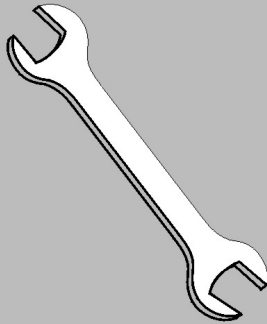


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Kit Instruction— KDWCSTF001



Please Read

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This manual may contain references to "yellow pages." Although the pages containing troubleshooting procedures are no longer printed on yellow paper, troubleshooting instructions, if any, will be contained in the easily located "Troubleshooting" chapter or section. See the table of contents.

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KDWCSTF001: 60044" DIVIDED CYLINDER REPAIR KIT

MSSM0307AE/9843AV



WARNING: Crush and Sever Hazard



Moving cylinder will crush or sever body parts caught in closing gaps. These include gaps between:

- Doors and shell front.
- Doors and cylinder.
- Shell front and cylinder.

- ☞ Before reaching into any of these gaps, lock off and tag out power to the machine.
- ☞ Immobilize the cylinder before starting repair.

NOTICE: Machine Damage



Use a competent, experienced welder for this repair procedure.

This kit (KDWCSTF001) is used to permanently repair cracks which may develop in specific areas of the cylinder on older machines, under certain conditions. Proceed as follows:

1. Locate the six cylinder tabs shown in FIGURE 1.
2. Cut out a 2" (51) circular portion of the cylinder surrounding each tab.
3. Grind each tab until 1/4" (6) clearance exists between the cylinder front and the cylinder divider as shown in FIGURE 2.
4. Using a continuous weld, fit the stiffeners (p/n 02 19117A, from the kit) over the holes in the cylinder.
5. Repair remaining cracks by drilling out both ends of the crack, gouging out the area between the ends, then filling the area with weld.

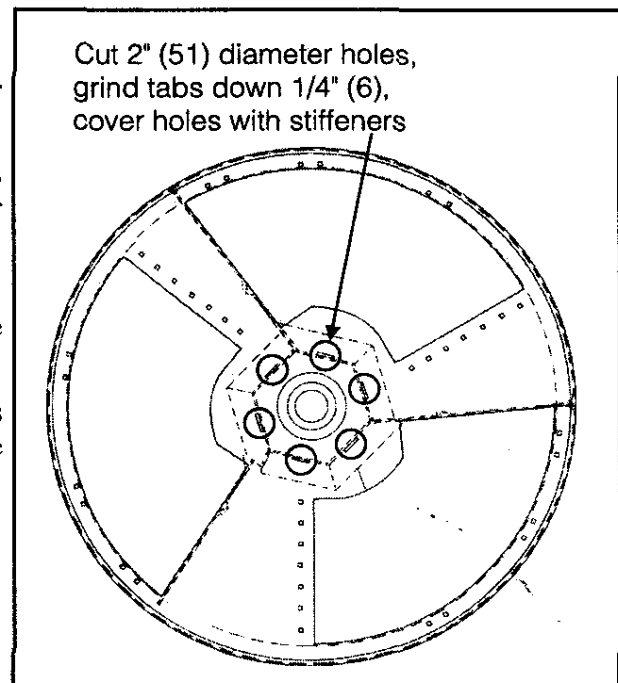


FIGURE 1: Identifying Cylinder Tabs (three pocket cylinder shown)

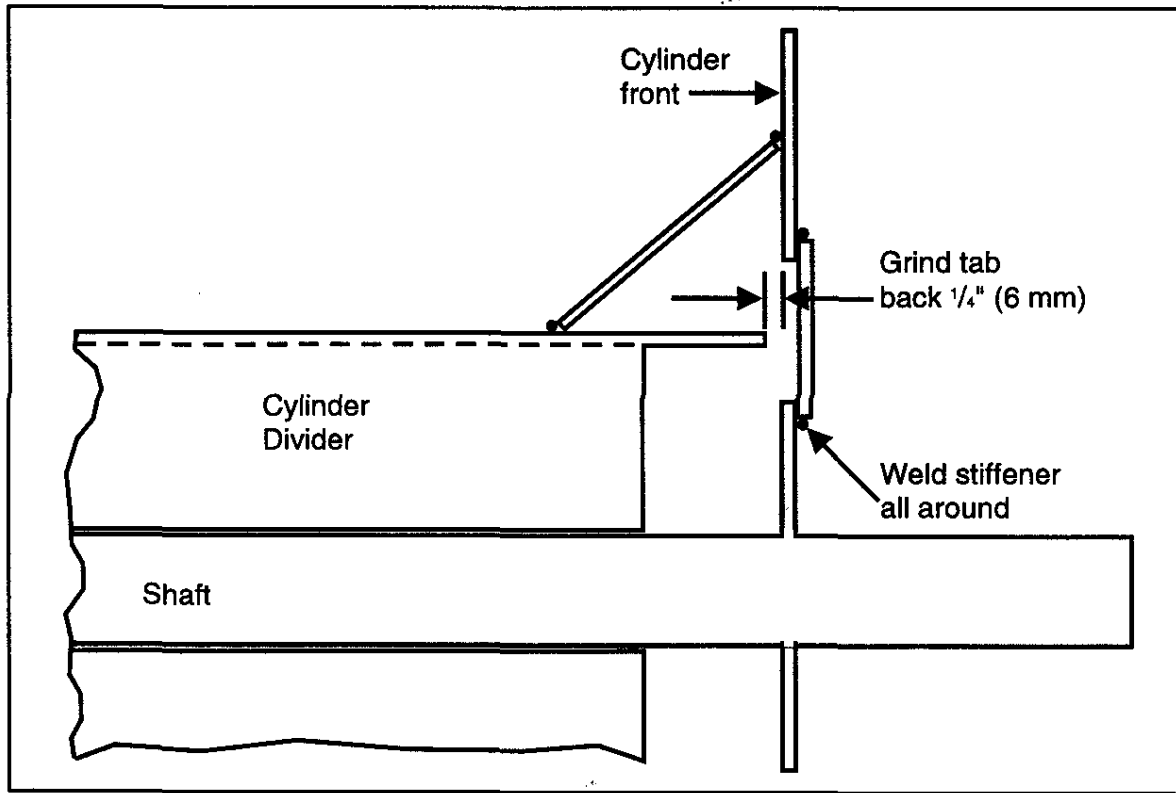


FIGURE 2: Cylinder Repair Details