



WHEN ORDERING REPLACEMENTS STATE SERIAL NUMBER AND SIZE STAMPED ON NAMEPLATE OF MACHINE AND DESIGNATE PARTS BY BOTH NAME AND NUMBER

1301	RAM	1328	FRONT GIB LINERS
1302	PITMAN	1338	KICKER PIN RETAINER
1303	PITMAN CAP	1350	UPPER KNOCKOUT SPRING ADJUSTER
1304	PITMAN BOLTS	1351	UPPER KNOCKOUT LEVER BUSHING
1305	PITMAN AND CRANKSHAFT BUSHING	1352	UPPER KNOCKOUT SPRING PLUNGER
1306	PITMAN WRIST PIN	1353	DRIVE PIN RETAINER
1307	PITMAN WRIST PIN BUSHING	1354	FRAME TOP REAR LINER
1308	RAM THRUST BUSHING	1355	FRAME BOTTOM REAR LINER
1309	PITMAN KICKER LUG INSERT	1356	FRAME FRONT SIDE LINER
1310	UPPER KNOCKOUT LEVER	1357	FRAME REAR SIDE LINER
1312	UPPER KNOCKOUT SPRING	1358	PITMAN BOLT STRAP
1313	UPPER KNOCKOUT LEVER FULCRUM PIN	1360	THRUST BUSHING RETAINER PLATE
1314	UPPER KNOCKOUT DRIVE PIN	1361	SPRING ADJUSTER KEEPER PLATE
1315	UPPER KNOCKOUT KICKER PIN	1362	SPACER BLOCK (AT FULCRUM PIN)
1321	RAM EXTENSION COVER PLATE	1363	FRONT GIB LINER SCREW
1322	RAM EXTENSION SIDE LINER	1364	FRAME SIDE LINER SCREWS
1323	RAM EXTENSION REAR LINER	1365	REAR GIB LINER SCREW
1327	FRONT GIBS - RIGHT HAND & LEFT HAND		

ADJUSTMENT FOR SIDE WEAR

1. REMOVE FRONT GIBS (1327).
2. LOOSEN SCREWS (1364) IN THE SIDE OF PRESS FRAME, AND REMOVE FRAME SIDE LINERS (1356 & 1357).
3. INSTALL SUITABLE SHIMS TO FIT BETWEEN LINERS AND PRESS FRAME ALLOWING FOR APPROX. .0005" (.013MM) PER INCH OF RAM WIDTH FOR TOTAL RUNNING CLEARANCE.
4. REPLACE LINERS BY REVERSING ABOVE PROCEDURE.
5. THE RAM EXTENSION SIDE LINERS (1322) MAY ALSO BE REMOVED, AND SUITABLE SHIMS INSTALLED BETWEEN THEM AND THE PRESS FRAME.

ADJUSTMENT FOR FRONT TO BACK WEAR

1. LOOSEN SCREWS (1363) IN FRONT GIBS AND REMOVE FRONT GIB LINERS (1328).
2. LOOSEN SCREWS (1365) IN REAR OF PRESS AND REMOVE FRAME REAR LINERS (1354 & 1355).
3. INSTALL SUITABLE SHIMS BETWEEN FRONT LINERS (1328) AND THE FRONT GIBS (1327), AND BETWEEN REAR LINERS (1354 & 1355) AND PRESS FRAME, ALLOWING FOR APPROX. .0005" (.013MM) PER INCH OF RAM WIDTH FOR TOTAL RUNNING CLEARANCE.
4. REPLACE LINERS BY REVERSING ABOVE PROCEDURE.
5. THE RAM EXTENSION REAR LINERS (1323) MAY ALSO BE REMOVED, AND SUITABLE SHIMS INSTALLED BETWEEN THEM AND THE PRESS FRAME. ALSO, IF NECESSARY, REMOVE SHIMS OF PROPER THICKNESS FROM UNDER THE RAM EXTENSION COVER PLATE (1321).

UPPER KNOCKOUT ADJUSTMENT

THE UPPER KNOCKOUT HAS BEEN PRESET FOR THE MAXIMUM STROKE OF THE KICKER PIN (1315). TO REDUCE THIS STROKE (TO SUIT BOLSTERS AND/OR DIES), THE KICKER PIN (1315) SHOULD BE REMOVED FROM THE RAM (1301) AND THE BOTTOM END OF THE PIN CUT OFF TO SUIT.

CAUTION

NEVER INCREASE UPPER KNOCKOUT STROKE BEYOND MAXIMUM LISTED ON THE TOOL AND DIE SPACE DRAWING, SINCE FAILURE IN THE UPPER KNOCKOUT MECHANISM WILL RESULT.