



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

1301	RAM	1318	UPPER KNOCKOUT ADJUSTING SCREW
1302	PITMAN	1321	RAM EXTENSION COVER PLATE
1303	PITMAN CAP	1322	RAM EXTENSION SIDE LINERS
1304	PITMAN BOLTS	1323	RAM EXTENSION REAR LINERS
1305	PITMAN AND CRANKSHAFT BUSHING	1324	FRAME REAR LINERS
1306	PITMAN WRIST PIN	1325	FRAME SIDE LINERS
1307	PITMAN WRIST PIN BUSHINGS	1326	FRAME SIDE LINER INSERTS
1308	RAM THRUST BUSHING	1327	FRONT GIBS- RIGHT AND LEFT HAND
1309	PITMAN KICKER LUG INSERT	1328	FRONT GIB LINERS
1310	UPPER KNOCKOUT LEVER	1329	RIGHT SIDE LINER SCREWS
1311	UPPER KNOCKOUT SPRING ROD	1330	LEFT SIDE LINER SCREWS
1312	UPPER KNOCKOUT SPRING	1338	KICKER PIN RETAINER
1313	UPPER KNOCKOUT LEVER FULCRUM PIN	1339	KICKER PIN SPRING
1314	UPPER KNOCKOUT DRIVE PIN		
1315	UPPER KNOCKOUT KICKER PIN		

ADJUSTMENT FOR SIDE WEAR

1. REMOVE GIBS (1327).
2. LOOSEN SCREWS (1329 & 1330) IN SIDE OF PRESS FRAME AND REMOVE LINERS (1325).
3. INSTALL SUITABLE SHIMS TO FIT BETWEEN LINER (1325) AND LINER INSERT (1326), ALLOWING APPROX. .0006" PER INCH OF RAM WIDTH FOR RUNNING CLEARANCE AND REPLACE LINERS, REVERSING THE ABOVE PROCEDURE.

ADJUSTMENT FOR FRONT TO BACK WEAR

4. REMOVE LINERS (1328) AND INSTALL SUITABLE SHIMS BETWEEN THEM AND FRONT GIBS (1327). ALSO REMOVE LINERS (1324) AND INSTALL SUITABLE SHIMS BETWEEN THEM AND BED. ALLOW OPERATING CLEARANCE OF APPROX. .0006" PER INCH OF RAM WIDTH.
5. TO COMPENSATE FOR FRONT TO BACK WEAR ON THE BEARING OF THE RAM EXTENSION, LINERS (1323) MAY BE REMOVED AND SUITABLE SHIMS INSTALLED BETWEEN THEM AND THE BED, AND IF NECESSARY, REMOVE SHIMS OF THE PROPER THICKNESS FROM UNDER THE EXTENSION COVER PLATE (1321).

UPPER KNOCKOUT ADJUSTMENT

6. THE UPPER KNOCKOUT HAS BEEN SET FOR MAXIMUM STROKE OF THE KICKER PIN (1315). TO REDUCE THIS STROKE, THE KICKER PIN SHOULD BE REMOVED FROM THE RAM, AND THE BOTTOM OF THE PIN CUT OFF TO SUIT THE REQUIRED STROKE.
7. THE UPPER KNOCKOUT LEVER (1310) SHOULD THEN BE ADJUSTED DOWNWARD WITH ADJUSTING SCREW (1318) TO JUST TOUCH THE KICKER PIN IN THE UP POSITION.

CAUTION:

IF ADJUSTMENT OF UPPER KNOCKOUT LEVER IS MADE BEYOND THIS POINT, FORGING LOAD IS TRANSFERRED TO ADJUSTING SCREW (1318).