

# INSTRUCTIONS FOR DISMANTLING AND RE-ASSEMBLING STYLE X.T.2 DIEHEADS — SIZES $\frac{1}{4}$ " — $\frac{1}{2}$ "

When dismantling and re-assembling Style X.T.2 Dieheads, the following instructions should be followed.

The tools required are the Allen-type wrenches supplied with the diehead, suitable spanners and screwdrivers.

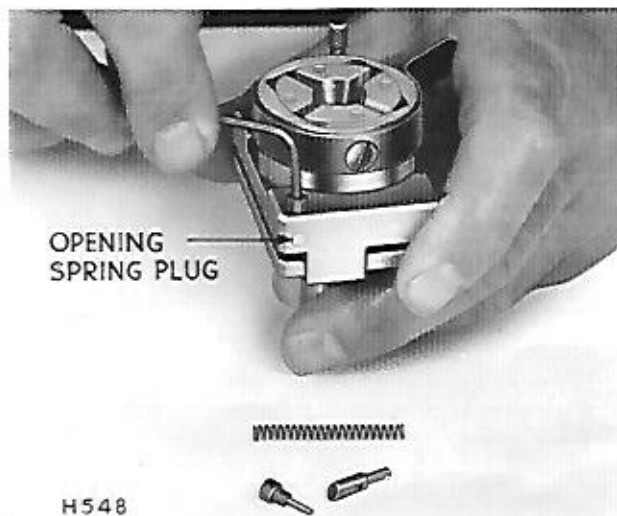
## Dismantling Instructions



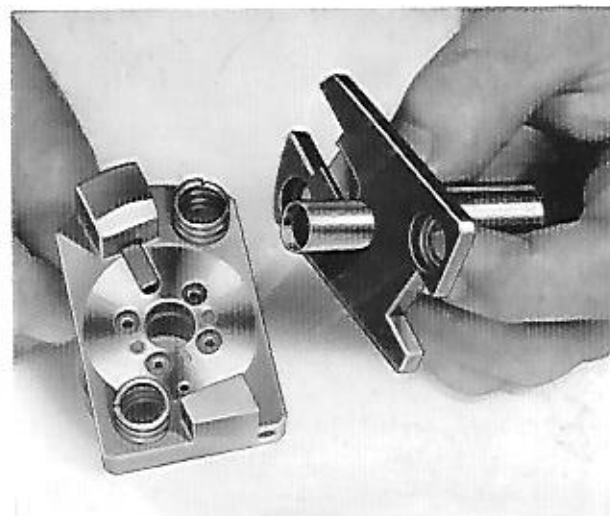
1. Close the diehead to relieve pressure on the dies. Remove front plate screws, front plate and dies. Re-open the diehead.



3. Unscrew the two draw-out-spring screws and remove springs, bushes and screws.



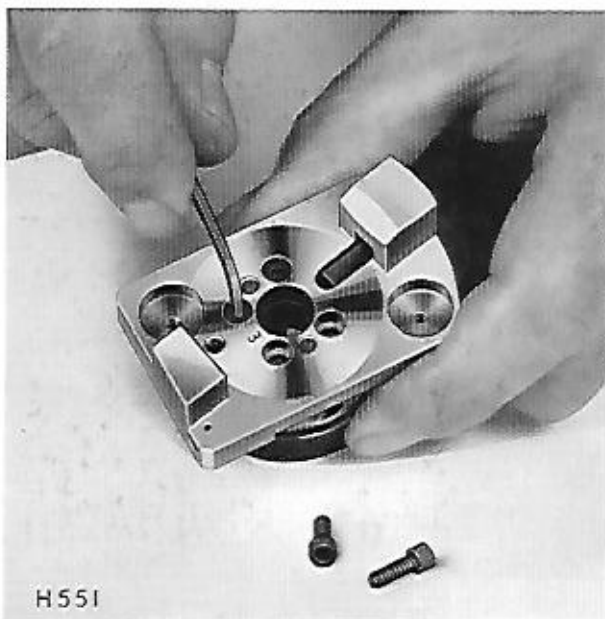
2. Hold the opening-spring plugs in position with the thumb or finger, unscrew Allen-head pins and remove opening springs.



4. Remove the shank. This exposes two cushion springs which should be removed.

*Alfred Herbert Ltd., Coventry, England*

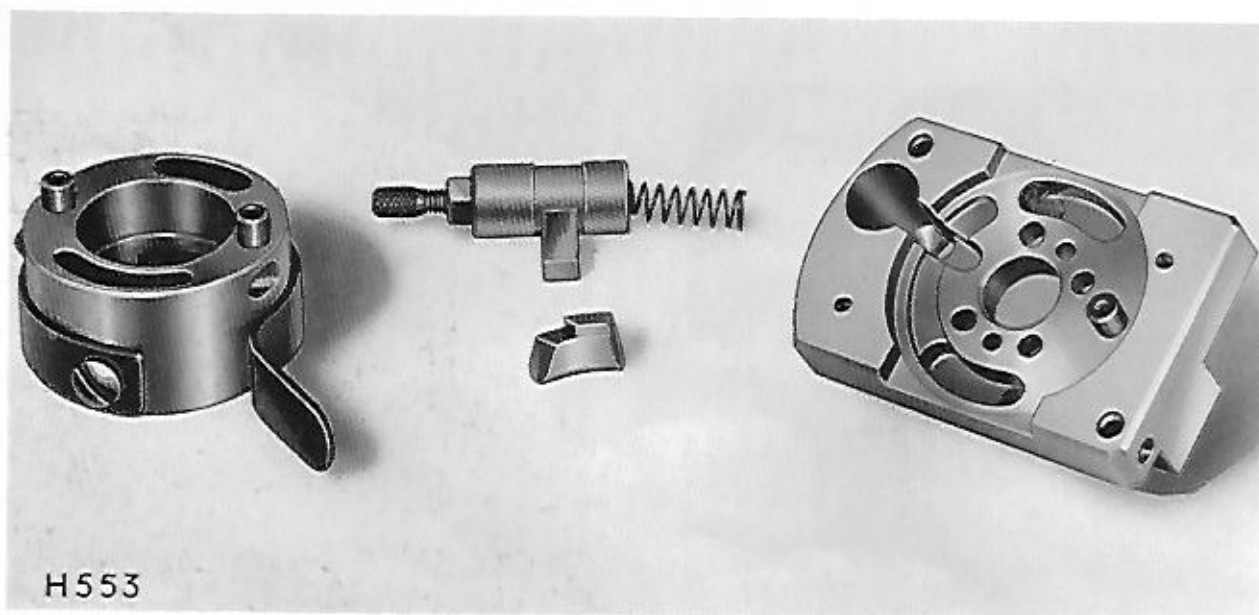
Dismantling Style X.T.2 Dieheads (contd.)



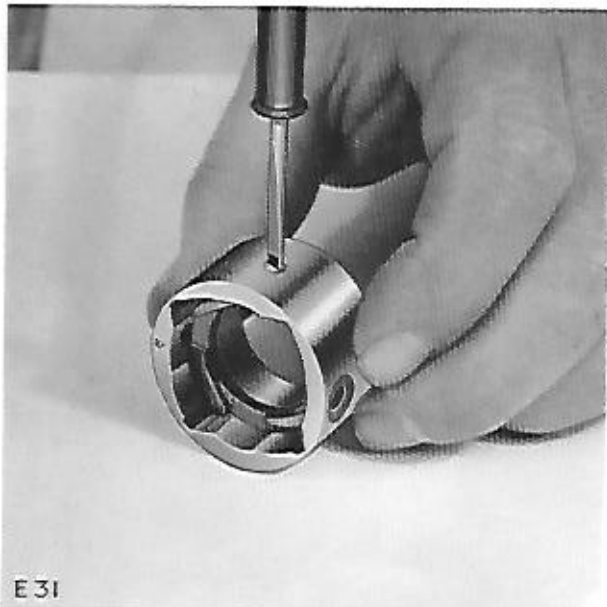
5. Remove the four backplate screws and the backplate. The plunger and its spring can now be withdrawn and the body can be removed from the external scroll.



6. Slacken off one of the two adjusting screws in the external scroll and remove the tooth.



7. The condition of the projection on the plunger can now be examined. These parts may be reconditioned, if necessary, by grinding a small amount off the face, ONLY of the plunger projection, and the front and top faces of the tooth.



8. Remove the two screws and the spring-steel auto die closer. This uncovers two scroll screws which should now be removed.



9. The internal scroll can now be removed from the external scroll.

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

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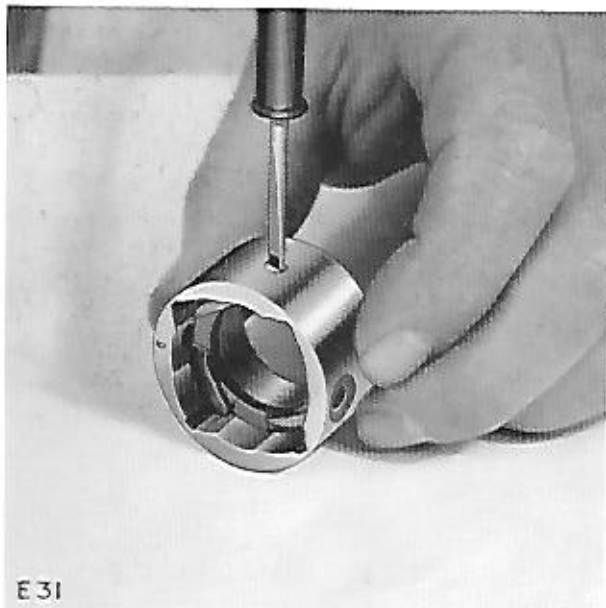
### Re-assembling Instructions

Before commencing, ensure that all parts are free from burrs, rust and dirt. All parts should be greased and the working parts lubricated with a good quality thin oil.

1. Replace the internal scroll in the external scroll. The number on the front face of the internal scroll should align with the corresponding number on the front face of the external scroll.



Re-assembling Style X.T.2 Dieheads (contd.)



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2. Replace and tighten the two scroll screws, and the auto die closer and screws.



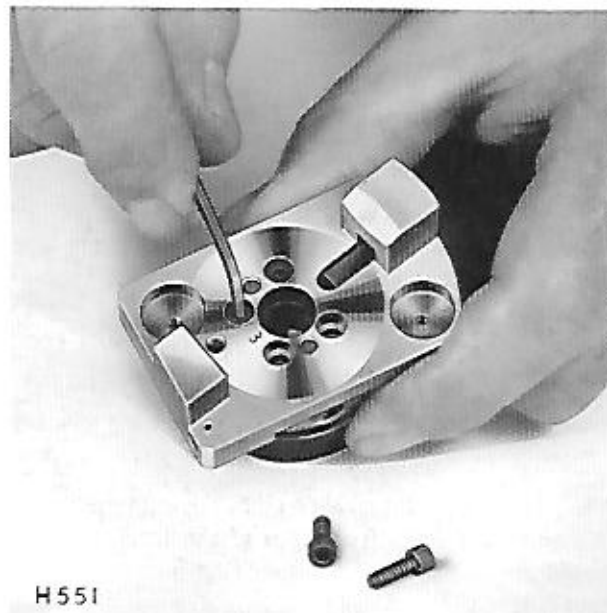
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4. Replace the body in the external scroll with the number on the back face diametrically opposite the tooth.



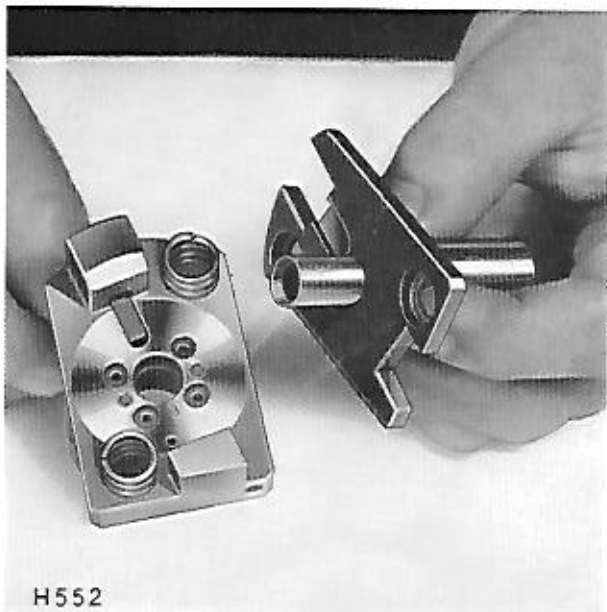
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3. Replace the detent tooth in the slot in the external scroll and lock securely with the adjusting screw.



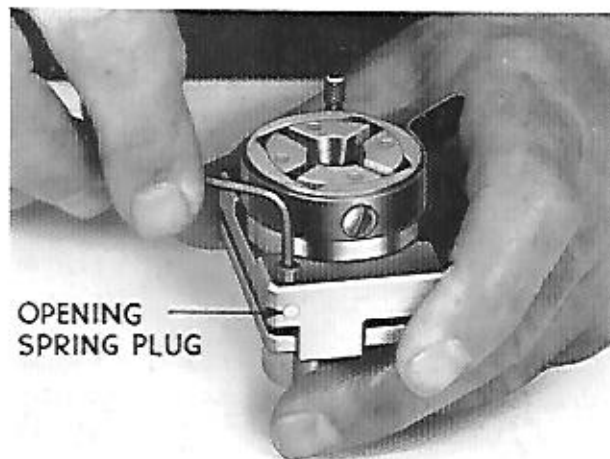
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5. Replace the plunger and its spring in the back plate and assemble with the body and external scroll, engaging the body pins with the holes in the backplate and ensuring that the number on the back face of the backplate is over the number on the back face of the body. Tighten up the backplate screws.



H552

6. Replace the cushion springs and the shank.



OPENING  
SPRING PLUG

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H548

8. Replace the opening spring and pad into the hole in the backplate. The end of the spring containing pad must be inserted first. Insert the relevant opening-spring plug and press this down with the thumb whilst inserting the Allen-head screwed pin. Repeat for the second opening spring.



H549

7. Replace the draw-out spring bushes, the springs and the screws. Tighten securely.



H547

9. Replace the dies and the front plate. Adjust the diehead to the zero position and tighten the screws securely.

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