PARTS
2 – Apron rods
2 – Lease sticks
1 – Double Back Beam Support - Left
(with insert installed)
1 – Double Back Beam Support - Right
(with insert, carriage bolt with washer
and lock nut, roll pin, and long barrel nut
installed)
1 – Rear Oval Beam
1 – Warp Beam (with brake hub and
axles installed)
1 – Brake Handle with Tab Assembly
1 – Warp Crank Bar with Tapered Handle
and hardware
1 – 61" Brake Cable Cord
Apron Cords (42" long): 5 – BW, 7 – MW,
4 – WP 8.10
2 – Black Threaded Knobs (2-1/4")
1 – Brake Bar (w/attached brake cable)
2 – Metal Fold-up Supports

HARDWARE
2 – 5/16" x 2" Carriage Bolts
1 – 1/8" x 1-3/16" Eye Screw
5 – 1/4" Nylon Washers
1 – 5/16" Regular Hex Nuts
2 – 3/16" x 1-1/4" Carriage Bolts
5 – 3/16" Washers
2 – 3/16" Lock Nuts
1 – 1/4" x 2" Truss Head Machine Screw
2 – 1/4" Barrel Nut
6 – 1/4" Washers
2 – 5/16" Locking Hex Nuts
1 – Slim 5/16" Locking Hex Nut
2 – 3/8" Washers
1 – 3/8" Washer (with large outer diameter)
2 – 1/4" x 1" Fender Washers
1 – Wolf Brake Cap Nut
1 – Wolf Brake Spring (w/attached insert)
1 – Wolf Brake Plastic Peg
1 – 1" S-Hook
1 – 1/4" Lock Nut
1 – Brake Bar Eye Bolt
2 – 1/4" x 1-1/4" Trusshead Machine Screws
DRILLING NEW HOLES (IF NECESSARY) FOR INSTALLING THE DOUBLE BACK BEAM ON OLDER WOLF LOOMS

1. Locate the Serial Number of your loom on the upper right castle side or under the harnesses on the cross brace (the first six digits of the serial are the manufacture date, for example, Serial # 110586-1 means a date of 11/05/86).

   A) If your serial number starts with a 4- or an 8- or has a serial number earlier than 100189-1, you will need to drill a few additional holes in the legs of your loom. Start with step 2.

   B) If your serial number is 100189-1 through 021090-1, go to step 4. [If holes (L) and (P) have already been drilled, go to the Assembly Instructions on page 4.]

   C) If your serial number is 020790-1 or later, go to the Assembly Instructions on page 4.

NOTE: It is essential that you mark and drill these holes accurately to insure that your loom will work its best (See FIGURE 1, p.3).

2. Drill 5/16” holes at (A) on both outside legs of the loom. Place these holes in the center of the legs and 30-7/8” down from the top edge of the leg.

3. Drill 3/16” holes at (C) on both inside legs of the loom. Place these holes in the center of the legs and 3” from the top edge of the legs. If your serial number is earlier than 4-2287 or 8-742, this hole should be 2-7/8” from the top of the rear oval beam (see FIGURE 2, p.3).

4. Drill a 1/4” hole (L) through the right outside leg, 4-1/2” from the top edge of the leg, and centered on the leg.

5. Drill a 1/8” hole (P) 5/8” deep centered in the right outside leg, 32-7/8” from the top

A NOTE ABOUT WOLF LOOMS:

• All Wolf Looms are built with similar basic frame designs, so while your loom may appear different from the looms illustrated in these instructions, the Inside Legs, where the double back beam attaches, are all, essentially, the same.
ATTACH THE DOUBLE BACK BEAM SUPPORTS (FIGURE 1)

1. Insert the 3/16" x 1-1/4" carriage bolts through the square holes in the metal fold-up bars. Place a 3/16" washer on the carriage bolt and then place the bolt through the hole in the inside legs at (C) from the outside to the inside of the leg so that the bar hangs straight down behind the loom's warp beam. Install a washer and 3/16" lock nut on the carriage bolt at the inside of the leg and tighten it so that the metal supports pivot freely, but not loosely.

2. From the outside to the inside of the outside legs, insert 5/16" x 2" carriage bolts through the holes in the at (A).

3. Align the double back beam supports with the recessed cutouts for the rear oval beam at the top and to the inside of the loom. (FIG. A)

4. Place the double back beam supports on the carriage bolts and fasten each support with a 1/4" washer and a regular (non-locking) 5/16" hex nut. Tighten the nut to draw the head of the carriage bolt all the way into the wood.

5. Remove the regular hex nut you have just tightened and install a locking 5/16" hex nut in its place. Tighten the lock nut just enough to allow the double back beam supports to pivot freely, but not loosely.

6. Insert the 1/4" x 1-1/4" trusshead machine screws through the round hole in the fold-up bars and screw them into the insert on the inside of the double back beam supports at (F).

7. Insert a 1/4" x 2" trusshead machine screw into the brake handle. Slide three 1/4" nylon washers onto the screw and insert the screw (from the outside in) through the outside leg at (L). Use a 1/4" washer and lock nut to secure the brake handle.

ASSEMBLE THE BRAKE RELEASE SYSTEM (FIGURES 1 & 2)

8. Insert one end of the 61" brake cable cord through the closed loop of the S-hook. Thread the other end of the cord through the 2nd hole from the end pulled through the S-hook and cinch tight. (FIG. B)

9. Screw the 1/8" x 1-3/16" eye screw into hole in the right outside leg. Be sure that the break in the screw eye is pointed down (P, insert). Thread the free end of the cord through the eye screw, then up through hole (R) in the brake handle. Put the plastic peg through the 10th hole from the end of the brake cord to hold the cord to the handle.

NOTE: When you pull the brake handle up to release the friction brake, pivot the tab over to hold it in the release position while you are either winding on a warp or winding your fabric onto the cloth beam.
INSTALL THE SECOND WARP BEAM, BRAKE CABLE AND APRON BARS (FIGURES 1-3)

10. Place one of the 3/8\" washers (with the smaller outside diameter) over each axle on the second warp beam. Insert the threaded brake axle into hole (E) on the newly installed right double back beam support. Gently spread the double back beam supports apart just enough to fit the other (non-threaded) warp beam axle into the stopped hole on the left double back beam support.

11. Place 3/8\" washer (with the large diameter) over the threaded brake axle on the outside of the right double back beam support. Place the warp crank handle over the threaded brake axle with the wood handle pointing away from the loom. Secure it with the cap nut. Holding the second warp beam in place, use the crank as a wrench to tighten the cap nut.

12. Place the rear oval beam in the slots in the top of the double back beam supports. Place the 1/4\" x 1\" fender washer on the 2-1/4\" black knobs. Attach the beam with the black knobs and barrel nuts.

13. Locate the carriage bolt that is already installed in the right double back beam support. Place the brake bar (with attached cable) over the bolt. Place a 1/4\" washer over the bolt. Working from the outside of the loom to the inside (FIG C), wrap the cable counter-clockwise around the brake hub four times. Place the cable loop over the bolt followed by another 1/4\" washer. Put a slim lock nut on the bolt and tighten, making sure the brake bar can still pivot freely.

14. Insert the open loop of the brake spring into the same hole on the brake bar the brake cable is attached to (FIG D). Place a 3/16\" washer on the eye bolt and insert the bolt through the barrel nut that was pre-installed on the right double back beam support and screw it into the insert set in the top of the brake spring. Tighten the eye bolt enough to prevent the warp beam from turning in a counter-clockwise direction when twisted by hand.

15. Attach the brake release cord to the brake bar by putting the S-hook that is now attached to the brake cord through the remaining hole in the back of the brake bar. Adjust the tension on the brake release at the front of the loom by changing which hole on the brake cord (near the brake release handle) has the plastic peg in it.
ATTACH THE APRON CORDS TO THE SECOND BACK BEAM ON A MAPLE LOOM (For instructions about attaching the apron cords on cherry looms, please see page 8)

NOTE: There is one cord for each hole in the warp beam.

16. Insert one end of a cord through a hole in the beam and pull the cord through a few inches. Insert the long end of the cord through the second loop from the cord end that you just put through the beam; pull firmly to tighten (FIG E). Repeat to install all the cords.

17. Starting with an outside cord, attach the apron bar to the apron cords. Fold the loose end of the cord 4" from the end and insert this loop through the second loop from the end (Fig F). Pull until the loop is large enough to accommodate the apron bar (Fig G). Slide the apron bar through this new loop (Fig H).

The extra apron bar can be used for warping methods that require an extra rod through warp loops.

18. Your double back beam is now ready to use. After you warp your loom, you may need to adjust each friction brake to be sure it is holding. The warp that needs to vary the most should be on the second back beam. This beam's brake is controlled by a hand lever, which provides greater control over the tension on the threads.
INSTALLING APRON BARS FOR CHERRY BABY AND MIGHTY WOLF LOOMS

These instructions replace those in steps 16-17.

PARTS
One long piece of Texsolv cord
One 1/4" dowel (27" long for Baby Wolf; 38" long for Mighty Wolf, 18" long for WP 8.10)
One apron bar

1. Fold one end of the cord approximately 2" from the end, pinch the fold tightly and insert the fold through the second loop from the end of the Texsolv cord. (FIGs F & G). Place this loop around one end of the 1/4" dowel and pull tight to fasten (FIG H).

2. Thread the other (long) end of the cord through the outermost hole on one end of the warp beam, and pull the cord through the hole until the cord and the dowel are snug against the warp beam. Now pass the cord around the apron bar leaving about 30" of distance between the warp beam and the apron bar, then bring the cord back to the warp beam and insert it in the return direction through the beam, and loop it around the dowel. Continue to thread the cord around the apron bar and through the beam in this manner, until there are four loops for the Baby Wolf, six loops for the Mighty Wolf, or loops for the WP 8.10 on the apron bar.

3. Thread the cord into the last hole on the beam and fasten the cord to the dowel in the same manner as in step 1.