RAYZER BLOCK™
Installation Manual

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The following procedure outlines the most efficient method of removing the old lead screw carrier blocks and replacing them with the new “Rayzer Blocks.” This is a one-time replacement procedure. “Rayzer Blocks” are designed to easily unbolts and split apart when they need to be replaced. Use this procedure only if the lead screws are serviceable.

SECTION 1: SAFETY PREPARATION

1. Remove the outside cover plates and run the head out until the old blocks are centered in the frame cutout (see figure 1-1).

2. Measure the distance from one edge of the frame cutout to the center of the roll shaft and record it.

3. Remove all power from the machine (ZES).

4. Remove the horizontal preparation bar.

5. Install a safety strap on each end of the head using the overhead cross tube as the support. The straps should go completely around the head and be loosely, yet securely fastened (see figure 1-2).

6. Use a small chain fall and strap to raise the head just enough to take the weight off the block. Attach the fall chain to the center idler stub shaft and the strap to the end cross tube. Connect the fall and the strap, making sure the strap is placed on the roll shaft and away from the pneumatic tubes. This simple rigging keeps your workers on the floor and allows for some fore/aft movement of the head (see figure 1-3).

7. Once safe and supported, remove the access plate(s).
SECTION 2: OLD BLOCK REMOVAL

1. A standard rotary tool is recommended to remove the old blocks (see figure 2-1). Use the standard rotary tool with the mini saw attachment, and the rip/cross-cut blade. Install two blades with the teeth offset to achieve the best cut (see figure 2-2).

2. Mark a full horizontal line 1.5 inches down from the top of the block (see figure 2-3).

3. Cut along the line with the standard rotary tool. Work slowly and make sure the blades cut to their fullest depth while maintaining a low rpm to prevent melting (see figure 2-4).

4. Remove the bushing and rotate the block away from the supported head. Move the head to clear the block, then repeat steps 1 and 2 in this section for the uncut side of the block.

5. Use a bronze chisel on the relieved slots to break the old block apart and then remove the block.

6. Move the head back to the starting position that was measured and recorded in Step 2 of Section 1.
SECTION 3: RAYZER BLOCK INSTALLATION

1. Place the inner block half so the hole is centered on the roll shaft end. Snap the block onto the lead screw (see figure 3-1). NOTE: The block fits tightly and may need to be tapped with a soft mallet.

2. Align the outer block half with the inner half and snap them together. Again, the block needs to be firmly tapped. NOTE: DO NOT use the shoulder bolts to “pull” the blocks together.

3. Install the bolts and tighten to 60 in. lb. with a 5/32” T-Handle wrench (see figure 3-2).

4. Install the bushing and then the retaining clip.

   NOTE: It is strongly recommended that both sides are replaced. Remember that each block is built as either a right or left side block and are marked as such.

SECTION 4: OPERATION

1. Recheck all bolts for tightness and make sure the bushing is secure (see figure 4-1).

2. Attach the cover plates.

3. Remove all straps, reinstall the preparation bar, and return power to the machine.

4. Run the head in, bottom the new blocks to the stop blocks and check that they are parallel.

5. If necessary, fine tune the blocks according to OEM procedure so that they are parallel.

   NOTE: It is strongly recommended that a dry lubricant is applied to the screws every week for best wear. DO NOT APPLY GREASE!