



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

1301 RAM	1317 UPPER KNOCKOUT WEDGE SUPPORT
1302 PITMAN	1318 UPPER KNOCKOUT ADJUSTING SCREW
1303 PITMAN CAP	1319 UPPER KNOCKOUT ADJ. SCREW PLATE
1304 PITMAN BOLTS	1320 DIE PLATE
1305 PITMAN AND CRANKSHAFT BUSHING	1321 RAM EXTENSION COVER PLATE
1306 PITMAN WRIST PIN	1322 RAM EXTENSION SIDE LINERS
1307 PITMAN WRIST PIN BUSHINGS.	1323 RAM EXTENSION REAR LINERS
1308 RAM THRUST BUSHING.	1324 FRAME REAR LINERS
1309 PITMAN KICKER LUG INSERT.	1325 FRAME SIDE LINERS
1310 UPPER KNOCKOUT LEVER	1326 FRAME SIDE LINER INSERTS
1311 UPPER KNOCKOUT SPRING ROD	1327 FRONT GIBS - RIGHT AND LEFT HAND
1312 UPPER KNOCKOUT SPRING	1328 FRONT GIB LINERS
1313 UPPER KNOCKOUT LEVER FULCRUM PIN	1329 RIGHT SIDE LINER SCREWS
1314 UPPER KNOCKOUT DRIVE PIN	1330 LEFT SIDE LINER SCREWS
1315 UPPER KNOCKOUT KICKER PIN	1331 LEFT SIDE LINER ADJUSTING PLUGS
1316 UPPER KNOCKOUT ADJUSTABLE WEDGE	1332 LEFT SIDE LINER ADJUSTING NUTS

ADJUSTMENT FOR SIDE WEAR

- 1- WITH RAM DOWN, LOOSEN LEFT SIDE LINER SCREWS (1330)
- 2- TIGHTEN ADJUSTING SCREW PLUGS (1331) BY TURNING THE NUTS (1332) TO TAKE UP ALL CLEARANCE, THEN BACK OFF TO ALLOW OPERATING CLEARANCE OF APPROXIMATELY .0006" PER INCH OF RAM WIDTH. 1/8 TURN EQUALS .015"
- 3- TIGHTEN HOLD BACK CAP SCREWS (1330).
- 4- CHECK OPERATING CLEARANCE WITH FEELERS, TURNING MACHINE OVER BY HAND.
- 5- IF OBJECTIONABLE SIDE WEAR HAS DEVELOPED ON THE BEARING OF THE RAM EXTENSION, LINERS (1322) MAY BE REMOVED AND SUITABLE SHIMS INSTALLED BETWEEN THEM AND BED.

ADJUSTMENT FOR FRONT TO BACK WEAR

- 6- 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 APPROXIMATELY .0006" PER INCH OF RAM WIDTH.
- 7- 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 BED, AND IF NECESSARY REMOVE SHIMS OF THE PROPER THICKNESS FROM UNDER EXTENSION COVER PLATE (1321).

UPPER KNOCKOUT ADJUSTMENT.

- 8- TURNING ADJUSTING SCREW (1318) COUNTERCLOCKWISE WILL DRIVE ADJUSTABLE WEDGE (1316) IN ABOVE KNOCKOUT LEVER (1310) LIMITING THE MOVEMENT AND FORMING A POSITIVE BACKING UP OF KICKER PIN (1315).