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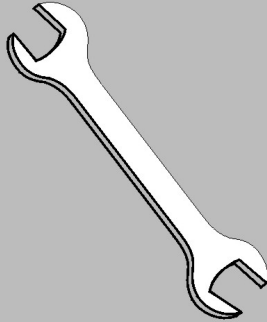
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Kit Instruction—

PK33 0008

PK33 0008A



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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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INSTALLING BASKET TO 30015 & 30022 MACHINES

TOOLS REQUIRED

(Milnor Parts)

15K235GA ¾" – 10 X 6 ½" Grade 8 Bolt

02 14359A Shaft Retainer Spacer 2 + ¾" SQ

(Templeton-Kenly and Co./ Phone 708-865-1500)

RC121 S/A Center Hole Cylinder – 12 ton (Single acting hollow bore hydraulic ram)

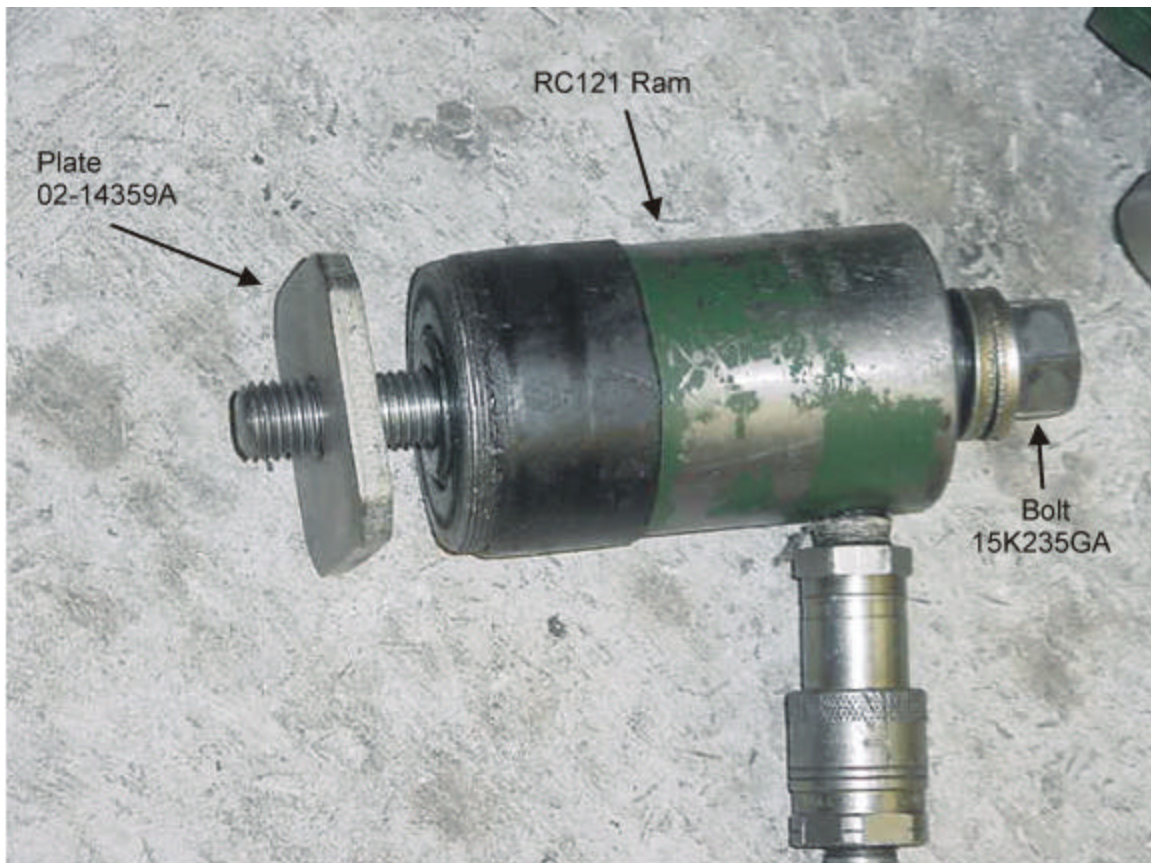
P42 Two speed, hand operated, hydraulic pump

HC6 ¼" ID X 6' long hose with coupler

GT30 3 ½" Gauge

GA1 Gauge Adapter

Complete view of assembled ram. See Figure A



Breakdown view of Hydraulic Ram and Installation Components.

Figure A

PROCEDURE

- 1) Clean shaft and the inside bore of the clutch or brake drum. Figure 1
- 2) Insert key to keyway slot on shaft. Figure 2
- 3) Slide the basket onto the shaft. Figure 3
- 4) Thread the pressing fixture into the shaft. Figure 4.
- 5) Hand tighten bolt to the shaft. Figure 4.
- 6) How the components look installed. Figure 5.
- 7) Pump the Porta-Power to 4,750 psi (5 tons) for 30015 or 9,500 psi (10 tons) for the 30022 machines. Figure 6
- 8) Release the pressure and remove the fixture
- 9) Install the shaft retainer hardware. This consists of the hexcapscrew, lockwasher, cover-shaft retainer, and spacer. Tighten the hexcapscrew as tight as possible.



Figure 1



Figure 2

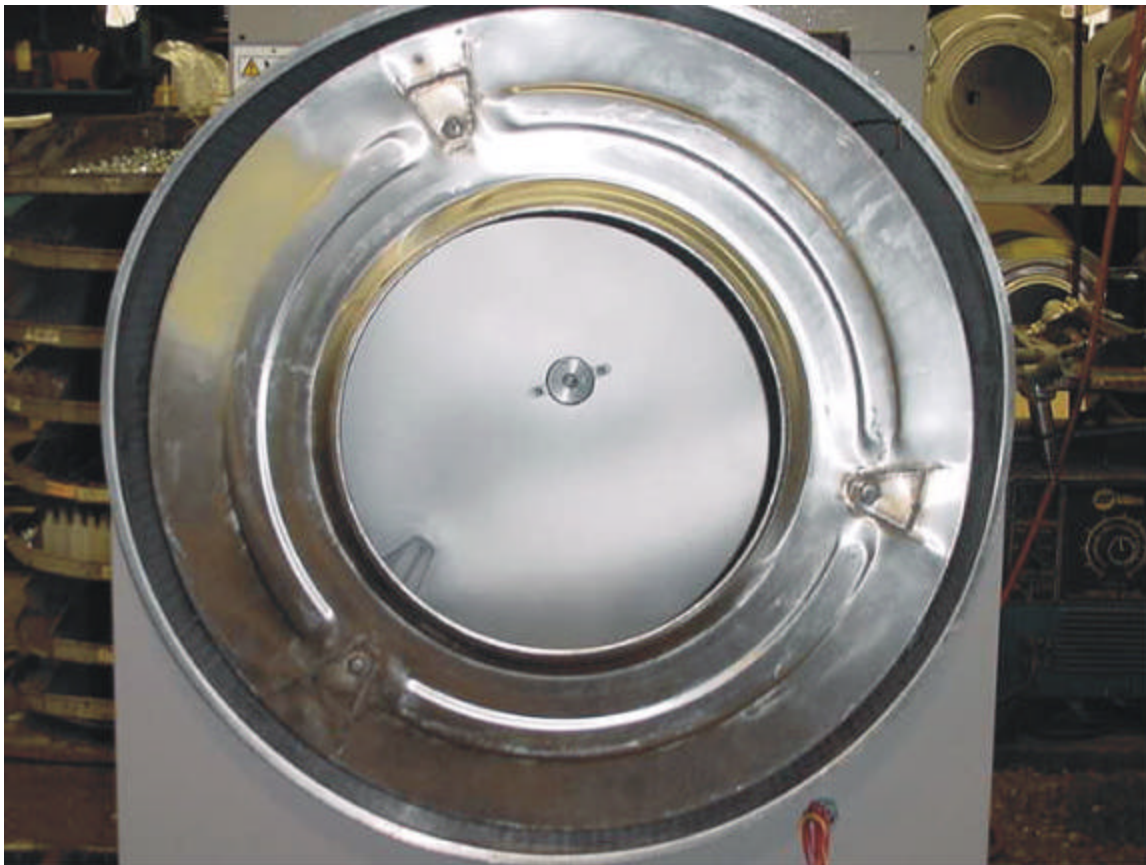


Figure 3

Rear of Basket

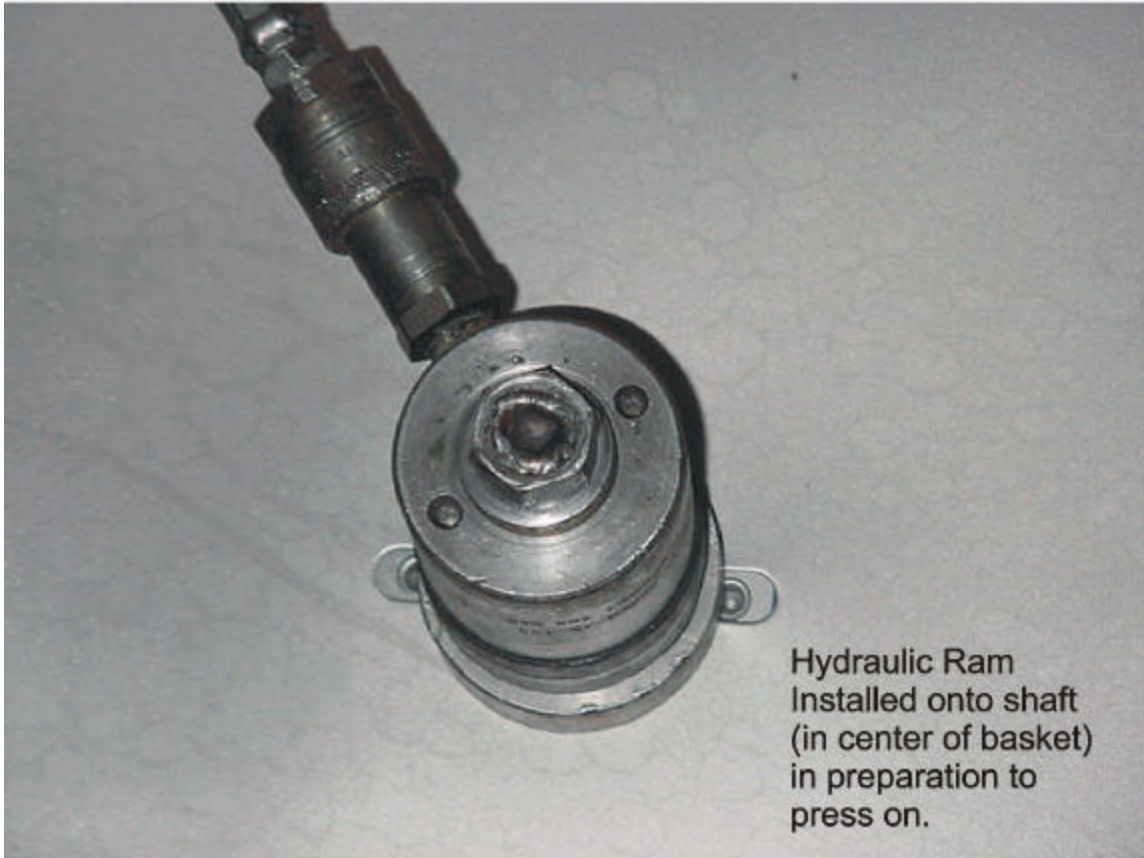


Figure 4

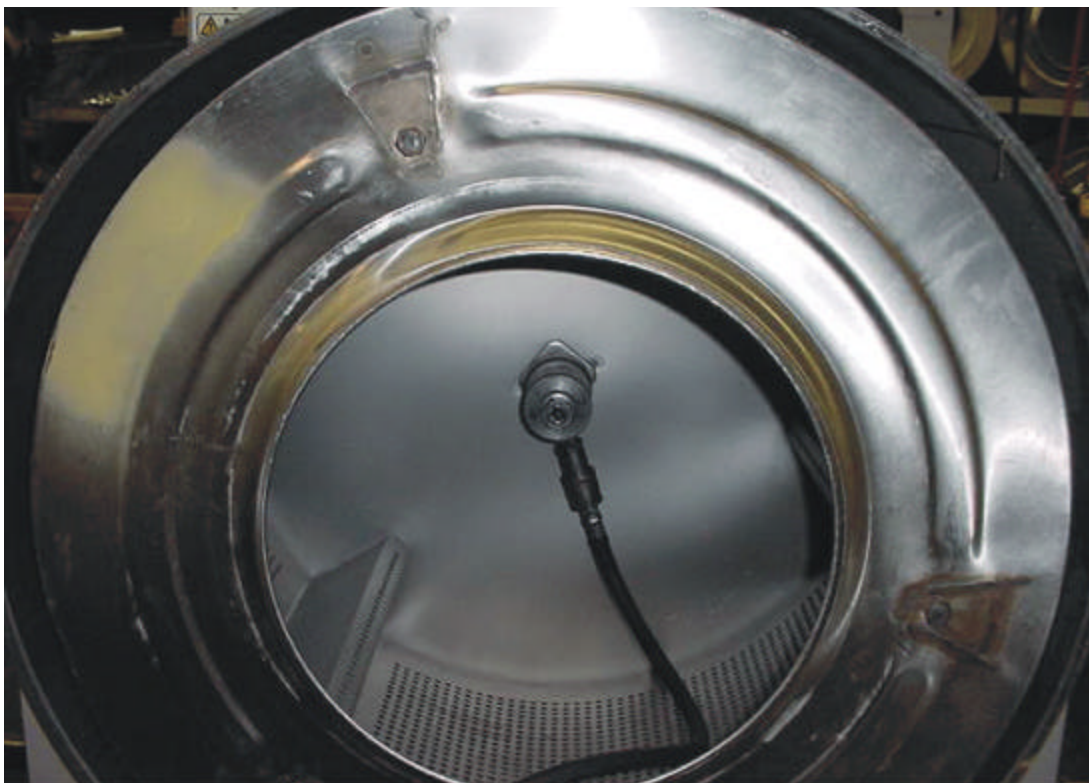


Figure 5

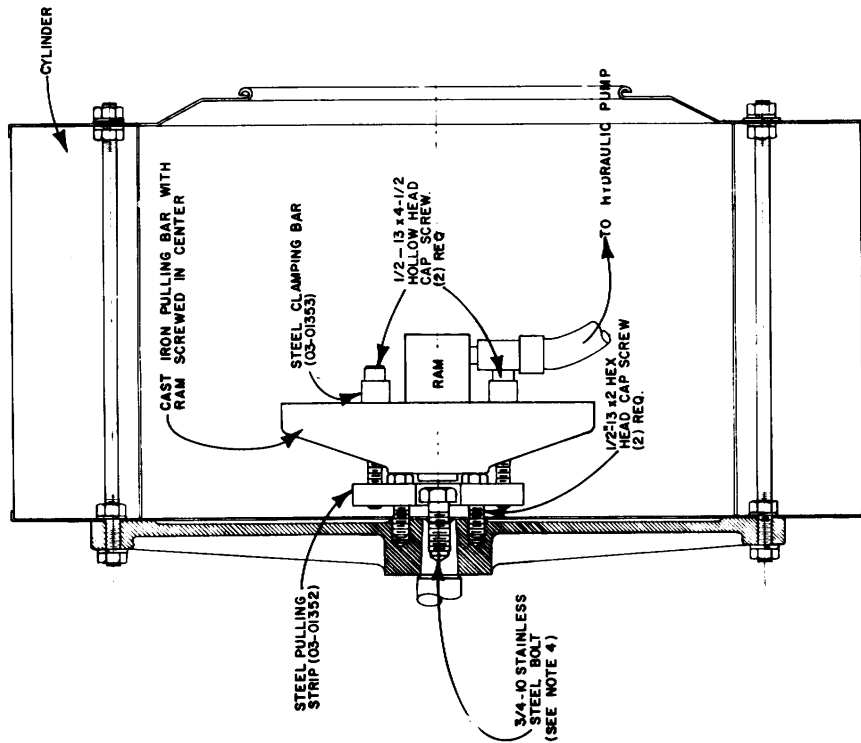


Figure 6

CYLINDER PULLING INSTRUCTIONS HYDRAULIC PULLER

TO REMOVE THE CYLINDER & SPIDER FROM THE MAIN SHAFT AS A COMPLETE UNIT PROCEED AS FOLLOWS:

1. REMOVE SHELL FRONT.
2. REMOVE 3/4" CYLINDER RETAINER AND LOCKWASHER. (ON LATER MODELS A STAMPED RETAINER WITH A SPACER IS USED INSTEAD OF THE CAST RETAINER).
3. REMOVE THE TWO 1/2" ALLEN HEAD SET SCREWS FROM THE SPIDER. THESE SCREWS WILL BE VISIBLE ONLY AFTER THE RETAINER IS REMOVED.
4. REPLACE THE 3/4" CYLINDER RETAINING BOLT WITHOUT THE RETAINER AND LOCKWASHER. THREAD THE BOLT INTO THE SHAFT AT LEAST 1". THIS IS A MOST IMPORTANT STEP SINCE THE HEAD OF THIS BOLT SERVES AS THE PUSHER IN THE REMOVAL OPERATION. UNLESS THIS BOLT IS REPLACED AS STATED, YOU STAND THE CHANCE OF DAMAGING THE THREADS IN THE END OF THE SHAFT.
5. BOLT THE STEEL PULLING STRIP TO THE CYLINDER 1/2"-13 x 2" HEX HEAD CAP SCREW.
6. ATTACH THE CAST IRON PULLING BAR AND RAM TO THE STEEL PULLING STRIP USING THE 1/2"-13 x 4-1/2" SOCKET HEAD CAP SCREWS. BE SURE THE RAM LINES UP WITH THE LARGE HOLE IN THE PULLING STRIP AND WILL PUSH ON THE HEAD OF THE 3/4" CAPSCREW.
7. TIGHTEN THE 1/2"-13 x 4-1/2" BOLT JUST ENOUGH TO HOLD ASSEMBLY IN LINE.
8. SLOWLY APPLY HYDRAULIC PRESSURE TO THE RAM UNTIL THE CYLINDER IS LOOSEMED



MATERIAL SPECS

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