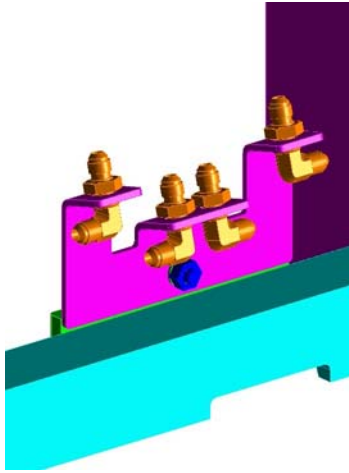
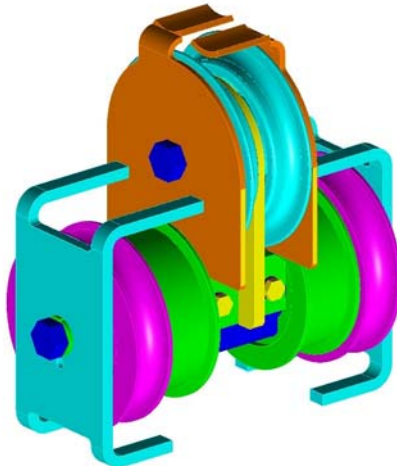


## Single to Double IHR Conversion Generic E Series Mast

1. Remove all IHR hoses from mast.
2. Remove carriage termination bracket, bolt and washer from carriage.
3. Remove fittings from old carriage termination bracket.
4. Install four 90° fittings to the new carriage termination bracket (two from SIHR on mast and two included with new kit).
5. Add new carriage termination bracket, bolt and washer to carriage.



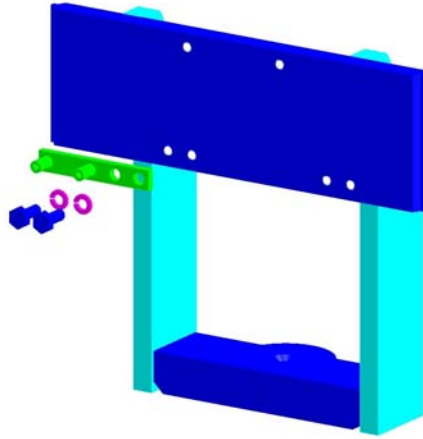
6. Remove bolt, washer, chain guard and spacer from each side of crosshead.
7. Add back to the crosshead the sheave, guard, washer and bolt in kit.



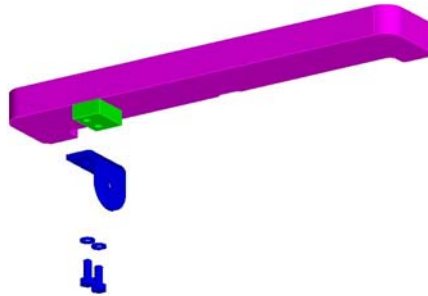
ENC: 1382	GENERIC SINGLE TO DOUBLE IHR CONVERSION INSTALLATION INSTRUCTIONS	DATE: 11/15/01
BY: MDODD		APP: BRIVES
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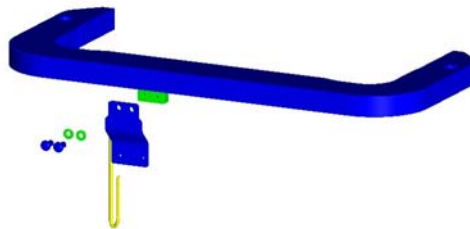
8. Add the following bracket to the back of the lower inner crossmember as shown:



9. Attach the following bracket to the bottom of the upper intermediate crossmember as shown:



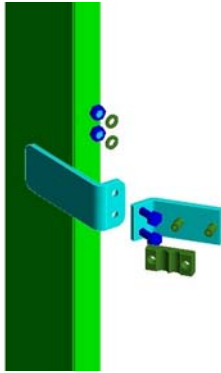
10. Attach the following bracket to the bottom of the upper outer crossmember as shown:



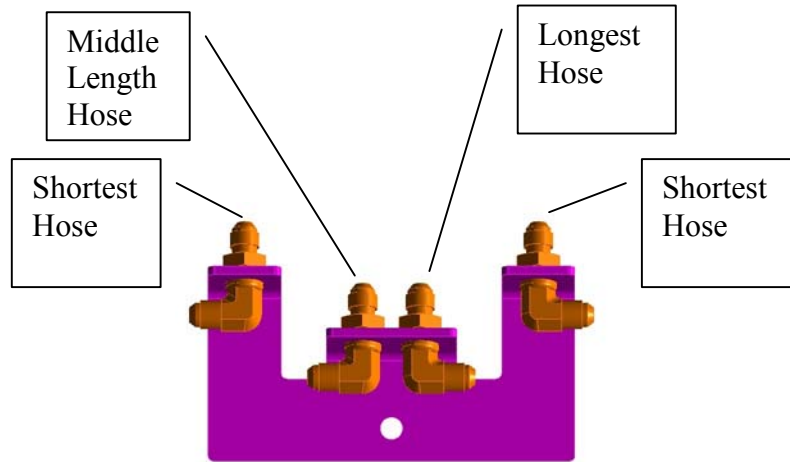
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11. Attach the following pieces to the left side of the outer weldment:

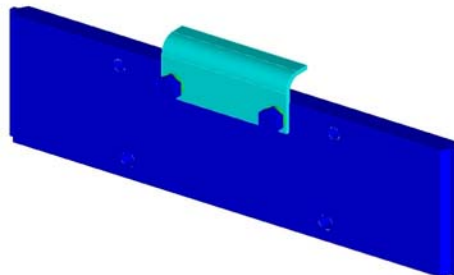


12. Attach hoses to the carriage termination bracket fittings as shown:



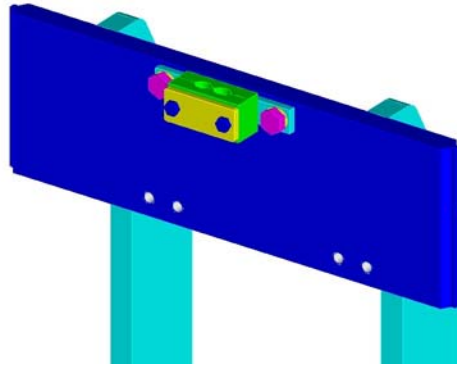
13. Route outside hoses over outside sheaves on crosshead and route middle hoses over sheaves above crosshead.

14. Pull the middle hoses over guard on middle inner crossmember shown here

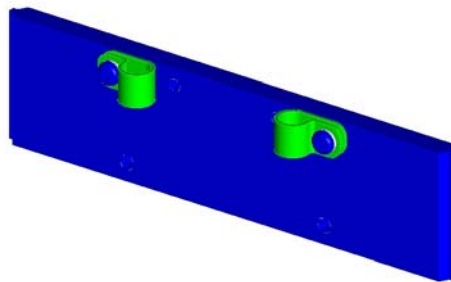


and route hoses down to lower inner crossmember. Tension hoses and clamp at bracket shown using clamps provided with SIHR:

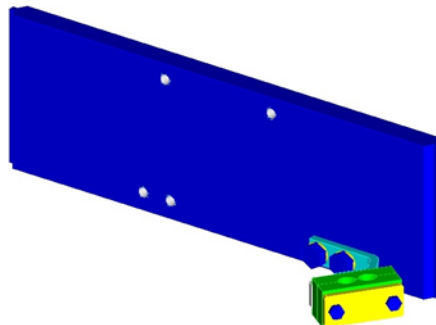
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15. Pull outside hoses down to middle inner crossmember and install hose clamps as shown to provide tension to hoses:



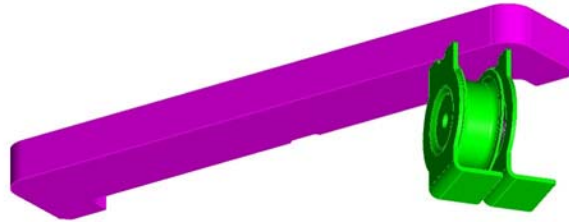
16. Route the outside right hose in front of the lower crossmember and the middle right hose behind the lower crossmember in gentle loops to the lower inner bracket shown below and loosely clamp using clamps provide with SIHR:



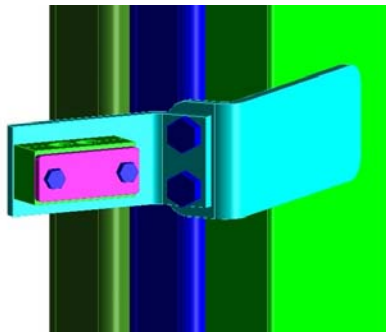
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17. Route hoses up to the sheave at the upper intermediate crossmember shown below:

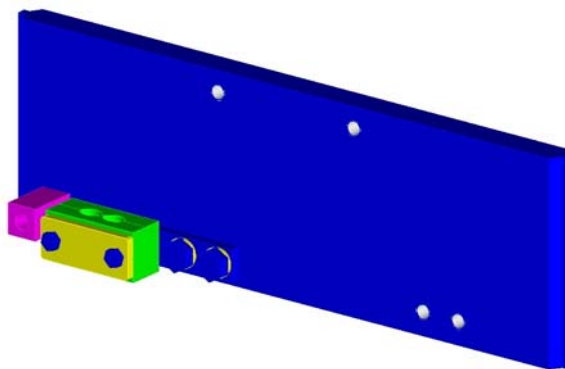


18. Route hoses down to the bracket on the outer weldment shown below:



19. Return to lower right side bracket and pull hoses through the bracket towards the bottom of the mast to provide tension in hoses between lower inner crossmember and middle outer crossmember. Tighten clamps to hold hoses in tension.

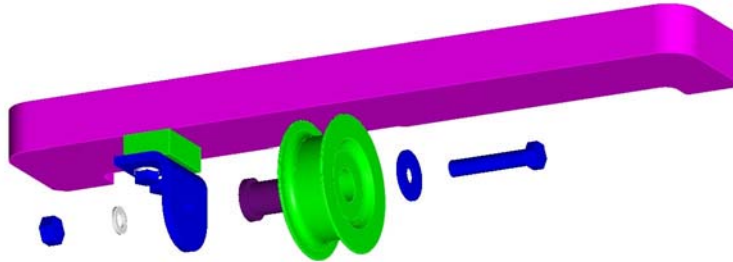
20. Route the outside left hose in front of the lower crossmember and the middle left hose behind the lower crossmember in gentle loops to the lower inner bracket shown below and clamp using clamps provided with new kit:



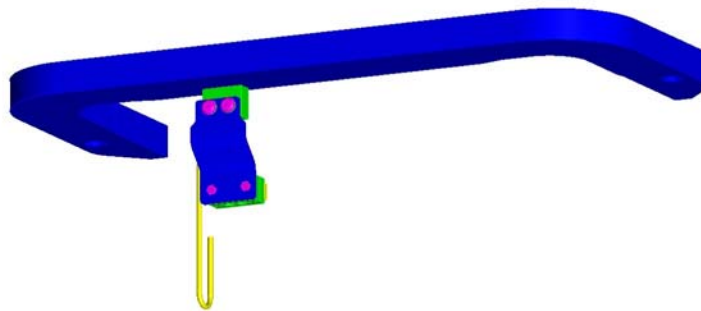
ENC: 1382	GENERIC SINGLE TO DOUBLE IHR CONVERSION	DATE: 11/15/01
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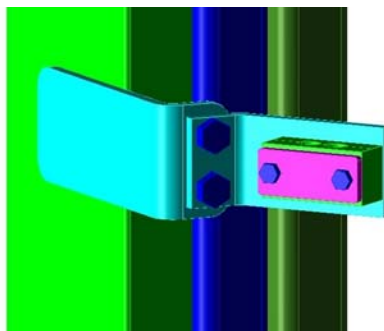
21. Route hoses up to the sheave at the upper intermediate crossmember shown below (install hoses onto sheave prior to installing sheave on bracket):



22. Route hoses down to hoses down to bracket attached to the upper outer crossmember. Tension hoses and clamp at bracket shown using clamps provided with new kit:



23. Route hoses through guide bar on the above bracket and route hoses down to the bracket on the outer weldment shown below:



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