

ALCO & FETTE FIXED TYPE THREAD ROLLING HEADS STRIP, ASSEMBLE, REPAIRS.



With the head in the open position
remove the front plate.

Heads covered, prefixed 'F' (Fette) or 'A' (Alco).
0, 1, 12, 2, 23, 233400, 3, 34.
Most parts for these heads are interchangeable.



Remove the nuts/washers and ring plate, if fitted, from the spring housing.



Withdraw the front of the head from the spring housing.



Inspect all parts for wear or damage. Frequent problems include; threads on pillars stripped, teeth missing on gears, gears cracked. The pillars are simply pressed into the back plate so can be knocked out. The outer gears are pressed onto the eccentric pins, they can be removed by tapping the eccentric pin out with a brass drift. The centre gear is held by a circlip. The main coil spring (see below) must be removed to access the circlip.



Check that the main coil spring is not broken and that there are no cracks in the spring housing.

If the spring is weak it may need to be retensioned by moving the hooked end round to the next anchor point.



Inspect the 'steps' between the shank and spring housing that lock the diehead closed.
If these are worn and rounded the end of the rolled thread will have a taper.
Replacement may be necessary!



Inspect the eccentric pins for wear or damage.
Carefully check both back and front plates for hairline cracks.
These are more often found in the front plate and cause bell mouthing and tapering of the thread.

The head is reassembled in the reverse order. It is important that the relationship between the inner and outer gears is correct. The flats that locate the outer gears onto the eccentric pins must face the centre gear as below.

