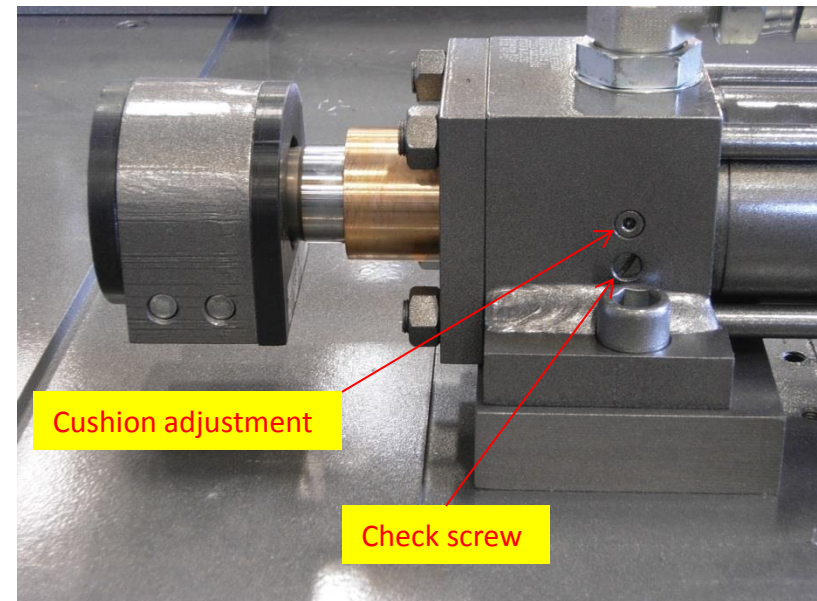
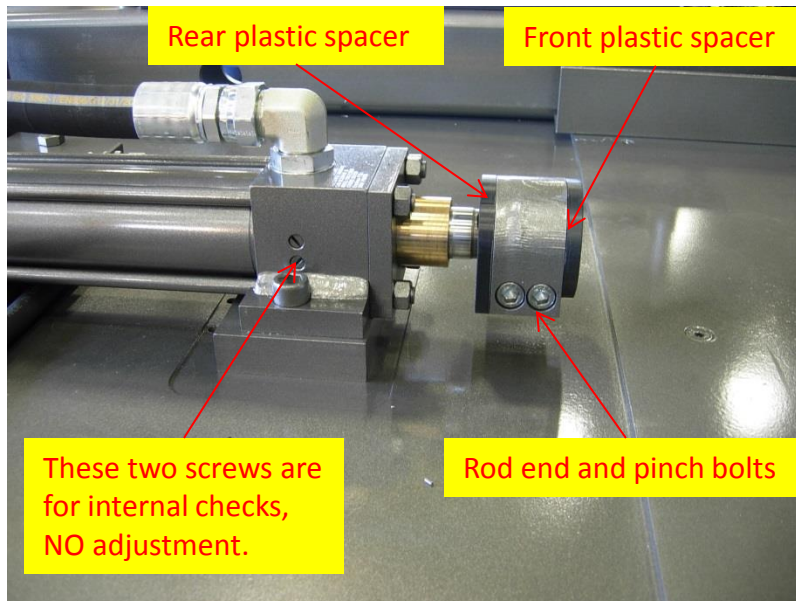


ALL BLOCK MACHINE FEED DRAWER CYLINDER CUSHION ADJUSTMENT AND ROD END



Before installing rod end, apply small amount of blue 242 Loctite to shaft and pinch bolt threads. Install rear plastic spacer on shaft. Thread rod end on till it bottoms out on shoulder of shaft. Use a rubber hammer and make sure it is tight to shoulder of shaft with one or two impacts. Tighten pinch bolts to 125 foot pounds, install front plastic spacer. When installing the feed drawer make sure the cylinder is as shown, completely retracted so the rod and grand are NOT put into a bind, this can cause cylinder and grand failure. Feed drawer should be lifted level and will fit tightly to rod end assembly.

The bottom screw is another internal check, NO adjustment. The Allen style is used to adjust the cushion. With the feed drawer installed adjust so the cylinder is NOT banging at end of stroke. This should be checked every six months for correct operation. Failure to do this will result in premature cylinder failure. Every cylinder new or rebuilt needs this adjustment performed.