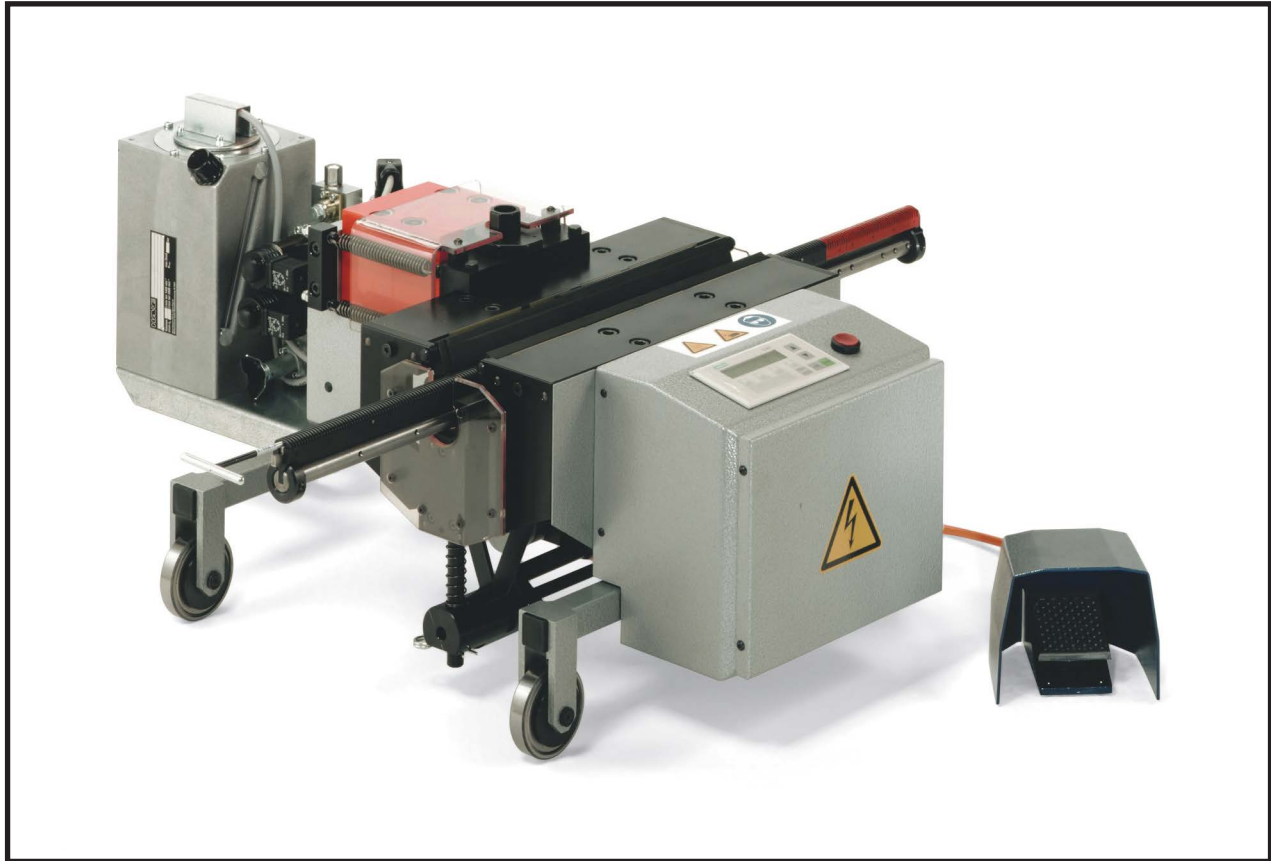


Pro 600 and Pro 6000

OPERATION MANUAL



Pro 6000 Lacer Pictured.

Your Lacer Identification

Model No. _____

Serial No. _____

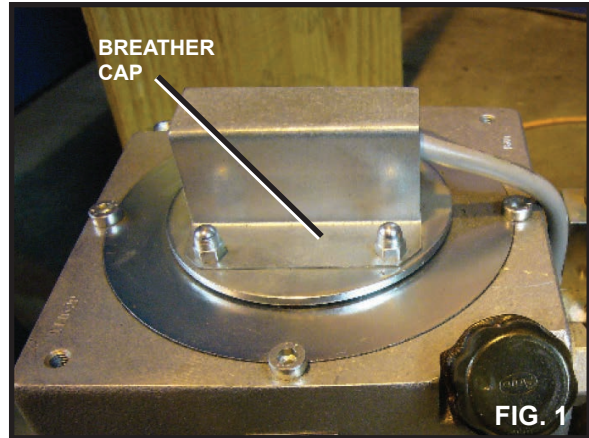
Date Purchased _____

Please use correct model number and serial number when corresponding with your Distributor or with Customer Service. Proper identification will help us to quickly and efficiently answer your question or service you with repair parts.

WE STRONGLY RECOMMEND THAT YOU READ THIS MANUAL IN ITS ENTIRETY.

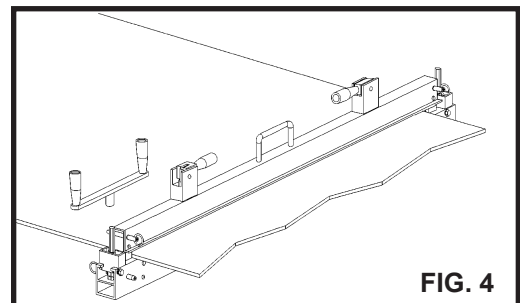
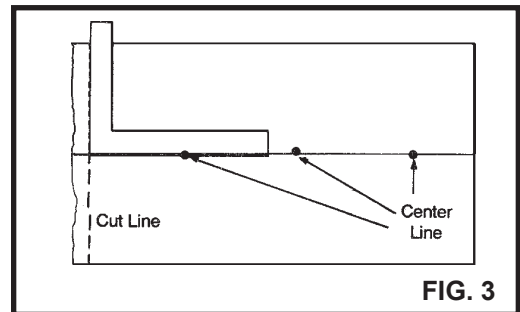
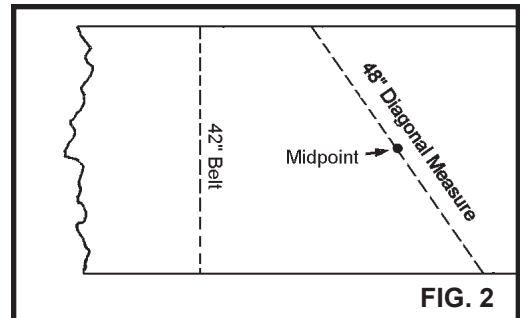
Unpacking and setting up your Pro Series Lacer

1. Remove bolts from bottom of shipping crate. Using caution to lift the lacer, place it on a solid work surface, ensuring it can not roll off the edge. See page 8 for a recommended workbench.
2. Unwrap control cables. **Do not plug power cable into an electrical outlet at this time.**
3. Visually inspect machine for possible damage during shipment. If damage has occurred, contact Flexco Customer Service at 1-800-541-8028.
4. Remove bolt from hydraulic reservoir. Save bolt to use if lacer needs to be transported. Screw in breather cap (See Fig. 1). Check fluid level by locating the clear fluid level viewing tube on the outside of the pump assembly. The fluid level should fill approximately $\frac{3}{4}$ of the clear tube. Add standard hydraulic fluid if level is low. Check the fluid level monthly.



Belt End Preparation

1. Square belt ends using the center line method as described below.
 - A. Take an even measurement wider than the belt width (Ex. 48" for a 42" belt). Measure diagonally and mark the center point (Ex. 24"). (See Fig. 2).
 - B. Repeat this step four more times, moving the tape measure 12" along the belt for each position. (See Fig. 3).
 - C. On a typical belt with worn edges, the center points marked will not be in a straight line. Using a straight edge, draw a line as close as possible to the center line of these points. This will be your average center line. (See Fig. 3).
 - D. Draw a line perpendicular to the average center line (See Fig. 3). The belt will be square when cut along this line.
 - E. A safe and accurate method to cut the belt is to use the portable Clipper® 845LD cutter. Cutter is available in widths from 36" – 72" (See Fig. 4).
2. Skive rough top. If belt has an impression cover, skive cover back 1" from the edge to be laced, across the entire width of the belt. Caution: Do



not cut into belt carcass. Measure the skived belt thickness when selecting the proper hook. (See Fig. 5).

3. Select the proper hook for the application. Refer to the enclosed “7 Steps to Selecting the Proper Fastener” brochure for additional help.

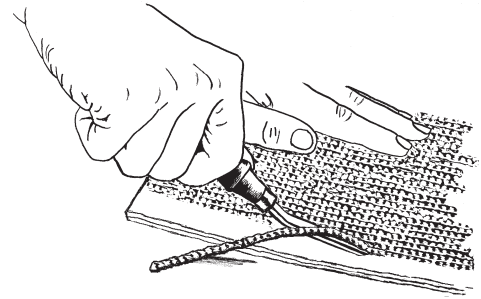


FIG. 5

Machine Preparation

1. Be sure the breather cap is properly installed (See page 1).
2. Before connecting the machine to the power supply, be sure the switch is in the “Off” position (See Fig. 6).
3. Connect the machine to the power supply
4. Select the proper comb. Proper comb is determined by the hook size you have chosen for installation. Combs are available in widths from 24" – 60". All combs have the ability to lace belts wider than the combs by using the continuous lacing feature. (See Fig. 7). Refer to the chart below to select the proper comb.

| Hook Size | Comb |
|-------------|------|
| 25 | 25 |
| 36, UCM, 30 | 36 |
| 1, UX-1 | 1 |
| 2-7, U2-7 | 2 |

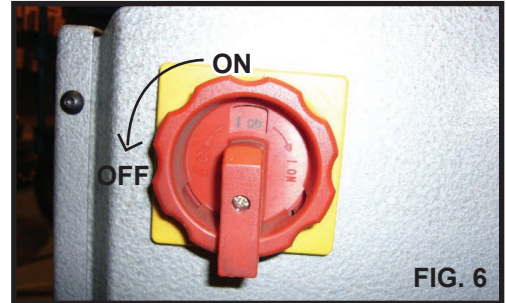


FIG. 6

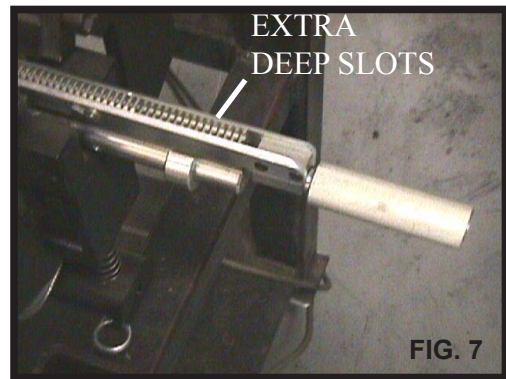


FIG. 7

5. Installing the comb:
 - A. Remove collar by loosening the set screw and sliding it off the end of the comb. (See Fig. 8).
 - B. Keeping comb level, push comb through the first bushing housing and then across the tool and into second bearing housing on the opposite side of the tool. Be sure to keep the comb level to avoid binding in the bushing housing during this operation. (See Fig. 9)
 - C. Collar is used to act as a stop. Position where desired and tighten set screw. This procedure will help ensure that the comb is not pulled out of the bushing housing when advancing the comb in the lacing procedure.

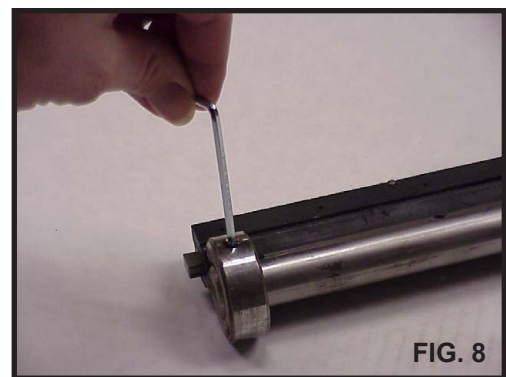


FIG. 8



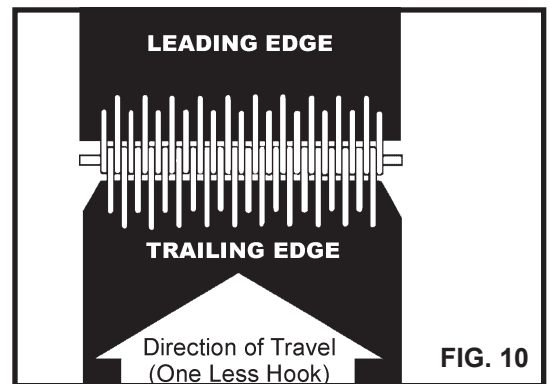
FIG. 9

6. Selecting the correct gauge pin (lacer pin). The proper gauge pin should be 20 – 30% thinner than your belt thickness. To select the proper gauge pin, measure the belt thickness and select the appropriate gauge pin. Below is a chart showing the gauge pins that come standard with the combs.

| Comb | Gauge Pins |
|------|-----------------------------|
| 25 | 1.5, 1.5 x 1.8, 1.5 x 2.0mm |
| 36 | 1.5, 1.5 x 1.8, 1.5 x 2.0mm |
| 1 | 1.8, 2.0, 2 x 2.5, 2 x 3mm |
| 2 | 2.5, 3.5 x 3.0, 4.0 x 3.0mm |

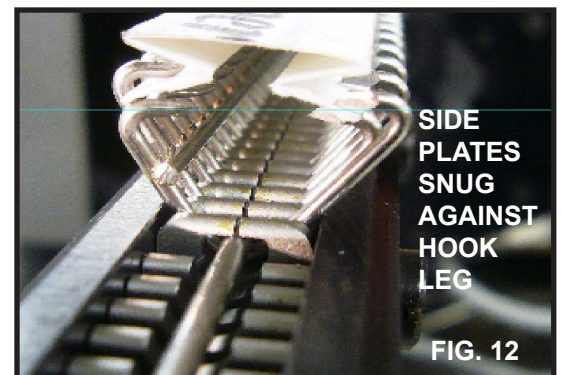
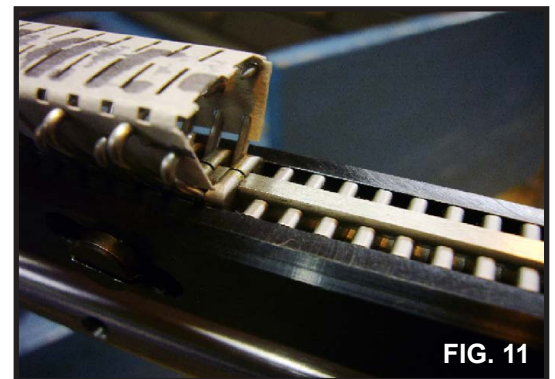
Determining the number of hooks required:

1. Lay strips of hooks end to end across the entire width of the belt, with the exception of ¼" - ½" on each belt end. When necessary, cut a strip of hooks down to the appropriate length. Carded hooks can be cut down with a small scissors. Unibar® hooks can be cut to the appropriate length with either a Unibar® cutter or by twisting.
2. The trailing end of the belt should have one less hook than the leading end (See Fig. 10). This prevents hooks from getting caught on the conveyor framework and pulling out. The trailing end should be notched after hooks are installed to prevent belt rips/tearing.

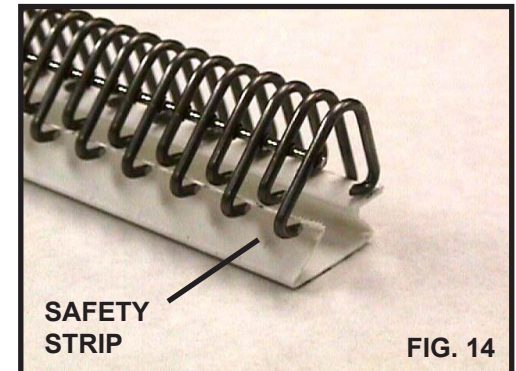
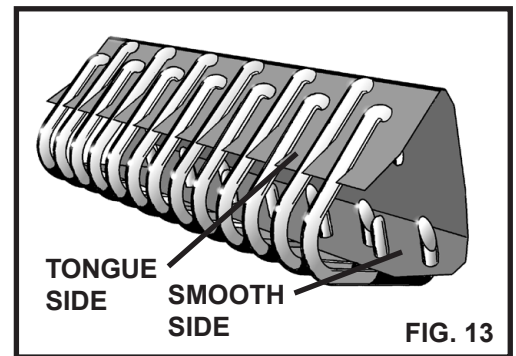


Insertion of hooks into the comb:

1. Insert hooks into the active lacing slots on the comb. Do not place unlaced hooks into the deep slots on the end of the comb.
2. Insert gauge pin into the comb. If using a “D” shaped pin, insert the pin into the comb with the flat side facing up. (See Fig. 11).
3. NOTE: If using the #2-7 combs, with fasteners and gauge pin in place tighten the adjusting side plates by turning the knob on the end of the comb until the side plates are snug against the hook legs. Once snug back the side plates off 1-1/2 turn. No further adjusting will need to be made while lacing the same size hook. (See Fig. 12).



4. If installing hooks into a belt that is wider than the width of the lacer jaws, position comb to one end of the lacer. This will allow you to install the hooks across the width of the belt in a continuous manner. **Note:** If installing hooks into a belt that is narrower than the width of the lacer jaws, position comb so that the hooks are centered in jaws. Failure to do this may cause the machine to apply unequal pressure to the jaws, jamming the machine.
5. If using carded hooks as shown in Figure 13, remove paper. It is easiest to remove the paper completely from the smooth side first (See Fig. 13) and then the opposite side. If using Unibar hooks, remove safety strip (See Fig. 14).
6. Insert belt between hook points, center and hold down perpendicular on comb.



Operating Instructions for Belt Lacers equipped with a SIEMENS TD200 – Control Unit

1. How to Change the Operational Mode:

You may change the operational mode by using the F1 – F7 functional keys. The preferred operational mode can be selected by pushing one of the functional keys. The lacing machine is supplied with the following pre-settings:

| | | | | | |
|-----|--|----------------------|----|--------------------|--|
| F1, | F5, | F6, and | F7 | | |
| | Pressing Mode | | | | |
| | Pressure: 75 bar | Holding Time: 1 sec | | Temperature: 25° C | |
| F2 | Pressing Mode | | | | |
| | Pressure: 300 bar | Holding Time: 5 sec | | Temperature: 25° C | |
| F3 | Pressing Mode | | | | |
| | Pressure: 400 bar | Holding Time : 5 sec | | Temperature: 25° C | |
| F4 | Pressing Mode | | | | |
| | Pressure: 500 bar | Holding Time : 5 sec | | Temperature: 25° C | |
| F8 | Switches Temperature °C to °F and Pressure bar to PSI. | | | | |

Note: We have used the pre-setting only for reference. You will have to change the settings according to your belt material, fasteners selected and belt width to be laced.

2. How to Change the Settings for Pressure, Temperature and Holding Time:

The settings of the F1 – F7 keys can be changed as follows:

Select the mode to be changed (F1 – F7). Then press the ▼ key till it arrives at the setting to be changed (pressure, temperature or holding time). To select the value to be changed press the ENTER key once or several times until the value of the required component is reached. To change the value push

▲ to increase the numerical value

▼ to decrease the numerical value

By constantly holding the ▲ or ▼ keys this process will accelerate. When the desired value is reached press ENTER to accept your settings.

Note: If you try to set the values beyond factory-set limits of your belt lacer, then the last setting will be kept and the new value will be ignored (see also no. 3, limiting values for belt lacer).

Follow this same process to change the parameter values for any of the pre-set keys F1-F7. We recommend that you categorize your belts into several groups to have the settings F2 – F4 set as such that you do not need to change the settings too often.

After you are finished setting and entering the values simply press the ▲ key or the footswitch to get back to the first screen.

3. Belt Lacer Parameters (Limiting Values)

Each Belt Lacer will be supplied with the following factory-set limits:

| | | |
|-----------------------------------|----|---------|
| - Minimum Pressure | => | 60 bar |
| - Maximum Pressure | => | 550 bar |
| - Maximum Temperature | => | 200°C |
| - Maximum Holding Time | => | 20 sec |
| - Pressure Difference Re-Pressing | => | 25 bar |

Important Notice: The factory-set values are protected by a password and may only be changed after having consulted the manufacturer. Improper change of these settings may lead to damage of the belt lacer or cause injuries. If changes are made without consulting the manufacturer our warranty and liability are waived.

4. Operation of Heating Mode - Pro 6000 Lacer Only

The jaw-heating is started by pushing the “heat-on” button. As long as the button flashes, the jaws have not yet reached the temperature selected. The selected temperature is reached when the button stops flashing and the light is continuously on.

Lacing Procedures:

1. With comb, belt and hooks in proper position as noted on pages 3 and 4, and with pressure/time/heat setting selected as noted above, press the foot switch. **CAUTION:** Do not place fingers/hands in jaws when depressing the foot switch. Keep loose clothing and jewelry away from jaws. The jaws will remain closed for the amount of time set on the timer switch. After the jaws begin to open it is recommended to momentarily depress the footswitch a second time. This allows the belt to adjust and the hooks to set properly.
2. Inspect the installed splice. A correct pressure is achieved when 1/3-1/2 of the wire diameter is embedded into the belt surface with a "U" shaped loop and the points are just visible from the opposite side of the belt. If the loop has a light-bulb shape to it, reapply the new hooks using a smaller gauge pin and/or with lower pressure. If the hook points are protruding through and curling over, the hook is too large. Reapply using a smaller hook.
3. Increase pressure setting in increments of 50 bars or less until proper setting of the hooks is achieved.
4. Once you have determined the correct lacer settings for your belt, record this data in your log (page 10). Then, with future installations you can refer back to the log and determine the necessary settings for this particular belt.
5. Pull the gauge pin completely out of the comb by pulling it straight, without bending or twisting. Twisting the gauge pin can break the handle off the gauge pin. If necessary, rock the belt back and forth to loosen the gauge pin.

6. Pull the belt straight up, out of the machine. Do not twist the belt as it is removed. If using carded hooks as shown in Figure 17, remove paper at this time.
7. Do not change the pressure setting if you will be making additional splices on the same belt.

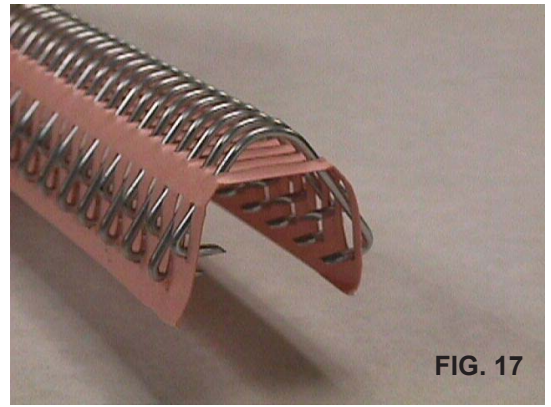


FIG. 17

Continuous Lacing:

If the belt you are lacing is wider than the width of the comb you will need to continuous lace the belt.

1. Lace the entire width of the comb first as noted earlier.
2. Load your remaining hooks into the comb starting with the first active slot next to the extra deep slots. Insert gauge pin through hooks, but not into the extra deep slots.
3. Remove the paper (if applicable).
4. Insert last laced hooks into the extra deep slots (See Fig. 18).
5. Insert gauge pin into the extra deep slots.
6. Install remaining hooks as described above. Repeat the continuous lacing procedure until entire belt width is complete.

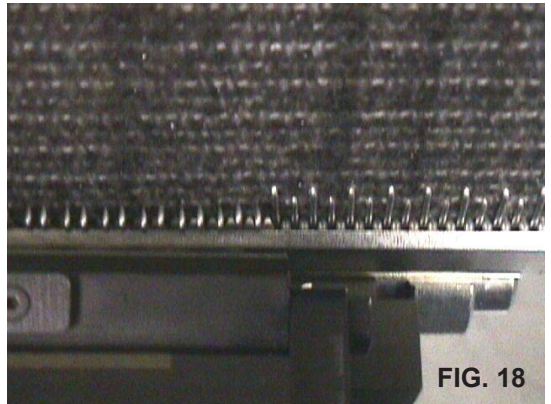


FIG. 18

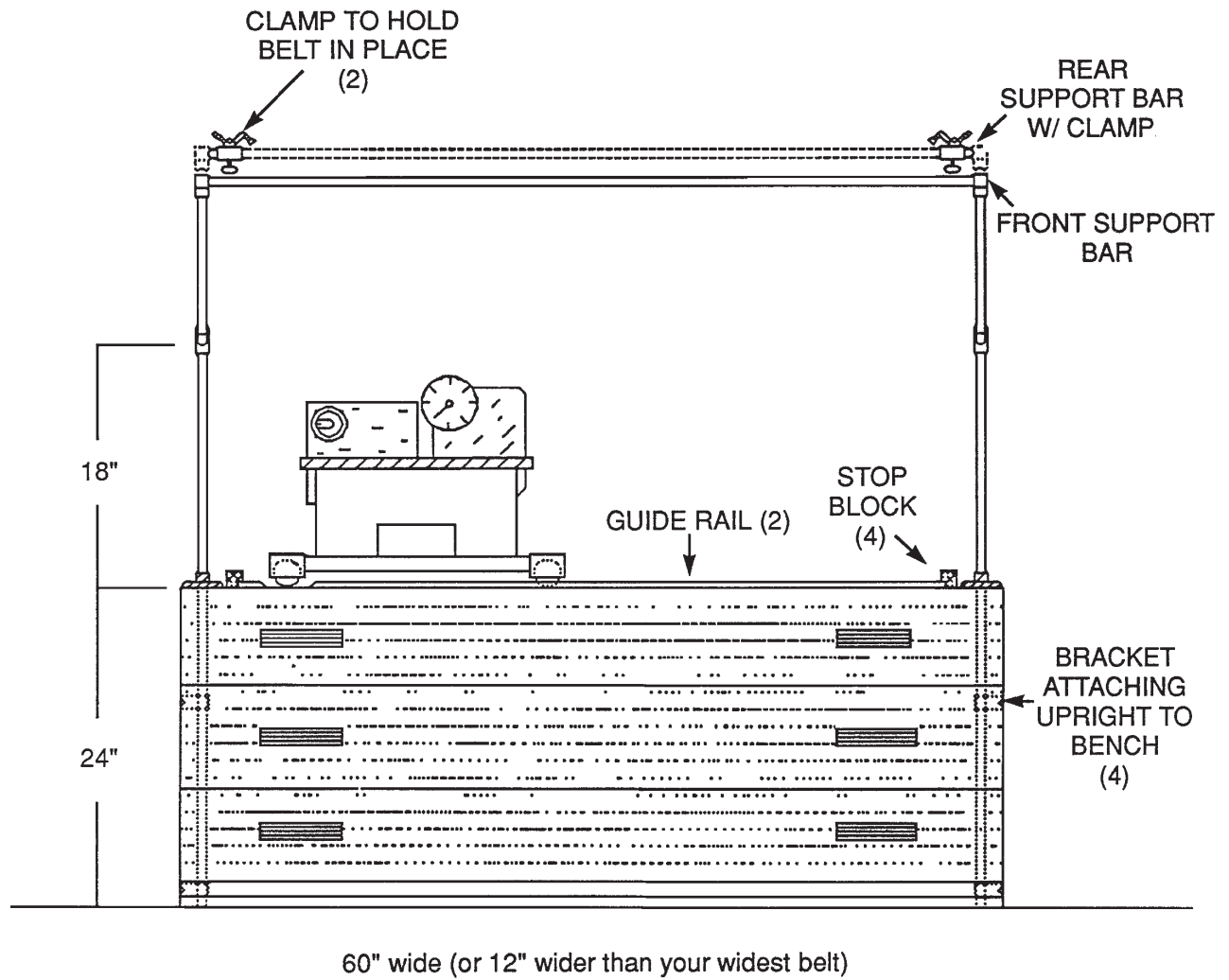
Miscellaneous:

Adjusting Cam - Adjusting cam can be turned to various settings to control how far the jaws open. The ideal setting is where there is adequate clearance to easily insert hooks into comb and remove paper, yet not excessive clearance. Excessive clearance requires more cycle time as jaws open and close.

Troubleshooting:

1. Machine will not operate.
 - A. Is machine plugged in and power switch on?
 - B. Check power supply. Is there electricity at the outlet?
 - C. Press reset button located inside the electrical box.
 - D. Change fuse located inside the electrical box. A spare fuse is located in the electrical box.
2. Electric pump operates but jaws do not move.
 - A. Is the pressure set above zero?
 - B. Have you checked the hydraulic fluid level and installed the breather cap?
 - C. Are jaws cocked at an angle?
3. Jaws close unevenly.
 - A. Close jaws 3 – 4 times without hooks or a belt inserted between the jaws. This should straighten out the jaws.

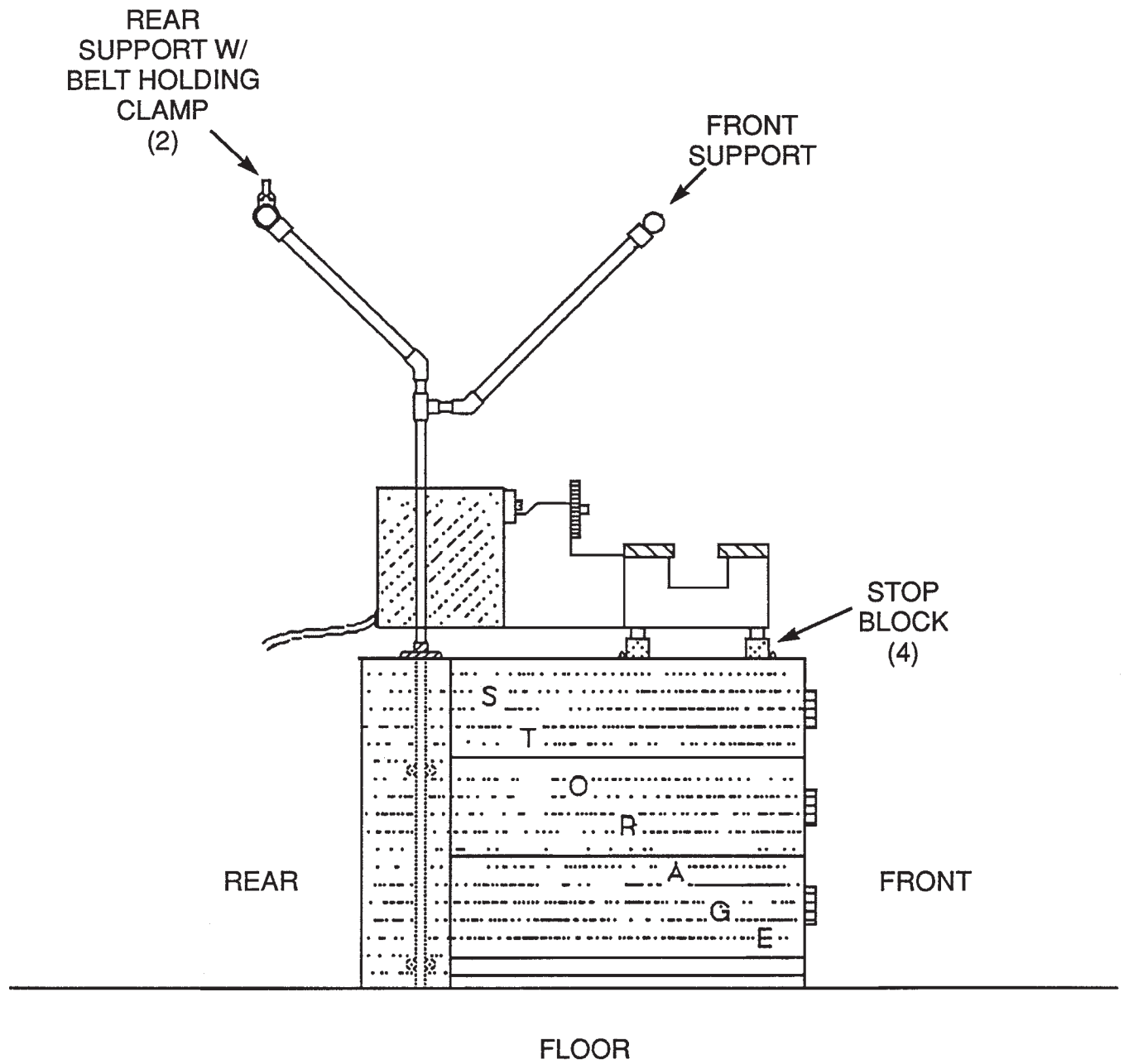
Suggested Workbench Setup:



FLOOR

FRONT VIEW

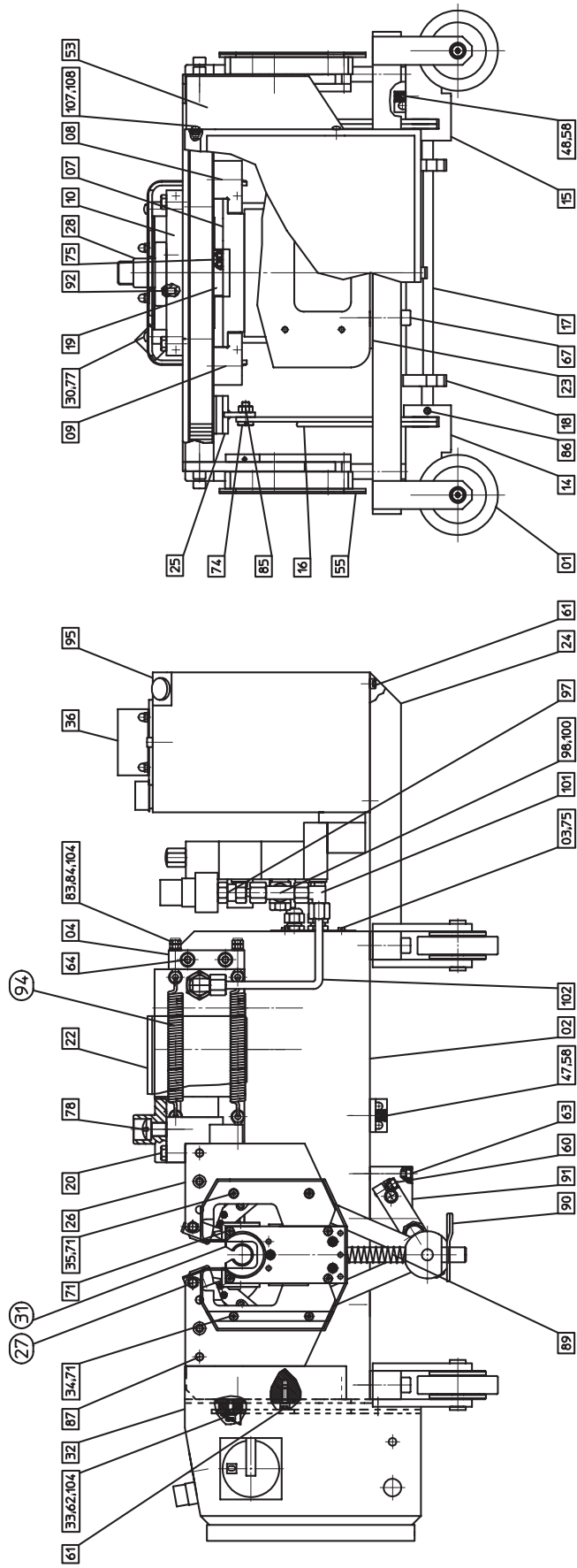
Suggested Workbench Setup:



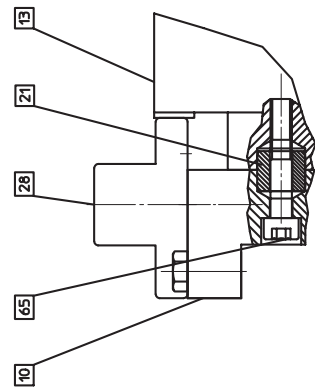
SIDE VIEW

LOG

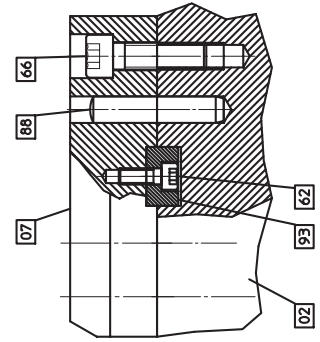
| BELT MFR. | BELT STYLE/ IDENTIFICATION | BELT THICKNESS | HOOK SIZE | GAUGE PIN USED | PRESSURE SETTING | JAW CLOSURE TIME | TEMPERATURE | HINGE PIN USED | COMMENTS |
|-----------|-------------------------------|-------------------|--------------|-------------------|------------------|---------------------|-------------|-------------------|----------|
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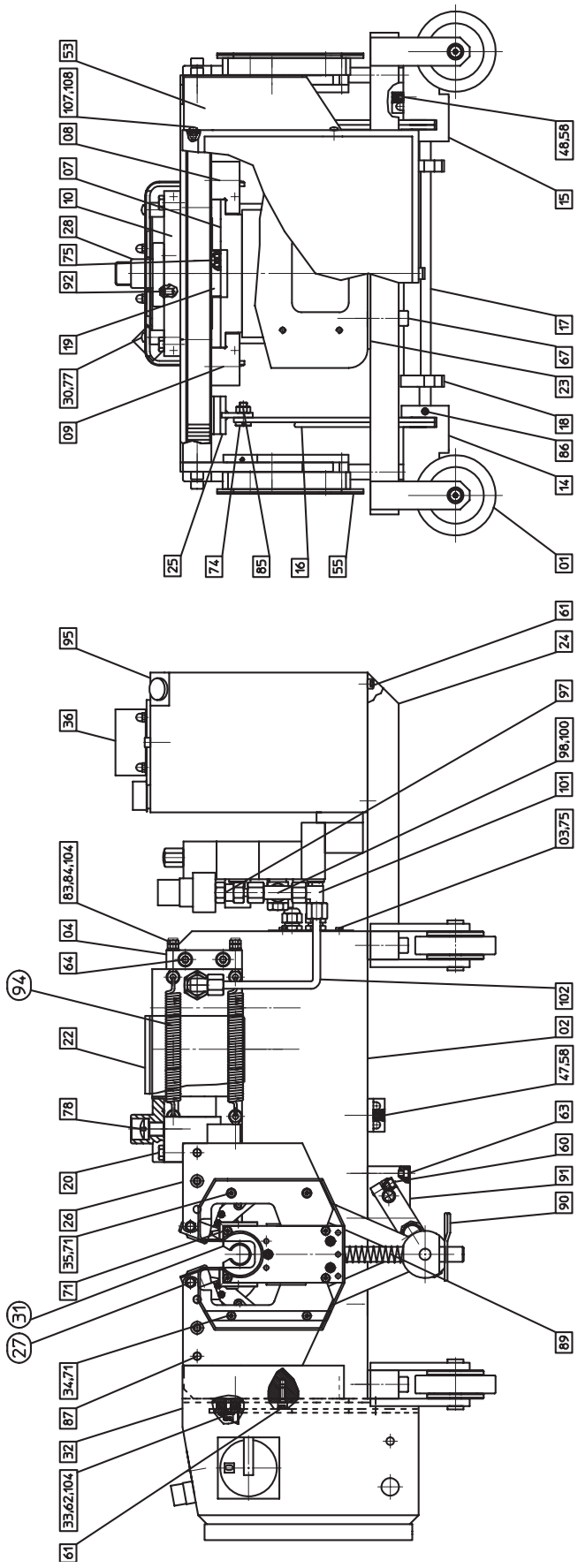
press block assembly 1:1



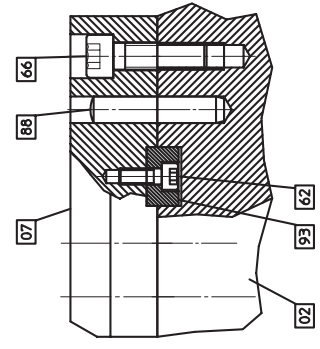
guide plate assembly 1:1



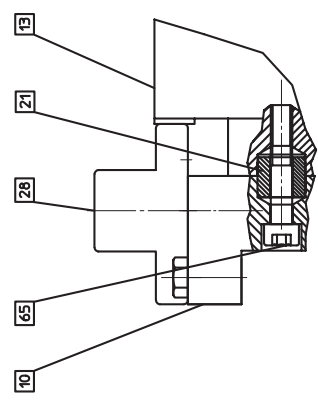
PRO 6000



guide plate assembly 1:1



press block assembly 1:1



PRO 600

SPARE PART LIST PRO6000

| POS | QTY | DESCRIPTION | Draw.-No. |
|------------|------------|-------------------------------|------------------|
| 01 | 2 | WHEEL BRACKET | AMK-4T-001 |
| 02 | 1 | CAST BODY | AMU-4T-005 |
| 03 | 1 | COVER SHEET REAR | AMU-4T-006 |
| 04 | 2 | SPRING HOLDER | AMU-4T-007 |
| 05 | 1 | SLIDING JAW | AMU-6T-002 |
| 06 | 1 | FIXED JAW | AMU-6T-001 |
| 07 | 1 | SLIDING JAW GUIDE PLATE | AMU-4T-010 |
| 08 | 1 | SLIDING JAW GUIDE TRACK RIGHT | AMU-4T-011 |
| 09 | 1 | SLIDING JAW GUIDE TRACK LEFT | AMU-4T-012 |
| 10 | 1 | PRESS BLOCK | AMU-4T-013 |
| 11 | 1 | PRESSING JAWS LONG | AMU-6T-003 |
| 12 | 1 | PRESSING JAWS SHORT | AMU-6T-004 |
| 13 | 1 | CYLINDER 200 KN | AMU-4T-016 |
| 14 | 1 | SHAFT-END LEFT | AMU-4T-017 |
| 15 | 1 | SHAFT-END RIGHT | AMU-4T-030 |
| 16 | 4 | ARMS | ARU-2T-020 |
| 17 | 1 | ROD | AMU-4T-019 |
| 18 | 1 | SHOCK-ABSORBER FORCK | AMU-4T-020 |
| 19 | 2 | SLIDING BLOCK | AMU-4T-024 |

SPARE PART LIST PRO6000

| POS | QTY | DESCRIPTION | Draw.-No. |
|-----|-----|----------------------------|-------------------|
| 20 | 2 | WASHER HEAD BOLT M8 | AMU-4T-025 |
| 21 | 1 | BUSHING | AMU-4T-026 |
| 22 | 1 | CYLINDER COVER | AMU-4T-027 |
| 23 | 1 | SPACER | AMU-4T-028 |
| 24 | 1 | PUMP BASE PLATE | AMU-4T-029 |
| 25 | 4 | LEVER | ARU-2T-018 |
| 26 | 2 | COMP TRACKING PLATE | ARU-2T-021 |
| 27 | 4 | WASHER HEAD BOLT M6 | ARU-2T-022 |
| 28 | 1 | SPACER WASHER | ARU-2T-024 |
| 30 | 2 | SPACER | ARU-2T-032 |
| 31 | 2 | SLIDING BLOCK GUIDE | ARU-2T-033 |
| 32 | 1 | ELECTRIC SWITCH BOX | ARU-2T-047 |
| 33 | 2 | SPACER | ARU-2T-048 |
| 34 | 2 | SLIDE BAR | ARU-2T-051 |
| 35 | 4 | SPACER | ARU-2T-052 |
| 36 | 1 | COVER SHEET | HP1000-003 |
| 37 | 1 | SLAT, PRESSING JAWS LONG | AMU-6T-005 |
| 38 | 1 | SLAT, PRESSING JAWS SHORT | AMU-6T-006 |
| 39 | 1 | COVER PLATE | AMU-6T-007 |
| 40 | 1 | LEVER | AMU-6T-008 |

SPARE PART LIST PRO6000

| POS | QTY | DESCRIPTION | Draw.-No. |
|------------|------------|--|------------------|
| 41 | 1 | INSULATION PLATE 1, SLIDING JAWS | AMU-6T-009 |
| 42 | 1 | INSULATION PLATE 2, SLIDING JAWS | AMU-6T-010 |
| 43 | 2 | INSULATION PLATE 1, SLIDING AND FIXED JAWS | AMU-6T-011 |
| 44 | 2 | INSULATION PLATE 2, SLIDING AND FIXED JAWS | AMU-6T-012 |
| 45 | 1 | INSULATION PLATE 1, FIXED JAWS | AMU-6T-013 |
| 46 | 1 | INSULATION PLATE 2, FIXED JAWS | AMU-6T-014 |
| 47 | 1 | DOUBLE CLAMP | ARU-3T-009 |
| 48 | 1 | SINGLE CLAMP | ARU-3T-010 |
| 49 | 1 | LEVER, PRESSING JAW SHORT | AMU-3T-014 |
| 50 | 1 | SUBLEMENTERY LEVER, PRESSING JAW LONG | AMU-3T-015 |
| 51 | 1 | SUBLEMENTERY LEVER, PRESSING JAW SHORT | AMU-3T-016 |
| 52 | 1 | WIREHOLDER | AMU-3T-017 |
| 53 | 1 | COVER RIGHT | AMU-4T-031 |
| 54 | 1 | COVER LEFT | AMU-4T-032 |
| 55 | 2 | SLIDING BLOCK GUIDE COVER | ARU-2T-050 |
| 56 | 4 | HS HC SCREW DIN 912 M3X6 | |
| 57 | 8 | HS HC SCREW DIN 912 M3X12 | |
| 58 | 1 | HS HC SCREW DIN 912 M4X12 | |
| 59 | 1 | HS HC SCREW DIN 912 M4X20 | |
| 60 | 4 | HS HC SCREW DIN 912 M5X20 | |

SPARE PART LIST PRO6000

| POS | QTY | DESCRIPTION | Draw.-No. |
|-----|-----|--|------------|
| 61 | 4 | HSHC SCREW DIN 912 M6X12 | |
| 62 | 6 | HSHC SCREW DIN 912 M6X16 | |
| 63 | 2 | HSHC SCREW DIN 912 M6X50 | |
| 64 | 4 | HSHC SCREW DIN 912 M8X30 | |
| 65 | 1 | HSHC SCREW DIN 912 M8X50 | |
| 66 | 4 | HSHC SCREW DIN 912 M10x35 | |
| 67 | 8 | HSHC SCREW DIN 912 M10x45 | |
| 68 | 4 | HSHC SCREW DIN 912 M12X35 | |
| 69 | 4 | HSHC SCREW DIN 912 M16X120 | |
| 70 | 26 | HS COUNTERSUNK HS DIN 7991 M3X6 | |
| 71 | 8 | HS COUNTERSUNK HS DIN 7991 M4X10 | |
| 72 | 8 | HS COUNTERSUNK HS DIN 7991 M4X12 | |
| 73 | 8 | HS COUNTERSUNK HS DIN 7991 M5X10 | |
| 74 | 4 | SLOTTED PAN HEAD SCREW DIN 923 M8 | ARU-2T-027 |
| 75 | 8 | HSHC SCREW DIN 7984 M8X20 | |
| 76 | 4 | SLOTTED CHEESE HEAD SCREW DIN 84 M4x6 | |
| 77 | 2 | BUTTON HEAD SOCKET SCREWS ISO 7380 M5x25 | |
| 78 | 1 | BUTTON HEAD SCREWS NLM 754-12 | |
| 79 | 4 | EYE BOLTS DIN 444 M6X30 | |
| 80 | 4 | EYE BOLTS DIN 444 M6X40 | |

SPARE PART LIST PRO6000

| POS | QTY | DESCRIPTION | Draw.-No. |
|-----|-----|---------------------------------------|------------|
| 81 | 4 | HEXAGON HEAD SCREWS DIN 933 M3x6 | |
| 82 | 4 | HEXAGON NUT DIN 934 M3 | |
| 83 | 4 | HEXAGON NUT DIN 934 M6 | |
| 84 | 4 | SELF LOCKING HEXAGON NUT DIN 985 M6 | |
| 85 | 4 | SELF LOCKING HEXAGON NUT DIN 985 M8 | |
| 86 | 1 | HS SET SCREW CONE POINT DIN 914 M6x10 | |
| 87 | 8 | PARALLEL PIN DIN 6325 8M6X22 | |
| 88 | 2 | PARALLEL PIN DIN 6325 10M6X50 | |
| 89 | 2 | SPRING | ARU-2T-052 |
| 90 | 2 | SPRING PIN SIZE 3 | |
| 91 | 1 | SHOCK-ABSORBER | |
| 92 | 2 | SPRING PLUNGER | |
| 93 | 2 | NOTCH-STONE NLM 03250-22 | |
| 94 | 4 | SPRINGS | |
| 95 | 1 | HYDRAULIC UNIT | |
| 96 | 1 | FOOTPEDAL STEUTE GFSM 1Ö/1S | |
| 97 | 1 | HYDRAULIC FITTING MAVE08SR1/4A3C | |
| 98 | 1 | HYDRAULIC FITTING WH08SRA3C | |
| 99 | 1 | HYDRAULIC FITTING GE08SRA3C | |

SPARE PART LIST PRO6000

| POS | QTY | DESCRIPTION | Draw.-No. |
|-----|-----|--|-----------|
| 100 | 1 | HYDRAULIC FITTING ET08SRA3C | |
| 101 | 2 | HYDRAULIC FITTING EW08SA3C | |
| 102 | 1 | HYDRAULIC TUBE 8X1.5MM | |
| 103 | 1 | REDUCTION PIECE RI1/2EDX1/4A3C | |
| 104 | 6 | WASHERS DIN 125-B-6.4 ZINC PLATED | |
| 105 | 2 | CARTRIDGE HEATER | |
| 106 | 1 | RESISTANCE THERMOMETER | |
| 107 | 4 | BUTTON HEAD SOCKET SCREWS ISO 7380 M4x10 | |
| 108 | 4 | SELF LOCKING HEXAGON NUT DIN 985 M4 | |

SPARE PART LIST PRO 600

| POS | QTY | DESCRIPTION | Draw.-No. |
|------------|------------|-------------------------------|------------------|
| 01 | 2 | WHEEL BRACKET | AMK-4T-001 |
| 02 | 1 | CAST BODY | AMU-4T-005 |
| 03 | 1 | COVER SHEET REAR | AMU-4T-006 |
| 04 | 2 | SPRING HOLDER | AMU-4T-007 |
| 05 | 1 | SLIDING JAW | AMU-4T-008 |
| 06 | 1 | FIXED JAW | AMU-4T-009 |
| 07 | 1 | SLIDING JAW GUIDE PLATE | AMU-4T-010 |
| 08 | 1 | SLIDING JAW GUIDE TRACK RIGHT | AMU-4T-011 |
| 09 | 1 | SLIDING JAW GUIDE TRACK LEFT | AMU-4T-012 |
| 10 | 1 | PRESS BLOCK | AMU-4T-013 |
| 11 | 1 | PRESSING JAWS LONG | AMU-4T-014 |
| 12 | 1 | PRESSING JAWS SHORT | AMU-4T-015 |
| 13 | 1 | CYLINDER 200 KN | AMU-4T-016 |
| 14 | 1 | SHAFT-END LEFT | AMU-4T-017 |
| 15 | 1 | SHAFT-END RIGHT | AMU-4T-030 |
| 16 | 4 | ARMS | ARU-2T-020 |
| 17 | 1 | ROD | AMU-4T-019 |
| 18 | 1 | SHOCK-ABSORBER FORCK | AMU-4T-020 |
| 19 | 2 | SLIDING BLOCK | AMU-4T-024 |

SPARE PART LIST PRO 600

| POS | QTY | DESCRIPTION | Draw.-No. |
|------------|------------|----------------------------|-------------------|
| 20 | 2 | WASHER HEAD BOLT M8 | AMU-4T-025 |
| 21 | 1 | BUSHING | AMU-4T-026 |
| 22 | 1 | CYLINDER COVER | AMU-4T-027 |
| 23 | 1 | SPACER | AMU-4T-028 |
| 24 | 1 | PUMP BASE PLATE | AMU-4T-029 |
| 25 | 4 | LEVER | ARU-2T-018 |
| 26 | 2 | COMP TRACKING PLATE | ARU-2T-021 |
| 27 | 4 | WASHER HEAD BOLT M6 | ARU-2T-022 |
| 28 | 1 | SPACER WASHER | ARU-2T-024 |
| 29 | 2 | SPACER | ARU-2T-032 |
| 30 | 2 | SLIDING BLOCK GUIDE | ARU-2T-033 |
| 31 | 1 | ELECTRIC SWITCH BOX | ARU-2T-047 |
| 32 | 2 | SPACER | ARU-2T-048 |
| 33 | 2 | SLIDE BAR | ARU-2T-051 |
| 34 | 4 | SPACER | ARU-2T-052 |
| 35 | 1 | COVER SHEET | HP1000-003 |
| 36 | 1 | COVER RIGHT | AMU-4T-031 |
| 37 | 1 | COVER LEFT | AMU-4T-032 |
| 38 | 2 | SLIDING BLOCK GUIDE COVER | ARU-2T-050 |
| 40 | 4 | HSHC SCREW DIN 912 M5X20 | |

SPARE PART LIST PRO 600

| POS | QTY | DESCRIPTION | Draw.-No. |
|-----|-----|--|------------|
| 41 | 4 | HSHC SCREW DIN 912 M6X12 | |
| 42 | 6 | HSHC SCREW DIN 912 M6X16 | |
| 43 | 2 | HSHC SCREW DIN 912 M6X50 | |
| 44 | 4 | HSHC SCREW DIN 912 M8X30 | |
| 45 | 1 | HSHC SCREW DIN 912 M8X50 | |
| 46 | 4 | HSHC SCREW DIN 912 M10x35 | |
| 47 | 8 | HSHC SCREW DIN 912 M10x45 | |
| 48 | 4 | HSHC SCREW DIN 912 M12X35 | |
| 49 | 4 | HSHC SCREW DIN 912 M16X120 | |
| 50 | 8 | HS COUNTERSUNK HS DIN 7991 M4X10 | |
| 51 | 8 | HS COUNTERSUNK HS DIN 7991 M4X12 | |
| 52 | 8 | HS COUNTERSUNK HS DIN 7991 M5X10 | |
| 53 | 4 | SLOTTED PAN HEAD SCREW DIN 923 M8 | ARU-2T-027 |
| 54 | 8 | HSHC SCREW DIN 7984 M8X20 | |
| 55 | 4 | SLOTTED CHEESE HEAD SCREW DIN 84 M4x6 | |
| 56 | 2 | BUTTON HEAD SOCKET SCREWS ISO 7380 M5x25 | |
| 57 | 1 | BUTTON HEAD SCREWS NLM 754-12 | |
| 58 | 4 | EYE BOLTS DIN 444 M6X30 | |
| 59 | 4 | EYE BOLTS DIN 444 M6X40 | |
| 60 | 4 | HEXAGON NUT DIN 934 M6 | |

SPARE PART LIST PRO 600

| POS | QTY | DESCRIPTION | Draw.-No. |
|-----|-----|---------------------------------------|------------|
| 61 | 4 | SELF LOCKING HEXAGON NUT DIN 985 M6 | |
| 62 | 4 | SELF LOCKING HEXAGON NUT DIN 985 M8 | |
| 63 | 1 | HS SET SCREW CONE POINT DIN 914 M6x10 | |
| 64 | 8 | PARALLEL PIN DIN 6325 8M6X22 | |
| 65 | 2 | PARALLEL PIN DIN 6325 10M6X50 | |
| 66 | 2 | SPRING | ARU-2T-052 |
| 67 | 2 | SPRING PIN SIZE 3 | |
| 68 | 1 | SHOCK-ABSORBER | |
| 69 | 2 | SPRING PLUNGER | |
| 70 | 2 | NOTCH-STONE NLM 03250-22 | |
| 71 | 4 | SPRINGS | |
| 72 | 1 | HYDRAULIC UNIT | |
| 73 | 1 | FOOTPEDAL STEUTE GFSM 1Ö/1S | |
| 75 | 1 | HYDRAULIC FITTING MAVE08SR1/4A3C | |
| 76 | 1 | HYDRAULIC FITTING WH08SRA3C | |
| 77 | 1 | HYDRAULIC FITTING GE08SRA3C | |
| 78 | 1 | HYDRAULIC FITTING ET08SRA3C | |
| 79 | 2 | HYDRAULIC FITTING EW08SA3C | |
| 80 | 1 | HYDRAULIC TUBE 8X1.5MM | |
| 81 | 1 | REDUCTION PIECE RI1/2EDX1/4A3C | |

SPARE PART LIST PRO 600

| POS | QTY | DESCRIPTION | Draw.-No. |
|-----|-----|--|-----------|
| 82 | 6 | WASHERS DIN 125-B-6.4 ZINC PLATED | |
| 83 | 4 | BUTTON HEAD SOCKET SCREWS ISO 7380 M4x10 | |
| 84 | 4 | SELF LOCKING HEXAGON NUT DIN 985 M4 | |



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