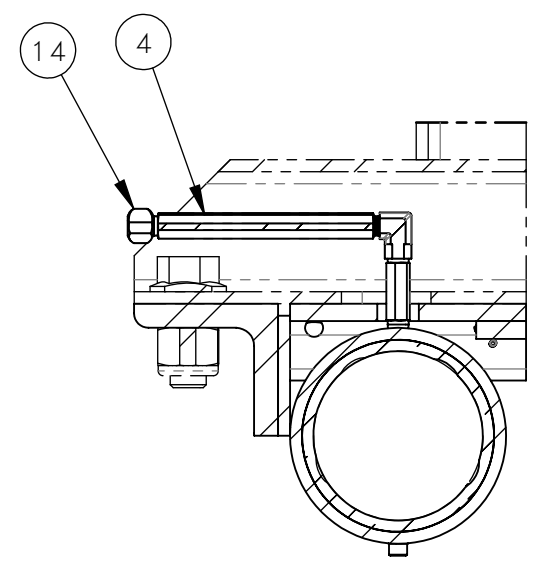
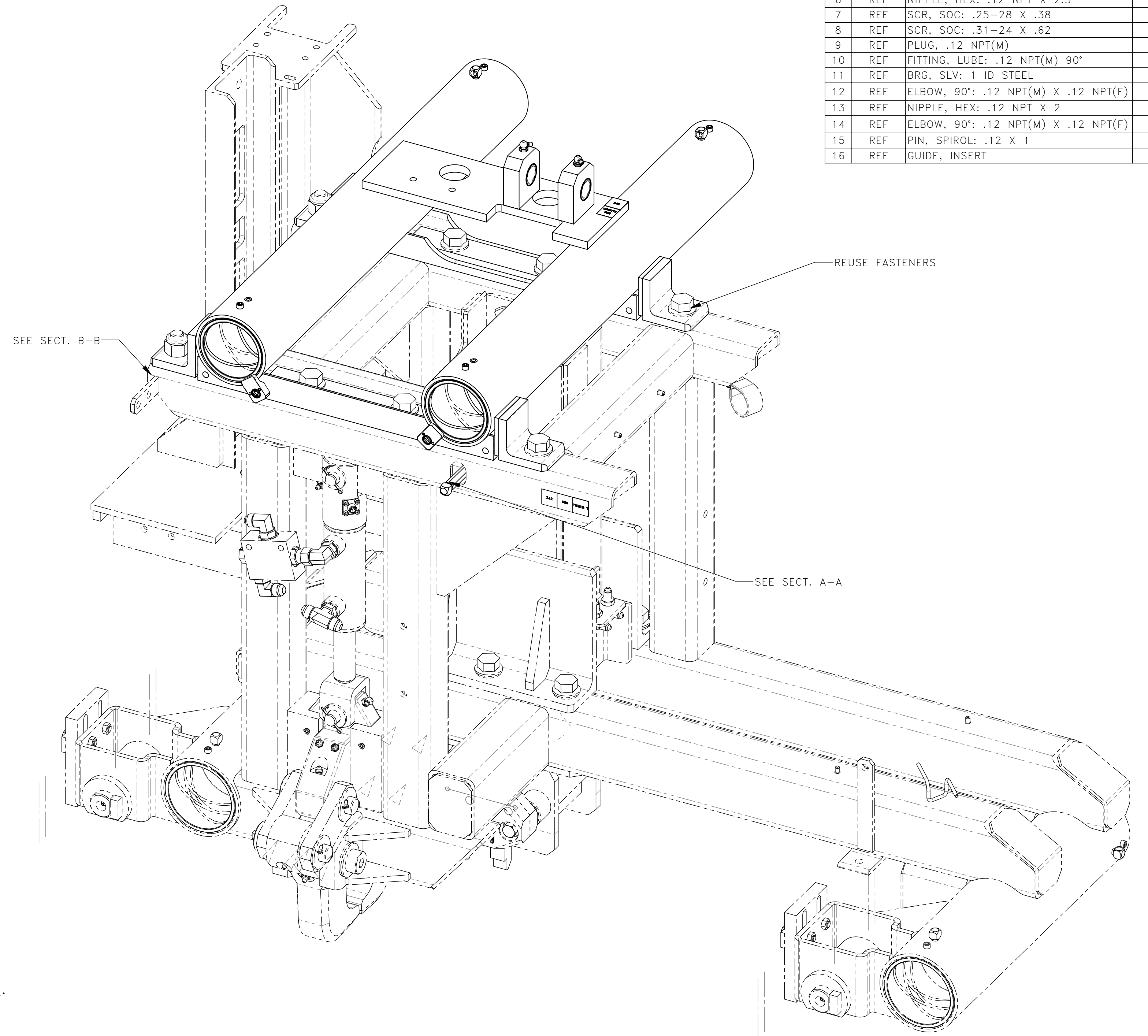
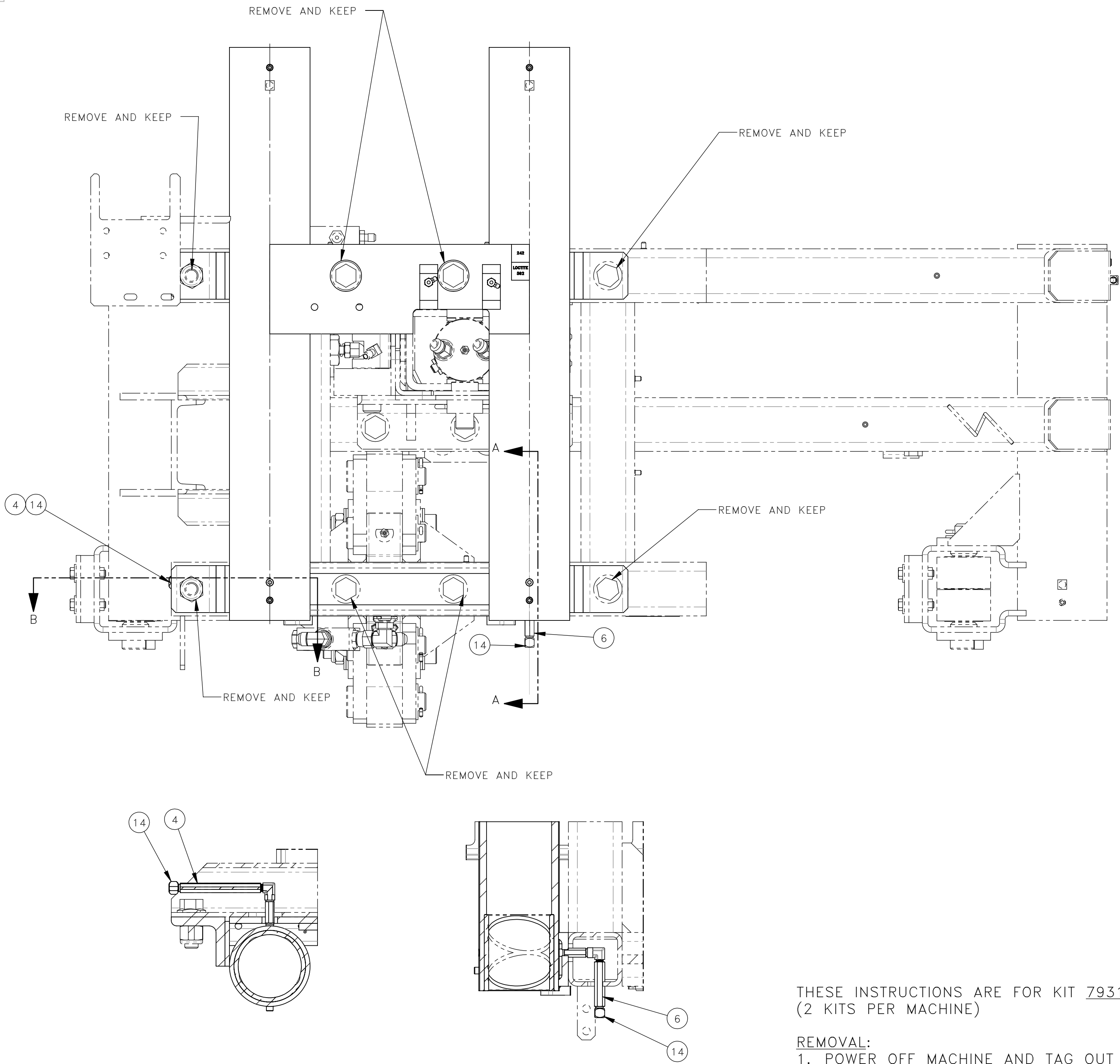
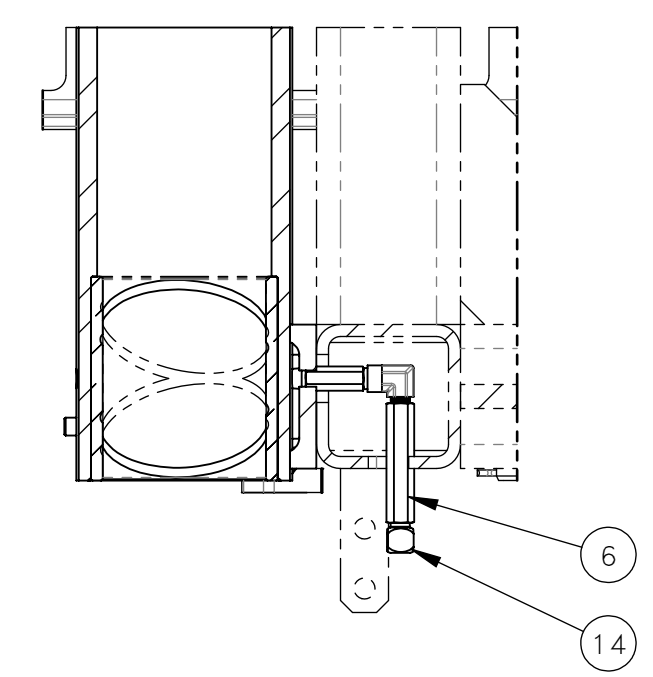


NO.	QTY	DESCRIPTION	PART NO.
1	REF	LOCTITE, 242	008806
2	REF	LOCTITE, 592	008807
3	REF	PLUG, .12 NPT(M) FLUSH	25005177
4	REF	NIPPLE, HEX: .12 NPT X 4.5	311433
5	REF	RETAINER, BEARING	397767
6	REF	NIPPLE, HEX: .12 NPT X 2.5	397973
7	REF	SCR, SOC: .25-28 X .38	400786
8	REF	SCR, SOC: .31-24 X .62	400802
9	REF	PLUG, .12 NPT(M)	400922
10	REF	FITTING, LUBE: .12 NPT(M) 90°	451214
11	REF	BRG, SLV: 1 ID STEEL	466025
12	REF	ELBOW, 90°: .12 NPT(M) X .12 NPT(F)	467671
13	REF	NIPPLE, HEX: .12 NPT X 2	467672
14	REF	ELBOW, 90°: .12 NPT(M) X .12 NPT(F)	472473
15	REF	PIN, SPIROL: .12 X 1	490696
16	REF	GUIDE, INSERT	780840



SECTION B-B



SECTION A-A

THESE INSTRUCTIONS ARE FOR KIT 793125.  
(2 KITS PER MACHINE)

**REMOVAL:**

1. POWER OFF MACHINE AND TAG OUT BEFORE PERFORMING CONVERSION.
2. DISCONNECT AND LABEL GREASE PORT HOSES FROM INSERT GUIDE.
3. REMOVE INSERT GUIDE. KEEP EXISTING FASTENERS.

**INSTALLATION:**

1. INSTALL NEW INSERT GUIDE WITH EXISTING FASTENERS & ITEM 1.
2. ATTACHED THE FITTINGS TO THE FRONT LOWER GREASE PORTS WITH ITEM 2 (SEE SECTION A-A AND B-B).
3. RECONNECT ALL LABELED GREASE HOSES TO PORTS WITH ITEM 2.
4. LOCTITE 242 ON ALL TAPPED HOLES.
5. LOCTITE 592 UDE ON ALL NPT'S AND HOSE CONNECTIONS.

REV	EN	DESCRIPTION	DATE	DRN
1	S927	NEW RELEASE	9-21	PR

DIMENSION TOLERANCES UNLESS OTHERWISE SPECIFIED

LINEAR	.XX=±.03	.XXX=±.010
ANGULAR	X' = ±1'	X.X' = ±.5'

SURFACE FINISH 125/√ NOT TO EXCEED SMOOTH ALL SHARP EDGES CLEAN ALL WELDS

THIS PRINT AND ALL INFORMATION WITHIN BELONGS TO RACINE RAILROAD PRODUCTS

**RACINE RAILROAD PRODUCTS**  
RACINE, WISCONSIN USA

DESCRIPTION  
INSTRUCTIONS, LEFT OR RIGHT INSERT GUIDE KIT

MATERIAL  
SEE BOM

USED ON	793125	SCALE	DATE
		1:4	09-30-21

DRN	CHK	APP	JOB NO	SHEET
PR			RD150003	1 OF 1

DWG SIZE	CATALOG	DWG NO
D	A	800362