

**PARTS LIST FOR**  
**MORSE P/N 1051-P COVER SET, CHAIN & GEAR, 185HD**

**A. ASSEMBLY INSTRUCTIONS FOR MODEL 185A-HD:**

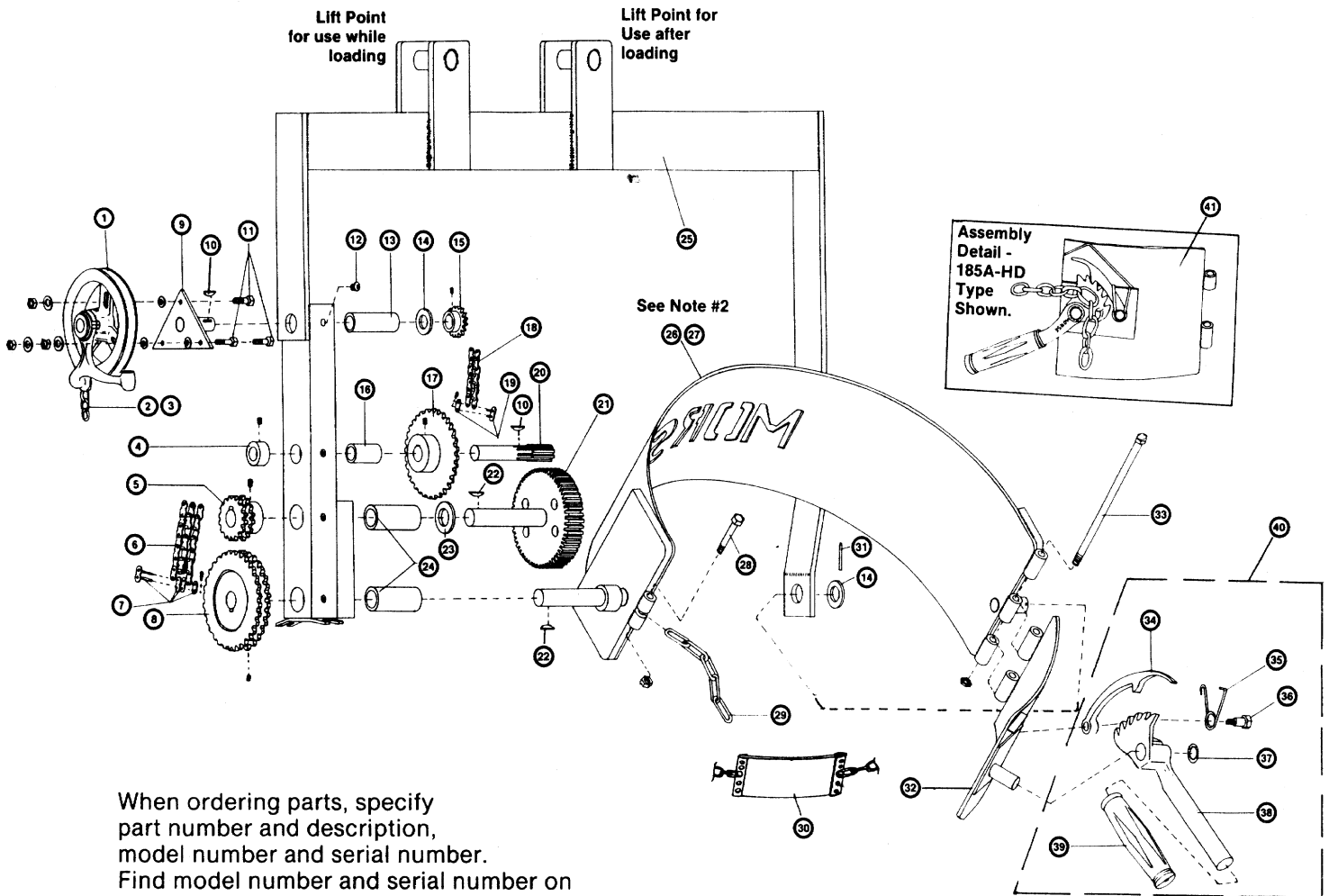
1. Remove #40d roller chain (6) at master link (7), loosen and remove 16t 40d sprocket (5) and 32t 40d sprocket (8). Remove #35 roller chain (18) at master link (19), loosen collar (4). Next, disconnect saddle, remove woodruff key (22) from saddle shaft, knock out roll pin (31) from idler shaft and proceed to pull out saddle (26). Remove woodruff key (22) from spur gear shaft, pull out spur gear (21). Finally, remove pinion gear (20) and 36t sprocket (17).
2. Place inner cover (item 1) in line with holes previously drilled in the power arm (if no previous holes have been drilled out see attached sheet for drilling instructions). Connect inner cover with the two bolts provided (item 5). Replace pinion gear (20) and 36t sprocket (17), tighten collar (4), reattach #35 roller chain (18) with master link (19). Next, replace spur gear (21), attach woodruff key (22), and tighten 16t 40d (5) sprocket.
3. Place outer cover, saddle side (item 2) over appropriate holes so it goes over inner cover and is flush with it. Attach covers together with two screws (item 4) mounted vertically (see diagram).
4. Next, reattach saddle (26), place drive shaft through bearing (24), attach woodruff key (22), tighten down 32t 40d sprocket (8). Reconnect #40d roller chain (6) with master link (7). Now place idler shaft through idler angle support and replace roll pin (31).
5. Finally, place outer cover (item 3) over saddle side cover (item 2). Attach covers using remaining tek screws (item 4), two on top and two vertically on end (see diagram).

ITEM	QTY	P/N	DESCRIPTION
1	1	2553-P	COVER, INNER, 185HD, 285HD
2	1	2554-P	COVER, OUT, SADDLE SIDE, 185HD
3	1	2557-P	COVER, OUT, 185HD
4	6	193-P	SCREW, TEK, 12-14 X ¾" 3 PT
5	2	2385-P	5/16 - 24 X ½ HHCS GR 5

**PARTS DIAGRAM FOR  
MORSE MODEL 185-HD SERIES HEAVY DUTY KONTROL-KARRIERS  
MODELS 185A-HD, 185B-HD, 185C-HD, 185D-HD.**

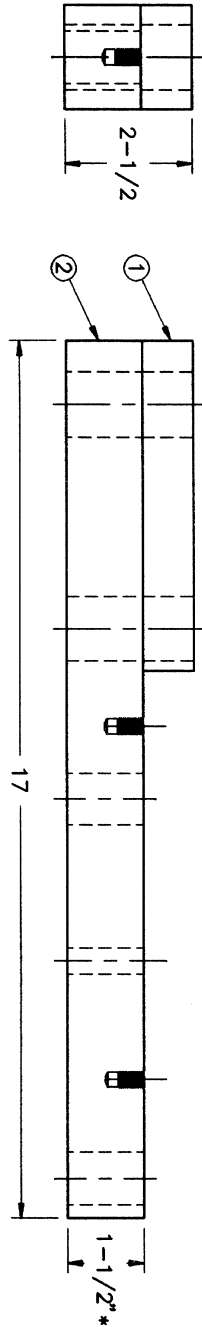
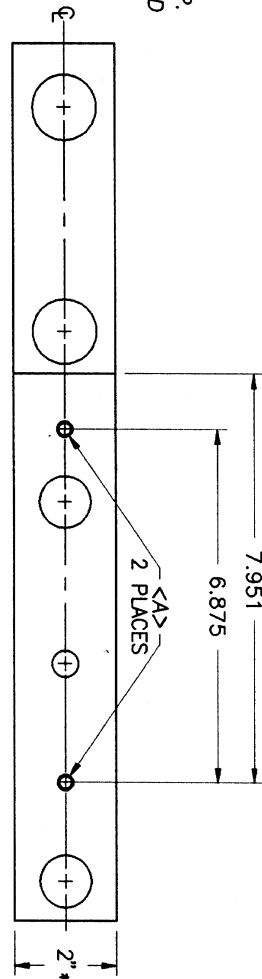
See opposite page for part numbers and descriptions.

The Parts shown are mostly of the style for #185A-HD.  
Some parts for 185B-HD, 185C-HD and 185D-HD may differ in appearance.



TOLERANCE  
.XXXX ±.0005

<A>: DRILL "M" DIA, 0.70" DEEP.  
TAP 5/16-24 FULL THREAD  
USING FORMING TAP.



ITEM #	PART NO.	QTY	DESCRIPTION	UNLESS OTHERWISE SPECIFIED	REVISION	DATE EFFECTIVE	INI
2	1419-P	1	POWER ARM BODY, HD	FRACTIONS ± 1/32 .XXX ± .005			
1	1418-P	1	POWER ARM BLOCK, HD	ANGLES ± 1' .XX ± .02			
				* = STOCK SIZE			

TITLE: POWER ARM, HD  
PART #: 1417-P

PART FOR: 185HD, 285HD

DRAWN BY: RCM  
SCALE: 1/3

DATE: 09-18-96  
PAGE: 8

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285A-HO  
Shown, However,  
Same detail  
for 185A-HO

