

## INSTRUCTIONS FOR DISMANTLING AND RE-ASSEMBLING STYLE C.H.S. COVENTRY DIEHEADS

The following instructions apply to Style C.H.S. Dieheads, Sizes  $\frac{1}{4}$ " to  $1\frac{1}{2}$ " (for 2" C.H.S. see page 48).

Tools required are a bench vice with soft jaws, a suitable screwdriver, several pieces of brass or copper rod for knocking out pins and bushes, the Allen-type key supplied with the diehead and a pair of pliers.

### Dismantling Instructions



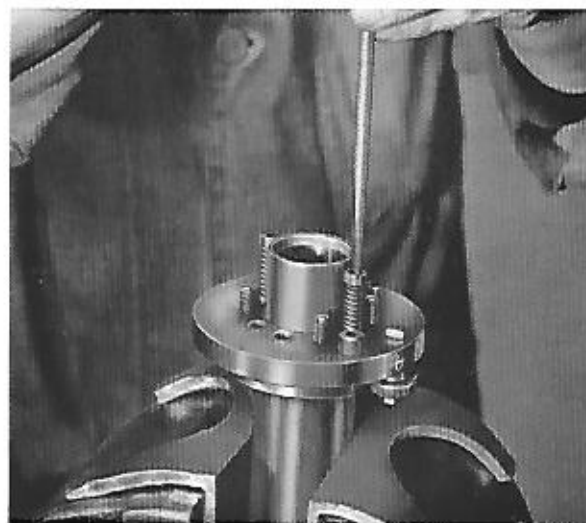
1. Close the diehead to relieve pressure on the dies. Loosen the front plate screws, remove the plate and the four dies. Open the diehead again.



3. The shank complete with backplate can now be removed. The condition of the opening spring and detent tooth can be clearly seen. The body can now be withdrawn from the outer scroll.



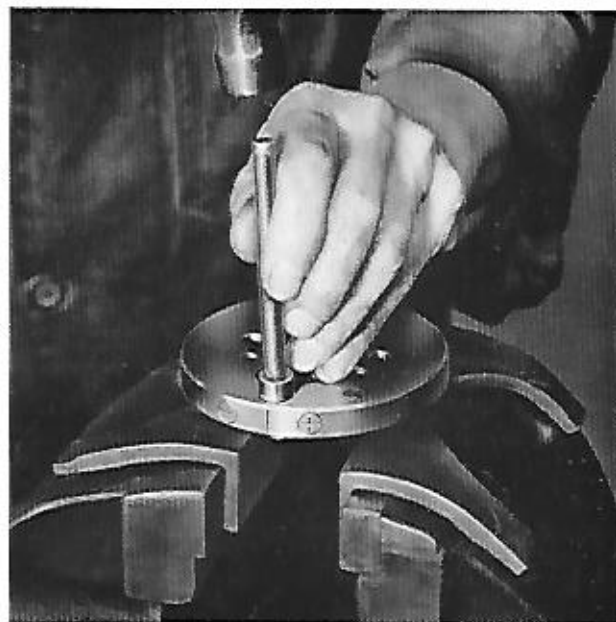
2. Release the four backplate screws. These are reached through clearance holes in the shank flange, using the special long hexagon key.



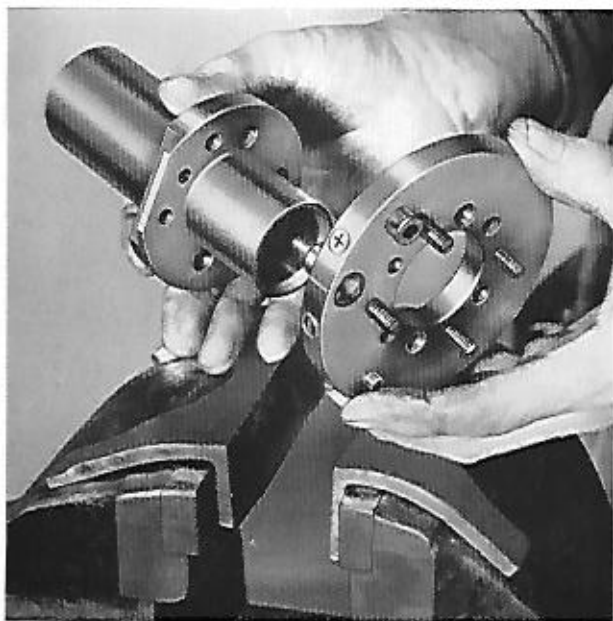
4. Remove the two closing spring screws.



5. Take off the detent-pin nut and handle. Detent pin and spring can now be removed.



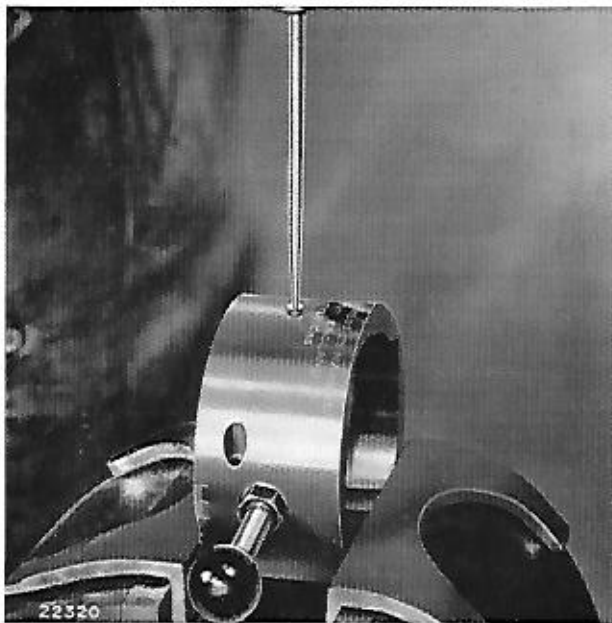
7. Drive out detent pin bush using brass rod.



6. Remove the stop screw. The backplate can now be taken off the shank.



8. Take out the opening spring. Release one of the two adjusting screws and the detent pin tooth can be taken out.



9. Remove the two screws which hold together the internal and external scrolls.



10. Withdraw the inner scroll from the outer scroll.

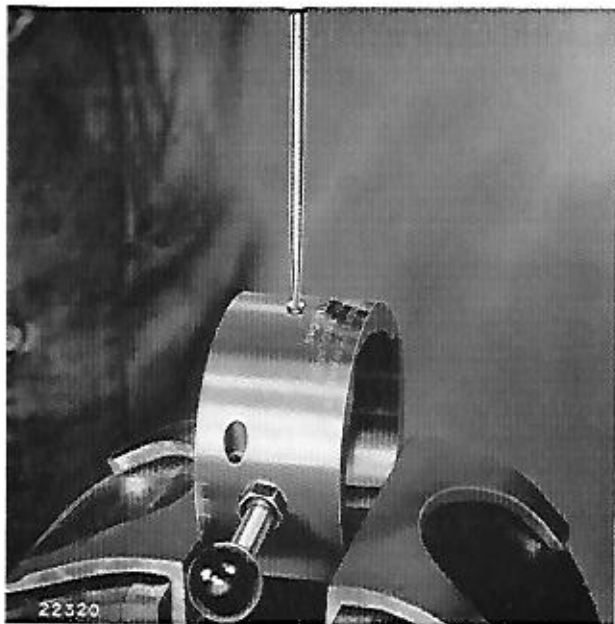
**THE DIEHEAD IS NOW SUFFICIENTLY DISMANTLED FOR ORDINARY PURPOSES**

**Re-assembling Instructions**

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

1. Replace the inner scroll in the outer scroll. The number on the face of the inner scroll should be facing the opening handle when the holes are in alignment. →





2. Replace the two scroll screws.



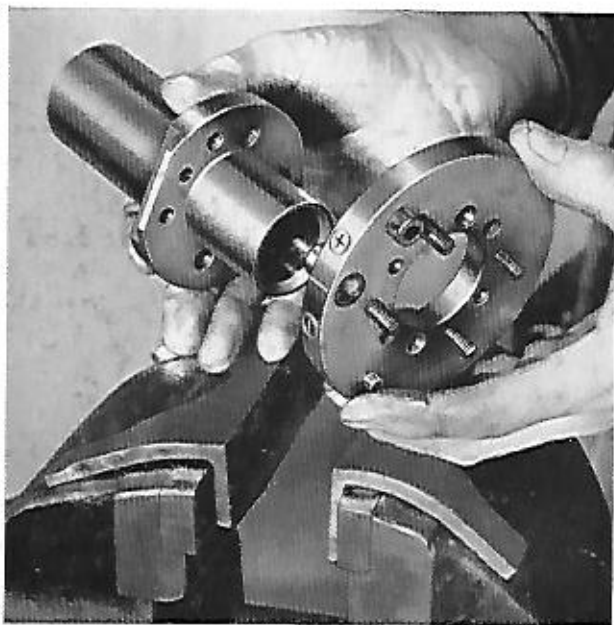
4. Replace the pads in the ends of the opening spring and, using a screwdriver, place the spring in the internal scroll.



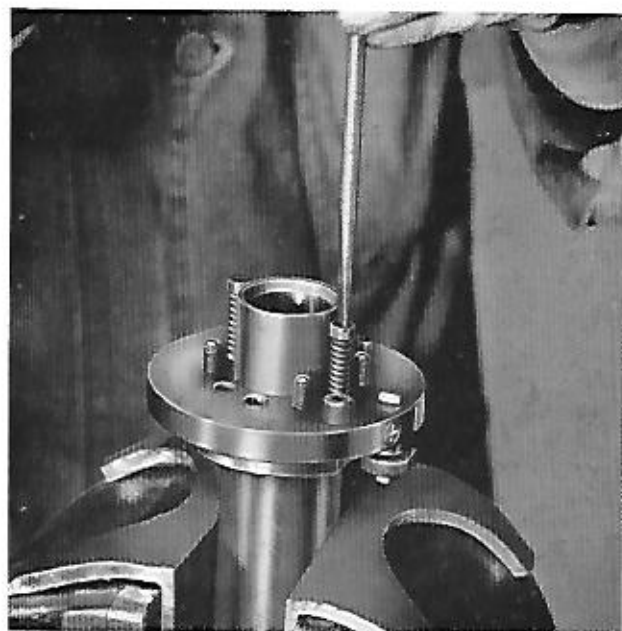
3. Replace the detent pin tooth and lock securely by means of the two adjusting screws.



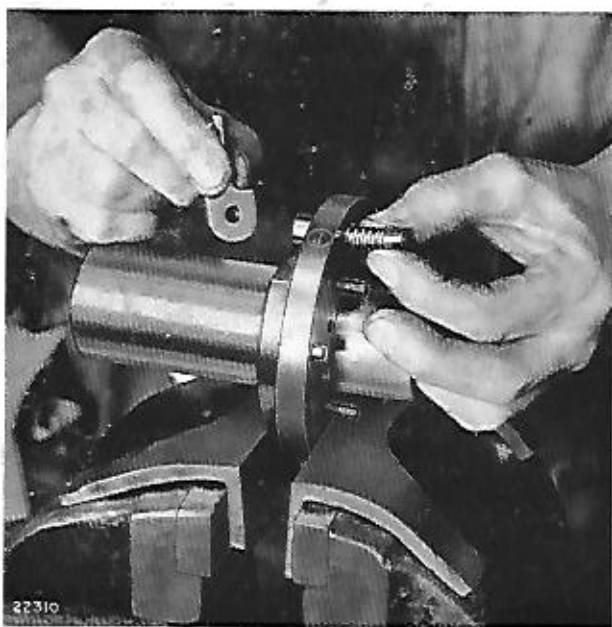
5. With cheese-head screw uppermost, drive the detent pin bush into the back plate using brass rod.



6. Insert the four cheese-head screws in the back-plate and assemble the plate on the shank.



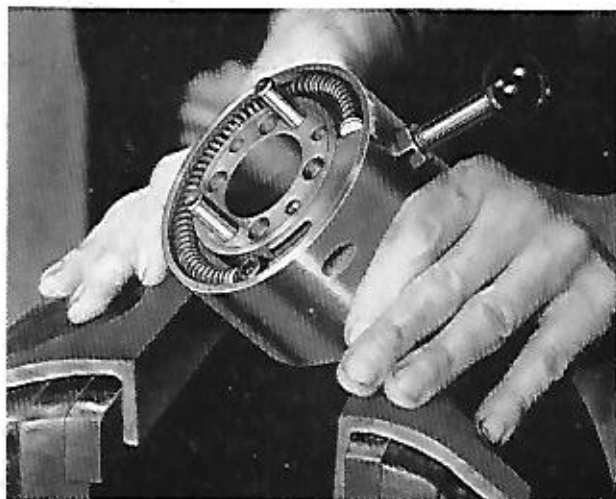
8. Replace the closing spring screws with their springs.



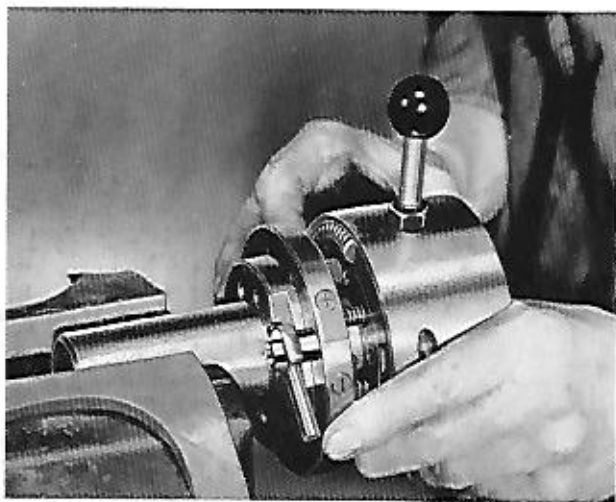
7. Replace detent pin and spring, and secure handle on taper end with nut. NOTE: The small flat on the pin end and the handle must be on the minus sign side. Hold detent pin head with pliers when tightening nut.



9. Replace the body in the outer scroll. NOTE: The number stamped on the body end must face the plain end of the tooth. Replace the two cushion pins and springs.



10. Lift the end of the opening spring in the outer scroll halfway above the end of the tooth.



11. Replace the body and outer scroll on to the shank, ensuring that the number stamped on the body is facing the detent pin when the cushion pins and dowels are in position. Partly screw down one of the backplate screws to prevent the body coming off.

Push the body on to the shank as far as it will go, bringing the end of the uplifted spring into contact with the cheese head screw.

Turn the outer scroll in an anti-clockwise direction, compressing the spring until the screw head can be pushed into the space between the spring and the end of the tooth.



12. Screw down tightly the four backplate screws.



13. Replace the dies and front plate, fixing screws tightly. Put the detent pin handle to the minus position and adjust the diehead to zero.

**The Diehead is now ready for use.**