

# REPLACING WAD CARRIER BUSHING INSTRUCTIONS

## MOST Models

1. Remove primer tray & track from machine.
2. Remove screw attaching actuating assembly to the crosshead (located underneath the right side of the crosshead just to the right of the Shell Insertion Station).
3. Remove Buttonhead cap screw (BHCS) holding the top tool head in place, remove head.

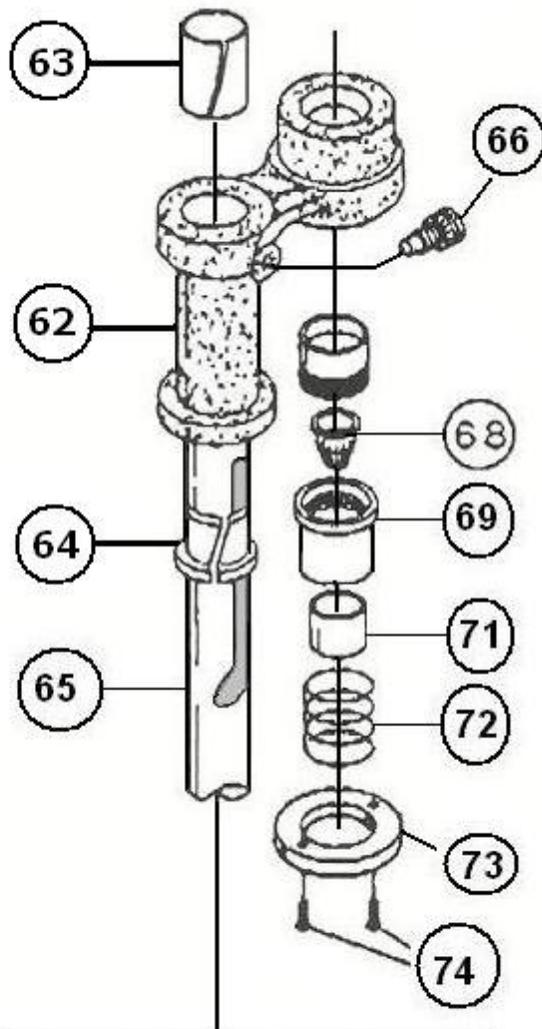
NOTE: These can be little buggers to loosen up. I recommend placing a hex socket into the recess and then smartly smack down on the socket with a hammer to break free the threads. I also recommend the reinstallation of new HEX-HEAD socket bolts and not the removed ones. Your kit may contain new bolts.

## INSTALL AND LINE UP NEW CARRIER BUSHING

1. Remove old wad carrier. You will have to remove #63, 1/4-20x3/4" BHCS and then remove both it and #62, Wad Carrier hold-down button.
2. With the Handle in the full down position (towards you), crosshead up, remove #63, 1/4-20x3/4" BHCS and then remove both it and #62, Wad Carrier hold-down button.
3. Remove (slide up the wad carrier assembly) by sliding up the left vertical post.
4. Remove old nylon bushings and thoroughly clean out the wad carrier housing.
  - A. May have to use a knife or small needle nose pliers to remove the top liner.
  - B. It would be a good time to remove the two setscrews #74 (enclosed drawing) and clean this area and inspect for wear. Often times the large coil spring #72 can work its way into and through the #73 Wad Carrier Washer making the unit operate sluggishly.
  - C. Inspect #66 Socket Head Cap Screw (SHCS) for ANY signs of a worn slat spot and replace as necessary.
5. Thoroughly clean out and grease the groove in #65 Left Guide Post.
6. Reinstall in reverse order. Grease the inside chamber of the Wad Carrier Assembly and both sides of the new bushing liners.
7. Check the line-up of the carrier and wad ram. Wad ram MUST be centered in the upper wad when the handle is in the down position. Failure to do so can break the wad carrier housing. SEE BELOW
8. IMPORTANT – When reinserting #66 SHCS, the Guide Post groove MUST BE VISIBLE. If some or all of the new top nylon bushing is blocking sight of the groove you MUST carefully rotate this bushing to its open cut slot to permit the reinsertion of the SHCS #66. Failure to do so will cause the SHCS to “punch” a hole through this liner, causing failure to correct operation.

LINE-UP COMMENTS – If you find that in the full down position, the Wad Carrier continually fails to line up directly under the wad ram, it may be necessary to rotate the Left Guide Post to obtain correct alignment.

1. To realign the Guide Post, loosen the top BHCS (or newly furnished bolt replacement).
2. Remove the two outer Allenhead set screws at the base of the Left Guide post, and the two inner set screws, if present), and slightly turn the entire Left Guide Post.
3. Rotate the Guide Post to the left or right until the wad ram is centered in the upper wad cup.
4. Tighten the top BHCS (or furnished bolt) above the Left Guide Post.
5. Push handle up and down allowing the wad carrier to move freely. Check alignment, and when you feel line-up is correct, replace the two setscrews in the base holding the Left Guide Post. Tighten them securely, both front and back. Replace the back up screws.



**Wad Carrier Assy**  
Same on all models