



Fig. 21 - Knife Indexing Adjustment

1. Adjusting Bolt
2. Thrust Bolt
3. Wedge
4. Heavy-Duty Bolt
5. Heavy-Duty Nut

Knife Indexing for Registering

The knife indexing is correct when the center of the knife sections are in line with the points of the guards at either end of the knife stroke.

The length of the knife stroke is fixed and *cannot* be altered. However, the position of the knife sections relative to the guards can be adjusted so that it indexes correctly.

To adjust the knife indexing, proceed as follows:

Turn the flywheel at the back of the table and the piston is at either end of its stroke.

Referring to Fig. 21, remove bolt, No. 1, connecting piston to away-bar block, No. 1.

Position the knife so that the knife sections are aligned with the points of the guard.

Loosen clamp, No. 1, and adjust lock assembly, No. 2, to align hole with away-bar block, No. 1, and remove bolt, No. 1. Install the nut by hand.

Rotate the flywheel and the piston and knife are at mid-stroke. Tighten nut on bolt, No. 1, to 40 to 70 ft.-lbs. torque.

IMPORTANT: Nut must be tightened with knife at mid-stroke.

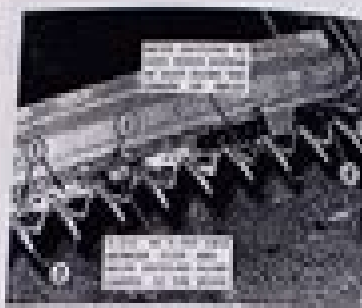


Fig. 22 - Knife Assembly

1. Knife Housing
2. Guide
3. Hold-Down Clips
4. Knife Strip

Knife Clearance

The knife assembly should be checked periodically for broken or damaged sections and to check the clearance along the length of the knife.

The clearances are shown in Fig. 22. These can be adjusted by repositioning the guards, No. 2, and the hold-down clips, No. 3, with a suitable tool.

Knife Installation

If at any time the knife is removed, the following *level* must be observed when re-installed.

The bolt connecting the knife strip, (knife head assembly) No. 4, Fig. 22, to the away-bar must be tightened to 40-70 ft.-lbs. torque when the knife is in the center of its stroke.

IMPORTANT: This torque must not be exceeded and the knife must be at mid-stroke.

SPECIAL NOTE

INSTALLATION OF HEAVY-DUTY NUTS (Accessory for 1675 and 1685 Tables)

This special note refers only to those a heavy-duty nut is ordered for 16 ft. and 18 ft. tables and is **FIRST** installed.

NOTE: When heavy-duty knife is ordered as Accessory, the clamps required must be ordered as a separate item, in addition to the knife.

To install the heavy-duty knife, proceed as follows:

At the knife assembly, remove the air-range bolts and nuts retaining the knife clips, No. 5, Fig. 22, and insert a .003" spacer under each clip.

Insert these all the way along the knife assembly. Install the heavy-duty knife into the guards, No. 1, Fig. 22, and under the clips checking as it is installed that it is free to move without binding.

Any binding of the knife guards can be corrected by repositioning the guard with a suitable tool sufficient to clear the knife sections.

The away-bar **MUST** be realigned with the knife strip, No. 4, Fig. 22.

To do this, the away-bar pivot assembly must be removed from the mounting bracket and the top alone is the assembly relocated and added to the lower alone to raise the away-bar .003".

The procedure for dismantling the away-bar pivot assembly is detailed in "Lubrication and Maintenance" section, and shown in Fig. 23. The only exception being, there is no necessity to loosen nut, No. 5, Fig. 23.

On completion of the heavy-duty knife installation, check the knife indexing and adjust if necessary, as described previously.

HEEL

The reel is driven through the sprocket



Fig. 23 - Reel Drive Belt

1. Reel Drive Pulley
2. Reel Drive Belt
3. Flywheel Pulley
4. Adjusting the reel belt
5. Flywheel Pulley
6. Separation Time
7. Reel Drive Pulley and Flywheel Assembly

and pulley assembly, No. 7, Fig. 23, which transmits the drive to the reel drive belt, No. 2, and hence to pulley, No. 1.

Reel Drive - Sprocket and Pulley Assembly

The sprocket and pulley assembly, shown in Fig. 24, provides a variable speed drive for the reel by reversing double sprocket, Nos. 3 and 4, Fig. 24, and by changing pulley, No. 1.

The double sprocket comprises sprocket, No. 4, Fig. 24, with 17 teeth and sprocket, No. 3, with 12 teeth. The sprocket can be reversed on its shaft from that shown in Fig. 24 when a reduction is required in speed.

The two sheaves comprising pulley, No. 1, Fig. 24, are separate and can be opened or closed by inserting shims between the two halves, thereby increasing or decreasing the driving diameter for the reel drive pulley.

A total of eleven spacers are supplied. These are .003" thick and two .002" thick.

Referring to Fig. 23 (top left), when the shims, No. 8, are located between the two sheaves, Nos. 1 and 2, the drive belt, No. 2, is located at the bottom of the groove and the driving diameter of the pulley is reduced.

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Table of Contents Massey Ferguson 36 Service Manual

1. Understanding the eBook Massey Ferguson 36 Service Manual
 - The Rise of Digital Reading Massey Ferguson 36 Service Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Massey Ferguson 36 Service Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Massey Ferguson 36 Service Manual
 - User-Friendly Interface

4. Exploring eBook Recommendations from Massey Ferguson 36 Service Manual
 - Personalized Recommendations
 - Massey Ferguson 36 Service Manual User Reviews and Ratings
 - Massey Ferguson 36 Service Manual and Bestseller Lists
5. Accessing Massey Ferguson 36 Service Manual Free and Paid eBooks
 - Massey Ferguson 36 Service Manual Public Domain eBooks
 - Massey Ferguson 36 Service Manual eBook Subscription Services
 - Massey Ferguson 36 Service Manual Budget-Friendly Options
6. Navigating Massey Ferguson 36 Service Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Massey Ferguson 36 Service Manual Compatibility with Devices
 - Massey Ferguson 36 Service Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Massey Ferguson 36 Service Manual
 - Highlighting and Note-Taking Massey Ferguson 36 Service Manual
 - Interactive Elements Massey Ferguson 36 Service Manual
8. Staying Engaged with Massey Ferguson 36 Service Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Massey Ferguson 36 Service Manual
9. Balancing eBooks and Physical Books Massey Ferguson 36 Service Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Massey Ferguson 36 Service Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Massey Ferguson 36 Service Manual
 - Setting Reading Goals Massey Ferguson 36 Service Manual
 - Carving Out Dedicated Reading Time

12. Sourcing Reliable Information of Massey Ferguson 36 Service Manual
 - Fact-Checking eBook Content of Massey Ferguson 36 Service Manual
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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web reading passages the same story will be read 3 times per evening monday thursday for homework your child s homework log will indicate which story is to be read each week

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web word lists phrases lists and fluency passages please be sure to open the document and print out the page s that your child is working on in class these word lists short phrases and leveled reading passages will help your child become a stronger natural fluent reader who is at grade level

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web on thursdays students get their fluency passages out and read independently set a 1 minute timer kids will try and finish reading the fluency passage in the 1 minute the decodable fluency passages i have are written with an appropriate amount of words for second graders to read in one minute or less the passages start off with only 50

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web search printable 1st grade reading fluency worksheets these first grade worksheets act as reading logs and journals for early readers to help build reading fluency they often include stories to help build reading and vocabulary skills

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web there are also comprehension questions included for each passage there are 3 sets of fluency passages set a set b and set c if you want to get them all these are also available online as a google slides product first grade fluency passages with online timer google slides digital learningcheck out all my other fluency passages for

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web the reading level of the passages at each grade level is at the midpoint of that grade level for example oral reading fluency practice and progress monitoring texas grade 3 has thirty passages each at grade 2 3 and 4 the grade two passages are at or near the middle of grade two in reading difficulty

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web fluency students read grade level text with fluency and comprehension students are expected to read aloud grade level

appropriate text with fluency rate accuracy expression appropriate phrasing and comprehension

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web created by anne gardner s reading resources these very first sight word sentences fluency passages and reading comprehension games for guided reading levels a and b are designed to help students build confidence with early literacy skills a high level of support is provided

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web these first grade fluency and comprehension passages contain 30 ready to print passages 15 fiction and 15 nonfiction each leveled reading fluency passage is in the 250 to 520 range and has between 145 and 216 words

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web the tmsfa examiner passages and student passages below include oral reading fluency orf and retelling materials for screening students at the beginning of year boy middle of year moy and end of year eoy printable versions examiner passages boy examiner passages boy moy examiner passages moy examiner passages

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web jan 25 2023 these lesson materials can help students with sight word fluency and word recognition skills with these materials students practice reading sight word lists for 3 to 7 minutes several days per week the lists begin with more frequently found words and words students commonly miss while reading

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web your child s teacher will give timed reading passages where kids read a story and are timed for one minute to record how many words they can read in that time by december most first graders can read 50 words correct per minute and by the end of the school year children should be reading 70 words per minute

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web jan 11 2022 building fluency is crucial for children s developing literacy by the end of 1st grade students should read

50 70 words per minute wpm accuracy isn't the only thing that matters students need to learn to read with meaning they should adjust their pace and use proper phrasing and expression to sound natural

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