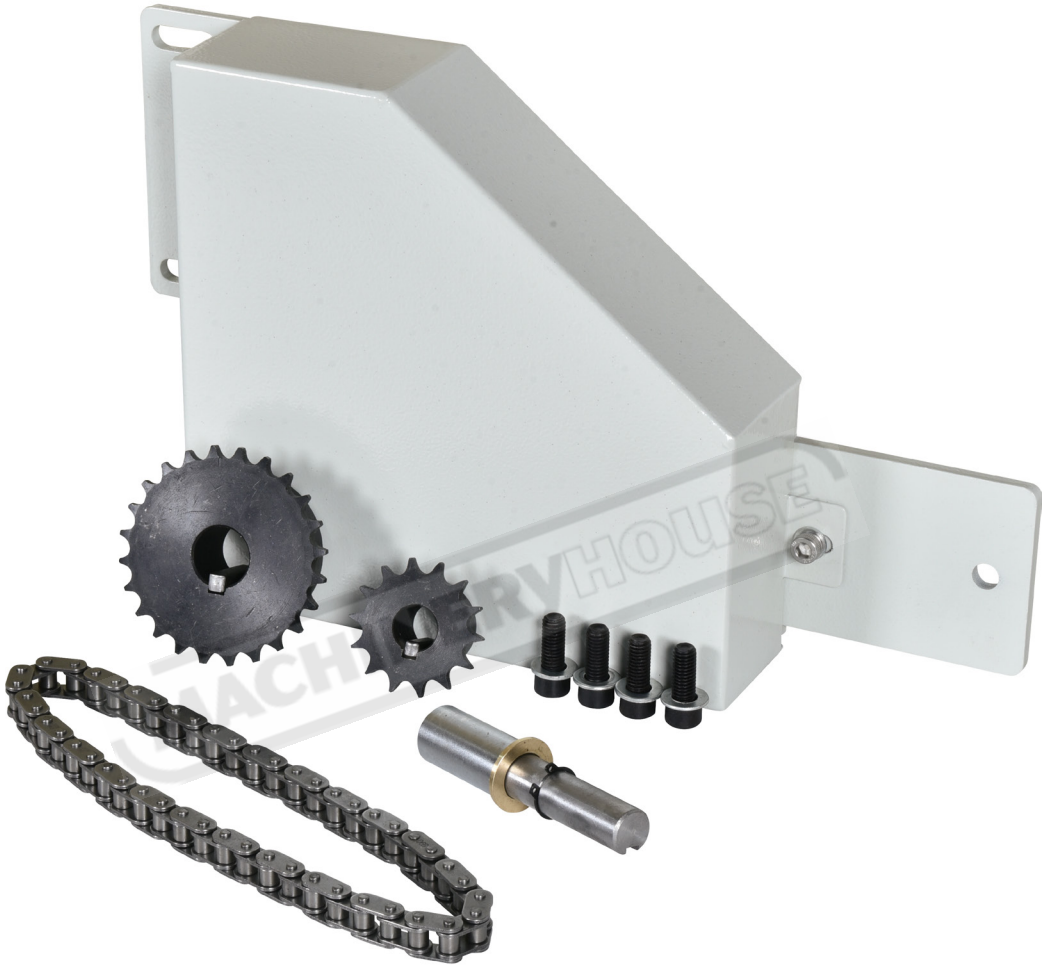
METALMASTER

FITTING INSTRUCTIONS



SLOW SPEED KIT

Model
MBR-SSK

Suit MBR-610 & MBR-1070

Order Code S6339

Edition No	: MBR-SSK-1
Date of Issue	: 07/2023

MBR-SSK - Slow Speed Drive Kit

OVERVIEW

Based on customer feedback Metalmaster has designed a conversion kit to slow the speed of the bead rollering machines (Model MBR-610 & MBR-1070) down to gain more control over the work piece, especially for tight radius work. This simple to fit conversion kit allows you to reduce the speed by approximately 50% to maintain torque at slow speeds on our first-generation motorised bead rollers.

FEATURES

- ❑ Easily retrofittable to either the MBR-610 or MBR-1070 Metalmaster Bead Roller
- ❑ Includes mounting hardware & safety cover

PACKING LIST

A. Safety Guard x 1

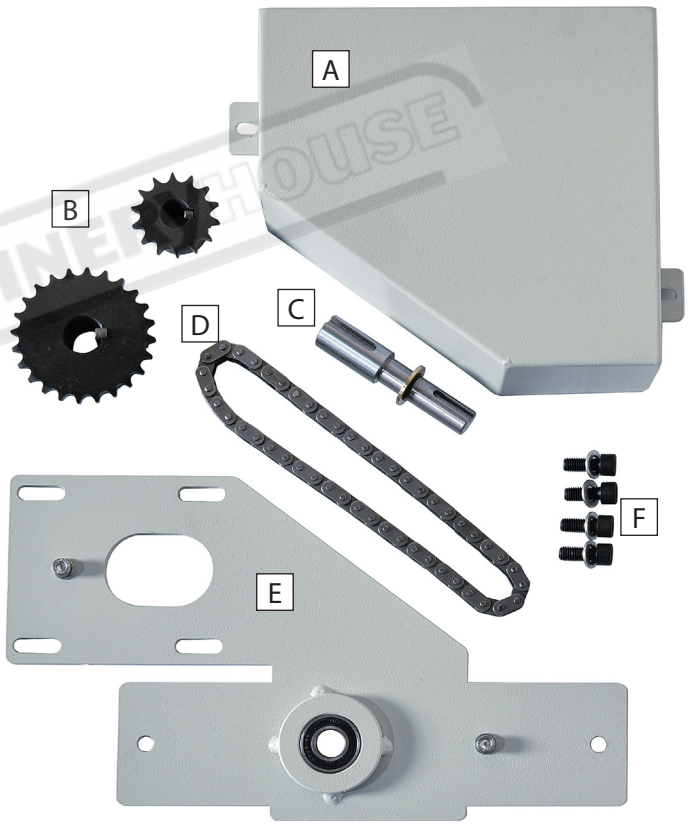
B. Drive sprockets x 2

C. Idler Shaft x 1

D. Chain Drive x 1

E. Mounting Plate. x 1

F. Socket Head Cap Screws x 4



CAUTION

Before attempting this feature, disconnect the machine from the power supply to avoid injury to the operator from accidental startup or damage to the machine

REMOVAL AND INSTALLATION

The following is the procedure for installing the Slow Speed Kit.

1. Disconnect the machine from the power supply and remove the plug from the socket.
2. With a Hex key remove the two mounting screws on the motor plate. (Fig. 1)

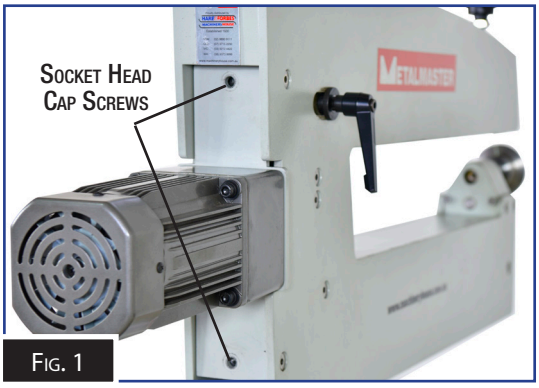


Fig. 1

3. Remove the motor from the machine. (Fig. 2)

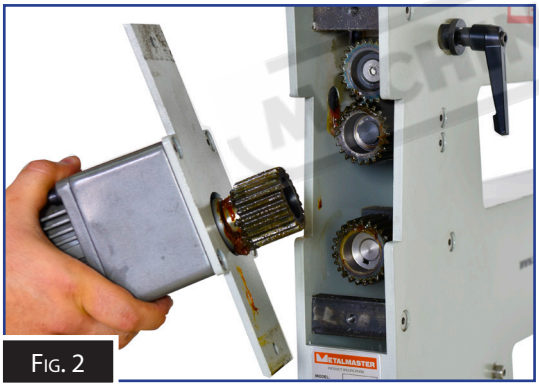


Fig. 2

3. Remove the grub screw from the gear and with a puller remove the gear from the motor shaft. (Fig. 3)

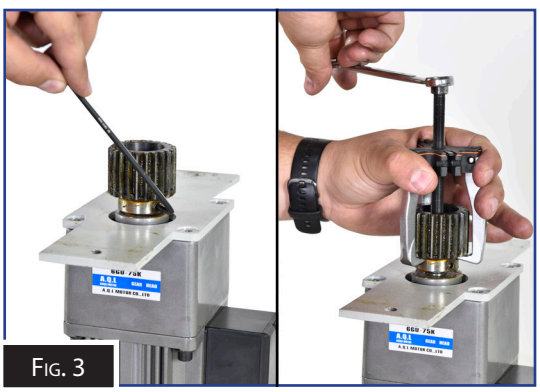


Fig. 3

4. Remove the four screws that hold the motor on the motor plate and remove the plate. (Fig. 4)


Fig. 4

5. Find the Idler shaft, brass washer and circlip. Using a soft face hammer press the idler shaft through the bearing in the new backing plate. (Fig. 5)


Fig. 5

6. Secure the idler shaft with the brass washer and then a circlip. Using the 4 socket head cap screws secure the motor to the new mounting plate (Fig. 6)

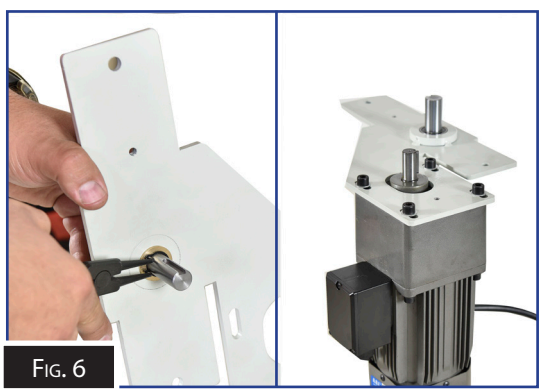


Fig. 6

7. Place the key in the keyway of the idler shaft. Place the drive gear from the motor onto the idler shaft and tap it home with a soft face hammer. (Fig. 7)

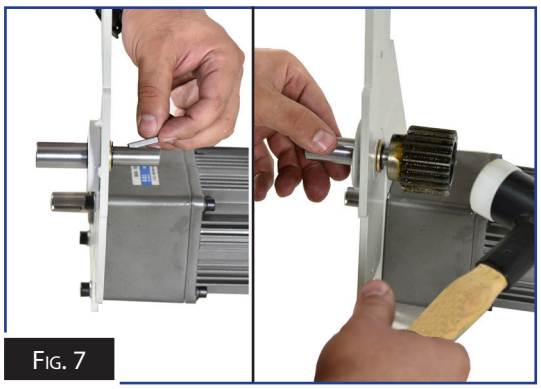


Fig. 7

8. Mount the new backing plate onto the machine using the 2 screws that held the old plate, making sure that the drive gear is engaged. Place the keys in the two exposed keyways. (Fig. 8)

Fig. 8

9. With a soft face hammer fit the large sprocket to the top shaft and the small sprocket to the motor shaft, with the boss with the grub screw facing out.(Fig. 9)

Fig. 9

10. Place the chain on the sprockets and adjust the motor position using the four mounting screws to tension the chain. (Fig. 10)

Fig. 10

11. Once the chain has been tensioned, using a straight edge adjust the sprockets so that they are aligned and the chain drive will operate correctly. Once this is done then tighten the grub screws on the sprockets. (Fig. 11)

Fig.11

12. Fit the guard to the machine, reconnect the power to the machine and test run the machine. Make sure that the machine runs smoothly.(Fig. 12)

Fig. 12