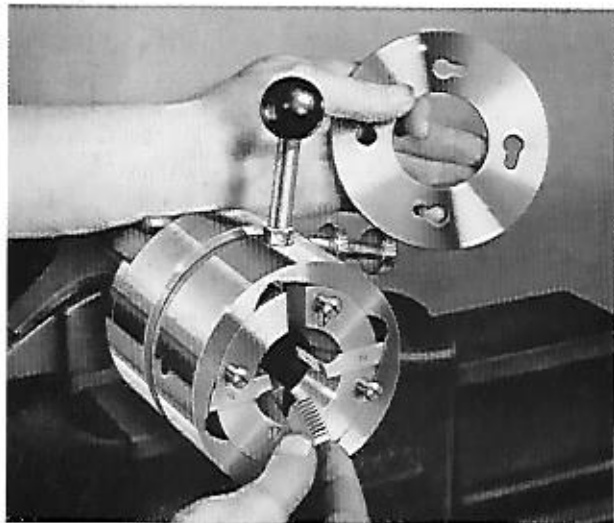


## INSTRUCTIONS FOR DISMANTLING AND RE-ASSEMBLING STYLE C.H. $\frac{1}{2}$ "-2" DIEHEADS

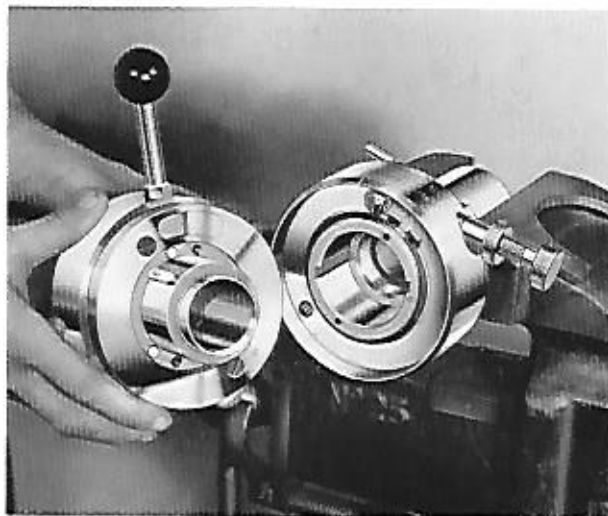
The following instructions apply when dismantling and re-assembling Style C.H. Dieheads sizes  $\frac{1}{2}$ " to 2" and, with slight but mainly obvious discrepancies, the  $\frac{1}{4}$ " and  $\frac{5}{16}$ " C.H., 2" C.H.S., 2 $\frac{1}{2}$ " and 3 $\frac{1}{2}$ " Style C Fine Thread Dieheads.

Tools required are a bench vice with soft jaws, two or three suitable screwdrivers, a hammer, several pieces of brass or copper rod for tapping out pins and bushes, and, if possible a pair of 'Circlip' pliers.

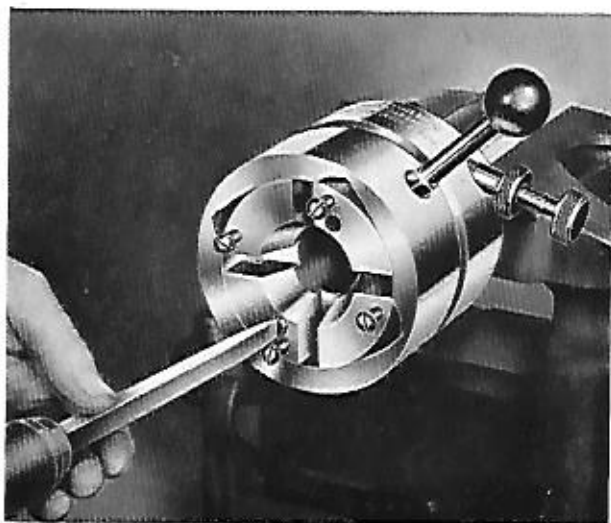
### Dismantling Instructions



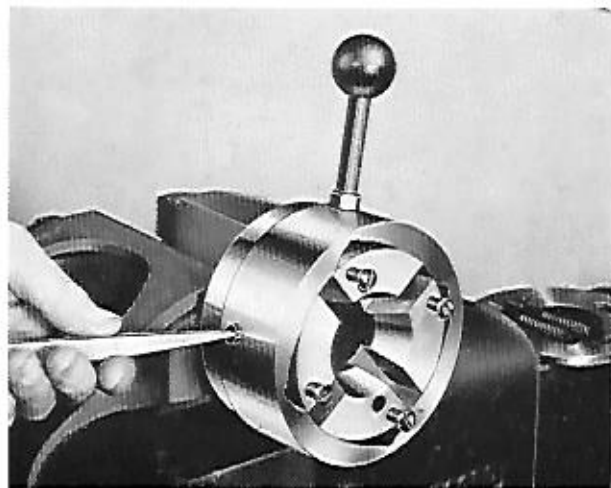
1. Close the diehead to take all pressure off the dies. Remove the front plate and dies.



3. Slide body out of adjusting ring support. Detent pin and tooth can now be examined. To remove tooth drive out the pin passing through it.

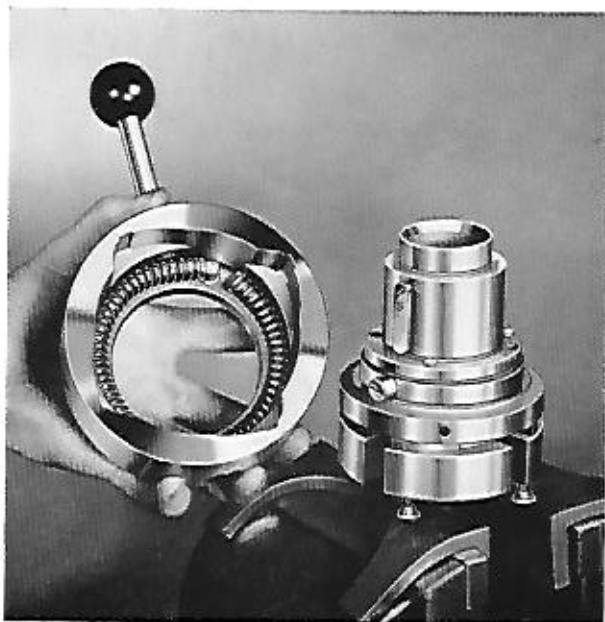


2. Open the diehead. Remove closing spring screws and springs.



4. Remove the two screws which hold together the external and internal scroll.

Dismantling Style C.H.  $\frac{1}{2}$ " to 2" Dieheads (contd.)



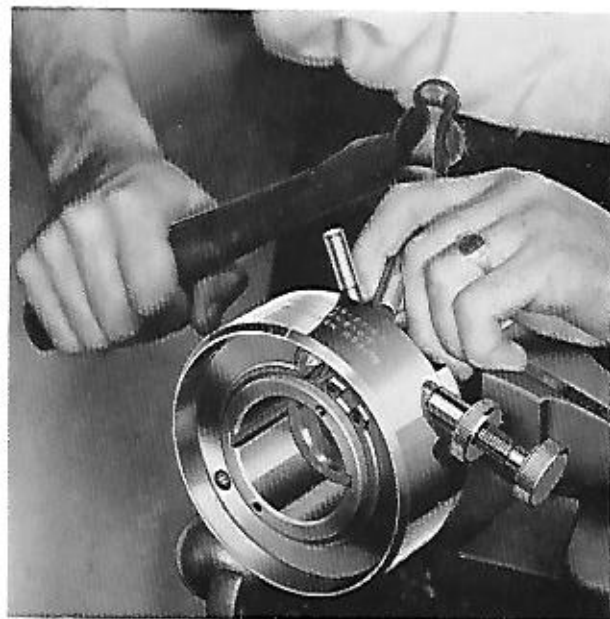
5. Lift the external scroll off the body. Opening springs can now be examined and removed, if necessary.



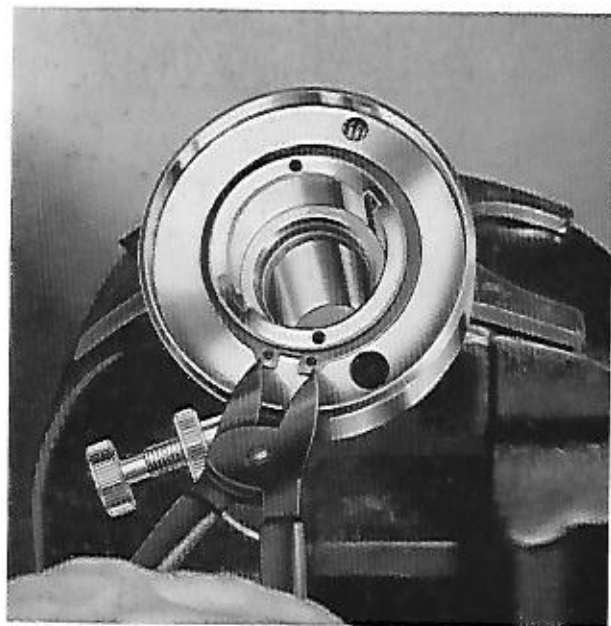
7. Remove the adjusting spring screw from the back of the adjusting ring support through the slot in the flange.



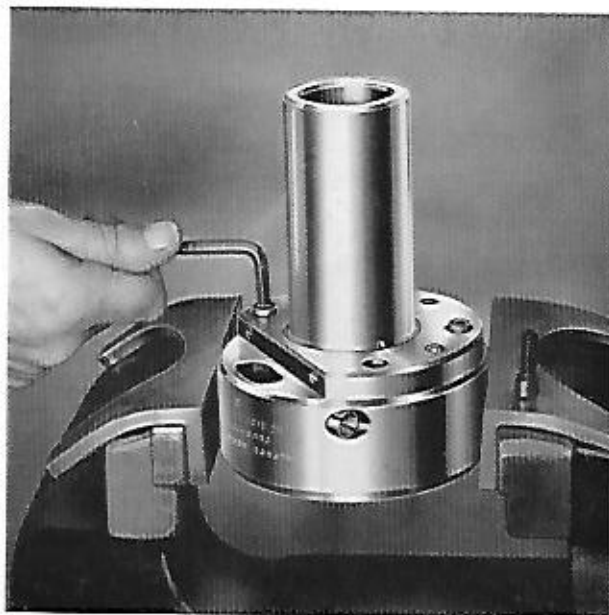
6. Remove the two cheese-head screws projecting from the body and lift off the internal scroll.



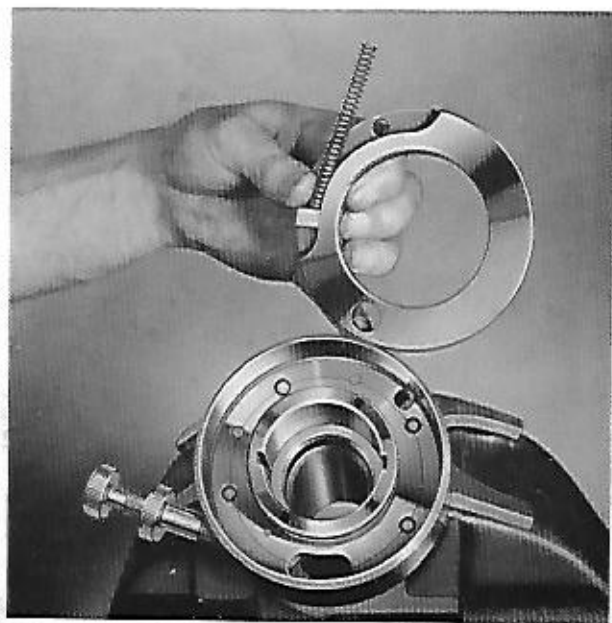
8. Remove the detent pin, nut and handle, and tap out the detent pin with its spring, then the bush.



9. Remove the 'Circlip' ring by expanding it with a special pair of pliers.



11. Remove the four shank screws and knock out the two taper dowels from the inside. The shank can now come off.



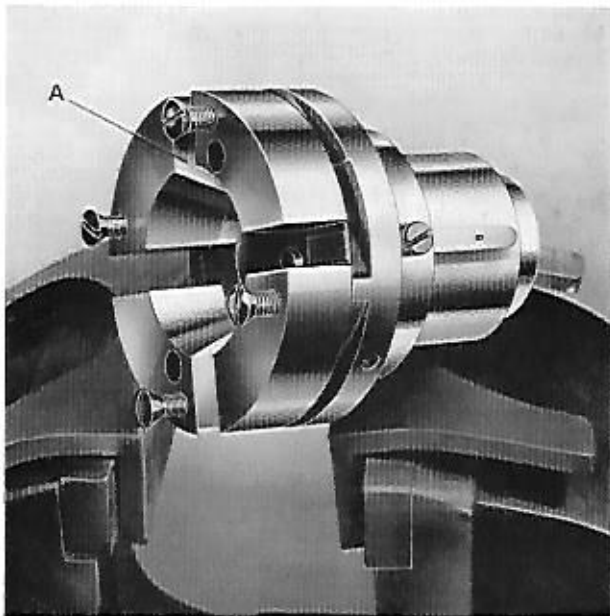
10. Remove the adjusting ring with its spring and take out the adjusting screw with its locknut.

**The Diehead is now sufficiently dismantled for ordinary purposes.**

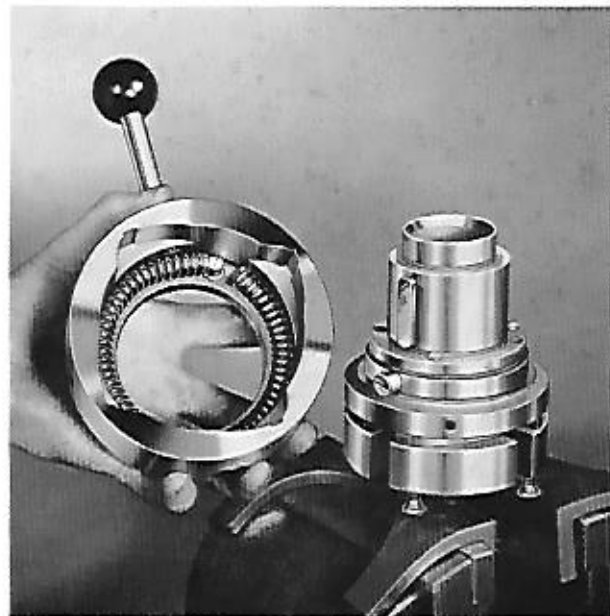
#### **Re-assembling Instructions**

Before beginning to re-assemble the diehead, ensure that all parts are free from burrs, rust and dirt. All parts should be greased and working parts lubricated with a good quality thin oil.

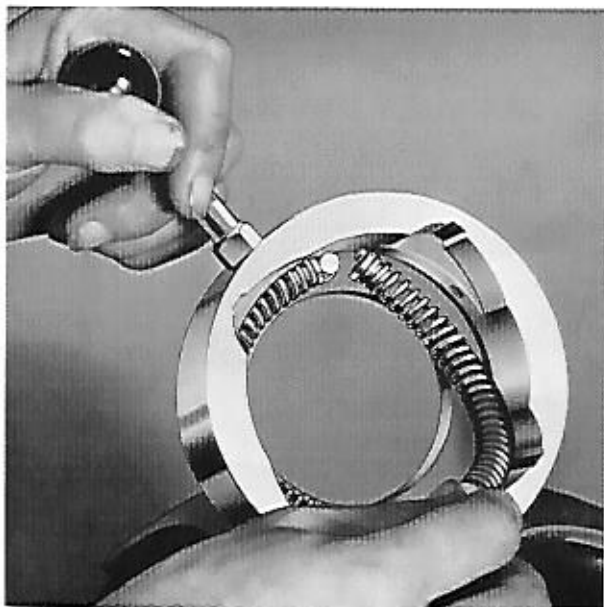
Re-assembling Style C.H.  $\frac{1}{2}$ " to 2" Dieheads (contd.)



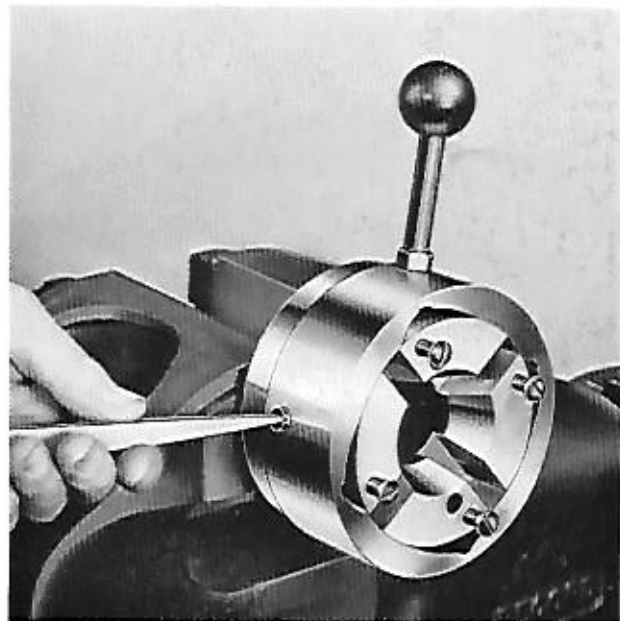
1. Replace the internal scroll on the body and the two cheese-head opening-spring screws. The numbered key on the body should be to the right of slot 'A' where the number on the face of the internal scroll can be seen.



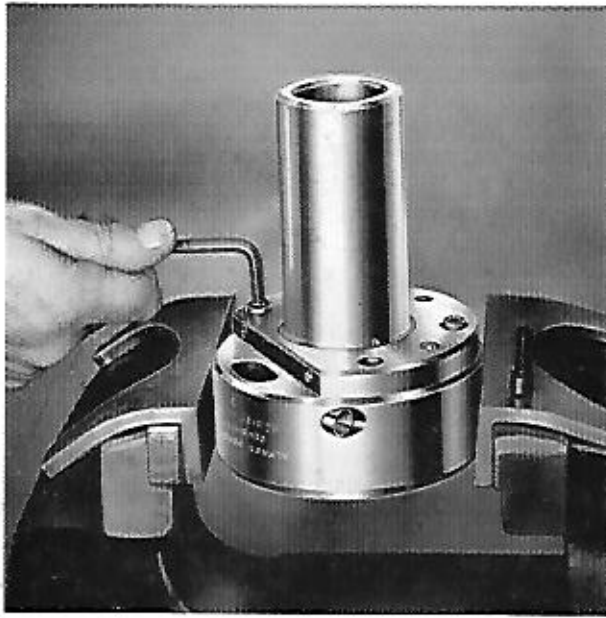
3. Replace the external scroll on the body. The closing handle must be on the same side as the numbered key.



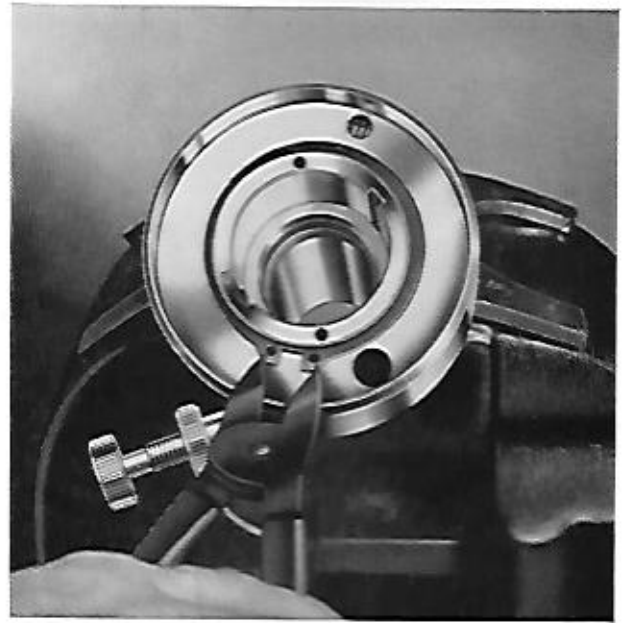
2. Replace the two opening springs with their pads in the external scroll.



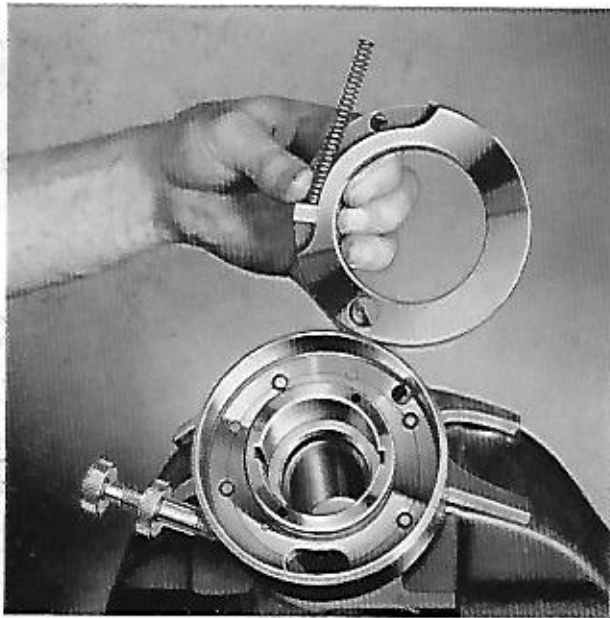
4. Line up the holes in the external scroll with the internal scroll and replace the two scroll screws.



5. Replace the shank on the adjusting ring support, knock in the two taper dowels and replace the four screws. Replace the adjusting screw and its nut.



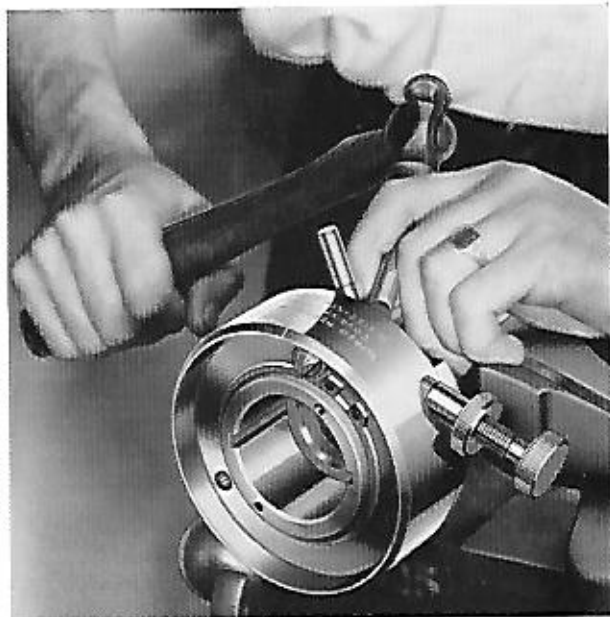
7. Replace the 'Circlip' with special pliers. Note the position of the two lugs in relation to the detent-pin bush hole. Replace the detent-pin in the adjusting ring.



6. Replace the adjusting ring with its spring into the adjusting ring support, with the detent pin bush hole over the elongated hole.



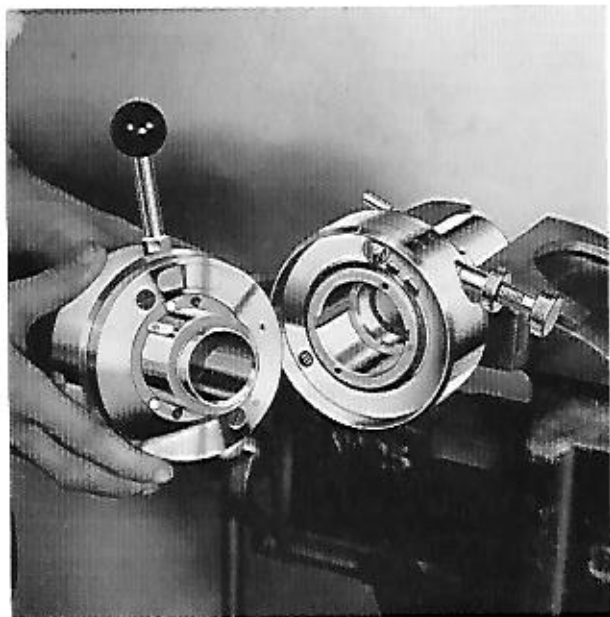
8. Press back the adjusting ring spring with two screwdrivers, coil by coil until clear of the hole, then replace the adjusting ring spring screw through the slot in the flange.



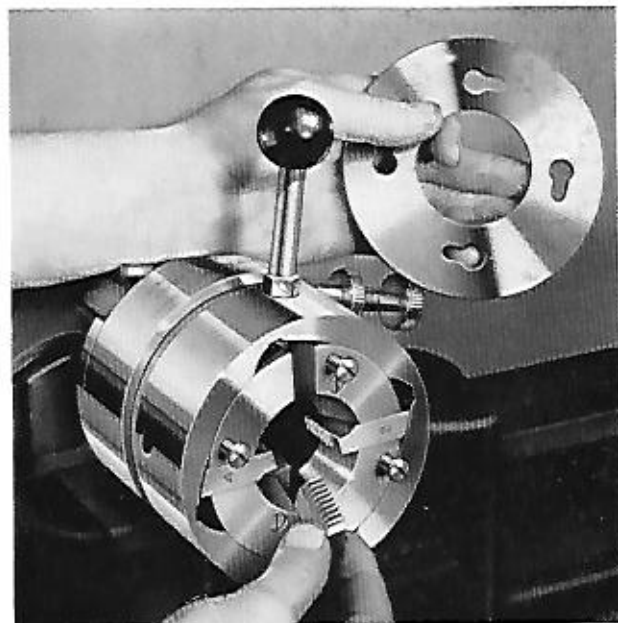
9. Replace the detent pin, handle and nut. Note the relation of the handle to the pin end.



11. Replace the two closing spring screws and springs. Now close the diehead.



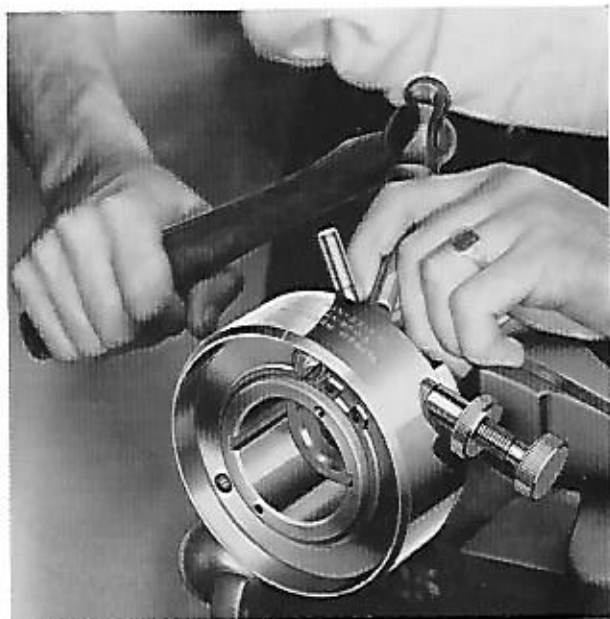
10. Replace the body with the external scroll in the adjusting ring support. The numbered key must go in the numbered keyway.



12. Replace the dies and front plate.

**The Diehead is now completely re-assembled and ready for use.**

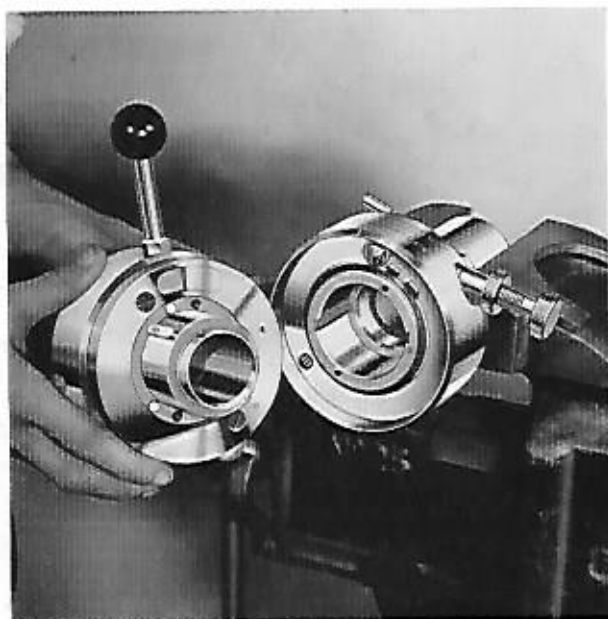
Re-assembling Style C.H.  $\frac{1}{2}$ " to 2" Dieheads (contd.)



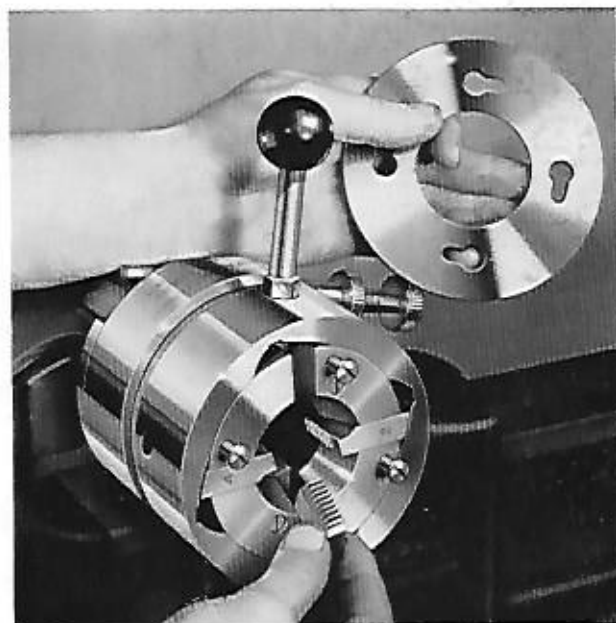
9. Replace the detent pin, handle and nut. Note the relation of the handle to the pin end.



11. Replace the two closing spring screws and springs. Now close the diehead.



10. Replace the body with the external scroll in the adjusting ring support. The numbered key must go in the numbered keyway.



12. Replace the dies and front plate.

**The Diehead is now completely re-assembled and ready for use.**

*Alfred Herbert Ltd., Coventry, England*