



# Instructions to Add Idler #65974 to the 2075

Form No. Z280  
Date 11-94

## Tools required:

- 1) 1/2" combination wrench
- 2) 7/16" socket, 9/16" socket, 6" extension, and ratchet
- 3) T-25 torx screwdriver;
- 4) needle-nose pliers

## Installation Instructions

1. UNPLUG THE MACHINE , OIL PUMP and HOSE
2. Remove 4 screws & the top motor cover, taking care to disconnect the 2 lamp wires .
3. Remove 4 screws from the motor side cover.
4. Remove the 4 ground wire screws from the back of the grinding head.
5. Disconnect the 2 motor lead wires, and set the motor cover aside.
6. Grasp the head end of the idler axle with a pliers. Remove the axle with a twisting and pulling motion.
7. Remove and discard the old idler pulley.
8. Remove the rubber bushing from the upright plate.
9. Add (1) #09556 nut to the end of the idler shaft. Place it about half-way up the threaded section.
10. Insert the pulley, shaft end first, thru the belt and into the hole on the upright plate.
11. Add the other #09556 nut to the end of the shaft.
12. Make sure the belt is tracking correctly on all three pulleys.
13. Adjust the side to side idler position by loosening and tightening the 5/16" nuts on the idler shaft.
14. Check that the belt tracks straight on all three pulleys.
15. Connect the 4 ground wires and the 2 motor lead wires.
16. Replace the 3 sided cover and the 4 screws securing it.
17. Plug in the unit and start the grinding head, being careful to keep clear of the pulley and belt.
18. Adjust the belt tension as outlined in the instructions.
19. TURN OFF AND UNPLUG THE UNIT
20. Connect the lamp to the matching black and white wires, while replacing the top cover and it's 3 screws.

21. Connect the oil pump cord and hoses.

## Belt Tension Adjustment for 2075

1. Remove the top cover over the grinding head motor and unplug the oil pump.
2. Loosen the locknut on the 1/4" bolt at the top of the motor mounting plate.
3. Back out the bolt until it clears the rubber mount, and the motor is supported by the belt.
4. Check the drive belt to ensure that it is properly seated in the motor, idler, and shaft pulleys.
5. The bottom of the motor mounting plate should be parallel with the cross slide casting. If it is not, loosen the 4 nuts under the motor and reposition it until the plate is parallel, and tighten the nuts.
6. Turn in the adjusting bolt until it contacts the rubber mount. Start the motor, making sure that items are clear of the drive belt and pulley.
7. Carefully turn the adjusting bolt in. ( A 7/16" nut-runner or socket and extension will be helpful in doing this. ) As the bolt is turned in, you will notice that there are positions where the upper part of the belt will vibrate or "flop". After approximately 6 turns in, you will be past these vibration points and the belt will seem quite loose. It may even be rubbing against the top of the slot in the casting. Now back out the bolt, (increasing the belt tension) stopping when the upper part of the belt begins to vibrate. At this point turn the bolt back in 1/4 turn, so the belt just stops vibrating. Tighten the locknut while maintaining this position. The belt tension is now set to the optimum position for smooth operation. Turn the head on and off several times to check for belt slippage on start-up.

If the belt should slip the tension setting may be increased as follows. Begin to back out the bolt 2 to 4 turns while observing the upper section of the belt. As tension is increased the belt will vibrate and then slowly stop as a nodal point is reached. When both the upper and lower parts of the belt have stopped vibrating, tighten the locknut. This is the maximum belt tension recommended. DO NOT run the unit with the adjusting bolt backed out farther than outlined above.

8. Stop the grinding head, replace the light and top cover, and plug in the oil pump motor.

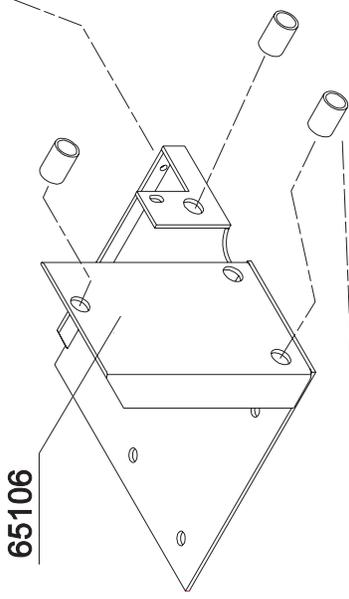
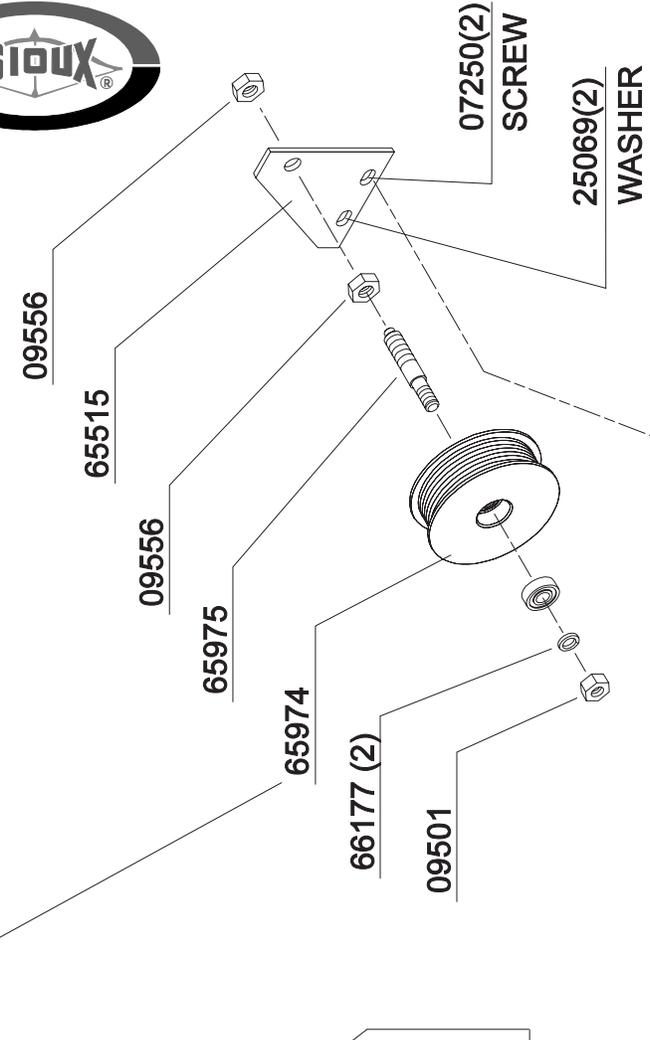
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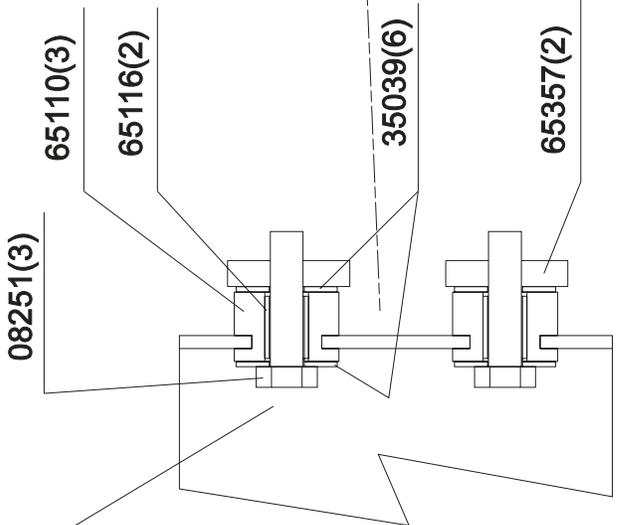
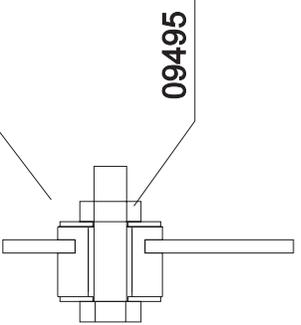
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65974 Includes 65975, 66177, 09501 & 09566 (2)



NOTE POSITION OF BOTTOM BUSHINGS  
UPPER BUSHING IS INSTALLED IN THE  
OPPOSITE DIRECTION



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