

 NOTE**Installation Of The Insertion Head Assembly**

To install the insertion head assembly, proceed as follows.



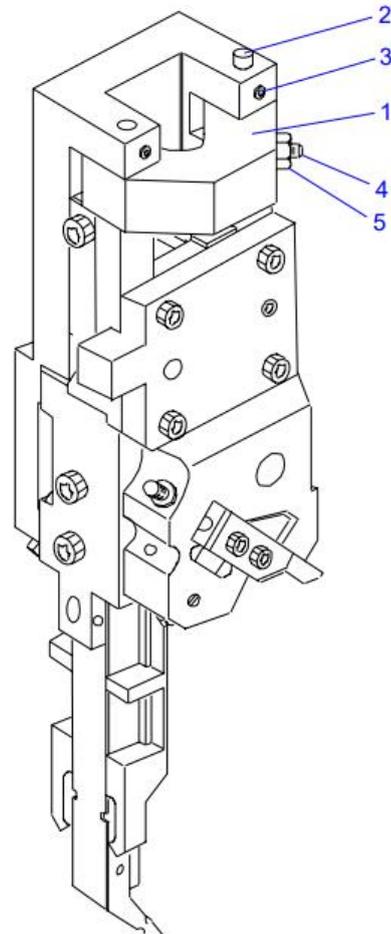
1. Power down the machine and perform Lockout/Tagout according to local procedures.

**WARNING**

The machine must be powered down and the local Lockout/Tagout procedure performed to ensure personal safety during this procedure.

2. Align the assembly from the back of the insertion head driver assembly and install the pusher onto the bottom of the main shaft.
3. Close the shaft clamp (1).
4. Install the tooling pin (2) and secure it with the set screw (3).
5. Tighten the socket set screw (4).
6. Tighten the hex jam nut (5).

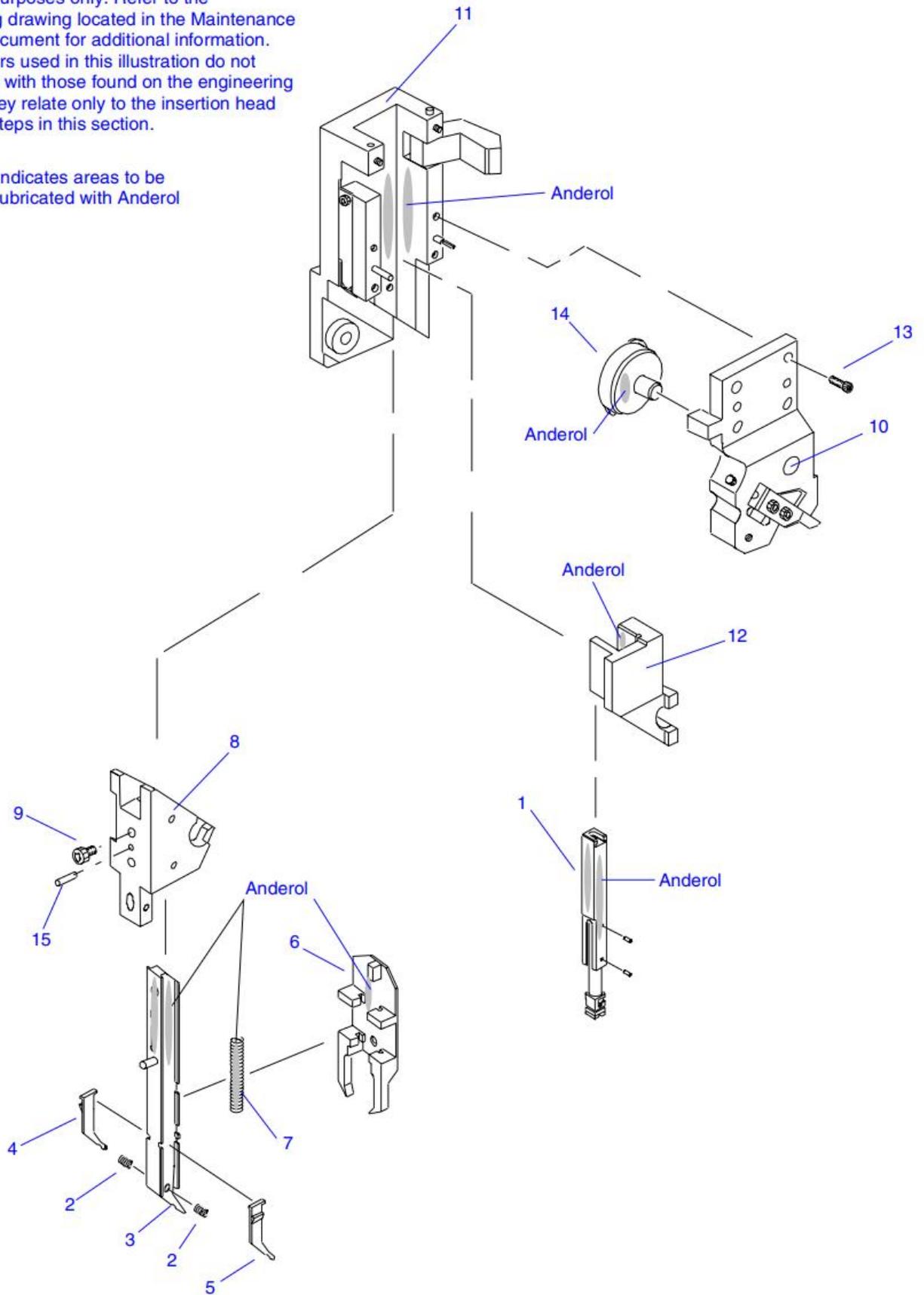
Note: This drawing is for reference purposes only. Refer to the engineering drawing located in the Maintenance Support Document for additional information. The numbers used in this illustration do not correspond with those found on the engineering drawing, they relate only to the insertion head installation steps in this section.



End of procedure

Note: The following drawing is provided for reference purposes only. Refer to the engineering drawing located in the Maintenance Support Document for additional information. The numbers used in this illustration do not correspond with those found on the engineering drawing, they relate only to the insertion head assembly steps in this section.

 Indicates areas to be lubricated with Anderol





Disassembly Of The Insertion Head Assembly

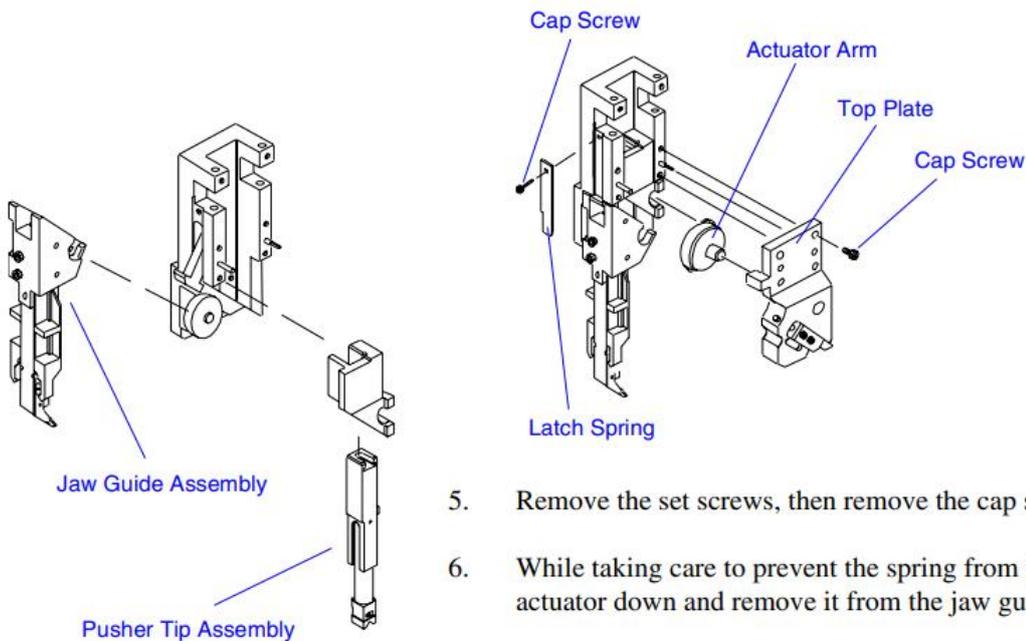
To disassemble the insertion head assembly, proceed as follows.

1. Remove the cap screw and latch spring.
2. Remove the cap screws and top plate assembly.
3. Remove the actuator arm.
4. Remove the jaw guide assembly and the slide with the pusher tip assembly.



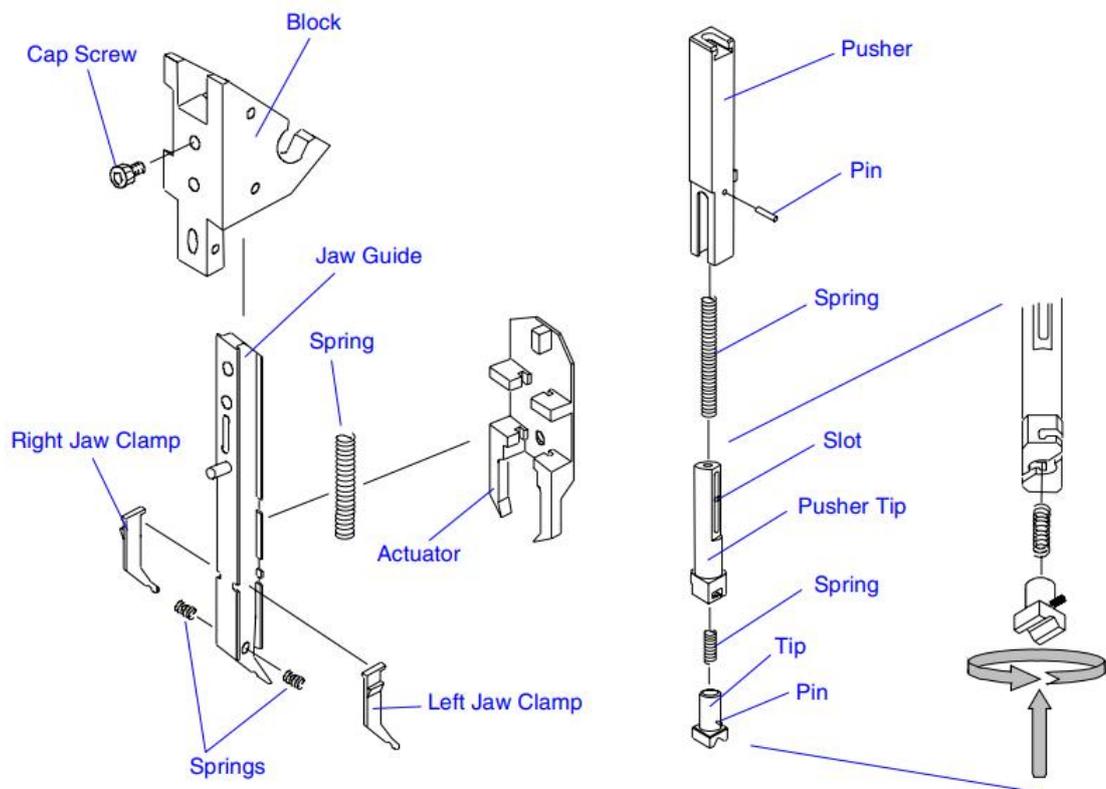
CAUTION

Do not remove the jaw guide from the block unless replacement of the jaw guide is necessary.



5. Remove the set screws, then remove the cap screws and block.
6. While taking care to prevent the spring from flying loose, slide the actuator down and remove it from the jaw guide.

7. Remove the right jaw clamp, left jaw clamp and two compression springs.
8. Push up and turn the tip clockwise to release it from the socket in the pusher tip, then remove the tip and spring.
9. Center the pin in the slot by pushing the pusher tip into the pusher. Hold it in this position.
10. Remove the pin from the pusher.
11. Remove the pusher tip and compression spring from the pusher.
12. Remove the compression spring from the pusher tip.



End of procedure

Assembly Procedure For The Insertion Head

To assemble the insertion head assembly, proceed as follows. Refer to the illustrations on the pages that follow.

1. Lubricate with anderol and install pusher (1) into slide (12). Set aside.
2. Lubricate both cam surfaces on the slide actuator (6) with anderol.
3. Apply a light coat of anderol into the slot and both grooves of the jaw guide (3).

4. Install the compression springs (2) into the jaw guide (3).
5. Install the right and left jaw clamps (4 and 5) over the springs and onto the jaw guide. Hold the assembly together until the slide actuator (6) is installed.
6. Install the slide actuator (6) over the jaw guide to secure the left and right jaw clamps to the jaw guide.
7. Install the compression spring (7) by inserting the spring through the opening between the slide actuator and the jaw guide.
8. Clean the threads and apply Loctite 242 to the cap screws.
9. Be careful not to separate the slide actuator from the jaw guide. Install the jaw guide into the block (8).
10. While keeping the jaw guide in the block, install the cap screws (9) into the block. Do not tighten the screws.
11. Install the dowel pin (15) into the block and jaw, then tighten the cap screws (9). Check for movement from front to back.
12. Install the jaw guide assembly (3) into the housing.
13. Install the arm actuator (14) into the top plate assembly (10).
14. Install the slide (12) into the housing (11).
15. Install the top plate assembly (10) to the housing, (11) and secure with cap screws (13).

End of procedure