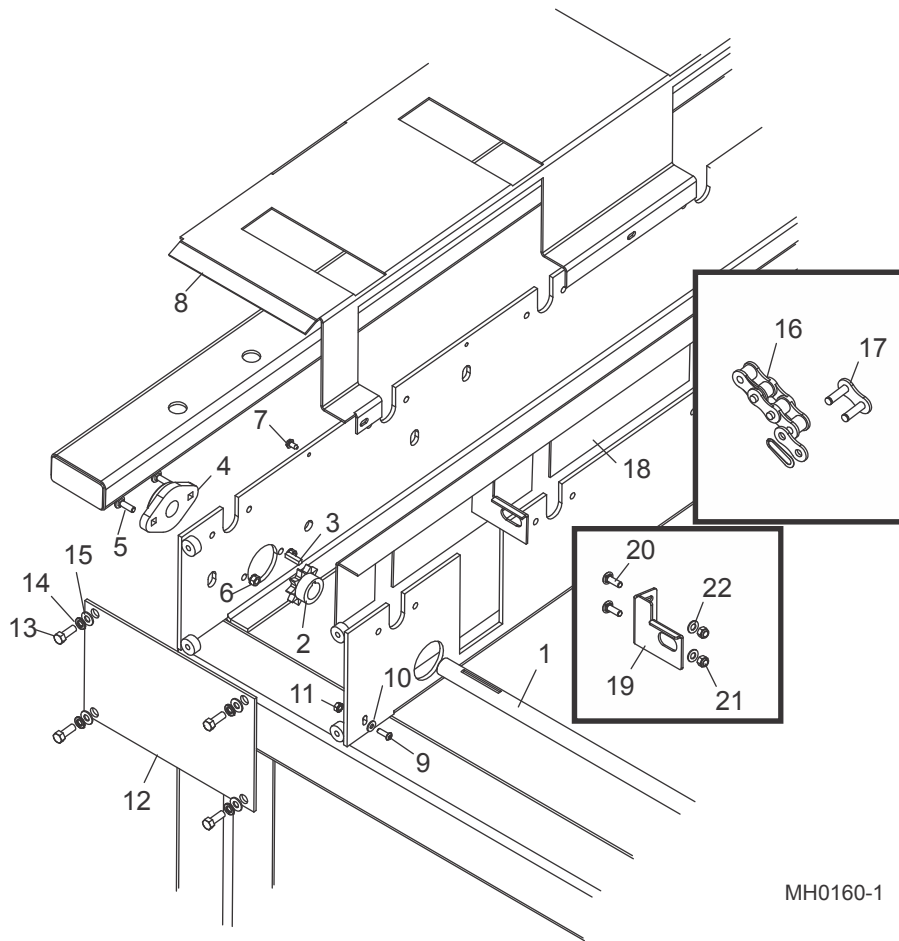
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	GEAR BOX, KICKER TABLE DRIVE	P21507	1	
2	COUPLER, SHAFT	S20185	1	
3	SCREW, 5/16-18 X 1/2" SOCKET HEAD SET BLACK OXIDE	F05006-38	2	
4	KEY, 1/4" SQ. X 1" LONG	S21486	6	
5	SHAFT, CROSS TABLE DRIVE	S21134	1	
	SHAFT, CROSS TABLE DRIVE, SPECIAL 10' MGR	S21134-10	1	
	BRACKET, SHAFT SUPPORT SPECIAL 10' MGR	N/A	1	
6	WASHER, 3/8" SAE FLAT	F05011-3	6	
7	WASHER, 3/8" SPLIT LOCK	F05011-4	6	
8	BOLT, 3/8-16 X 1" HEX HEAD	F05007-7	4	
9	BEARING, 1" STAMPED PILLOW	P21491	1	
10	BOLT, 3/8-16 X 1 1/2" HEX HEAD GRADE 5	F05007-78	2	
11	NUT, 3/8-16 HEX	F05010-1	2	
12	SHAFT, 6' MGR CONVEYOR DRIVE	S21133	1	
	SHAFT, 8' MGR CONVEYOR DRIVE	S21133-8	1	
13	SPROCKET, 50BS28X1	P21503	2	

**Merry-Go-Round Parts**  
*Kicker/Transfer Gear Box Assembly*

**2**

<b>14</b>	<b>SPROCKET, 50BS10X1</b>	P21414	2	
<b>15</b>	<b>CHAIN W/MASTER LINK, R50 X 40 PITCH ROLLER (GEAR BOX DRIVE)</b>	P20207-40	1	
<b>16</b>	Master Link, #50 Chain	P20208	1	

**2.3 Kicker Table Cross Shaft Assembly**



MH0160-1

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	SHAFT, CROSS TABLE DRIVE	S21134	1	
	SHAFT, CROSS TABLE DRIVE, SPECIAL 10' MGR	S21134-10	1	
	BRACKET, SHAFT SUPPORT SPECIAL 10' MGR	N/A	1	
2	SPROCKET, 50BS10X1	P21414	1	
3	KEY, 1/4" SQ. X 1" LONG	S21486	1	
4	BEARING, 1" FLANGED	P21490	1	◆
5	BOLT, 5/16-18 X 1" ROUND HEAD	F05006-9	2	
6	NUT, 5/16-18 SELF-LOCKING HEX	F05010-20	2	
7	SCREW, 1/4-20 X 1/2" SLOTTED HEX HEAD	F05015-1	8 1/6 <sup>2</sup>	
8	COVER (IDLE SIDE), 8' KICKER TABLE ROLLER	S21609 <sup>1</sup>	1	
	COVER (IDLE SIDE), 6' KICKER TABLE ROLLER	S21090 <sup>2</sup>	1	
9	SCREW, 1/4-20 X 3/4" BUTTON HEAD	F05005-60	4	
10	WASHER, 1/4" SAE FLAT	F05011-11	4	



**Merry-Go-Round Parts**  
*Kicker Table Cross Shaft Assembly*

2

11	<b>NUT, 1/4-20 SELF-LOCKING</b>	F05010-9	4	
12	<b>COVER, TABLE END</b>	S21088	1	
13	<b>BOLT, 3/8-16 X 1" HEX HEAD</b>	F05007-7	4	
14	<b>WASHER, 3/8" SPLIT LOCK</b>	F05011-4	4	
15	<b>WASHER, 3/8" SAE FLAT</b>	F05011-3	4	
16	<b>CHAIN, W/MASTER LINK, R50 X 230 PITCH ROLLER (TABLE ROLLER IDLE)</b>	P20207-230	1	
	<b>CHAIN, R50 X 86 PITCH ROLLER (8' TABLE ROLLER DRIVE EXTENSION)</b>	P20207-86 <sup>3</sup>	1 <sup>1</sup>	
17	Master Link, #50 Chain	P20208	1	
18	<b>FENCE WELDMENT, 6' MGR KICKER</b>	W21079	1	
	<b>FENCE ASSEMBLY, 8' MGR KICKER</b>	W21079-8 <sup>4</sup>	1	
18	Fence, MGR Cant	S21607	1	
19	Bracket, MGR Fence Mount	S21078	4	
20	Bolt, 5/16-18x1 Carriage Gr5	F05006-90	8	
21	Nut, 5/16-18 Nylok Hex	F05010-58	8	
22	Washer, 5/16 SAE Flat	F05011-17	8	

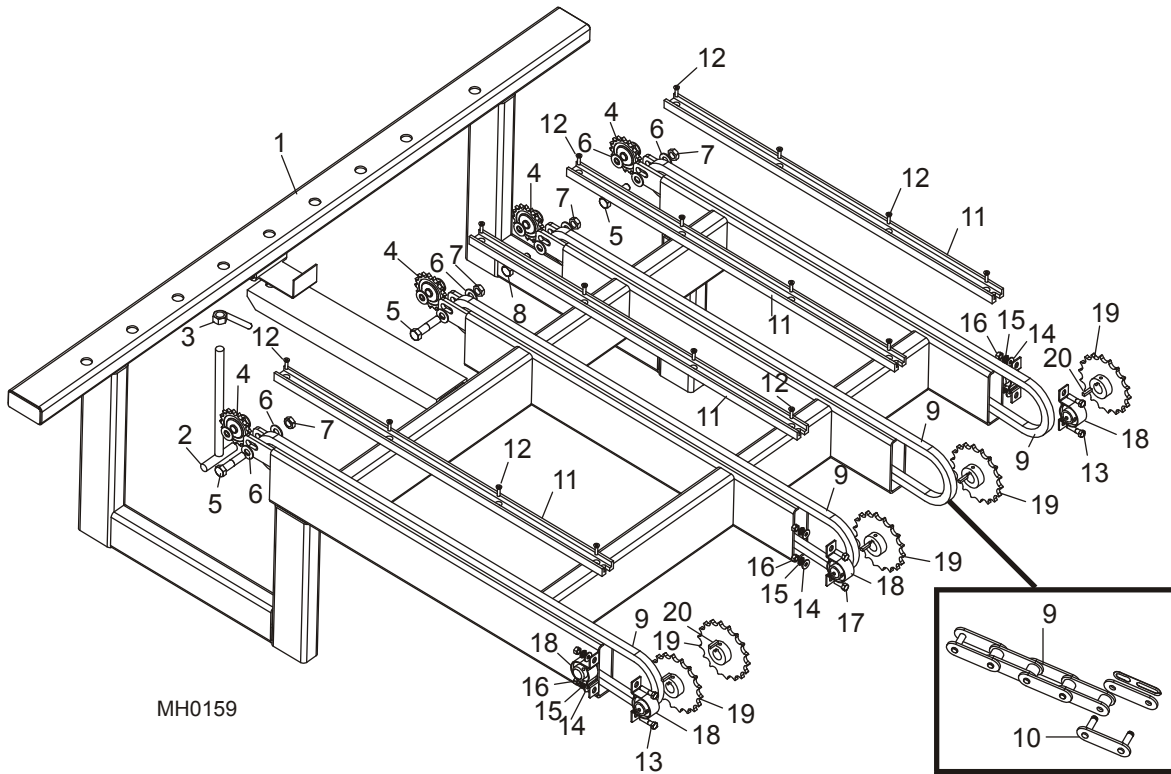
<sup>1</sup> Part numbers and quantities apply to MGR's with 8' capacity only

<sup>2</sup> Part numbers and quantities apply to MGR's with 6' capacity only.

<sup>3</sup> Add to P20207-230 to create 316 pitch drive chain for MGR's With 8' capacity.

<sup>4</sup> W21079-8 changed from weldment to assembly to make it adjustable to fit in kicker assembly properly (9/16).

2.4 Kicker Conveyor Table



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	TABLE WELDMENT, 8' MGR KICKER	W21469-8R <sup>1</sup>	1	◆
	TABLE WELDMENT, 6' MGR KICKER	W21469-6R <sup>2</sup>	1	◆
2	T-HANDLE, KICKER ADJUSTMENT	W21441	1	
3	NUT WELDMENT, 3/4-10 HEX	W21619	1	
4	SPROCKET, 50BB17H X 5/8"	P21504	5 1/4 <sup>2</sup>	
5	BOLT, 5/8-11 X 2 3/4" HEX HEAD GRADE 5	F05009-21	4 1/3 <sup>2</sup>	
6	WASHER, 5/8" SAE FLAT	F05011-5	20 1/16 <sup>2</sup>	
7	NUT, 5/8-11 HEX NYLON JAM	F05010-96	5 1/4 <sup>2</sup>	
8	BOLT, 5/8-11 X 2 1/2" HEX HEAD GRADE 5	F05009-20	1	
9	CHAIN W/MASTER & OFFSET LINK, C2050 X 80 PITCH CONVEYOR	P21509-80	5 1/4 <sup>2</sup>	
10	Link, C2050 Chain Master	P21558	5 1/4 <sup>2</sup>	
11	STRIP, 39" GROOVED NYLON	S21330-1	5 1/4 <sup>2</sup>	
	STRIP, GROOVED NYLON SPECIAL 10' MGR	S21130-10	4	
12	SCREW, 1/4-20 X 1" FLAT HEAD CROSS SLOTTED	F05015-26	20 1/16 <sup>2</sup>	
13	BOLT, 3/8-16 X 1 1/2" HEX HEAD GRADE 5	F05007-78	4	
14	WASHER, 3/8" SAE FLAT	F05011-3	6	

**Merry-Go-Round Parts**  
*Kicker Conveyor Table*

**2**

15	WASHER, 3/8" SPLIT LOCK	F05011-4	6	
16	NUT, 3/8-16 HEX	F05010-1	6	
17	BOLT, 3/8-16 X 1" HEX HEAD	F05007-7	2	
18	BEARING, 1" STAMPED PILLOW	P21491	5	
19	SPROCKET, 50BS28X1	P21503	6 <sup>1</sup> / <sub>5</sub> <sup>2</sup>	
20	KEY, 1/4" SQ. X 1" LONG	S21486	6 <sup>1</sup> / <sub>5</sub> <sup>2</sup>	

<sup>1</sup> Part numbers and quantities apply to MGR's with 8' capacity only

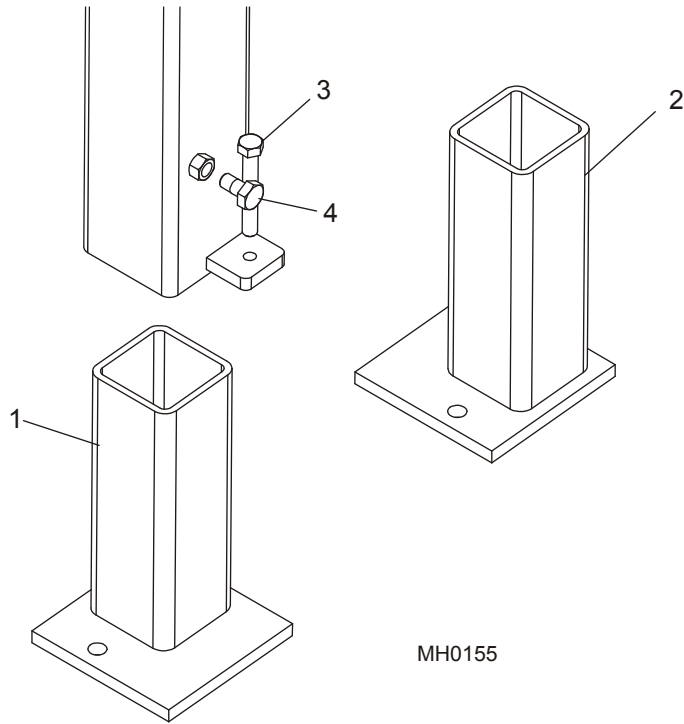
<sup>2</sup> Part numbers and quantities apply to MGR's with 6' capacity only.

# 2

## Merry-Go-Round Parts

### Table Legs

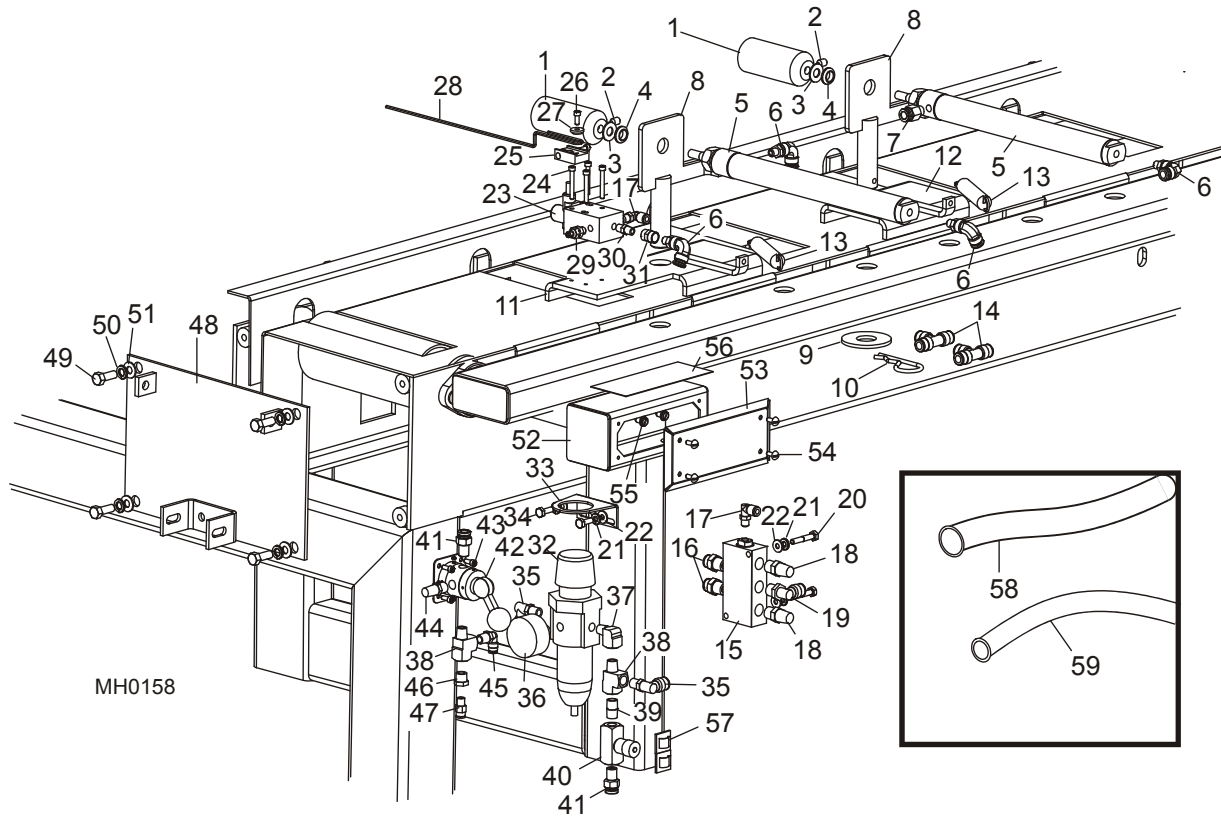
### 2.5 Table Legs



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	LEG, MERRY-GO-ROUND ADJUSTABLE TABLE	W21342 <sup>1</sup>	4	
2	LEG, MERRY-GO-ROUND ADJUSTABLE TABLE	W21342-1 <sup>1</sup>	4	
3	BOLT, 1/2-13 X 3 1/2" HEX HEAD GRADE FULL THREAD	F05008-11	8	
4	BOLT, 1/2-13 X 1" HEX HEAD GRADE 2	F05008-50	8	

<sup>1</sup> Two W21342 and W21342-1 used on each table.

## 2.6 Kicker Air System



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	<b>PISTON KIT, KICKER AIR</b>	A21616	2	
1	Piston, Kicker Air Cylinder 7/16-20 End	S21445	1	◆
2	Screw, 3/8-24 x 1/2" Socket Head Flat Point	F05007-25	1	
3	Washer, 7/16" SAE Flat	F05011-43	1	
4	Grommet, 5/8" Rubber	C05692	1	
	Instruction Sheet, Kicker Piston Replacement	A21616-434	1	
5	<b>CYLINDER, 25D-D-10D KICKER PISTON AIR</b>	P21549	2	
6	<b>FITTING, 1/8" NPT - 3/8" TUBE 90° ELBOW</b>	P21552	4	
7	<b>FITTING, 1/8" NPT - 3/8" TUBE STRAIGHT</b>	P21553	1	
8	<b>PLATE, KICKER AIR CYLINDER MOUNT</b>	W21477-R <sup>1</sup>	2	
9	<b>WASHER, 1" SAE FLAT</b>	F05011-28	2	
10	<b>PIN, 3/16" X 2 1/4" COTTER</b>	F05012-26	2	
11	<b>PLATE, KICKER/AIR SWITCH MOUNT</b>	W21476-R <sup>1</sup>	1	
12	<b>PLATE, KICKER MOUNT</b>	W21475-R <sup>1</sup>	1	
13	<b>SPRING, LE-093G-6MW</b>	P02787	2	
14	<b>FITTING, 3/8" TUBE 'T'</b>	P21529	2	

## 2

**Merry-Go-Round Parts***Kicker Air System*

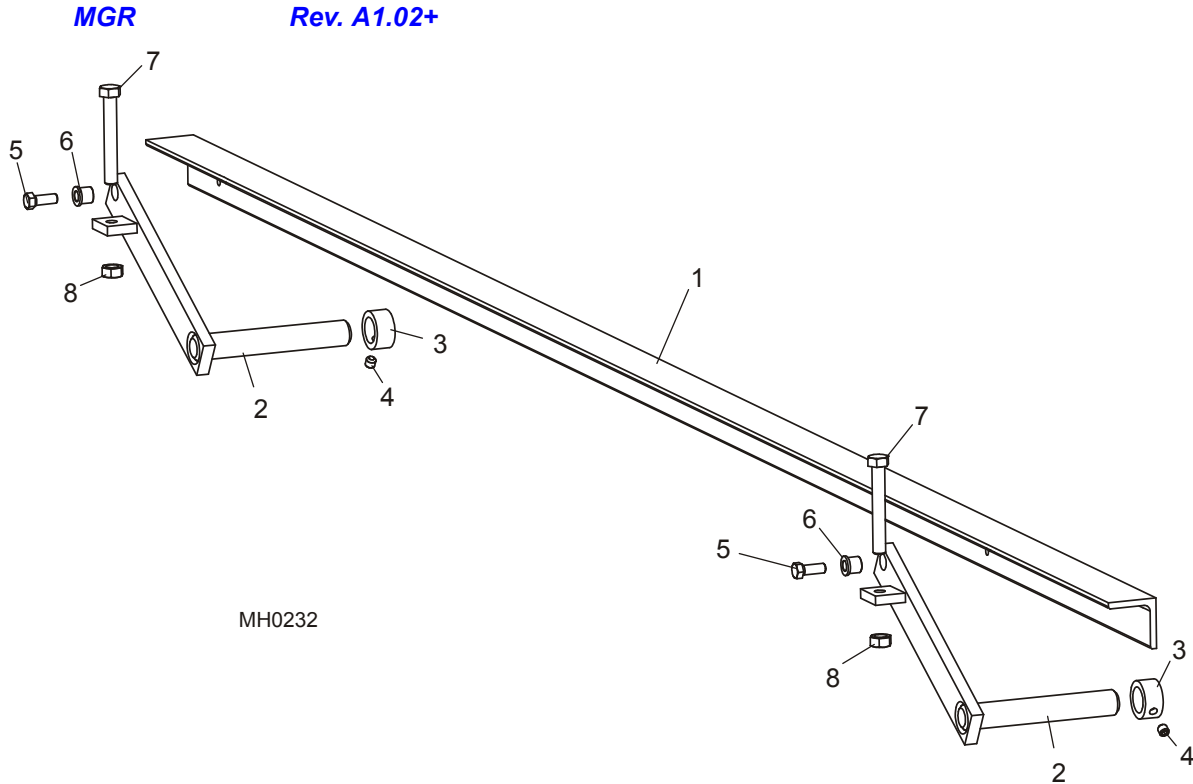
15	VALVE, 345-4A AIR MANIFOLD	P21514	1	
16	FITTING, 3/8" NPT - 3/8" TUBE STRAIGHT	P21527	2	
17	FITTING, 1/8" NPT - 1/4" TUBE 90° ELBOW	P09736	2	
18	MUFFLER, 3/8" NPT AIR	P21528	2	
19	FITTING, 3/8" NPT - 3/8" TUBE 90° ELBOW	P21526	1	
20	WASHER, 1/4" SAE FLAT	F05011-11	4	
21	WASHER, 1/4" SPLIT LOCK	F05011-14	4	
22	BOLT, 1/4-20 X 1 1/2" HEX HEAD GRADE 2	F05005-5	2	
23	SWITCH, 402 LIMIT	P21515	1	
24	SCREW, #10-24 X 1 1/2" SOCKET HEAD	F05004-51	4	
	<b>WAND BLOCK ASSEMBLY, TRANSFER TABLE AIR SWITCH</b>	A21496	1	
25	Block, Transfer Table Air Switch Wand	S21492	1	◆
26	Washer, Wand Assembly Clamp	S21493	1	
27	Screw, #10-24 x 1/2" Socket Head Cap	F05004-26	2	
28	WAND, KICKER AIR SWITCH	S21497	1	
29	FITTING, 1/8" NPT SNUBBER	P21517	1	
30	FITTING, 1/8" NPT NIPPLE	P02764	1	
31	FITTING, 1/8" NPT COUPLER	P05748	1	
32	FILTER/REGULATOR, B11-02 WJC AIR	P21510	1	
33	BRACKET, SAR10Y57 AIR FILTER/REGULATOR MOUNT	P21511	1	
34	BOLT, 1/4-20 X 3/4" HEX HEAD FULL THREAD	F05005-1	2	
35	FITTING, 1/4" NPT - 3/8" TUBE 90° ELBOW	P21521	2	
36	GAUGE, 275Y160WS AIR	P21512	1	
37	FITTING, 1/4" NPT MF 90° ELBOW	P05383	1	
38	FITTING, 1/4" NPT MFF 'T'	P05382	2	
39	FITTING, 1/4" NPT NIPPLE	P21524	1	
40	VALVE, N400B FLOW CONTROL	P21551	1	
41	FITTING, 1/4" NPT - 3/8" TUBE STRAIGHT	P21559	2	
42	VALVE, 250V3 AIR	P21513	1	
43	SCREW, #10-24 X 1/2" SOCKET HEAD	F05004-26	4	
44	MUFFLER, 1/4" NPT AIR	P20904	1	
45	FITTING, 1/4" NPT - 1/4" TUBE 90° ELBOW	P21519	1	
46	FITTING, 1/4" NPT - 1/8" NPT REDUCER	P22680	1	
47	FITTING, 1/8" NPT - 1/4" TUBE	P03078	1	
48	PLATE W/BRACKET, KICKER END	W21499	1	
49	BOLT, 3/8-16 X 1" HEX HEAD	F05007-7	4	
50	WASHER, 3/8" SPLIT LOCK	F05011-4	4	
51	WASHER, 3/8" SAE FLAT	F05011-3	4	
52	CONTROL BOX, REMOTE	W20736	1	
53	COVER, REMOTE CONTROL BOX	024736 <sup>2</sup>	1	
54	SCREW, #8-32 X 1/2" SLOTTED ROUND HEAD	F05004-12	4	
55	SCREW, 1/4-20 X 1/2" SLOTTED HEX HEAD	F05015-1	2	
56	DECAL, REMOTE CONTROL	M20541	1	

57	CLIP, ADHESIVE HOSE	P04445	2	
58	HOSE, 3/8" O.D. PLASTIC	R01869-1	As Req'd	
59	HOSE, 1/4" O.D. PLASTIC	R01869	As Req'd	
	BRACKET, TABLE SPECIAL 10' MGR (NOT SHOWN)	N/A	2	

<sup>1</sup> Order -L part for left-hand MGR.

<sup>2</sup> Replaces S20737 originally supplied before 11/99

**2.7 Fence Assembly**



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	<b>FENCE ASSEMBLY, 6' MGR CROWDER</b>	A21109 <sup>1</sup>	2	◆
	<b>FENCE ASSEMBLY, 8' MGR CROWDER</b>	A21109-8 <sup>2</sup>	2	◆
1	Fence, 6' MGR Crowder	S21108 <sup>1</sup>	1	
	Fence 8' MGR Crowder	S21108-8 <sup>2</sup>	1	
2	Bracket, Crowder Fence Pivot	036338	2	
3	Collar, 1" Dia. Lock	S20159	2	
4	Screw, 3/8-16 x 3/8" Cup Point Set	F05007-68	2	
5	Bolt, 3/8-16 x 7/8" Hex Head Grade 5	F05007-185	2	
6	Bushing, 3/4" x .505" Flanged	036336	2	
7	Bolt, 1/2-13 x 3 1/2" Hex Head Full Thread	F05008-11	2	
8	Nut, 1/2-13 Hex	F05010-35	2	

<sup>1</sup> Part numbers and quantities apply to MGR's with 6' capacity only.

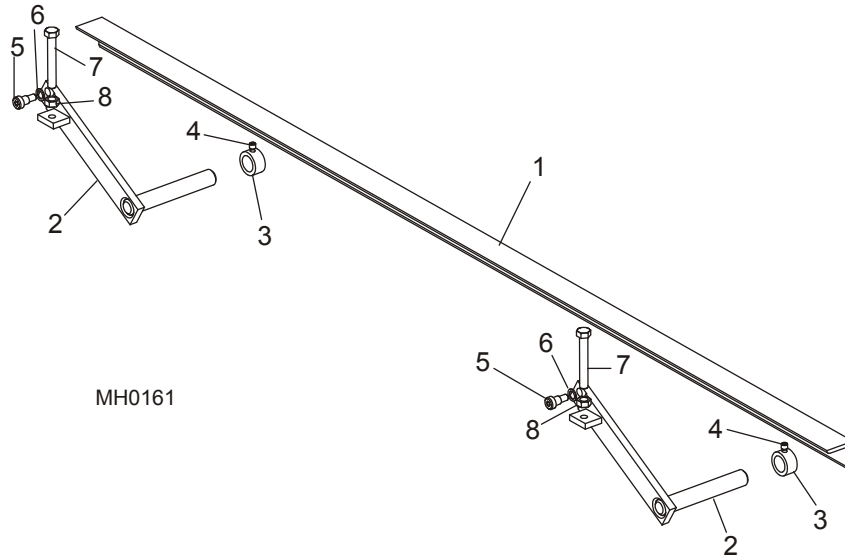
<sup>2</sup> Part numbers and quantities apply to MGR's with 8' capacity only



## 2.8 Fence Assembly

MGR

Rev. A1.00 - A1.01



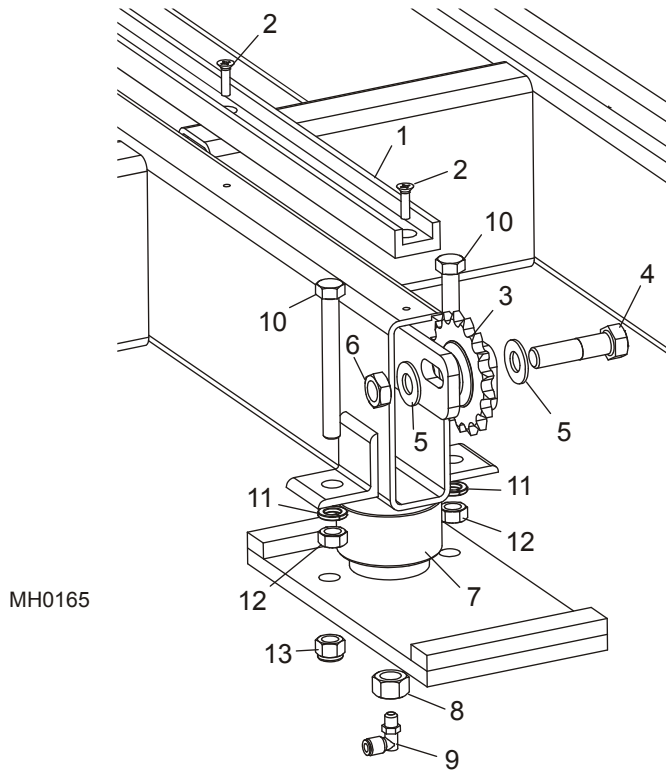
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	<b>FENCE ASSEMBLY, 6' MGR CROWDER</b>	A21109 <sup>1</sup>	2	◆
	<b>FENCE ASSEMBLY, 8' MGR CROWDER</b>	A21109-8 <sup>2</sup>	2	◆
1	Fence, 6' MGR Crowder	S21108 <sup>1</sup>	1	
	Fence 8' MGR Crowder	S21108-8 <sup>2</sup>	1	
2	Bracket, Crowder Fence Pivot	W22252 <sup>3</sup>	2	
3	Collar, 1" Dia. Lock	S20159	2	
4	Screw, 3/8-16 x 3/8" Cup Point Set	F05007-68	2	
5	Bolt, 1/2" x 1/2" Shoulder	F05008-63 <sup>3</sup>	2	
6	Washer, 1/2" I.D. x 3/4" O.D. x .062" Thick Nylon	P05251-1 <sup>3</sup>	2	
7	Bolt, 1/2-13 x 3 1/2" Hex Head Full Thread	F05008-11	2	
8	Nut, 1/2-13 Hex	F05010-35	2	

<sup>1</sup> Part numbers and quantities apply to MGR's with 6' capacity only.

<sup>2</sup> Part numbers and quantities apply to MGR's with 8' capacity only

<sup>3</sup> Pivot Brackets, mounting bolts and washers revised Rev. A1.02 ([See Section 2.7](#)).

**2.9 Transfer Air Lift Assembly**



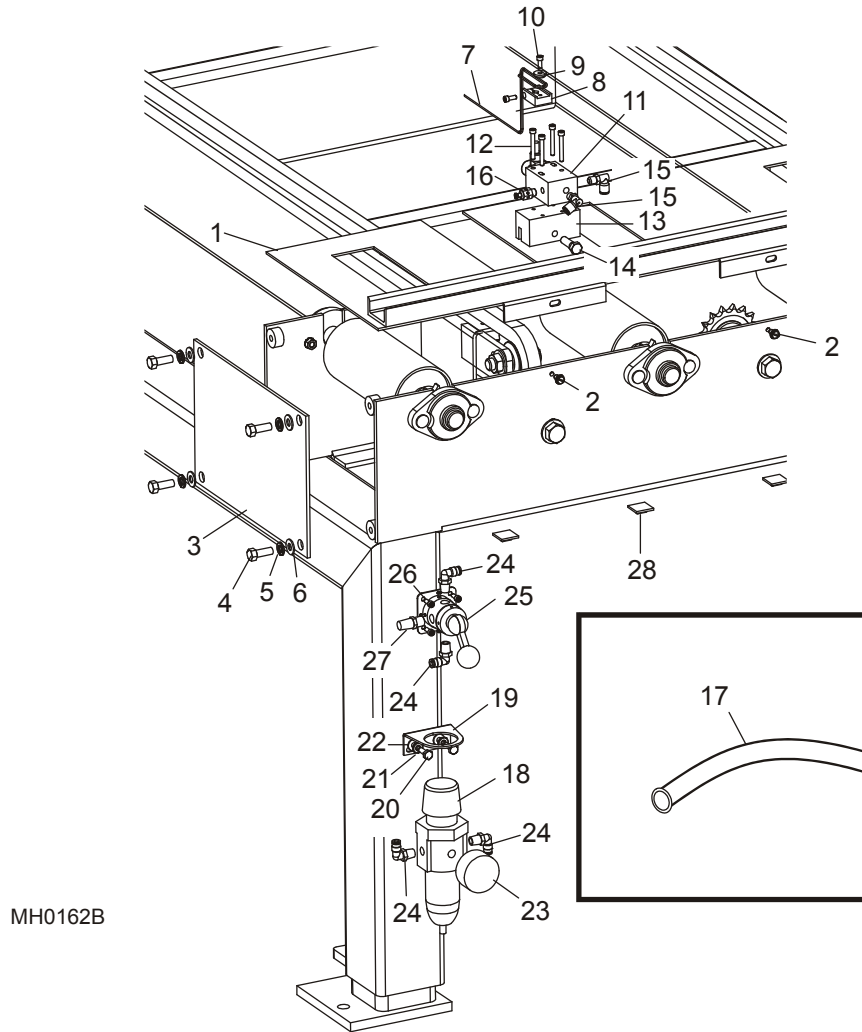
REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	STRIP, 48" GROOVED NYLON	S21330	5 1/4 <sup>2</sup>
2	SCREW, 1/4-20 X 1" FLAT HEAD CROSS SLOTTED	F05015-26	25 1/20 <sup>2</sup>
3	SPROCKET, 50BB17H X 5/8"	P21504	5 1/4 <sup>2</sup>
4	BOLT, 5/8-11 X 2 1/2" HEX HEAD GRADE 5	F05009-20	5 1/4 <sup>2</sup>
5	WASHER, 5/8" SAE FLAT	F05011-5	20 1/16 <sup>2</sup>
6	NUT, 5/8-11 HEX NYLON JAM	F05010-96	5 1/4 <sup>2</sup>
7	BAG, MGR TRANSFER TABLE 1M1A AIR	033168 <sup>3</sup>	1
8	NUT, 5/8-11 HEX	F05010-5	1
9	FITTING, 1/8" NPT - 1/4" TUBE 90° ELBOW	P09736	1
10	BOLT, 1/2-13 X 4 1/2" HEX HEAD FULL THREAD	F05008-16	2
11	WASHER, 1/2" SPLIT LOCK	F05011-9	2
12	NUT, 1/2-13 HEX	F05010-35	2
13	NUT, 1/2-13 NYLON LOCK	F05010-8	2

<sup>1</sup> Part numbers and quantities apply to MGR's with 8' capacity only

<sup>2</sup> Part numbers and quantities apply to MGR's with 6' capacity only.

<sup>3</sup> Directly replaces P21538 (duplicate part numbers).

## 2.10 Transfer Air System



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	COVER W/SWITCH RAIL, 8' TRANSFER TABLE ROLLER	W21042-8 <sup>1</sup>	1	
	COVER W/SWITCH RAIL, 6' TRANSFER TABLE ROLLER	W21042 <sup>2</sup>	1	
2	SCREW, 1/4-20 X 1/2" SLOTTED HEX HEAD	F05015-1	7 1/5 <sup>2</sup>	
3	COVER, TABLE END	S21088	1	
4	BOLT, 3/8-16 X 1" HEX HEAD	F05007-7	4	
5	WASHER, 3/8" SPLIT LOCK	F05011-4	4	
6	WASHER, 3/8" SAE FLAT	F05011-3	4	
7	WAND, TRANSFER TABLE AIR SWITCH	S21494 <sup>3</sup>	1	
	WAND BLOCK ASSEMBLY, TRANSFER TABLE AIR SWITCH	A21496	1	
8	Block, Transfer Table Air Switch Wand	S21492	1	◆

# 2

## Merry-Go-Round Parts

### Transfer Air System

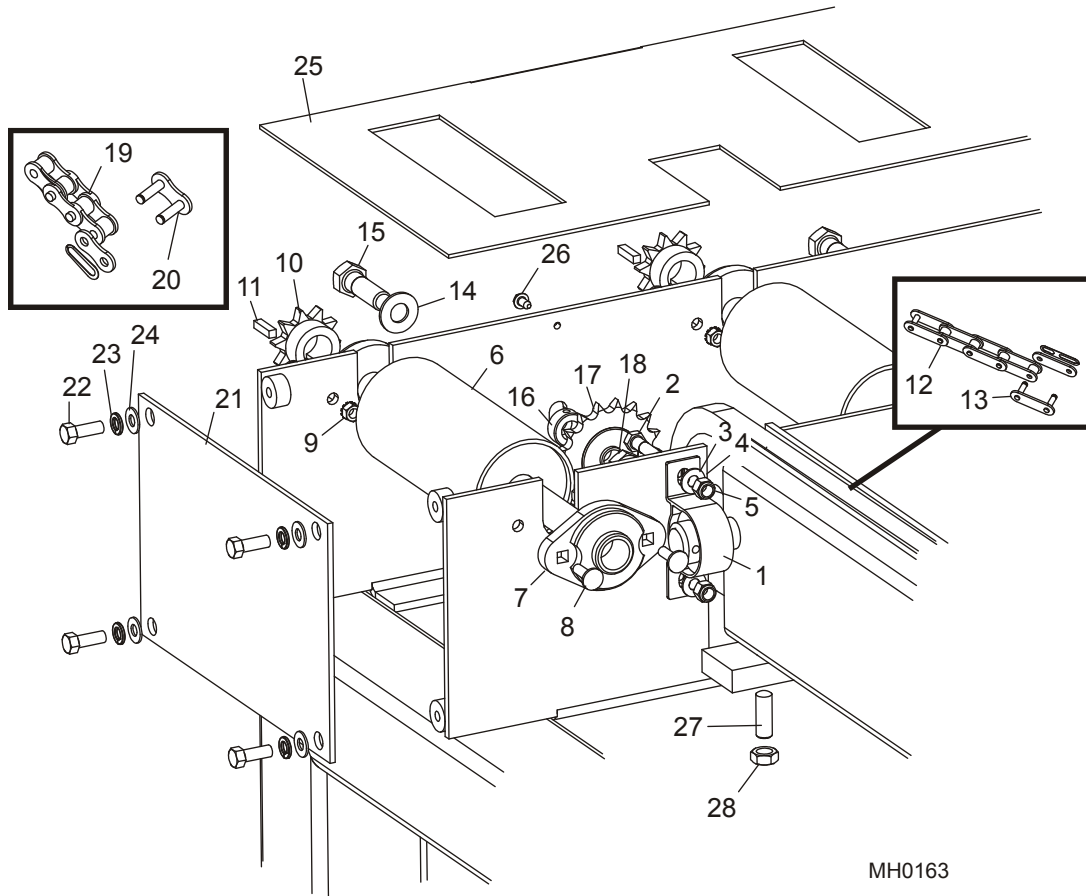
9	Washer, Wand Assembly Clamp	S21493	1	
10	Screw, #10-24 x 1/2" Socket Head Cap	F05004-26	2	
11	<b>SWITCH, 402 LIMIT</b>	P21515	1	
12	<b>SCREW, #10-24 X 1 1/2" SOCKET HEAD</b>	F05004-51	4	
13	<b>BLOCK, TRANSFER TABLE AIR SWITCH MOUNT</b>	S21128	1	
14	<b>BOLT, 3/8-16 X 1 1/4" HEX HEAD GRADE 2</b>	F05007-2	1	
15	<b>FITTING, 1/8" NPT - 1/4" TUBE 90° ELBOW</b>	P09736	2	
16	<b>FITTING, 1/8" NPT SNUBBER</b>	P21517	1	
17	<b>HOSE, 1/4" O.D. PLASTIC</b>	R01869	As Req'd	
18	<b>FILTER/REGULATOR, B11-02 WJC AIR</b>	P21510	1	
19	<b>BRACKET, SAR10Y57 AIR FILTER/REGULATOR MOUNT</b>	P21511	1	
20	<b>BOLT, 1/4-20 X 3/4" HEX HEAD FULL THREAD</b>	F05005-1	2	
21	<b>WASHER, 1/4" SPLIT LOCK</b>	F05011-14	2	
22	<b>WASHER, 1/4" SAE FLAT</b>	F05011-11	2	
23	<b>GAUGE, 275Y160WS AIR</b>	P21512	1	
24	<b>FITTING, 1/4" NPT - 1/4" TUBE 90° ELBOW</b>	P21519	4	
25	<b>VALVE, 250V3 AIR</b>	P21513	1	
26	<b>SCREW, #10-24 X 1/2" SOCKET HEAD</b>	F05004-26	4	
27	<b>MUFFLER, 1/4" NPT AIR</b>	P20904	1	
28	<b>CLIP, ADHESIVE HOSE</b>	P04445	4	

<sup>1</sup> Part numbers and quantities apply to MGR's with 8' capacity only

<sup>2</sup> Part numbers and quantities apply to MGR's with 6' capacity only.

<sup>3</sup> Replaces W21100 (4/11/95).

## 2.11 Transfer Roller Assembly



MH0163

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	BEARING, 1" STAMPED PILLOW	P21491	5	
2	BOLT, 3/8-16 X 1 1/2" HEX HEAD GRADE 5	F05007-78	4	
	BOLT, 3/8-16 X 1" HEX HEAD	F05007-7	2	
3	WASHER, 3/8" SAE FLAT	F05011-16	6	
4	WASHER, 3/8" SPLIT LOCK	F05011-4	6	
5	NUT, 3/8-16 HEX	F05010-1	6	
	ROLLER ASSEMBLY, MGR 15 1/4" TABLE	A21081	15 1/11 <sup>2</sup>	
6	Roller Weldment, MGR 15 1/4" Table	W21082	1	
	Bearing Assembly, 1" Flanged	A21621	2	
7	Bearing, 1" Flanged	P21490	1	◆
8	Bolt, 5/16-18 x 1" Carriage	F05006-9	2	
	Washer, 5/16" Split Lock	F05011-13 <sup>3</sup>	2	
	Washer, 5/16" SAE Flat	F05011-17 <sup>3</sup>	2	
9	Nut, 5/16-18 Self-Locking Hex	F05010-20	2	

# 2

## Merry-Go-Round Parts

### Transfer Roller Assembly

	Instruction Sheet, 1" Flanged Bearing Replacement	A21621-384	1	
10	Sprocket, 50BS10X1	P21414	1	
11	Key, 1/4" Sq. X 1" Long	S21486	1	
12	<b>CHAIN W/MASTER &amp; OFFSET LINK, C2050 X 95 PITCH CONVEYOR</b>	P21509-95	5 1/4 <sup>2</sup>	
13	Link, C2050 Chain Master	P21558	5 1/4 <sup>2</sup>	
14	<b>WASHER, 5/8" SAE FLAT</b>	F05011-5	12 1/10 <sup>2</sup>	
15	<b>NUT, 5/8-11 HEX NYLON JAM</b>	F05010-96	12 1/10 <sup>2</sup>	
16	<b>BOLT, 5/8-11 X 2" HEX HEAD GRADE 2</b>	F05009-2	12 1/10 <sup>2</sup>	
17	<b>COLLAR, 5/8" I.D. LOCK</b>	P05035	12 1/10 <sup>2</sup>	
18	<b>SPROCKET, 50BB17H X 5/8"</b>	P21504	12 1/10 <sup>2</sup>	
19	<b>CHAIN, R50 X 236 PITCH ROLLER (TABLE ROLLER DRIVE)</b>	P20207-236	1	
	<b>CHAIN, R50 X 86 PITCH ROLLER (8' TABLE ROLLER EXTENSION)</b>	P20207-86 <sup>4</sup>	1 <sup>1</sup>	
20	Master Link, #50 Chain	P20208	1	
21	<b>COVER, TABLE END</b>	S21088	1	
22	<b>BOLT, 3/8-16 X 1" HEX HEAD</b>	F05007-7	4	
23	<b>WASHER, 3/8" SPLIT LOCK</b>	F05011-4	4	
24	<b>WASHER, 3/8" SAE FLAT</b>	F05011-3	4	
25	<b>COVER, 6' TRANSFER TABLE ROLLER</b>	S21105 <sup>2</sup>	1	
	<b>COVER, 8' TRANSFER TABLE ROLLER</b>	S21613 <sup>1</sup>	1	
26	<b>SCREW, 1/4-20 X 1/2" SLOTTED HEX HEAD</b>	F05015-1	7 1/5 <sup>2</sup>	
27	<b>SCREW, 1/2-20 X 1 1/2" OVAL POINT SET</b>	F05008-73	4 1/2 <sup>2</sup>	
28	<b>NUT, 1/2-20 HEX JAM</b>	F05010-16	4 1/2 <sup>2</sup>	

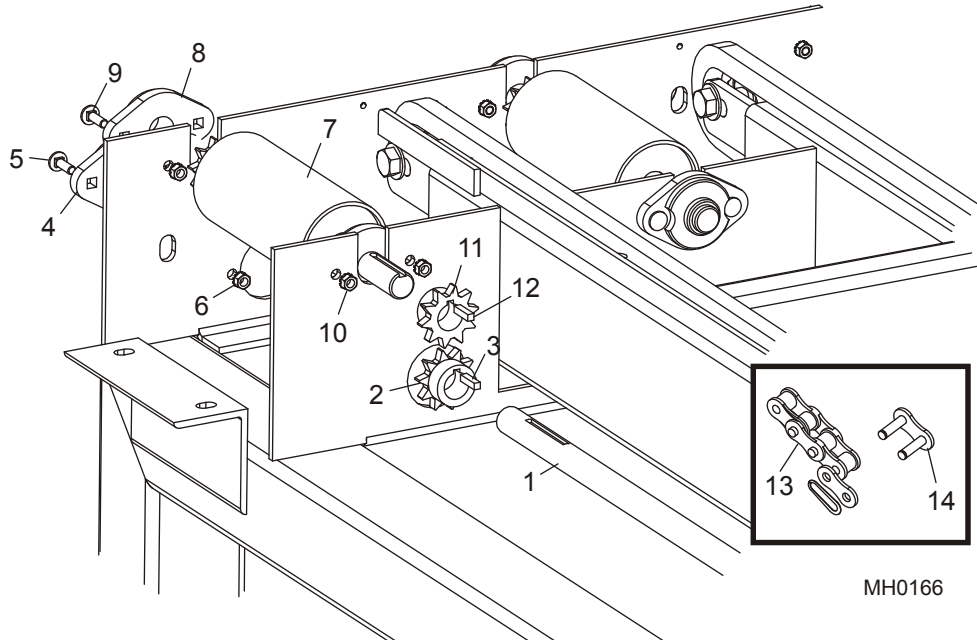
<sup>1</sup> Part numbers and quantities apply to MGR's with 8' capacity only

<sup>2</sup> Part numbers and quantities apply to MGR's with 6' capacity only.

<sup>3</sup> Additional hardware to mount bearings to frames with tapped holes.

<sup>4</sup> Add to P20207-236 to create 322 pitch drive chain for MGR's With 8' capacity.

## 2.12 Transfer Table Cross Shaft Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	SHAFT, CROSS TABLE DRIVE	S21134	1	
2	SPROCKET, 50BS10X1	P21414	1	
3	KEY, 1/4" SQ. X 1" LONG	S21486	1	
	<b>BEARING ASSEMBLY, 1" FLANGED</b>	A21621	2	
4	Bearing, 1" Flanged	P21490	1	◆
5	Bolt, 5/16-18 x 1" Carriage	F05006-9	2	
	Washer, 5/16" Split Lock	F05011-13 <sup>1</sup>	2	
	Washer, 5/16" SAE Flat	F05011-17 <sup>1</sup>	2	
6	Nut, 5/16-18 Self-Locking Hex	F05010-20	2	
	Instruction Sheet, 1" Flanged Bearing Replacement	A21621-384	1	
	<b>ROLLER ASSEMBLY, MGR 15 3/4" TABLE</b>	A21097	1	
7	Roller Weldment, MGR 15 3/4" Table	W21083	1	
	Bearing Assembly, 1" Flanged	A21621	2	
8	Bearing, 1" Flanged	P21490	1	◆
9	Bolt, 5/16-18 x 1" Carriage	F05006-9	2	
	Washer, 5/16" Split Lock	F05011-13 <sup>1</sup>	2	
	Washer, 5/16" SAE Flat	F05011-17 <sup>1</sup>	2	
10	Nut, 5/16-18 Self-Locking Hex	F05010-20	2	
	Instruction Sheet, 1" Flanged Bearing Replacement	A21621-384	1	
11	Sprocket, 50BS10X1	P21414	2	
12	Key, 1/4" Sq. X 1" Long	S21486	2	

# 2

## Merry-Go-Round Parts

### *Transfer Table Cross Shaft Assembly*

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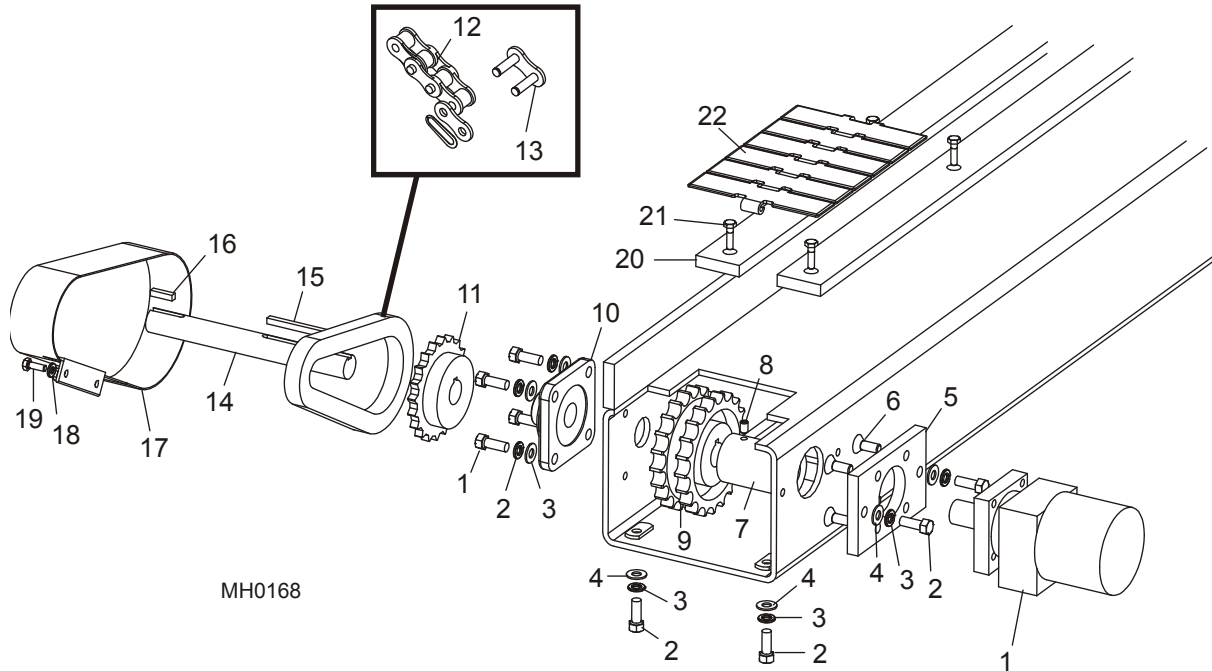
13	CHAIN, W/MASTER LINK, R50 X 230 PITCH ROLLER (TABLE ROLLER IDLE)	P20207-230	1	
	CHAIN, R50 X 86 PITCH ROLLER (8' TABLE ROLLER DRIVE EXTENSION)	P20207-86 <sup>2</sup>	1	
14	Master Link, #50 Chain	P20208	1	

<sup>1</sup> Additional hardware to mount bearings to frames with tapped holes.

<sup>2</sup> Add to P20207-230 to create 316 pitch drive chain for MGR's With 8' capacity.



### 2.13 Return Track Drive Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
1	MOTOR, MG06-13-13AAAB HYDRAULIC	P21506	1
2	BOLT, 3/8-16 X 1" HEX HEAD	F05007-7	8
3	WASHER, 3/8" SPLIT LOCK	F05011-4	8
4	WASHER, 3/8" SAE FLAT	F05011-3	8
5	PLATE, FEED TRACK MOTOR MOUNT	S20173	1
6	SCREW, 3/8-16 X 1" FLAT SOCKET HEAD	F05007-64	4
7	COUPLING, FEED TRACK MOTOR SHAFT	S20185	1
8	SCREW, 5/16-18 X 1/2" SOCKET HEAD SET	F05006-38	2
9	SPROCKET, 21-22T FEED TRACK DRIVE	P20202	1
10	BEARING, VJC 1 FLANGED	P20201	1
11	SPROCKET, 50BS20X1	P21129	1
12	CHAIN W/MASTER LINK, R50 X 38 PITCH ROLLER (RETURN/TRANSFER)	P20207-38	1
13	Master Link, #50 Chain	P20208	1
14	SHAFT, MGR RETURN TRACK DRIVE	S21135	1
15	KEY, 1/4" SQUARE X 4.25"	S22440	1
16	KEY, 1/4" SQUARE X 1"	S21486	1
17	GUARD, MGR RETURN TRACK CHAIN	W21118	1
18	WASHER, 1/4" SPLIT LOCK	F05011-14	2
19	BOLT, 1/4-20 X 3/4" HEX HEAD FULL THREAD	F05005-1	2
20	RETURN TRACK NYLON PADS (See Section 2.14)		
21	BOLT, 1/4-20 X 1" HEX HEAD SELF-DRILL SELF-TAP	F05005-87	As Req'd

**2****Merry-Go-Round Parts***Return Track Drive Assembly*

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22	<b>CHAIN, 6" FLAT FEED TRACK</b>	P20204 (1')	As Req'd	
	Pin, Track Link Connecting	022424	As Req'd	



# 2

## Merry-Go-Round Parts

### Return Track Nylon Pads

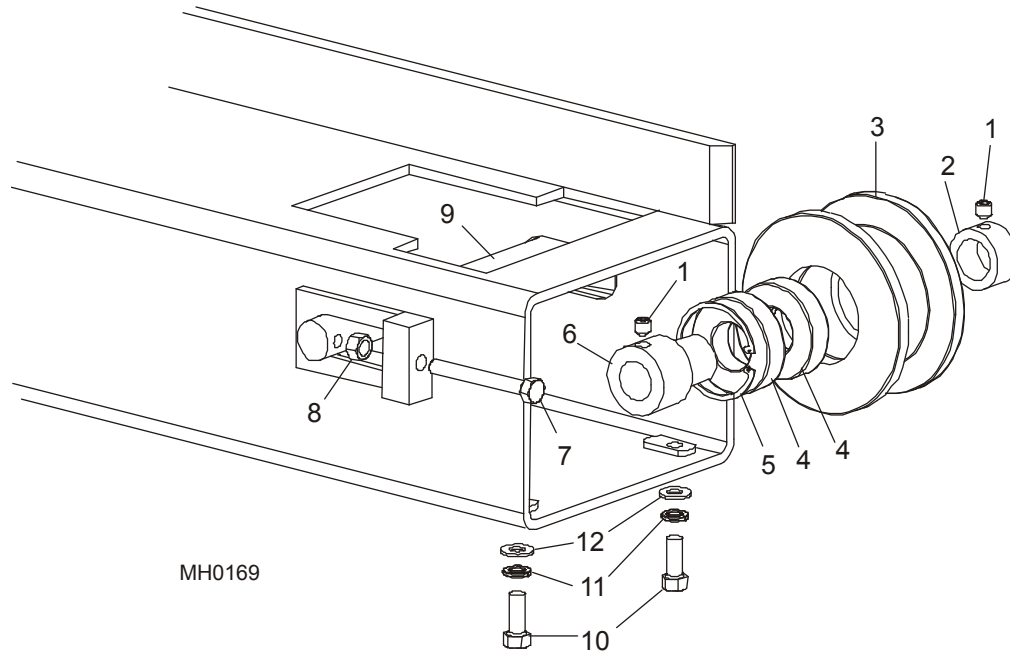
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#### 2.14 Return Track Nylon Pads

Model	1/2" x 2" Nylon Pads		
	See Qty. Below to replace entire set of track pads <sup>1</sup>		
	S22778 (60")	S22779 (56")	S22780 (10")
M28	4	--	2
M48	4	2	2
M68	4	4	2

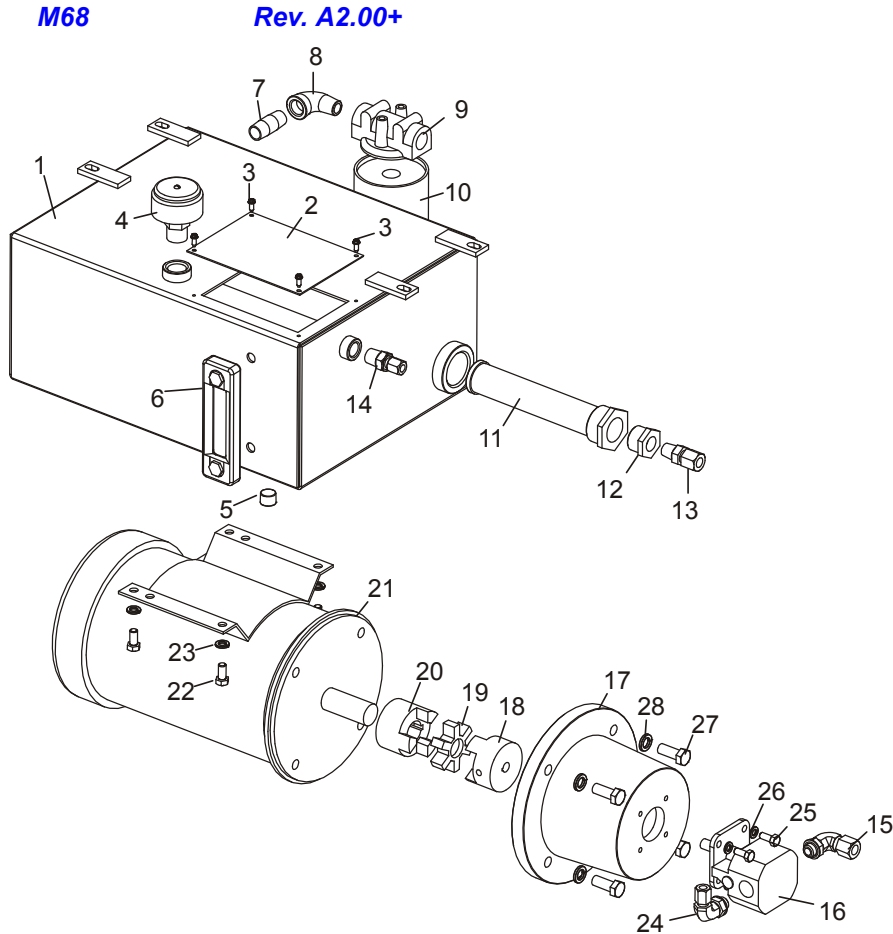
<sup>1</sup> 022120, 022121 & 022122 single-length strips no longer available. All pads should be replaced in complete sets.

## 2.15 Return Track Idle Assembly



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
	<b>SHAFT ASSEMBLY, MGR IDLE</b>	A21458	1	◆
1	Screw, 3/8-16 x 3/8" Cup Point Set	F05007-68	2	
2	Collar, Locking	S20159-1	1	
3	Pulley, Feed Track Idle	S20282	1	
4	Bearing, 6206-2RS	P11035	2	
5	Ring, 62mm Interior Retaining	F04254-12	1	
6	Bushing, Feed Track Idle	S20286	1	
7	Bolt, 3/8-16 x 3" Hex Head Full Thread	F05007-1	2	
8	Nut, 3/8-16 Hex	F05010-1	2	
9	Shaft, Feed Track Idle	S20285	1	
10	<b>BOLT, 3/8-16 X 1" HEX HEAD</b>	F05007-7	2	
11	<b>WASHER, 3/8" SPLIT LOCK</b>	F05011-4	2	
12	<b>WASHER, 3/8" SAE FLAT</b>	F05011-3	2	

**2.16 Hydraulic Tank Assembly (6-Head)**



MH0248-2

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>TANK ASSEMBLY, HR/MGR HYDRAULIC</b>	065489	1
	Fluid, Conoco MV32 All Weather Hydraulic (1 Gallon)	006397	8
1	Tank Weldment, Hydraulic Fluid	065490	1
2	Lid, Hydraulic Fluid Tank Access	S20331	1
3	Screw, #8-32 x 1/2" Slotted Hex Head	F05015-18	4
4	Cap, Hydraulic Tank Fill/Breather	P20212	1
5	Fitting, 1/2" NPT Male Plug	P26258	1
6	Gauge, Hydraulic Fluid Level Sight	P20211	1
7	Fitting, 1/2" NPT x 2" Long Nipple	O16844	1
8	Fitting, 1/2" NPT 90° Elbow	P22684	1
9	Manifold, Hydraulic Cartridge Filter	P22683	1
10	Filter, S28 Hydraulic Cartridge	P20301	1
11	Filter, Hydraulic Tank Suction	P20210	1
12	Fitting, 1" NPT - 1/2" NPT Reducer	P20239	1
13	Fitting, 1/2" NPT - 1/2" Tube	P20243	1

**Feed Track/Frame Parts**  
*Hydraulic Tank Assembly (6-Head)*

**2**

14	Fitting, 1/2" NPT - 3/8" Tube Straight	P20242	1	
15	Fitting, 1/2" Tube - 1/2" O-Ring 90° Elbow	P20245	1	
16	Pump, Hydraulic	P20213	1	
17	Adaptor, Hydraulic Pump/Motor	065484	1	
18	Coupler, L099 x 1/2" Shaft	065482	1	
19	Coupler, L100 Spider	042779	1	
20	Coupler, L100 x 1 1/8" Shaft	065483	1	
21	Motor, 5HP 3PH 3450RPM Baldor	065479 <sup>1</sup>	1	
22	Bolt, 3/8-16 x 3/4" Hex Head Grade 5	F05007-118	4	
23	Washer, 3/8" Split Lock	F05011-4	4	
24	Fitting, 1/2" O-Ring - 3/8" Tube 90° Elbow	P20244	1	
25	Bolt, 5/16-18 x 3/4" Hex Head Grade 5	F05006-102	4	
26	Washer, 5/16" Split Lock	F05011-13	4	
27	Bolt, 1/2-13 x 1 1/4" Hex Head Grade 5	F05008-37	4	
28	Washer, 1/2" Split Lock	F05011-9	4	

<sup>1</sup> To service models originally equipped with 5HP motor after Rev. A2.00 only. Use Kit 065492 to retrofit 4HP motors on earlier revisions (Kit includes Motor, Couplings, Pump Adaptor & Hardware).

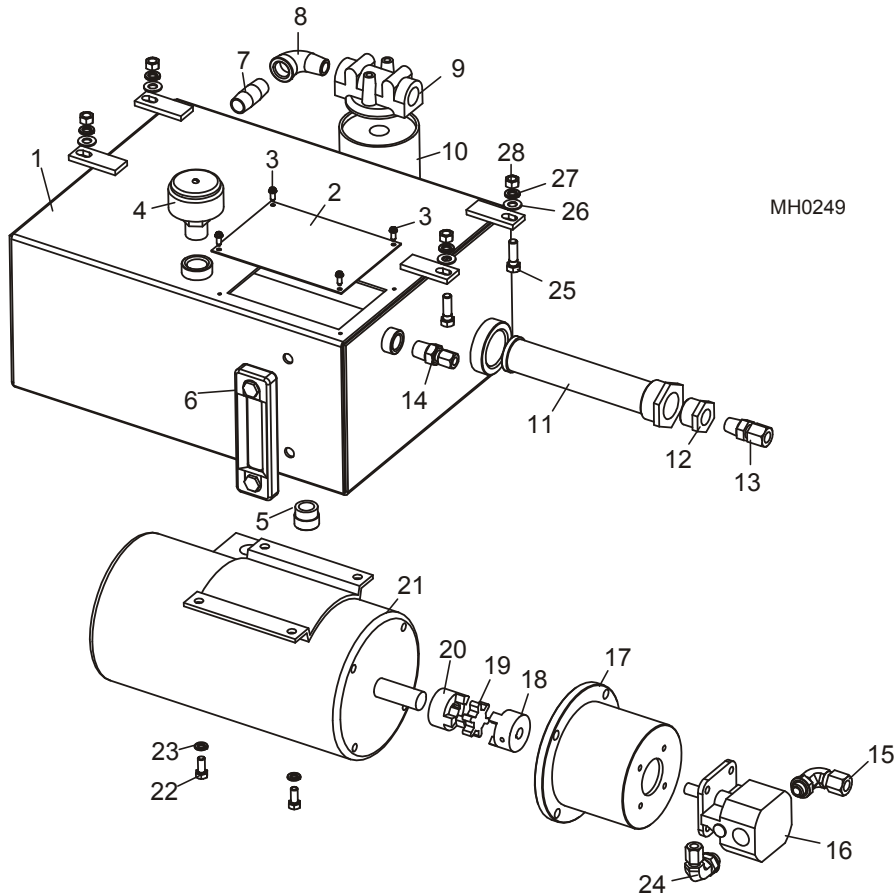
## 2 Feed Track/Frame Parts

### Hydraulic Tank Assembly (6-Head)

#### 2.17 Hydraulic Tank Assembly (6-Head)

M68

Rev. A1.00 - A1.05



REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.
	<b>TANK ASSEMBLY, MGR HYDRAULIC</b>	033412	1
	Fluid, Conoco MV32 All Weather Hydraulic (1 Gallon)	006397	8
1	Tank Weldment, Hydraulic Fluid	W22108	1
2	Lid, Hydraulic Fluid Tank Access	S20331	1
3	Screw, #8-32 x 1/2" Slotted Hex Head	F05015-18	4
4	Cap, Hydraulic Tank Fill/Breather	P20212	1
5	Fitting, 1/2" NPT Male Plug	P26258	1
6	Gauge, Hydraulic Fluid Level Sight	P20211	1
7	Fitting, 1/2" NPT x 2" Long Nipple	O16844	1
8	Fitting, 1/2" NPT 90° Elbow	P22684	1
9	Manifold, Hydraulic Cartridge Filter	P22683	1
10	Filter, S28 Hydraulic Cartridge	P20301	1
11	Filter, Hydraulic Tank Suction	P20210	1
12	Fitting, 1" NPT - 1/2" NPT Reducer	P20239	1
13	Fitting, 1/2" NPT - 1/2" Tube	P20243	1



**Feed Track/Frame Parts**  
*Hydraulic Tank Assembly (6-Head)*

2

14	Fitting, 1/2" NPT - 3/8" Tube Straight	P20242	1	
15	Fitting, 1/2" Tube - 1/2" O-Ring 90° Elbow	P20245	1	
16	Pump, Hydraulic	P20213	1	
17	Adaptor, Hydraulic Pump/Motor	P20215	1	
18	Coupler, 1/2" Shaft	P20217	1	
19	Coupler, L075 Spider	P20218	1	
20	Coupler, 7/8" Shaft	P20216	1	
21	Motor, 4HP Custom 3 Phase w/Thermistats	P22735 <sup>1</sup>	1	
22	Bolt, 5/16-18 x 3/4" Hex Head	F05006-5	4	
23	Washer, 5/16" Split Lock	F05011-13	4	
24	Fitting, 1/2" O-Ring - 3/8" Tube 90° Elbow	P20244	1	
25	Bolt, 3/8-16 x 1 1/4" Hex Head	F05007-2	4	
26	Washer, 3/8" SAE Flat	F05011-3	4	
27	Washer, 3/8" Split Lock	F05011-4	4	
28	Nut, 3/8-16 Hex	F05010-1	4	

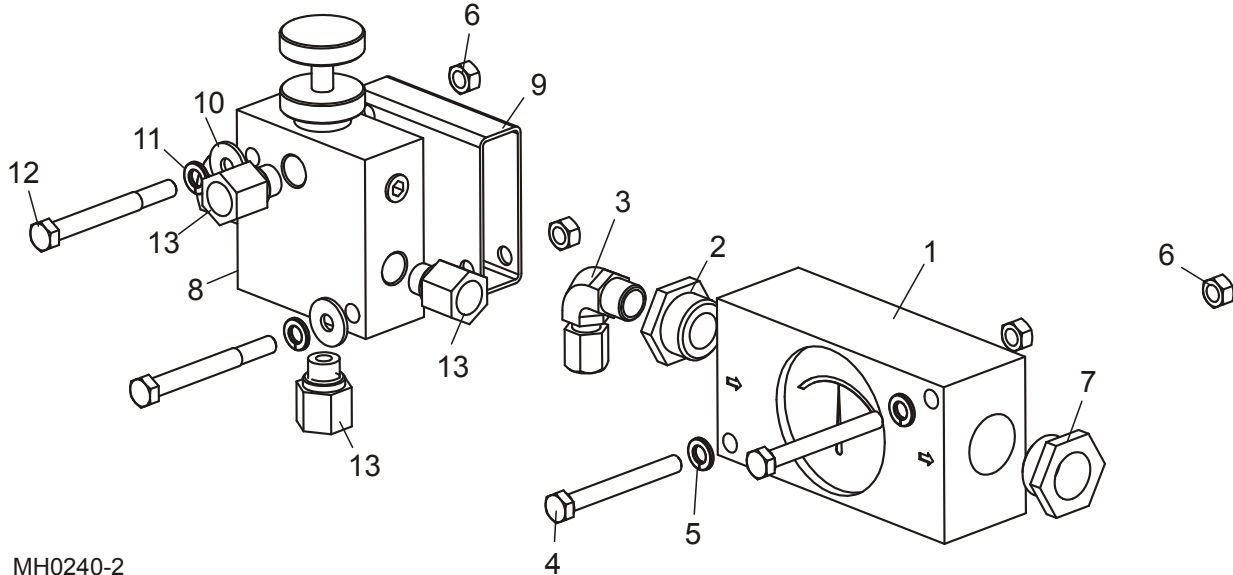
<sup>1</sup> Motor available while supplies last. When stock depleted, upgrade to 5HP motor with kit 065492 (Includes Motor, Couplings, Pump Adaptor & Hardware - [See Section 2.16](#)).

# 3

## Feed Track/Frame Parts

### Hydraulic Valve Assembly (6-Head)

#### 2.18 Hydraulic Valve Assembly (6-Head)



MH0240-2

REF	DESCRIPTION (◆ Indicates Parts Available In Assemblies Only)	PART #	QTY.	
1	METER, FLOW	033414	1	
2	BUSHING, 3/4" MPT X 3/8" FPT	033418	1	
3	FITTING, 3/8" MPT X 3/8" TUBE 90°	033416	1	
4	BOLT, 5/16-18 X 2 3/4" HEX HEAD GRADE 5	F05006-28	2	
5	WASHER, 5/16" SPLIT LOCK	F05011-13	2	
6	NUT, 5/16-18 HEX	F05010-17	4	
7	BUSHING, 3/4" MNPT X 1/2" FNPT PIPE	038742	1	
	<b>VALVE ASSEMBLY, 6-HEAD/MGR FLOW CONTROL</b>	006486 <sup>1</sup>	1	
8	Valve, 6-head Merry-Go-Round Flow Control	033413 <sup>1</sup>	1	◆
9	Spacer, MultiHead Flow Control Valve	006064	1	
10	Washer, 5/16" Standard Flat	F05011-16	2	
11	Washer, 5/16" Split Lock	F05011-13	2	
12	Bolt, 5/16-18 x 3" Hex Head Grade 5	F05006-62	2	
13	Fitting, 3/8" SAE x 3/8" NPT Adaptor	006487	3	

<sup>1</sup> Flow Control Valve 033413 from new vendor (Rev. A1.05). Use assembly 006486 for service to ensure compatibility.

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