



## REPLACING UPPER ACTUATING ARM

### INSTALLATION INSTRUCTIONS

Part Number: **SIZE290100**

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1. Empty all components from machine, drain shot and powder reservoirs, remove shot and powder reservoir plate assembly, and remove gear rack.
2. Remove 1/4-28 x 1 button head cap screw (BHCS) "A" on the underside of the Crosshead. LOOSEN THE 3/8-16 X 1 BHCS "B" in the toolhead 2/3 the way out and tap it with a soft hammer (i.e. plastic or brass) or mallet to knock the actuating assembly with the finish shell or knockout out of the toolhead and off the two guide pins.
3. Now, remove screw "B" and the assembly will drop out.
4. Remove 10-32 x 3/8 "C" screw (one of two) and remove Upper Actuating Arm and replace with the new arm.

**IMPORTANT:** When replacing the actuating arm onto the hex shaft, be sure it tilts BACK 60° (one notch) when the Lower Actuating Arms "D" are pointed STRAIGHT DOWN.

5. Reinstall and tighten screw "C", install assembly in Toolhead. I use BLUE Loctite on screw "C" when I do this. Be sure to align holes in the top Knockout assembly *with the two guide pins in the tool head*. If these are NOT lined up, when you tighten screw "A," these pins will rise up and out of the toolhead and could bend. Should this occur, you have turned part # 48 180°. Turn and install correctly.
6. Install screw "B" and tighten (pulling the assembly up into place in the toolhead.)
7. Replace the Rack Gear with the timing marks lined up with the marks on the shot and powder gears.
8. Replace shot and powder reservoir plate.
9. See reverse side for areas to check to avoid future breaking.

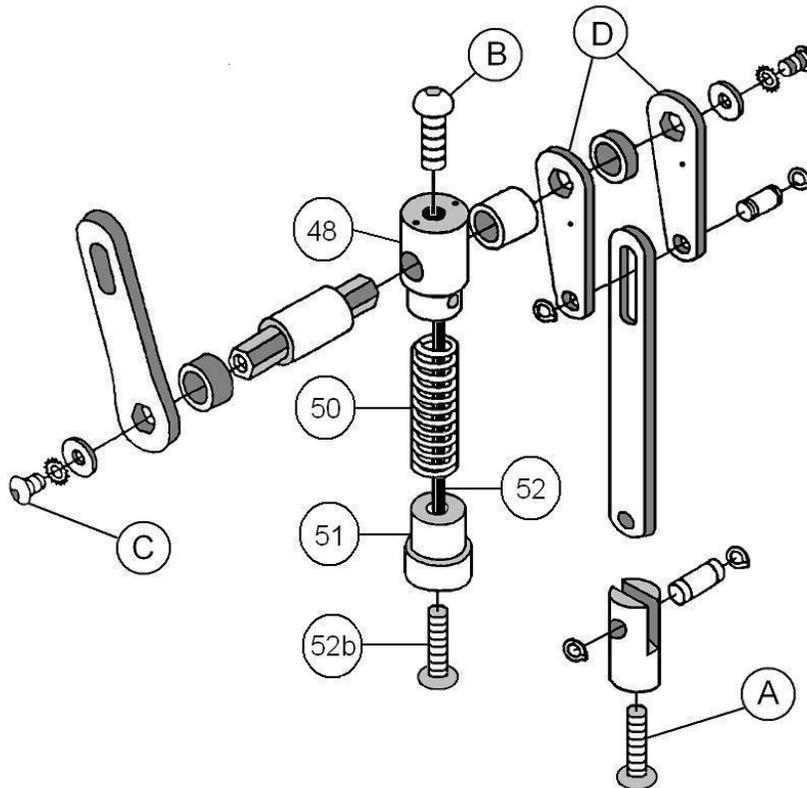
>>> SEE REVERSE SIDE FOR SCHEMATIC <<<

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Upon completing the replacement you want to carefully check several areas:

1. The Upper Actuating Arm should NOT wobble left-to-right.
2. Allenhead screws "C" should be tight against the upper link with NO "play".  
Often one will find the hex shaft is either worn, OR it is a couple thousandths too long, permitting the wobble. If this is the case, replace it.
3. Be sure that all moving parts have been liberally oiled or greased.
4. The Upper Actuating Link should NEVER touch/bind at the rear of the top toolhead's opening. There should be no more than about 1/8" of front-to-rear "play" when the operating handle is all the way back at rest. See Index Pad Instruction on my website for further explanation and correction, should this be your situation.

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