







Husqvarna Construction Products North America

Instruction Sheet: Sealed Blade Shaft Kit

Purpose: Installation of Sealed Bladeshaft Kit for models shown. Note: Modification of frame is required for retrofit onto older models.

Models: Magnum Super Mag Special, Dimas FS6500, Magnum 38 Special, Dimas FS3800, Dimas FS4000E.

	Before starting up machine make sure you read these instructions and the operation manual, and are familiar with the operation of this machine.
	Wear Eye protection while performing any maintenance.
	WARNING: Before performing any maintenance, ALWAYS locate the machine on a level surface with the engine / motor OFF and the start switch in the OFF position, and the power source disconnected.
	Any persons not involved in the work should leave the area.
	The working area must be completely clear, well lit and all safety hazards removed (no water or dangerous objects in the vicinity).
	Retain this information for future reference, and parts orders.

Parts in Kit: Verify that all parts are present before beginning installation.

Parts Included in Kit 542 20 64-41
(14": Supermag, FS 6500, 38 Special, FS3800)

Part Number	Qty	Description
541 20 72-61	1	BLADESHAFT ASSY, SM-SP 14"
539 99 03-33	4	WASHER, LOCK 5/8 ZPLATE
539 30 06-20	4	BOLT, 5/8-11 X 1-3/4 HHCS GR
541 20 72-80	4	SPACER, BEARING, 3/8 THK BLA
542 20 11-24	1	INSTRUCTION SHEET (THIS DOCUMENT)

Parts Included in Kit 542 20 64-42
(20"-26": Supermag-40E, FS4000E)

Part Number	Qty	Description
541 20 72-62	1	BLDSHAFT ASSY, SM-SP, 40E 20/26"
539 99 03-33	4	WASHER, LOCK 5/8 ZPLATE
539 30 06-20	4	BOLT, 5/8-11 X 1-3/4 HHCS GR
541 20 72-80	4	SPACER, BEARING, 3/8 THK BLA
542 20 11-24	1	INSTRUCTION SHEET (THIS DOCUMENT)

Parts Included in Kit 542 20 64-43
(30"-36": Supermag, FS 6500, 38 Special, FS3800)

Part Number	Qty	Description
541 20 72-63	1	BLADESHAFT ASSY, SM-SP 30/36
539 99 03-33	4	WASHER, LOCK 5/8 ZPLATE
539 30 06-20	4	BOLT, 5/8-11 X 1-3/4 HHCS GR
541 20 72-80	4	SPACER, BEARING, 3/8 THK BLA
542 20 11-24	1	INSTRUCTION SHEET (THIS DOCUMENT)

Parts Included in Kit 542 20 64-44
(30"-36": Supermag-40E, FS4000E)

Part Number	Qty	Description
541 20 72-67		BLADESHAFT ASSY, 40 E/30-36
539 99 03-33		WASHER, LOCK 5/8 ZPLATE
539 30 06-20		BOLT, 5/8-11 X 1-3/4 HHCS GR
539 97 69-82		FLATWASHER, 5/8 SAE PLTD
541 20 72-80		SPACER, BEARING, 3/8 THK BLA
542 20 11-24	1	INSTRUCTION SHEET (THIS DOCUMENT)

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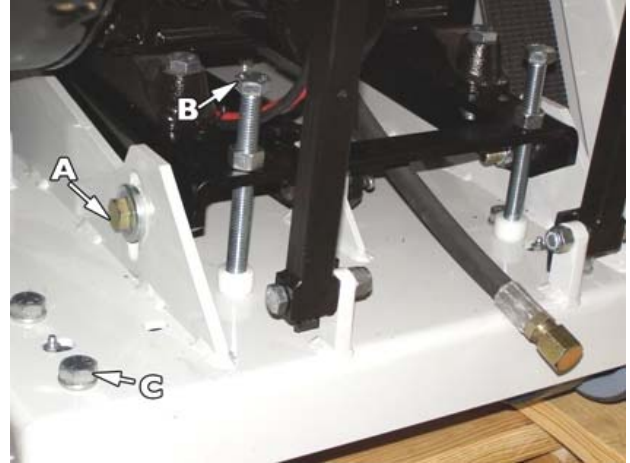
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Installation:

Remove Existing Blade Shaft:

1. Remove blade from machine, and lower blade shaft to lowest position.
2. Set start key switch to OFF (0) position, push emergency stop switch inward (to the stopped position).
3. Remove belt guard.
4. From **FIGURE 1**: Loosen two bolts, marked "A". Loosen jam nuts on bolt marked "B". Rotate the two bolts, marked "B" counter-clockwise to lower engine, and allow removal of drive belts. Remove drive belts.
5. From **FIGURE 1**: Remove the four (4) blade shaft bolts, marked "C", so blade shaft can be removed.
6. Using the hydraulic raise-lower control, slightly raise the saw to allow removal of the blade shaft assembly. Remove the blade shaft assembly from the working area.

Figure 1:



Frame Modification (Rework):

7. Two stiffener plates, under the front of the frame, must have material removed to allow installation of the sealed blade shaft. Position the saw so that the lower front side of the frame can be accessed. Secure the saw in this position.
8. Use the paper template (541 20 74-76) included in this kit to make the cut shown in **FIGURE 2**.
9. Cut out paper template (supplied), or use the paper template to make a template from sheet metal. Align template with bottom edge of stiffener plate, and inside front edge of frame. Use spray adhesive or other method to hold the template in position.
10. Scribe a line along the curved lower edge of the template.
11. Cut out the required area (See **FIGURE 2**). Paint newly cut area.
12. Repeat for other stiffener plate.

Figure 2:



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Install New "Sealed" Blade Shaft:

13. Position the new sealed blade shaft assembly so that it is near the original position of the "old" shaft, with the tapped bolt holes facing up.
14. Place two of the blade shaft spacers (P/N 541207280) at each set of threaded holes (See **Figure 3**).
15. Remove the saw from its "secured" position. Use the hydraulic raise-lower control to lower the saw down onto the blade shaft until it just touches the spacer plates. Then slightly raise the machine enough to take it's weight off of the blade shaft assembly.
16. Using the four 5/8-11UNC x 1-3/4 bolts (P/N 539 30 06-20) and lock washers (provided in kit), align threaded holes in blade shaft assembly, holes in spacers, and holes in frame, snug the bolts down.
17. Using a straight edge, such as a 4' level (Shown in **Figure 4**), place its edge across the outer face of the blade shaft collar on the end opposite the pulley, and check to verify that the outer face is parallel to the frame. Tighten the four 5/8" attaching "C" bolts so that the blade shaft position can still be adjusted.
18. Using the straight edge, align the blade shaft pulley, with the engine pulley. Using loctite, tighten the set screws over the keyway. On the remaining two set screws, "drill point" the shaft (see "drill pointing" below). Use low pressure compressed air to blow out the metal shavings from the hole.

NOTICE

Drill Pointing: Using a 1/4" (.25") drill bit through the threaded hole in the pulley, drill approx 1/32" to 1/16" deep into the shaft. The setscrew will then be tightened so that it's point will rest inside this recessed area. This should eliminate pulley loosening from shaft.

Figure 3:

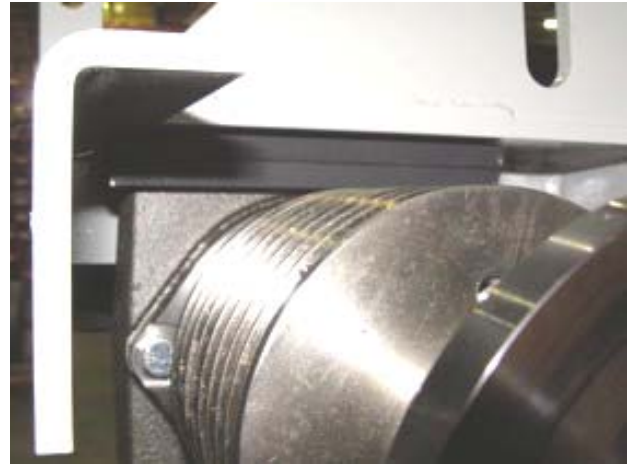


Figure 4:



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19. Using loctite, install & tighten the two remaining set screws (See **Figure 5**).
20. Finish tightening the four 5/8" blade shaft attaching bolts "**C**". Torque to 140 lbf-ft (189 N-m).
21. Install belts and raise engine base to tension belts (See **Figure 1 & Step 4**), hand tighten the "**A**" bolts, then tighten the bolts "**B**" to tension the belts. Note: If the belt tension is not uniform for all belts, bolts "**B**" may be adjusted up or down to provide equal tension for all belts (the two "**B**" bolts should be kept within one revolution of each other. Tighten the jam nuts, on the "**B**" bolts, against the engine base. Tighten the two "**A**" bolts. Reinstall all guards.

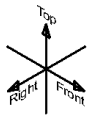
Figure 5:



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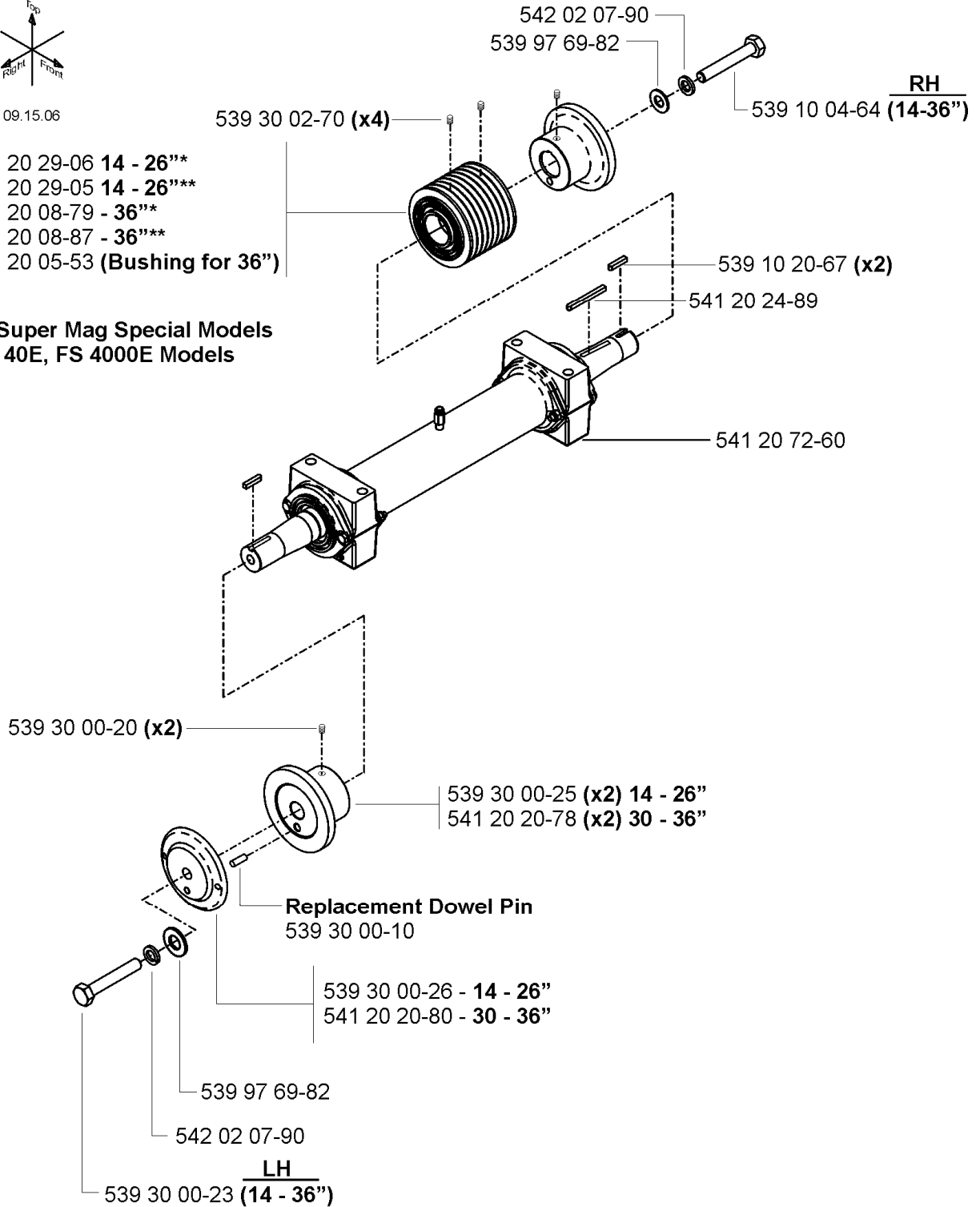
Spare Parts List Diagram 1:



09.15.06

- 541 20 29-06 14 - 26^{**}*
- 541 20 29-05 14 - 26^{**}*
- 541 20 08-79 - 36^{**}*
- 541 20 08-87 - 36^{**}*
- 541 20 05-53 (Bushing for 36^{**})

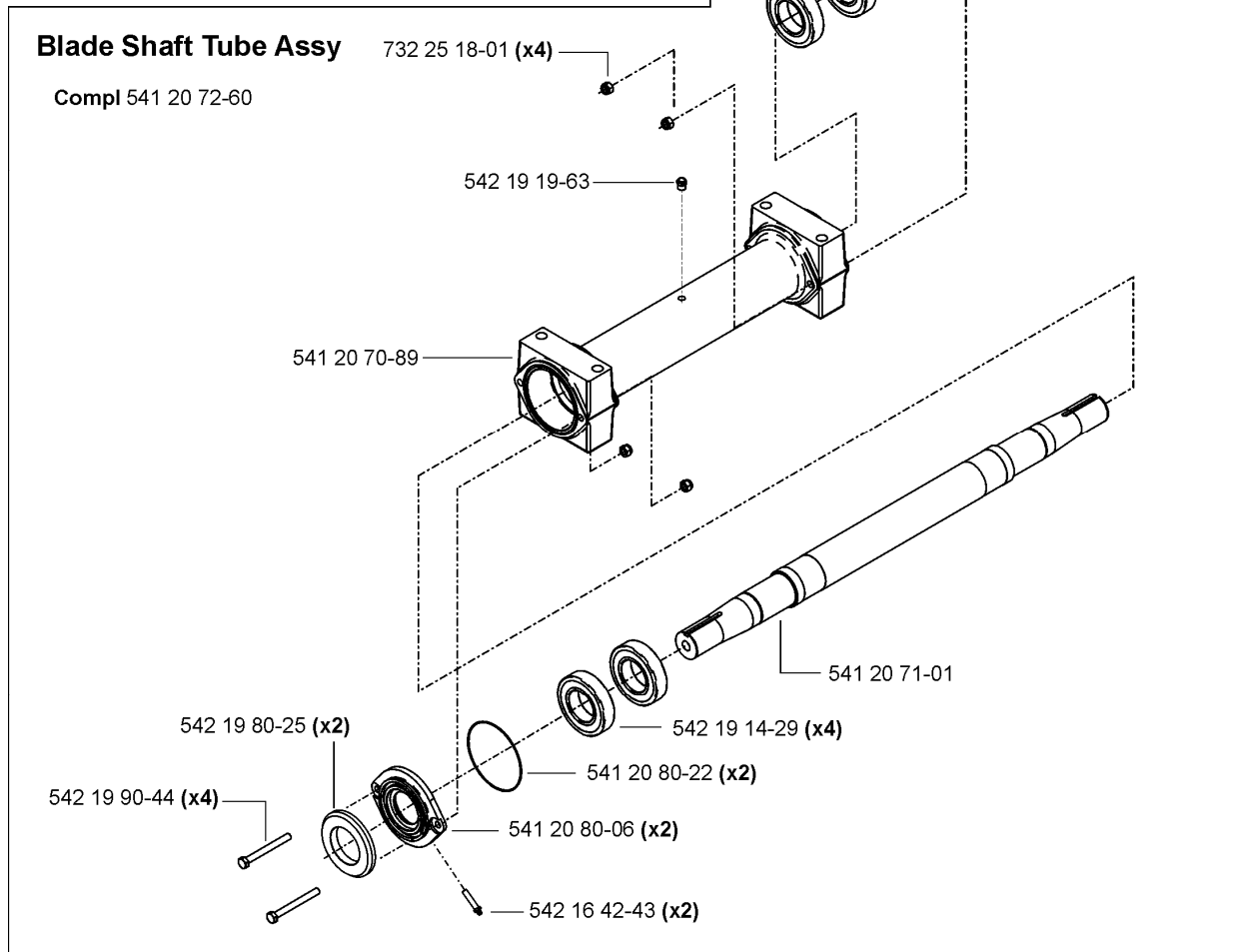
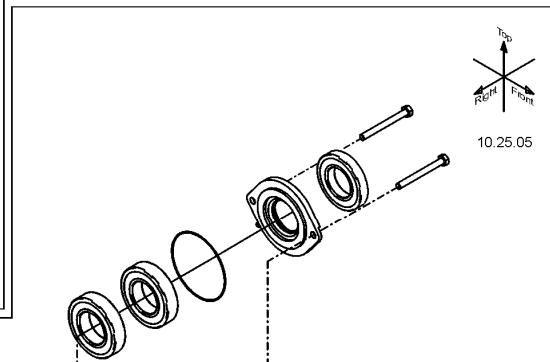
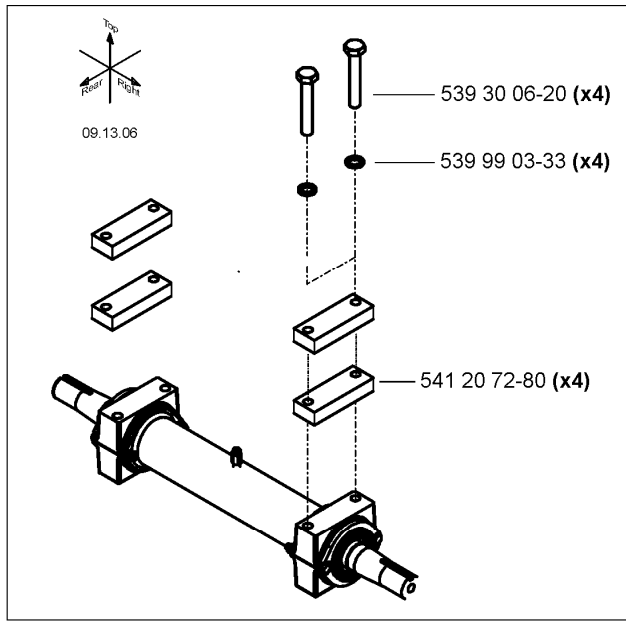
* For Super Mag Special Models
 ** For 40E, FS 4000E Models



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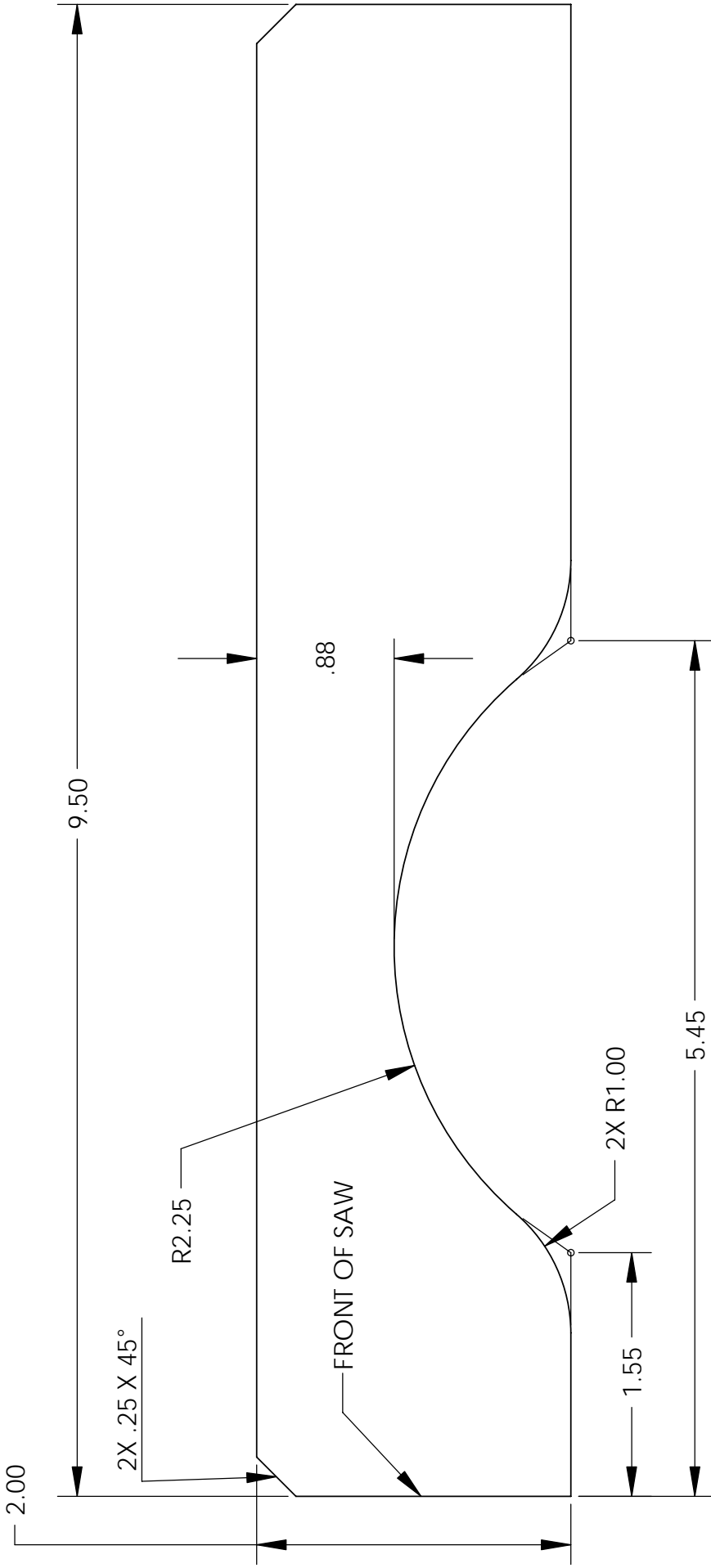
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Spare Parts List Diagram 2:



REVISIONS

REV.	DESCRIPTION	ECO	DATE	BY	APP



Husqvarna Husqvarna Construction Products		North America Olathe, KS
TITLE: TEMPLATE OF 541207139 STIFFENER BAR		SIZE DWG. NO. REV A 541207476 -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ±1/16 ANGULAR ±1° ONE DECIMAL PLACE ±.060 TWO PLACE DECIMAL ±.030 THREE PLACE DECIMAL ±.015	NAME RMK DATE 5-22-06 DRAWN BY CHECKED BY RELEASE ECO 7258	THIRD ANGLE PROJECTION:
GENERAL NOTES: PARTS TO BE CLEAN AND FREE OF BURRS. BREAK ALL SHARP EDGES. MATERIAL		SCALE: 1:1 SHEET 1 OF 1

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