



INSTRUCTION SHEET

No. 2 LC Jaw Bushing Replacement Kit

A228501

This instruction sheet describes the steps necessary to replace the guide rod bushings and seals in a No. 2LC movable jaw.

Kit Contents: Removal tool (212503), Bushing installation tool (212506), Seal installation tool (212507), Support plate (212504), Reamer (MJL00069)

Tools Necessary: Arbor Press (Minimum Working Height 8'), Slotted Screwdriver

1. Remove the movable jaw from the unit.
2. Remove the seals and wipers from one face of the movable jaw as shown in Fig. 1.



Fig. 1

3. Align the jaw to the support plate using the bushing installation tool (212506) as shown in Figs. 2 & 3. (Note: The seals on the back side of the jaw will retain the jaw bushing installation tool in place and guarantee alignment with the bore in the support plate.)



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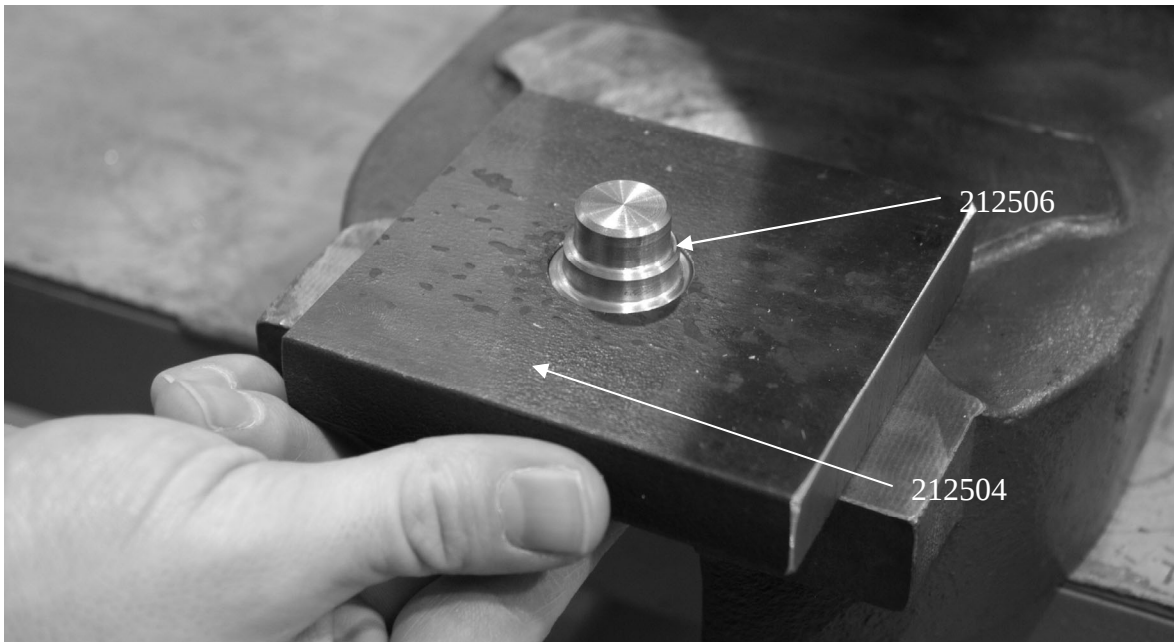


Fig. 2



Fig 3.



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4. Insert the removal tool (212503) and press out the old bushings using an arbor press as shown in Fig. 3. Be careful to catch the installation tool, both bushings, and the removal tool as they clear the bottom of the jaw to avoid damage to the tools and possible injury.
5. Install one bushing from the front of the jaw using the installation tool as shown. Install one bushing from the back side of the jaw using the installation tool as shown in Fig. 4.

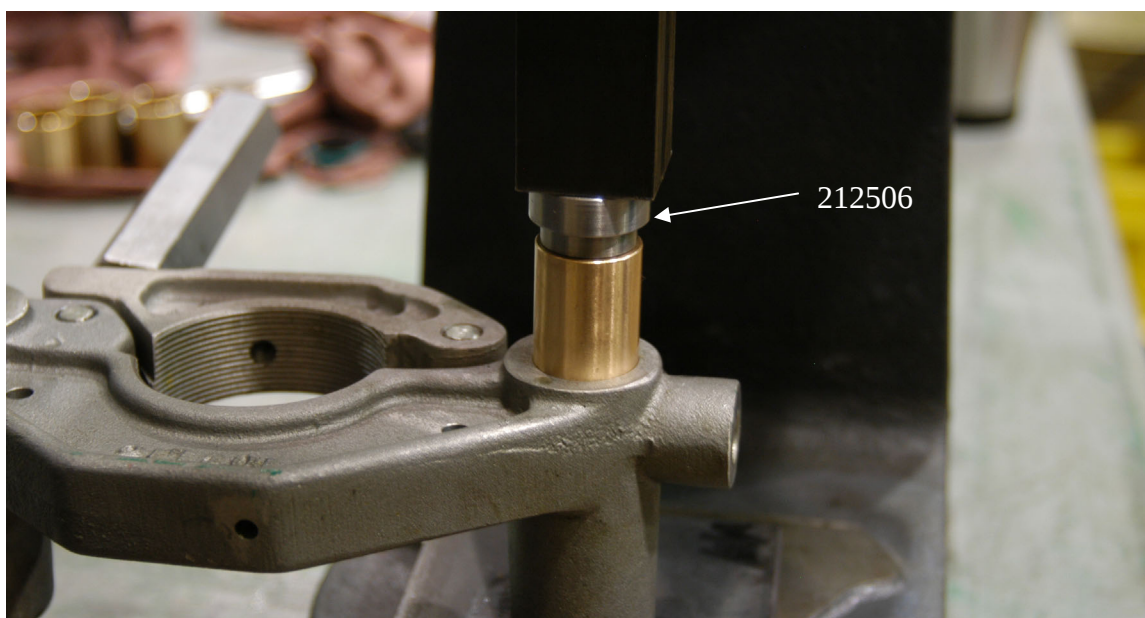


Fig. 4

6. Repeat steps 2-5 for the other side of the jaw.
7. Assemble unit and check to ensure that the jaw slides on the guide rods with a minimum amount of force required on the lever handle. Remove the movable jaw.
8. If necessary, ream the bushings using the supplied reamer (MJL00069). Otherwise proceed directly to step 9.
9. Install the seals with the flat sides facing each other, as shown in Fig. 5. Use the jaw seal installation tool (212507) as shown in Fig. 6.



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Fig. 5



Fig. 6

10. Reassemble the jaw onto the Unit.

11. Refill the oil reservoirs on top of the jaw with 10W40 motor oil. Take care not to over tighten the pipe plug after filling.