REPAIR PROCEDURES
FOR THE
SAWSMITH RADIAL ARM SAW

This bulletin covers the procedures required to find and repair all normal problems encountered in the Sawsmith Radial Arm Saw.

PLEASE NOTE: The parts in this bulletin are often given two part numbers. In these cases, the six digit number should always be used in ordering. The four digit number (always in parenthesis) is only to be used as reference when old manuals and literature is available.

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How to change drive belt on the Sawsmith.

Tools required: Screw driver, small block of wood, approximately 1 1/2 x 1 1/2 x 3".

Before doing any repairs on the Sawsmith, remove all attachments from spindles.

Step #1 With power on, turn speed selector to slowest speed then turn off the power.

Step #2 Remove cover from cradle and cover assembly by removing four (4) screws, (#6666) 117295. Pull cover off bearing.

Step #3 Remove the two (2) screws, #503412 (6662) that fasten the motor to the cradle assembly.

Step #4 Turn speed selector (with power off) to fastest setting on dial.

Step #5 Lift motor (end opposite sheave assembly) and insert small wood block between cradle assembly and motor.

Step #6 Remove old belt by rotating sheave assembly manually.

Step #7 Place new belt into position on lower pulley on spindle pulley and slip belt on housing of sheave assembly of motor.

Step #8 Using both hands, grasp the friction sheave assembly, placing the fingers between the halves of the sheave assembly and palms of hands resting on end of motor shaft. Squeeze until spring is compressed.

Step #9 When spring is compressed, hold in position with one hand and slip belt on sheave. Rotate sheave so that belt is below the level of the sheave.

Step #10 Remove wood block.

Step #11 Place motor into position so that threads in motor frame are in the center of the hole in the cradle casting. Replace two (2) screws, #503412 (6662) and tighten.

Step #12 Reverse cover assembly and place over bearing while the cover with one hand with enough pressure to keep spindle parallel with motor shaft (spindle is parallel when the bottom of the lower pulley is even with the cradle casting) turn on power and observe belt alignment, by turning the selector to speed 30.
Step 13  If belt is not running true, loosen two (2) screws, #503412 (6662) that fastens motor to cradle assembly and move the motor in the direction necessary.

Step 14  Tighten screw, #503412 (6662), replace cover, cover can be replaced easily if speed dial is turned to fast speed while motor is stopped.

It must be remembered that under normal operating conditions speed dial should not be moved unless motor is running.

Trouble Shooting Pulley Alignment of the Sawsmith

Procedure A: Belt runs hot and belt life is short.

Solution:

Step 1 Dial speed selector to speed 30 and shut off power.

Step 2 Remove cover casting from cradle by removing four (4) screws, #117285 (6666).

Step 3 Check belt alignment by sighting along sheaves.

Step 4 If belt is not in alignment, loosen two (2) screws, #503412 (6662) that fastens motor to cradle casting and move motor until belt is in alignment.

Step 5 Tighten two (2) screws, #503412 (6662).

Step 6 Assemble cover on the cradle and tighten four (4) screws, #117285 (6666). Cover can be assembled easily if speed selector is set on slowest speed.

Procedure B: Replacing sheave assembly, #503243 (700027) or adjusting sheave for proper alignment.

Solution:

Step 1  Perform steps 1 thru 6 of "How to Change Drive Belt on the Sawsmith."

Step 2  This sheave assembly is fastened to the spindle by allen set screw, #139042 (6606). It is necessary to hold the two (2) halves of this sheave assembly apart during this operation. This can be done by using the head of a 5/16 x 1 1/4" counter sunk screw or by the head of a similar type screw.

Step 3  Place the fingers of both hands between the halves of the sheave assembly and compress the spring. Hold the spring under compression and place the head of the screw between the halves of the sheave assembly and against the shaft, then release the spring.
Step 4 Using allen wrench loosen set screw, #139042 (6606). The entire pulley assembly can be slipped from the shaft. Be sure that the screw remains in place between the halves of the sheave.

Procedure C: To replace the sheave assembly, #503243 (700027) on motor shaft or to adjust sheave assembly for proper belt alignment.

Solution:

Step 1 Place entire sheave assembly on the motor shaft, spreading halves of the sheave assembly by using a screw as described in steps 2 and 3 of problem B.

Step 2 Use small straight edge or square. Place straight edge or square against the outside surface of the spindle pulley (fixed half, #503237 (4739) so that it extends vertically past the sheave assembly, #400027 (sheave on the motor shaft). The distance, horizontally from the straight edge to the rear surface of the sheave, #503242 (4742) should be 1-1/16".

Step 3 Tighten allen screw, then check distance, remove screw holding sheave halves apart.

Step 4 To re-assemble unit perform steps 7 thru 14 of "How to Change Drive Belt on the Sawsmith."

Procedure D: Motor has whine type noise. This whine noise usually occurs when speed dial is set a fastest speed.

Solution:

Step 1 Turn on power, adjust speed dial to fastest setting.

Step 2 Remove cover from cradle assembly by removing four (4) screws, #117285 (6656).

Step 3 Check position of belt as follows:
(a) Belt may be extending above surface of two (2) halves of the motor pulley assembly, #503243 (700027). This allows belt to work in lower pulley assembly, (spindle pulley) until teeth on inside of belt are rubbing against spindle.

Step 4 Using small allen wrench loosen set screw, #140870 (6664) in speed dial, #503220 (700046), remove dial assembly.

Step 5 Loosen four (4) screws, #6652 that holds locator, turn locator clockwise, tighten screws. (This changes cam setting so the drive belt will not work down into lower pulley to the extent that the teeth on inside of belt touch spindle.)
Step 6  It may be necessary to drill holes in part #503215 (4727) to get enough movement. (This part was changed after first production models so the new part has clearance in holes and screw driver slots in part #503215 (4727) so that it is possible to rotate this easily.)

Step 7  Replace dial assembly and make sure it is set in the same relative position as when removed.

Bevel scales does not show zero degree setting when headstock is returned to that position after making 45 degree bevel cut.

Solution:

Step 1  See item number one in Sawsmith Owners Manual, page number two.

Step 2  Tighten securely, the three (3) socket set screws, #6636 that fasten item #700030 handle assembly in place.

Step 3  Release pivot lock pin and twist lock handle and turn 45 degree, return to zero degree setting, check indicator for accuracy.

Operator experiences difficulty in moving headstock from zero degree setting to 45 degree bevel cut position.

Solution:

Step 1  Check twist lock handle to be sure it has been loosened enough to allow cradle assembly to be moved.

Step 2  If cradle assembly still binds in any manner with twist lock loose, it will be necessary to install a shim between part #700030.

Operator experiences difficulty in moving the headstock because a loop of the cord catches on ribs of arm casting.

Solution:

Step 1  Remove cord box and tighten loop by placing cord over rod.

Procedure H: Pivot nut, #503207 (4841) not tight enough.

Solution:

Step 1  Loosen set screw, #115321 (1014):

Step 2  Turn nut clockwise and tighten set screw.

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How to replace Curl Cord, or remove for correction of tension.

At times if the entire headstock of the Sawsmith is rotated more than 360 degrees in the same direction there is a tendency for the curl cord to unwind or to add curls to the cord. Which of the above conditions happens depends upon direction of rotation.

Solution:

Step 1  Remove two screws #503415 (6474) that fasten locking lever #503102 (700061) to front of arm. Place headstock assembly in center of arm and lock into position.

Step 2  Remove nut #503390 (1482) that is located on #503097 (4686) rod - near the column. Be sure to remove spacer #503095 (4687) at the same time.

Step 3  Place curl cord #503098 (4694) on rod so that there are no curls over the rod. If curl cord is to be replaced these additional steps must be taken:

3-a. Rotate motor assembly 45 degrees left. Using needle nose pliers remove electrical fitting from box #503257 (4847). Disconnect the wires on the curl cord from box. Remove screw #163187 (6671) holding cord clamp to yoke.

3-b. Remove two #503415 (6747) cap screws at front of arm. These fasten locking handle #503102 (700061) to arm.

3-c. Remove two screws #163187 (6671) holding cord clamps to arm casting.

3-d. Disconnect wires from switch.

3-e. Remove curl cord by pulling locking rod and handle assembly out of cord.

3-f. Replace new cord by inserting locking rod and handle through cords. Be sure that curl cord end which fastens to electrical box is on left side of locking rod.

Proceed by following steps 3-e, 3-d, 3-c, 3-b and 3-a in that order and replacing items removed. Then follow steps 2 and 1 assembling the articles removed under these steps.

Lubrication of Sheave Assemblies

Solution:

Step 1  With the power on, turn dial to slow setting then turn off power.

Step 2  Remove cover from cradle (this is over right hand spindle) by removing four screws #117235 (6666).
Step 3 Turn speed dial to fast setting (this is done with power off to remove tension on belt). Pull cover off bearing.

Step 4 Lubricate the shafts of both upper and lower pulley assembly with light weight oil. A few drops on each is sufficient.

Step 5 Replace cover and four screws #117285 (6666).

Step 6 Turn on power and turn speed dial to slow setting, then back to fast setting.

To disconnect curl cord wire from box #503247 (4847) located on motor assembly. To change relay on capacitor.

Solution:

Step 1 Rotate motor assembly left approximately 45 degrees.

Step 2 The small electrical fitting in the side of the box #503247 (4847) can best be removed by using needle nose pliers. It is necessary to grip the fitting with the pliers so that the top section of the fitting (this section moves up and down to lock fitting into the box) is pushed down, then connection can be removed from the box.

Step 3 Loosen two screws #193238 (6675) and remove bxc.

Step 4 The curl cord can be disconnected, or the capacitor or relay changed. (Be sure to replace electrical connections correct. See diagram in Manual.

Step 5 Replace all parts by following steps #3, 2, and 1 and replacing items removed under these steps.

How to replace #503118 (700057) Switch Assembly

Solution:

Step 1 Remove the two #503415 (6474) cap screws at front of arm. These fasten locking handle #503102 (700061) to arm. Put headstock assembly in about center of arm and lock into position with carriage lock. Allow lock rod and handle assembly hang until rod is stopped by headstock.

Step 2 Remove the two small screws #163187 (6671) from front of arm. This allows switch to be free.

Step 3 Remove two screws #503410 (6651), these hold switch and green ground wire.

Step 4 Transfer wires to new switch.

Step 5 Replace green wire under screw #503410 (6651) and fasten. Replace the other screw.

Step 6 Follow steps #2 and 1 - replacing parts removed under those steps.

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In some instances due to manufacturing tolerances in early model Sawsmith it may be found that it is impossible to adjust the arm to be square with the table by adjustments given in owners manual. If this happens, the following steps are necessary to enlarge holes in castings of column #503387 (4670).

Solution:

Step 1 Remove drive pin #503389 (6683) (was roll pin #455734 (1609) from coupling #503154 (4817) which is part of the raising and lowering mechanism located under base assembly. Remove rod.

Step 2 Push carriage assembly all the way to the rear and lock.

Step 3 Remove four screws (426370 (6456) that fasten #503387 (4670) column to metal base #503123 (700003).

Step 4 Lift entire assembly off base.

Step 5 Enlarge holder in base of column approximately 1/16" or to 15/32 size.

Step 6 Replace column assembly and secure bolts.

Step 7 Replace rod by installing #503389 (6683) drive pin removed in Step #1.

Step 8 Adjust arm correctly following Step #5 page number four of Owners Manual.

To remove entire headstock assembly from arm for replacing track #503089 (4671) or changing complete headstock assembly, place carriage about 1/3 of way toward rear and lock.

Solution:

Step 1 Remove cover assemblies #503322 (700062 and #503279 (700063) by removing four small screws fastening each. Remove knob from lever - #503189 (700055) and #503199 (4712) by pulley over end of lever. Lower Drive assembly until it is about 2½" from table. Pull table all the way to front.

Step 2 Pivot entire headstock approximately 45 degrees to left so that it is possible to remove front carriage stop. (This can be removed by lining up the hole in yoke casting with allen wrench to remove stop screw. Pivot motor and cradle assembly to right approximately 65 degrees for greater clearance). The small rubber stop will pull off screw, do not lose.

Step 3 Pivot motor and cradle assembly to 90 degrees and lock.

Step 4 Remove cord clamp #503387 (6670) by removing screw #163187 (6671). Rotate motor and cradle to 0 degree and lock.
Step 5 Unlock carriage lever - Pull entire headstock off front of arm. Be careful to hold weight of entire headstock so that when bearing come over end of track no damage will be done to rear bearing. Place on table.

Step 6 Using small screw driver, pry track off. This can best be done by using the small screw driver to pry at the very rear part of arm and track. In most cases the track and roll pins will come off together. The rod can be removed best by sliding the screw driver along the rod and prying a small amount along various places.

Step 7 Replace track or rotate track 90 degrees. If entire headstock is to be replaced see step 3-a, procedure I for removal of curl cord from headstock.

Step 8 Pick up headstock - line up bearing with track and place on arm. Lock carriage lever.

Step 9 Re-assemble unit by following steps 4, 3, 2, and 1 and replace all items removed under those steps.

Replacement of Bevel gears #503153 (4676)

Solution:

Step 1 Remove roll pin #453676 (1638) from bevel gear attached to #503155 (4618) shaft by using 1/8" punch.

Step 2 If this is gear that is damaged, replace gear, replace roll pin.

2-a. Remove Roll pin #453676 (1638) fastening gear #503153 (4676) to shaft #506975 (4674) by using 1/8" punch.

2-b. Replace gear on shaft and install roll pin #453676 (1638).

Replacement of #503142 (700050) bracket assembly. Place carriage all the way to rear and lock in position.

Solution:

Step 1 Remove Drive pin #503329 (6633) from coupling #730120 (4817) that is attached to #503206 (4318) shaft by using 1/8" punch.

Step 2 Remove rod, save drive pin.

Step 3 Remove four screws #426370 (6456) that attach column #503387 (4670) to base #503417 (700003). Be careful to hold entire column.

Step 4 Remove column assembly and lay in position so that arm is perpendicular to bench or table.

Step 5 Remove three cap screws #100121 (6353) that secure bracket to column.

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Step 6  Remove both bevel gears by removing roll pin in each part 
        \#453676 (1638) using 1/8" punch.

Step 7  Replace bracket \#503142 (700060) with bushings installed.

Step 8  Replace parts by steps 6, 5, 4, 3, 2, and 1.

To replace \#506785 (4674) shaft - screw or \#503147 (700007) tube assembly.

Solution:

Step 1  See procedure P - Follow steps 1 through 6.

Step 2  Tube assembly can be removed from column by lifting off of
        the pin \#503181 (4700) - note (Teflon washer is mounted
        next to bracket casting and plain washer \#120394 (1502)
        is above it).

Step 3  Part \#506975 (4674) and \#503147 (700007) can be separated by
        turning shaft out of tube assembly.

If part \#506975 (4674) is to be replaced it will be necessary
        to take the following steps:

a.  Place shaft screw in bracket \#503142 (700060).

b.  Place \#503153 (4676) bevel gear on extension of shaft
        screw into bracket and the bevel gear toward the
        bracket by use of clamping arrangement.

c.  Drill 1/8" hole through shaft extension with gear in
        place and by using hole in bevel gear as pilot.

Adjustment of pulley \#503237 (4739) for proper alignment.

Pulley \#503237 (4739) is now attached to Spindle with
set screw \#102581 (1061) instead of roll pin \#6576.
This change was made at Sawsmith Serial number 7001869.
In some cases the Sawsmith may have belt noise at low
or high speed.  The noise is usually caused by the pulley
opening so that the inside of belt (with serrated type
teeth) runs against spindle.  This can be eliminated
by proper pulley adjustment.

Solution:

Step 1  If the noise occurs at high speed it is necessary to move
        pulley \#503237 (4739) to the left (toward the motor assembly.)

Step 2  If the noise occurs at high speed it is necessary to move
        pulley \#503237 (4739) to the right (toward right end of
        spindle) a small amount.

Step 3  Be sure to check the alignment of the upper and lower pulley
        assemblies after making adjustments.
To Remove Arm & Collar Assembly

Solution:

Step 1  Remove two screws #503409 (6650) to remove Cap Assembly, Miter, #700064.

Step 2  Use large Snap Ring pliers to remove Snap #6475.

Step 3  Place wood block under motor and cradle assembly. Lower Motor Assembly to rest on block.

Step 4  Loosen #222460 (1058) Set Screw to remove #503181 (4700) Collar Pin.

Step 5  Lift entire Arm and Collar Assembly from column #503327 (4870).

Step 6  To replace Collar and Arm - Lubricate entire surface of Arm Casting and Collar with light lubricant - Parafin.

Step 7  If Collar or Arm has to be replaced, Procedure M. should be performed before starting Procedure E.
SUBJECT: Sawsmith #500003 (700000), Handle Assembly

An engineering change in the bill of materials has been written replacing the three allen head screws #6636 with longer hex head cap screws which are part number #122040 (6343) (5/16 x 13 x 1/8"

These three screws fasten 70039 handle assembly in place. There is the possibility that the #6636 allen head screw, which is shorter than the hex head screw #122040 (6343) will allow the handle assembly to move slightly when the Sawsmith is changed from an 0 setting to a 45 bevel setting repeatedly. The movement causes the bevel scale to read something other than 0 when indexed.

The hex cap screws will enable the operator to apply enough pressure on the screw with an open end wrench to prevent the movement from the zero degree setting once it has been properly adjusted.

All spare parts orders for allen head screw #6636 will be changed by the order writing department to hex head screw #122040 (6343).
SUBJECT: Improved belt alignment and adjustment of Sawsmith.
Effective Serial #7001869.

#503237 (4739) – Sheave has been changed as follows:

1. Roll Pin #6576 has been replaced by set screw #102581 (1061) to allow adjustment of Sheave #503237 (4739) on Spindle #503222 (4732).

2. Pulley #503237 (4739) will be shipped effective this date with set screw #102581 (1061) included.

3. If pulley #503237 (4739) must be replaced on units with serial # lower than #7001869 it is possible to use the spindle that is on the unit.

4. If spindle #503222 (4732) must be replaced on units with Serial #7001869 it will be necessary to order pulley #503237 (4739) also for replacement.
SERVICE BULLETIN #75

February 4, 1960

SUBJECT: Replacement of Scales on Sawsmit

These scales are located on assembly #700054 Miter Cap and #700030 Cradle Control Handle. The Miter Scale assembly #700064 is #503110 (4912). The Bevel Scale on assembly #700050 is #503263 (4802).

The scales can be applied by cleaning the surface with carbon tetrachloride. Apply a small amount of carbon tetrachloride to the back of scale and put in place. The scale has the type adhesive that is activated by the carbon tetrachloride.

Care should be taken when the scales are applied so that they will be in proper position.
SERVICE BULLETIN #30

September 21, 1960

SUBJECT: Engineering Changes in Sawsmith which affect interchangeability of Spare Parts.

1. Number 700010 collar and number 503107 (4307) pin were changed with serial number 704576. The new style collar has no knurling on outside surface, the new locking pin has knurls.

REPAIR INSTRUCTIONS

Order spare parts for Sawsmith by serial number. Old collars and pins are available and should be used on units below serial number 704576.

2. Indexing of Saw Arm

a. Number 700010 collar was changed beginning with serial number 706080 to place index hole at 70 degrees from automatic setting for Add-A-Tool Bracket. All units above this serial number do not have indexing automatic stop at 90 degrees right. Units below this serial number will have to be set in place and locked for Add-A-Tool adaption.

3. When ordering parts for Sawsmith include the following information:

   (1) Model number of unit.
   (2) Serial number of unit.
   (3) Part number of parts.
   (4) Description of parts as given in parts manual.
SERVICE BULLETIN #01

October 5, 1960

SUBJECT: Proper indexing of Sawsmith Radial Arm Saw

In some cases dealers have reported that the indexing of the arm on the Sawsmith does not function properly in that the saw blade does not return to the same position if the arm is moved from 30 degrees or more right back to zero as it does from 30 degrees or more left, back to zero.

Corrective Steps to Take if this Occurs:


2. Lubricate the lock pin by spray type lubricating oil.

3. Move the arm 30 degrees right, hold the arm lock lever up towards the arm until tension can be felt on the lever, then return slowly to zero degrees. Mark the position of the blade on the table. Follow the same procedure and move the arm to the left and return to zero. Blade position should be same as before.

4. In some cases the index pin does not seal properly because the arm lock lever is allowed to hang free and the arm is moved rapidly back to zero. Hold the arm lock lever in position towards the arm until spring tension is felt on the lever, move the arm slowly back to zero setting.
SERVICE BULLETIN #92

October 5, 1960

SUBJECT: Checking Indexing of Motor Carriage Assembly on Sawsmit.

The Sawsmit is manufactured with automatic stops for bevel cuts at 0, 45 and 90 degrees right and left. Field reports indicate that after many hours of use there may be movement when the unit is indexed at these positions. This is caused by the small inserts #503205 (4810) that are pressed into the yoke casting being pounded oblong from slamming the motor and carriage from one index position to another. This movement can be corrected by replacing the inserts in the yoke assembly - part number 503203 (700015).

Procedure:

1. Remove (3) three bolts holding handle assembly to the yoke casting. (Support the motor assembly on wood block when removing bolts.)

2. Remove the large allen screw #503277 (4852) holding rear of cradle and motor to yoke.


4. Use correct size punch and drive inserts out of yoke. Drive from rear toward front.

5. Place new inserts #503205 (4810) into position and drive into place using wood block to drive inserts and support rear of yoke casting with heavy block to prevent bending of yoke casting.

The #503205 (4810) is now shown in parts manual but is available. The same insert #503205 (4810) is used in top of yoke casting for indexing the yoke casting horizontally.
SERVICE BULLETIN \#24

October 5, 1960

SUBJECT: Relay for Sawsmith Radial Arm Saw

Relay Identification:

The relay used on the Sawsmith Radial Arm Saw is part number 503331 (6478) and has the following identification marking:

3ARR 3T 7BB5
SERVICE BULLETIN #96

October 31, 1960

SUBJECT: Changes in Part Numbers on Sawsmitl beginning with Serial No. 709952 on Model No. 500005 (700005) and Serial No. 710851 on Model No. 705000 Dual Voltage.

1. 500005 (700005) Sawsmitl is manufactured with 6727 U.L. Marker.

2. Part No. 503274 (4946) knob locking added to cradle control.

The units beginning with the above serial numbers have the following changes in the parts manual on page 3 and 4.

1. Reference #108 not shown part #503274 (4946) knob locking on cradle control.

2. Reference #48 part #4849 handle replaced by #503272 (4944).

3. Reference #59 part #455277 (6483) Pin, Roll replaced by number 455734 (1609) Pin, Roll.

4. Reference #95 part #700030 handle, cradle control replaced by part #503260 (700069), cradle control handle.

5. Reference #96 part #700032 cam shaft assembly replaced by part #503269 (700071) cam shaft assembly.
SERVICE BULLETIN #62
November 1, 1960


Adjustment of Yoke Lock Lever:

1. If the yoke lock lever does not properly lock the yoke when moved to a setting between automatic index stops the following steps should be followed:

   a. Move yoke lock lever to lock position.

   b. Remove plastic knob from lever #503129 (700055) lever assembly and remove cover #503322 (700062) by removing four (4) mounting screws.

   c. Loosen allen set screw #426094 (1060) (Early models have #6655 set screw with screw driver slot - these should be replaced with #426094 (1060)).

   d. Move lock lever to index position while pushing against part No. 503133 (4704) screw clamp with small screw driver. Tighten allen screw #426094 (1060) (do not over tighten). This screw should be coated with loctite. This should make lever adjustment enough so that yoke is locked into position at any stop. Check to be sure assembly indexes properly before installing cover.

If pin does not index properly, too much force has probably been applied to allen screw. The loctite will prevent the set screw from loosening during operation so extreme pressure need not be applied.

The above procedures should be followed until correct adjustment is obtained.

Adjustment of Carriage Lock:


2. Be sure allen screw is finger tight.