INSTALLING THE "ON GRADE CONVERSION KIT" ON THE MODEL 210B-3,-4,-5 SRA

(Refer to "ON GRADE CONVERSION KIT" pages in Parts Book/Operators Manual)

To begin, the machine, which is set up in the "slab-rider" configuration, will have to have the drill systems dropped down in the horizontal position. Since the drill systems, in the horizontal position, will be below the wheels, you will either need to block up the wheels off the ground or move the machine over to the edge of a concrete slab at least 9" thick.

Turn off the air and disconnect the main air hose from the air compressor. Begin to disconnect the entire drill systems assembly from the main frame assembly of the machine.

1) Disconnect all hoses and tubing at the drill systems.
2) Remove both "raise and lower" cylinders (0520857 CYL).
3) Remove both lower tool bars (2-1/2" square tube - SRS 1649) and upper tool bar (black round tube - SRS 1634) and hinges (SRS 1635) by loosening all clamps (MFA0642).
4) Where the upper tool bar was, install the bushings (SRS 1662).
5) Take the conversion mast (SRS 1660) and match up the "ears" on it to the "ears" on the main frame mast. Bolt the conversion mast to the main frame mast.
6) Slide the upper tool bar (black round tube - SRS 1634), that was earlier removed, through the bosses on the conversion mast and the hinges; tighten setscrews (25590 BLT).

Move the mainframe to the opposite end of the feed systems.

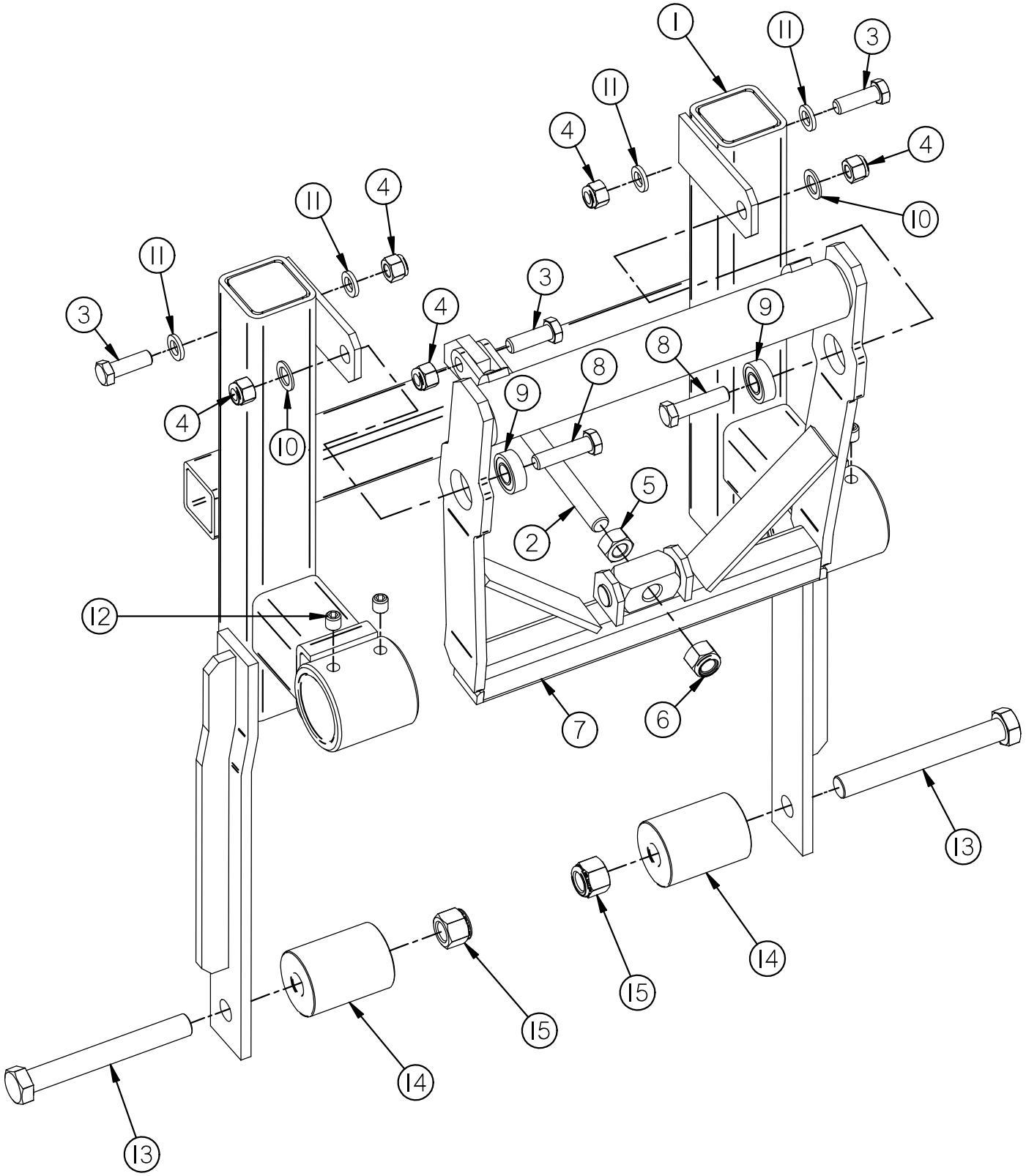
1) Lower the mast (by turning the large nuts on top of the mast - loosen ½" bolts on the sides of the mast first). Lower it down until you can slide the lower tool bar through the clamps on the feed systems (the one that is closest to the main frame) and the hinges (SRS 1635). Center the feed systems and tighten the clamps.

IMPORTANT: BE SURE TO CENTER THE CYLINDER MOUNTS (SRS 1620 & SRS 1621) AND POSITION THEM SO THAT THEY ARE POINTING STRAIGHT UP

2) Reinstall both "raise and lower" cylinders (0520857 CYL).
3) Ensure that the nuts on the adjustable clevis (SRS 1661) are backed away approximately 1" from either side of the auto align pivot (SRS 1659). This allows the drill systems to "float", allowing for changes in the subgrade and keeps the drill systems horizontal.
4) Reconnect all hoses and tubing.

Install both wheel assemblies on the outer tool bar close to the center of the frame. The wheels will ride on top of the slab. Adjust the height of the wheels to level the drills. Also, adjust the screw jacks on the machines main frame to level the other end of the drill systems. **IMPORTANT:** Loosen the ½" bolts on the sides of the mast before adjusting the screw jacks. Re-tighten the ½" bolts after adjusting the height.

ON GRADE CONVERSION KIT



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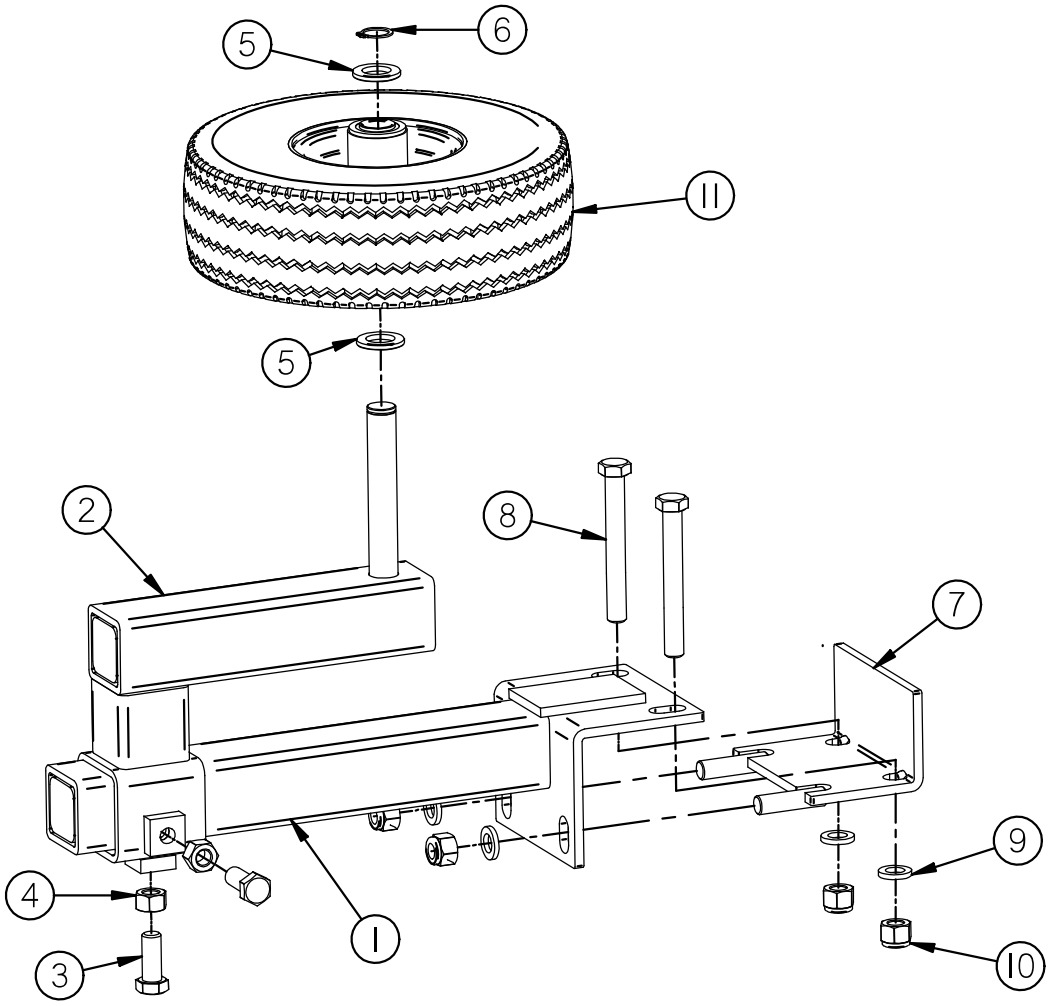
ON GRADE CONVERSION KIT

Item No.	Part No.	Quantity	Description
1	SRS1660	1	MAST CONVERSION
2	SRS1661	1	ADJUSTABLE CLEVIS
3	2562 BLT	3	1/2" NC X 1.50" HX HD TAP BOLT
4	2734NUT	5	1/2" NC NYLON INSERT LOCKNUT
5	2740 NUT	1	5/8" NC STD. HEX NUT
6	2743NUT	1	5/8" NC NYLON LOCK NUT
7	SRS1659	1	ALIGN PIVOT CONVERSION
8	2563 BLT	2	1/2" NC X 2.00" HX HD BOLT
9	04030BRG	2	5/8" X 1 3/8" BEARING WITHOUT FLANGE
10	2840WAS	2	5/8" MACHINERY BUSHING (14GA.)
11	2831WAS	4	7/8" OD X 1/2" ID WASHER 10GA.
12	25590 BLT	4	1/2" -13NC X 1/2" LG. SET SCREW
13	25997 BLT	2	3/4" NC X 6.0" HX HD TAP BOLT
14	SRS1662	2	ON GRADE CONVERSION BUSHING
15	2749NUT	2	3/4" NC NYLON LOCK NUT

GUIDE WHEEL ASSEMBLY
FOR ON GRADE CONVERSION KIT



Item No.	Part No.	Quantity	Description
1	SRU1336	1	SPINDLE ADJUSTOR MOUNTING BRACKET
2	SRU1335	1	SPINDLE ADJUSTOR
3	2560BLT	2	1/2" NC X 1.25" HX HD BOLT
4	2732 NUT	2	1/2" NC STANDARD NUT
5	2851 WAS	2	3/4" X 10 GA. WASHER
6	3038PIN	1	SNAP RING 3/4"
7	MFA0642	1	2-1/2" TOOL BAR CLAMP (5" WIDE X LONG BOLT)
8	2570BLT	2	1/2" NC X 4.00" HX HD BOLT
9	2831WAS	4	7/8" OD X 1/2" ID WASHER 10GA.
10	2734NUT	4	1/2" NC NYLON INSERT LOCKNUT
11	0202 WHL	1	4.10-3.50-4 TIRE-WHEEL

3-30-21

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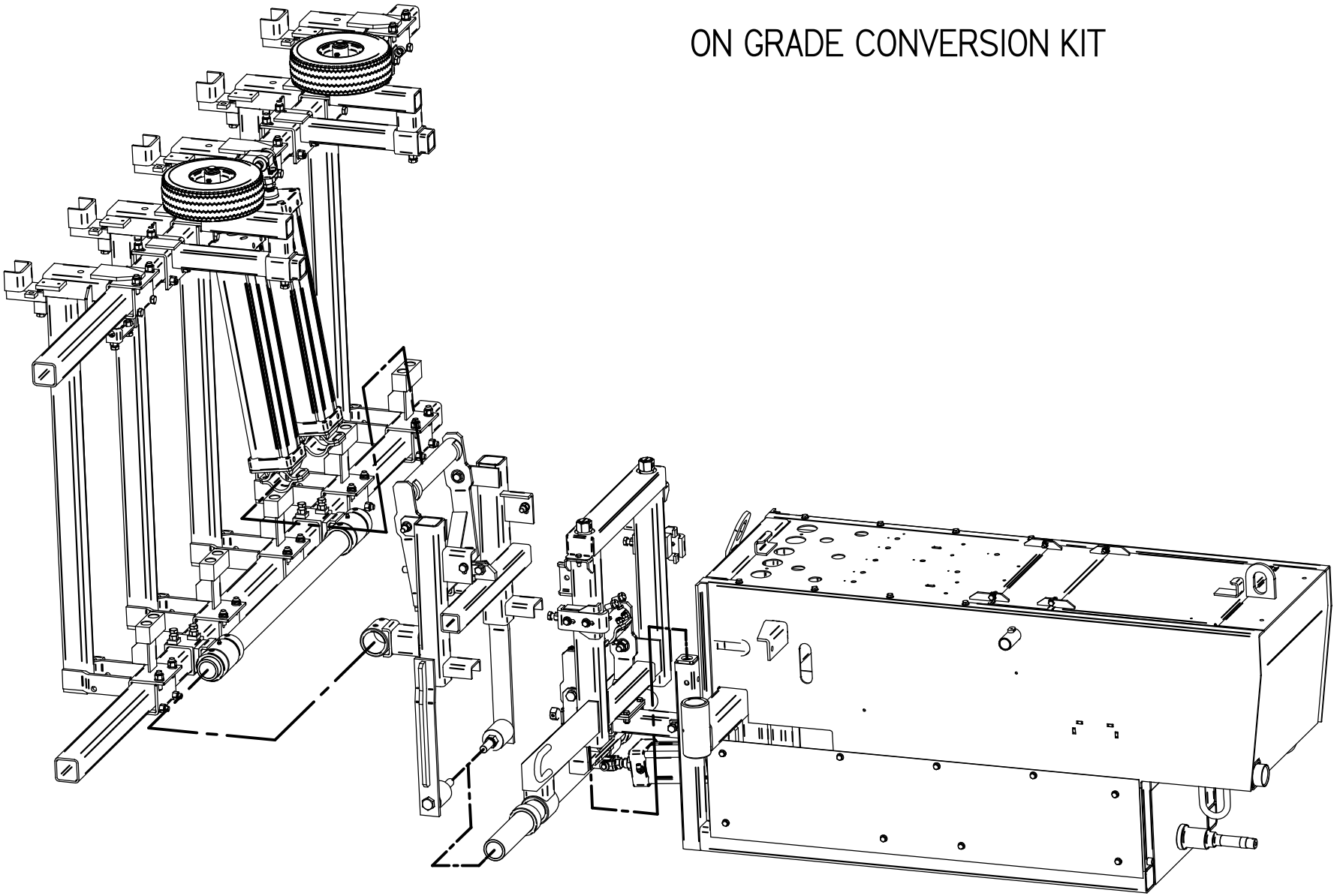
ON GRADE CONVERSION KIT



PICTURE SHOWS THE FEED BARS IN THE UP POSITION

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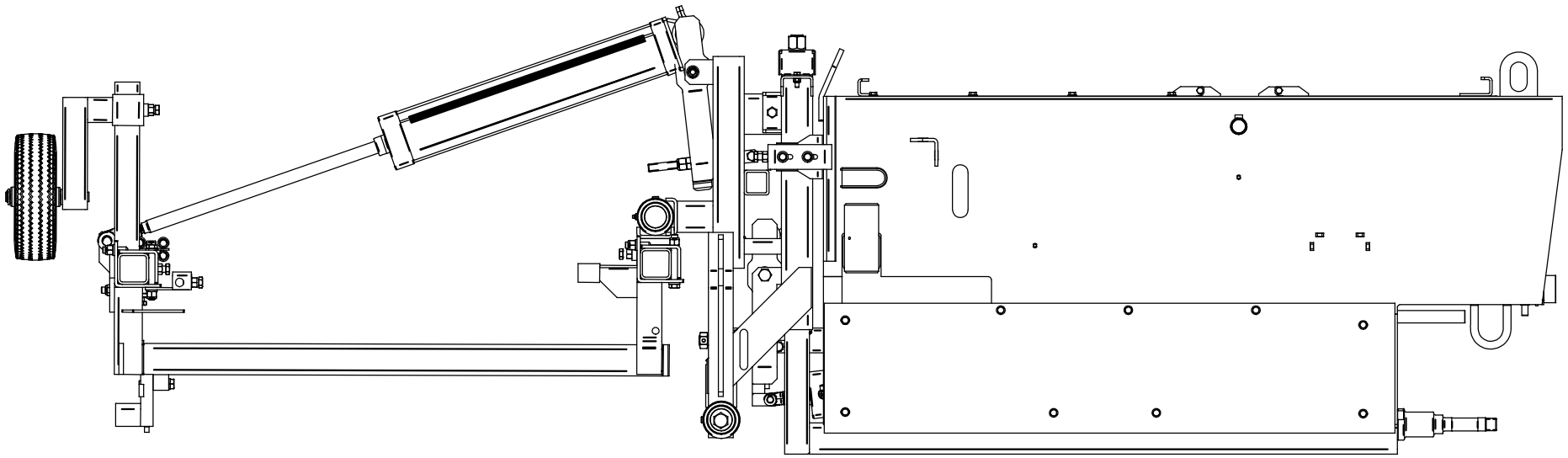
ON GRADE CONVERSION KIT



PICTURE SHOWS THE FEED BARS IN THE DOWN POSITION

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