



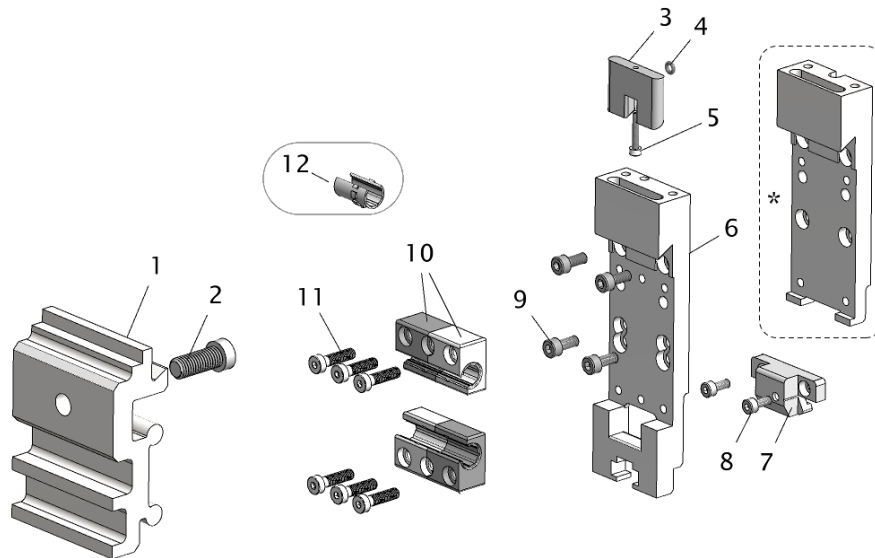
Follow all company safety procedures when working with knifeholders.

Blades are sharp – may cause bodily harm.

Wear protective gear or use tools when removing and handling blades.

Interchangeable parts

The Tidland DuraGlide bearing mount system is interchangeable with the standard guide bar setup used with Tidland knifeholders. The DuraGlide guide bar is typically pre-drilled and cut to length to match your existing system. Parts supplied for a retrofit include:



Item	Description	Class II Auto		Class III Auto		Class II Manual	
1	Guide bar extrusion	270020956	1	270020956	1	270020956	1
2	Soc hd, low head 3/8-16	270023032	—	270023032	—	270023032	—
Kit Part Numbers		270023373		270023374		270022477	
3	Brake shoe	27L531758	1	27L531758	1	27L531758	1
4	O-ring (Parker 2-006)	27L130136	1	27L130136	1	27L130136	1
5	Screw, brake shoe adjustment	27L598977	1	27L598977	1	27L598977	1
6	Backplate	270022398	1	270022407	1	270022406*	1
7	Dovetail stop	270022465	1	270022470	1	—	—
8	Soc hd, low head	M4 x 10mm	27L130184	2	—	—	—
		M5 x 12mm	—	—	270022505	2	—
9	Soc hd cpscr	M5 x 12mm	27L130467	4	—	27L130467	4
		M6 x 12mm	—	—	27L250116	4	—
10	Bearing ** (includes liners)	270022463	2	270020869	4	270022463	2
		270022462	2	—	—	270022462	2
11	Soc hd, low head M5 x 20mm	270022475	6	270022475	8	270022475	4
12	Bearing liners (replacement)	270024599	—	270023370	—	270024599	—

* Class II Manual KH only: Uses standard backplate — 360 degree blade guard not available.

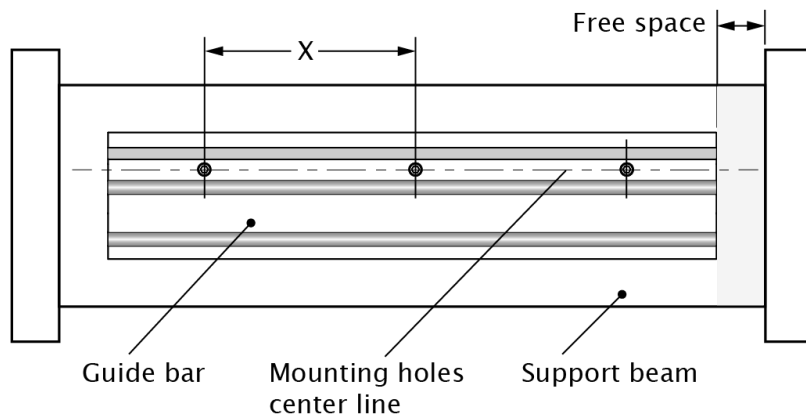
** Class II bearing is made up of two modified bearing pieces and sold only as a set; set includes liners.

Install guide bar on support beam



The guide bar must be straight within 0.010" (0.25 mm) on a rigid and vibration-free support.

Avoid scratches or dents to the guide bar during installation.



Existing installation

Remove your guide bar and replace with the DuraGlide guide bar. Use the low-head socket head cap screws provided with your retrofit kit.

New installation

1. Recommended free space — Class II: 3" (76.2 mm)
Class III: 4" (101.6 mm)
2. Determine the center-to-center distance between the mounting bolt holes (**X**) on the guide bar. Standard pre-drilled dimension is 12" (304.8 mm).
3. Drill and tap support beam for standard pre-drilled guide bar: 3/8"-16 NC holes.*
4. Use only low-head socket head bolts to mount guide bar.

* Unless using non-standard bolt size.

If bearings bind on the guide bar

Knifemaker movement should be smooth along the length of the guide bar. If the bearings drag or catch, check the guide bar for debris and wipe it clean. Use a light coating of dry silicone lubricant spray; let dry and wipe off.

Serious binding indicates:

- possible damage to the guide bar
 - the guide bar may not have been installed per the specifications above
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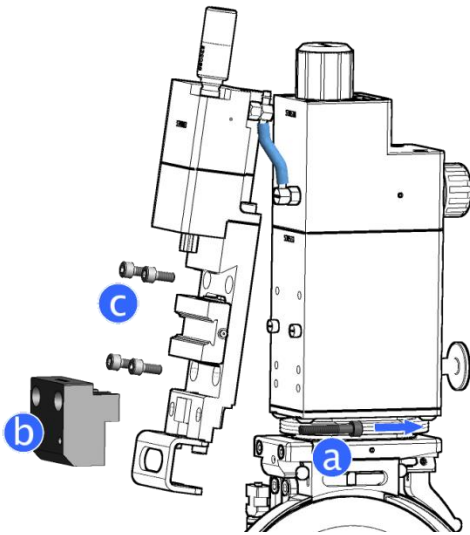
Maintenance

The bearing liners act as wipers and help to keep the guide bar clean. Check for build-up on the guide bar at regular intervals, which will vary depending on your slitting environment.

Lubricate the guide bar periodically with a silicone dry film lubricant. Tidland recommends using *Dow Corning 557 Silicone Dry Film Lubrication* to assure smoother knifemaker movement. Follow the manufacturer's instructions for use.

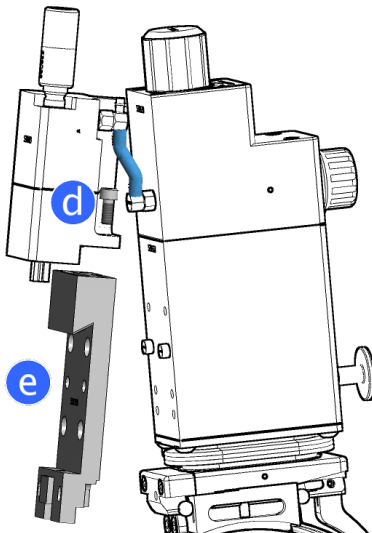
Remove the existing guide bar mount assembly from the knifeholder

Gib or *EasyGlider* mount

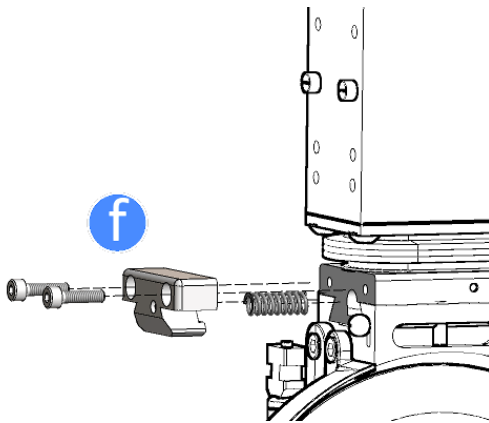


1. Remove two screws (a) that secure item (b) gib or stop block, depending on your mount type.
2. Remove four screws (c) to detach mount assembly from the knifeholder. Keep screws for re-use.

If you have an *EasyGlider* mount, you can leave the bearing on the backplate during removal. You will be using a different backplate with the DuraGlide.



3. Remove two screws (d) to detach backplate (e). Keep screws for re-use.



4. **Automatic knifeholders only:**
Remove two screws and dovetail stop (f).

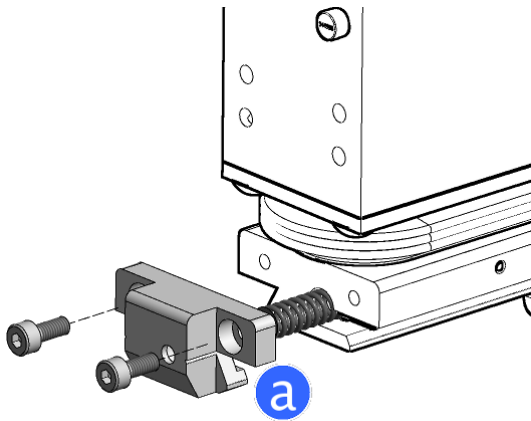
Discard the screws. Keep the spring; you will need it when installing the modified dovetail stop and different screws supplied with the DuraGlide kit.

Install the DuraGlide mount assembly

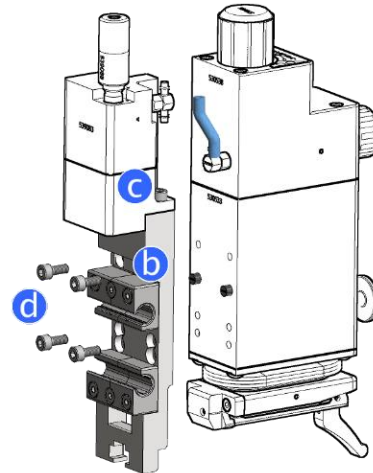
Gib or EasyGlider mount

Note: The DuraGlide backplate is designed to accommodate the 360° Blade Guard cartridge for Automatic knifeholders only.

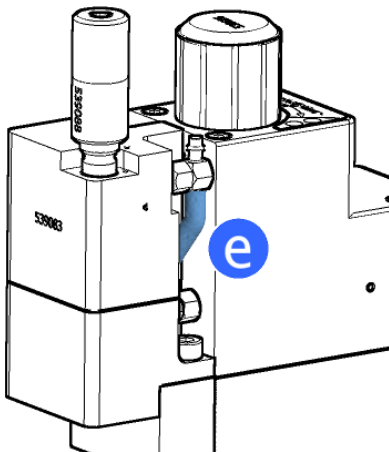
Class III: You may need to loosen the bearings in order to install screws (d). After the backplate is mounted to the knifeholder, put the knifeholder on the short piece of guide bar (supplied with kit), align the bearings, checking for smooth movement, and tighten them down.



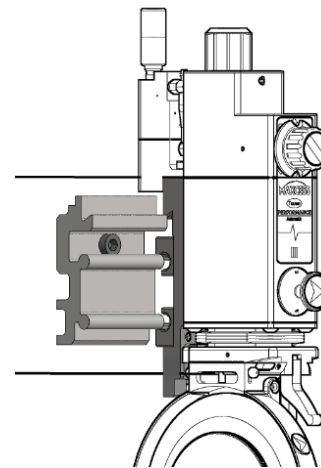
1. **Automatic knifeholders only:**
Install the spring and modified dovetail stop (a). Use the two screws supplied with the kit.



2. Attach the pre-assembled mount components (b) to the top block (c).
3. Secure the mount assembly to knifeholder with four screws (d).



4. Reconnect air hose (e) if detached during the retrofit.



5. Position the knifeholders on the DuraGlide guide bar and lock them in place.



AMERICAS
Tel +1.360.834.2345
Fax +1.360.834.5865
sales@maxcessintl.com
www.maxcessintl.com

EUROPE, MIDDLE EAST
AND AFRICA
Tel +49.6195.7002.0
Fax +49.6195.7002.933
sales@maxcess.eu
www.maxcess.eu

CHINA
Tel +86.756.881.9398
Fax +86.756.881.9393
info@maxcessintl.com.cn
www.maxcessintl.com.cn

INDIA
Tel +91.22.27602633
Fax +91.22.27602634
india@maxcessintl.com
www.maxcess.in

JAPAN
Tel +81.43.421.1622
Fax +81.43.421.2895
japan@maxcessintl.com
www.maxcess.jp

KOREA, TAIWAN,
AND SE ASIA
asia@maxcessintl.com
www.maxcess.asia

