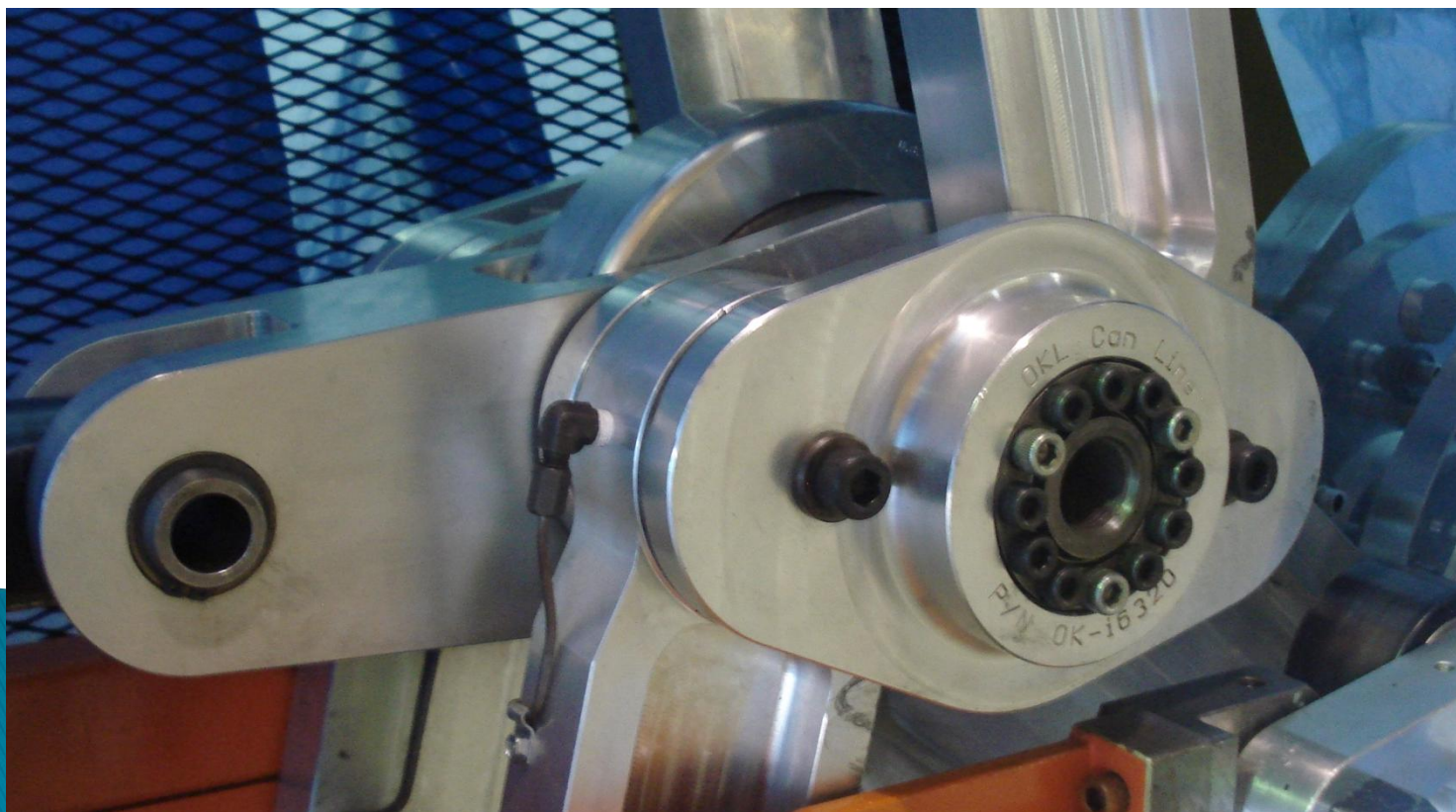




# A.P.M.A Installation





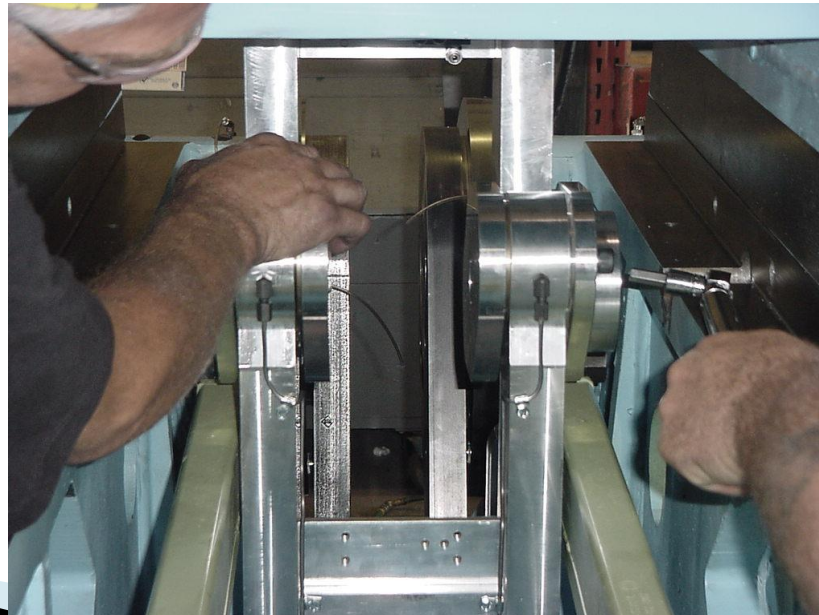
- ▶ The upper and lower idler arms need to be centered independently and have their running clearance set.
- ▶ Once this has been set  $.014'' - .020''$  running clearance and within  $.005''$  of centre.
- ▶ You are ready to connect the upper and lower idler together using the journals.



- ▶ Install journal (2 places)– item OK-I6310
- ▶ Install the PMA spacer onto each of the inner bearing race (4 places).
- ▶ Bring the arms together ensuring the bottom arm is in front of the top then slide the journal through both the bearing races.



- ▶ Install the journals (outside) 2 places -item 32(OK-I6320).
- ▶ The boss should fit snug into the inner race - OK-I6330.
- ▶ Install the ½” x 13 screw 4 places in the journal assembly.





- ▶ Install the shaft– OK–I6200 through the 2” hole in the frame. The aluminum handle which comes with the kit needs to be used.
- ▶ Tighten up the  $\frac{1}{2}$ ”x13 bolts drawing together the halves, finally torque them to 75ft/lbs.

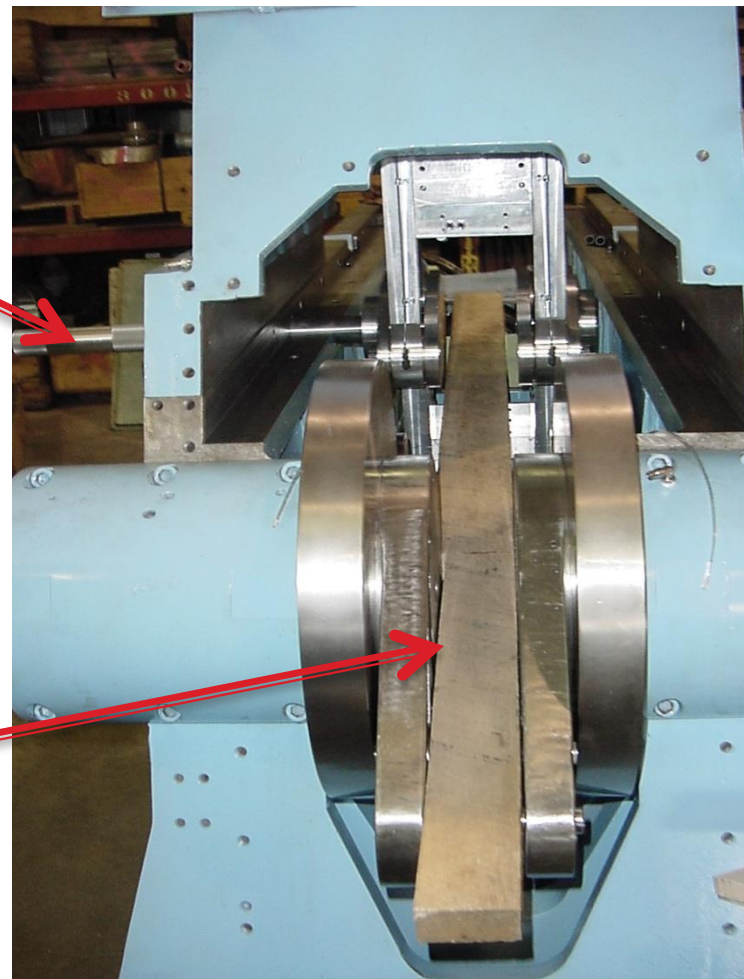


- ▶ Using the aluminum handle withdraw the shaft until the end of the shaft is flush with the journal (inner) operators side.
- ▶ Install the crank pin into the teardrops and place a 2"x4" between them so it rests on the crank pin and the support on the lower arm.



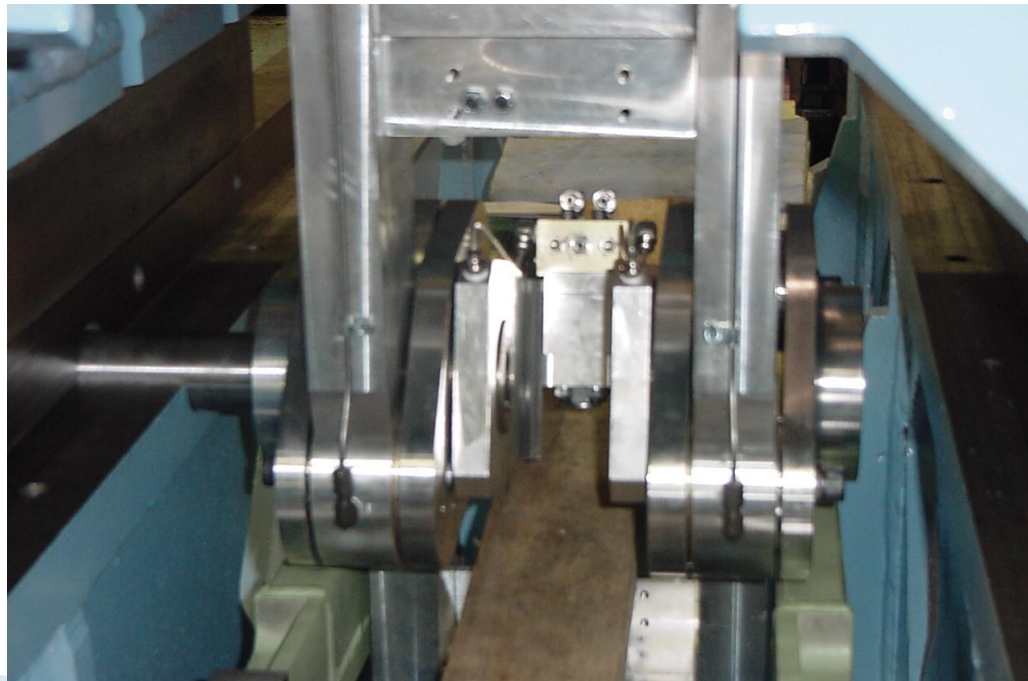
Aluminum  
handle

2"x4" piece of  
wood



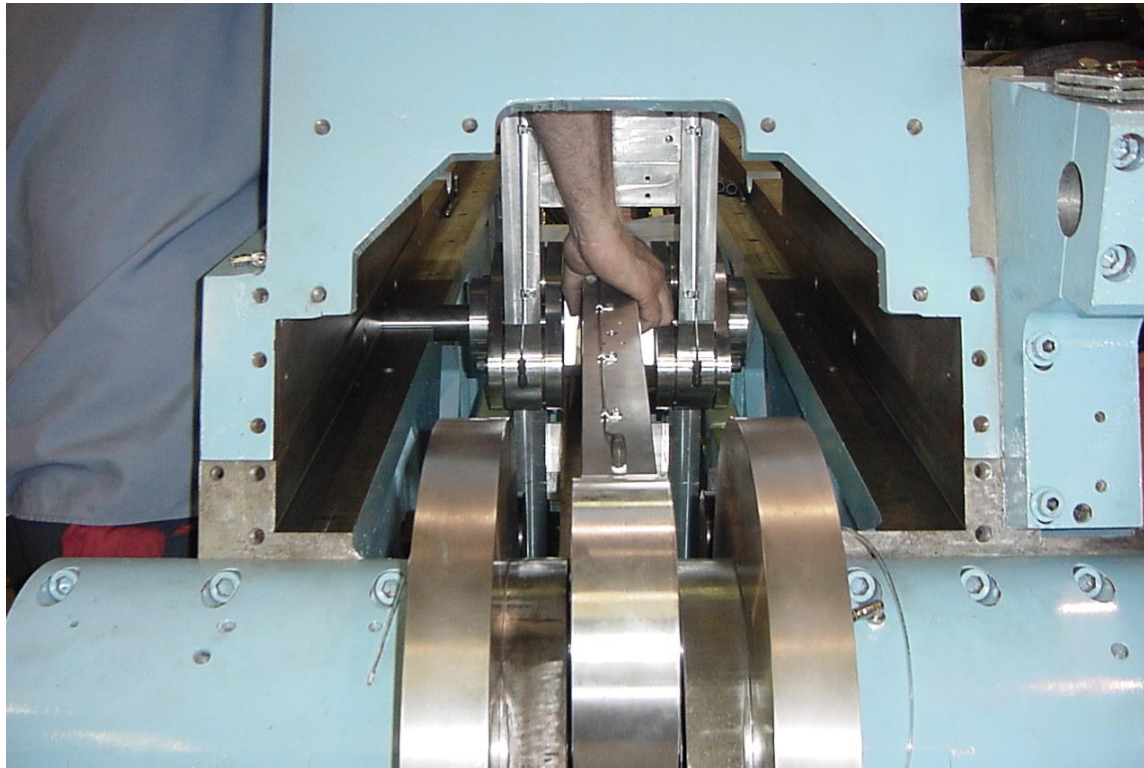


- ▶ Position the connecting link (OK-I6110) between the inner journals.
- ▶ Install the shaft into the connecting link; make flush with the inner most edge of the bearing (operators side).





- ▶ Position the connecting rod (OK-I6010) between the sides of the connecting link. While holding the rod in position, work the shaft through.

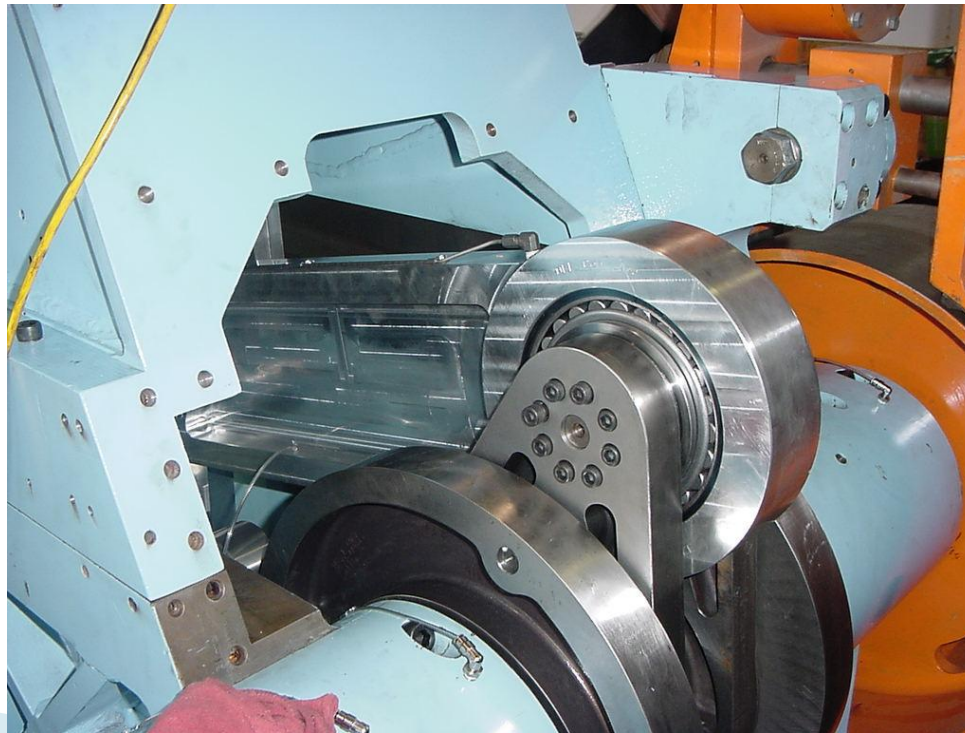




- ▶ Install the ring fedder (drive side) and tighten in a cross pattern until the bolts are tightened to 25–35ft/lbs. the aluminum handle can then be removed.
- ▶ Install the ring fedder into the operator side and tighten bolts to 25–35ft/lbs.
- ▶ Attach the connecting link to the ram using the same procedure as the steel knuckle assembly .



- ▶ Attach the connecting rod to the crank shaft using the same procedure as a steel-knuckle assembly.



# Follow up and removal tips



- ▶ After 1–2 hours run time when the ram is being rechecked, the ring feeders should be checked to ensure the torque has not diminished (due to the aluminum parts reaching operating temperature).
- ▶ When the knuckle assembly needs to be removed, reverse the procedure. To separate the journals (inside –outside), remove the ½”x13 SHCS and install ½”x13 set screws into the holes (this will protect the threads).



- ▶ Next use 5/8"–11 screws into the journal (outside) to jack the journals apart.
- ▶ To replace the inner race the part OK–6060, use 4 pin punches and a press.