

Service Procedure

CF8 Spring Plunger

Replacing & Setting Spring Plunger (PN S5003)

Prepare CF8

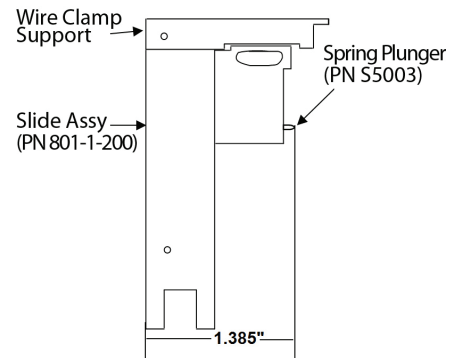
To prepare the CF8 for spring plunger replacement:

1. Unplug machine power.
2. Remove the transport wheels.
3. Close station 1 (Infeed Chute Adjustment).
4. Remove all dies from stations 6 & 7.
5. Set station 6 & 7 to 700.
6. Set station 8 & 9 to 0 (zero).

Remove Spring Plunger

To remove the spring plunger from the CF8:

1. Loosen set screw in crank (PN 801-1-7) in station 8 & 9.
2. Remove crank pin (PN 801-1-12).
3. Remove slide assembly (PN 801-1-200) by lifting it upward.
4. Remove 2 cap screws securing wire clamp (PN 801-1-9) to wire support.
5. Rotate clamp support 90 degrees and lift roller support upward.
6. Remove clamp support as follows. For machines built:
 - before 09/1988: use vlier wrench and remove spring plunger (PN S5003).
 - after 09/1988: loosen set screw (PN TCAN0832012) and then remove the spring plunger (PN S5003).



Replace Spring Plunger

To install a new spring plunger in the CF8:

1. Prior to installing a new spring plunger (PN S5003), place a drop of oil on plunger tip and then work plunger spring. For machines built prior to 09/1988, use teflon tape on plunger threads.
2. Install spring plunger to measure 1.385" \pm 0.001" from back side of slide assembly to tip of plunger.
3. *For machines built after 09/1988 only:* Tighten set screw.
4. Secure wire clamp to clamp support in reverse of [Step 4 \(Remove Spring Plunger\)](#).
5. Place slide assembly (PN 801-1-200) into die block and lower slide to bottom of die blocks.
6. Align hole in slide with holes in crank (PN 801-1-7) and install crank pin (PN 801-1-12).
7. Center crank pin so ends of the pin do not protrude from edge of slide, and then install and tighten set screw.
8. Lubricate slide assemblies per standard manual instructions.