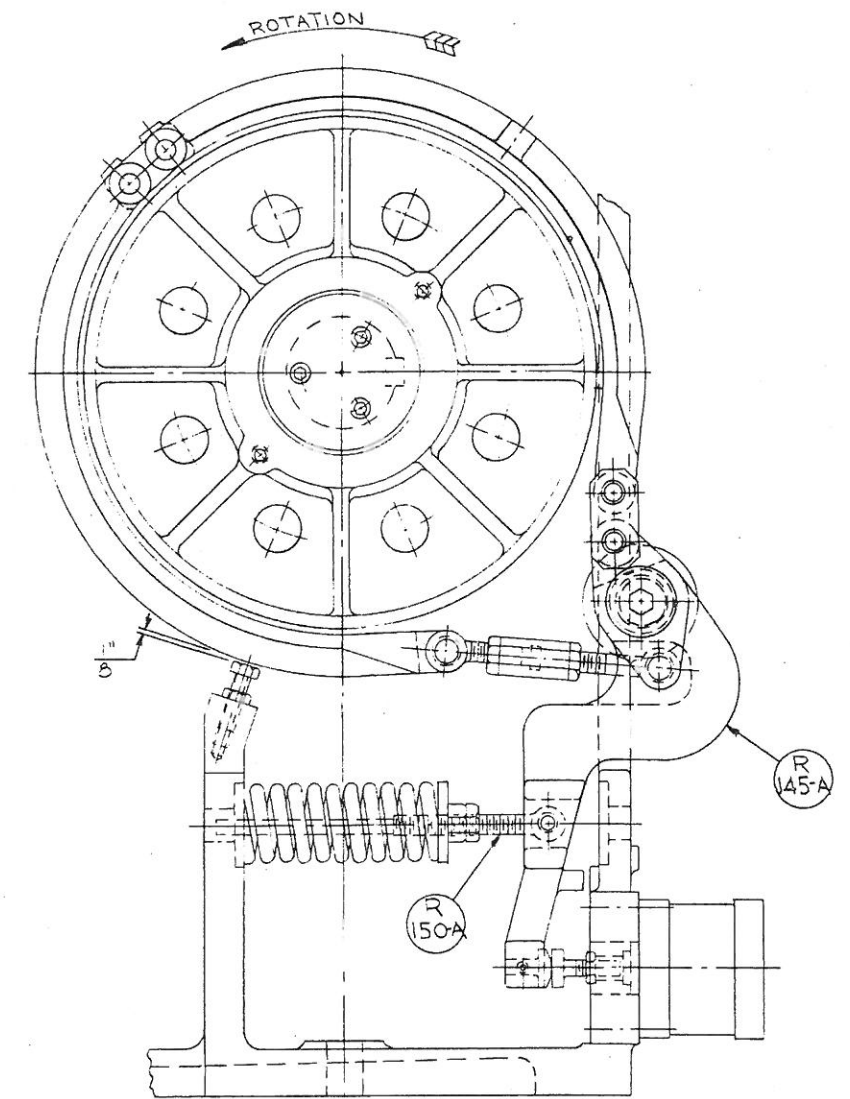


WHEN ORDERING REPLACEMENTS, STATE SERIAL NUMBER AND SIZE STAMPED ON NAME PLATE OF MACHINE AND DESIGNATE PART BY BOTH NAME AND NUMBER.

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|---|---|
| R-131 BRAKE DRUM. | R-287 BRAKE LEVER & ANCHOR CONN. LINK PINS. |
| R-132 BRAKE SHOES. | R-288 BRAKE ANCHOR INNER CONN. LINK. |
| R-133 BRAKE LININGS & RIVETS. | R-440 BRAKE ANCHOR CONN. LINK BUSHINGS (INNER). |
| R-139 BRAKE ADJ. TOP EYE SCRT. PIN. | R-441 BRAKE ANCHOR OUTER CONN. LINKS. |
| R-140 BRAKE ADJ. TOP EYE BOLT. | R-442 BRAKE LEVER SPACER. |
| R-145 BRAKE LEVER. | R-443 BRAKE ADJ. BOTTOM EYE BOLT. |
| R-145-A BRAKE LEVER. | R-444 BRAKE ADJ. BOTTOM EYE BOLT PIN. |
| R-146 BRAKE LEVER FULCRUM PIN. | R-445 BRAKE ADJ. TOP EYE BOLT BUSHING. |
| R-149 BRAKE SPRING ADJ. ROD PIN. | R-446 BRAKE ADJ. BOTTOM EYE BOLT BUSHING. |
| R-150 BRAKE SPRING ADJ. ROD. | R-447 BRAKE ADJUSTING TURNBUCKLE. |
| R-150-A BRAKE SPRING ADJ. ROD. | R-448 BRAKE LEVER RETAINER PLATE. |
| R-152 BRAKE SPRING. | R-449 BRAKE SPRING ADJ. ROD BUSHING. |
| R-153 BRAKE SPRING WASHER. | R-450 BRAKE AIR CYLINDER BUMPER PLUG. |
| R-168 BRAKE RELEASE AIR CYLINDER. | R-451 BRAKE LEVER BUMPER PLUG. |
| R-281 BRAKE LEVER FULCRUM PIN BUSHING. | |
| R-283 BRAKE ANCHOR CONN. LINK BUSHINGS (OUTER). | |
| R-284 BRAKE SHOE LINK. | |
| R-286 BRAKE SHOE LINK PINS. | |



ADJUSTMENT OF BRAKE SHOES (R-132) BY MEANS OF ADJUSTING TURNBUCKLE (R-447) DETERMINES DISTANCE "Y". IT NEED NOT BE CHANGED AS LONG AS DISTANCE "Y" IS BETWEEN 1/2" AND 1/8". WHEN DISTANCE "Y" IS LESS THAN 1/8", ADJUST.

USING BRAKE SPRING ADJUSTING ROD (R-150 OR R-150-A), BRAKE SPRING (R-152) SHOULD BE ADJUSTED TO STOP THE ROLL DIES IN PROPER POSITION FOR STOCK FEEDING. IF BRAKE SPRING (R-152) MUST BE ADJUSTED SO TIGHTLY THAT AIR CYLINDER (R-168), WITH NORMAL AIR PRESSURE, CANNOT COMPLETELY RELEASE THE BRAKE, CHECK THE CLUTCH TO MAKE SURE THAT IT IS RELEASING PROMPTLY.

IF THE BRAKE AND CLUTCH ARE PROPERLY ADJUSTED AND THE DIES ARE STILL STOPPING IN IMPROPER POSITION, CHANGE THE CLUTCH AND BRAKE CAM SWITCH TIMING.

INVERTING BRAKE SHOES (R-132), WHEN LINING (R-133) IS HALF WORN AT THE ANCHOR END, WILL DOUBLE BRAKE SHOE LIFE.

IF BRAKING IS IRREGULAR, CLEAN LINING (R-133) AND DRUM (R-131) WITH NON-FLAMMABLE DETERGENT TO PREVENT SCORING DRUM (R-131), USE ONLY BRASS RIVETS IN BRAKE LININGS (R-133), AND NEVER LET STEEL BRAKE SHOES (R-132) CONTACT BRAKE DRUM (R-131).

THE BRAKE LINING USED WILL WITHSTAND 500°F BUT IF IT RUNS THIS HOT INVESTIGATE.