



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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| 1301 RAM | 1328 FRONT GIB LINERS |
| 1302 PITMAN | 1338 KICKER PIN RETAINER |
| 1303 PITMAN CAP | 1350 TOP KNOCKOUT SPRING ADJUSTER |
| 1304 PITMAN BOLTS | 1351 LEVER BUSHING |
| 1305 PITMAN AND CRANKSHAFT BUSHING | 1352 SPRING PLUNGER |
| 1306 PITMAN WRIST PIN | 1353 DRIVE PIN RETAINER |
| 1307 PITMAN WRIST PIN BUSHING | 1324 FRAME REAR LINERS |
| 1308 RAM THRUST BUSHING | 1325 FRAME SIDE LINERS |
| 1309 PITMAN KICKER LUG INSERT | 1326 FRAME SIDE LINER INSERTS |
| 1310 TOP KNOCKOUT LEVER | 1329 RIGHT SIDE LINER SCREWS |
| 1312 TOP KNOCKOUT SPRING | 1358 PITMAN BOLT STRAP |
| 1313 TOP KNOCKOUT LEVER FULCRUM PIN | 1359 PITMAN SHIM |
| 1314 TOP KNOCKOUT DRIVE PIN | 1360 THRUST BUSHING RETAINER PLATE |
| 1315 TOP KNOCKOUT KICKER PIN | 1361 SPRING ADJUSTER KEEPER PLATE |
| 1321 RAM EXTENSION COVER PLATE | 1362 SPACER BLOCK |
| 1322 RAM EXTENSION SIDE LINERS | 1330 LEFT SIDE LINER SCREWS |
| 1323 RAM EXTENSION REAR LINERS | 1333 RAM REAR LINERS |
| 1327 FRONT GIBS - RIGHT AND LEFT HAND | 1334 RAM SIDE LINERS |
| | 1335 RAM FRONT LINERS |

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. .0005" 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 FRAME. ALLOW OPERATING CLEARANCE OF APPROX. .0005" PER INCH OF RAM WIDTH.
5. TO COMPENSATE FOR FRONT TO BACK WEAR ON BEARING OF THE RAM EXTENSION LINERS (1323) MAY BE REMOVED, AND SUITABLE SHIMS INSTALLED BETWEEN THEM AND THE FRAME, AND IF NECESSARY, REMOVE SHIMS OF THE PROPER THICKNESS FROM UNDER THE EXTENSION COVER PLATE (1321).

TOP KNOCKOUT ADJUSTMENT

6. TOP KNOCKOUT HAS BEEN SET FOR MAXIMUM STROKE. TO REDUCE THIS STROKE, MACHINE OFF END OF TOP KNOCKOUT KICKER PIN (1315).

CAUTION

NEVER INCREASE KICK BEYOND MAXIMUM STROKE (PER TOOL & DIE SPACE) SINCE THAT WILL CAUSE FAILURE IN TOP KNOCKOUT MECHANISM.

NOTE

AT FINAL ASSEMBLY SPOT WELD PITMAN BOLT STRAP (1358) TO TOP OF PITMAN BOLT (1304). SPOT WELD CAP SCREWS TO PITMAN BOLT STRAP (1358).