



REPLACING UPPER ACTUATING ARM

INSTALLATION INSTRUCTIONS

Part Number: **SIZE290100**

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1. Empty all components from machine, drain shot and powder reservoirs, remove shot and powder reservoir plate assembly, and remove gear rack.
2. Remove 1/4-28 x 1 button head cap screw (BHCS) "A" on the underside of the Crosshead. LOOSEN THE 3/8-16 X 1 BHCS "B" in the toolhead 2/3 the way out and tap it with a soft hammer (i.e. plastic or brass) or mallet to knock the actuating assembly with the finish shell or knockout out of the toolhead and off the two guide pins.
3. Now, remove screw "B" and the assembly will drop out.
4. Remove 10-32 x 3/8 screw "C" and remove Upper Actuating Arm and replace with the new arm.

IMPORTANT: When replacing the actuating arm onto the hex shaft, be sure it tilts BACK 60° (one notch) when the Lower Actuating Arms "D" are pointed STRAIGHT DOWN.

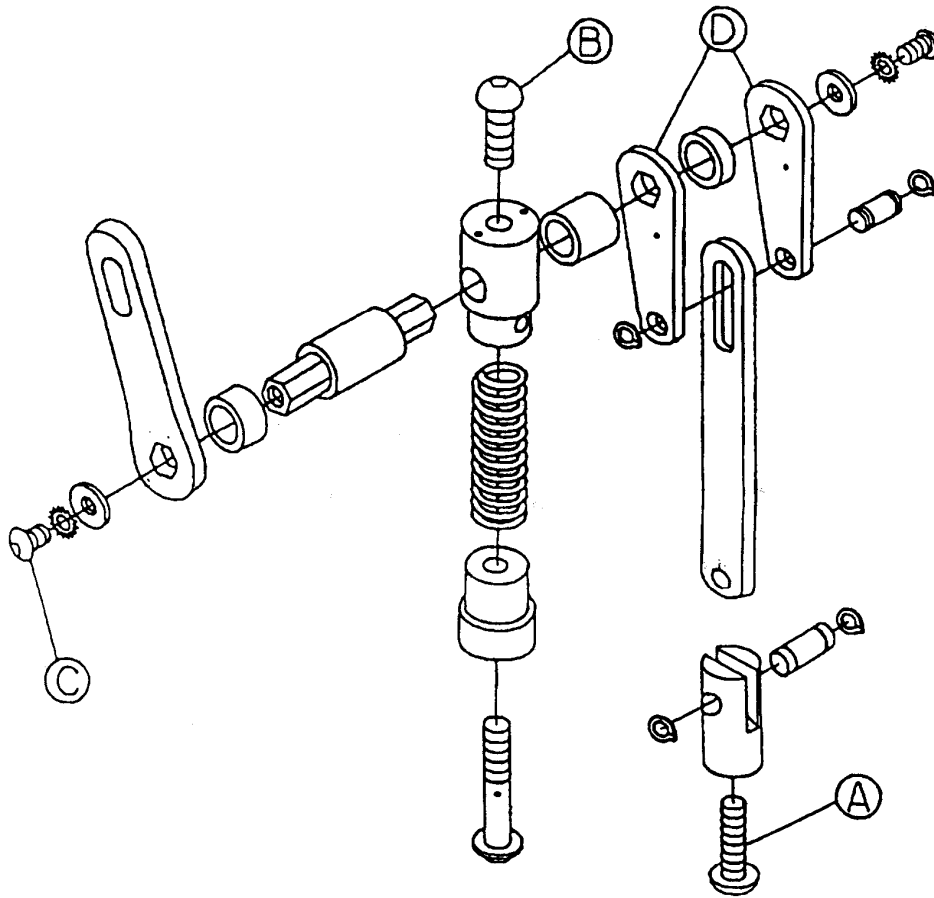
5. Reinstall and tighten screw "C", install assembly in Toolhead. Be sure to align holes in the top Knockout assembly *with the two guide pins in the tool head*. If these are NOT lined up, when you tighten screw "A," the pins will rise out of the toolhead and could bend. I use BLUE Loctite on screw "C" when I do this.
6. Install screw "B" and tighten (pulling the assembly up into place in the toolhead.)
7. Replace the Rack Gear with the timing marks lined up with the marks on the shot and powder gears.
8. Replace shot and powder reservoir plate.

SEE REVERSE SIDE FOR SCHEMATIC

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