

# **REPLACING THE** **MILL FINE FEED CLUTCH DOG** **GN1300 SERIES**

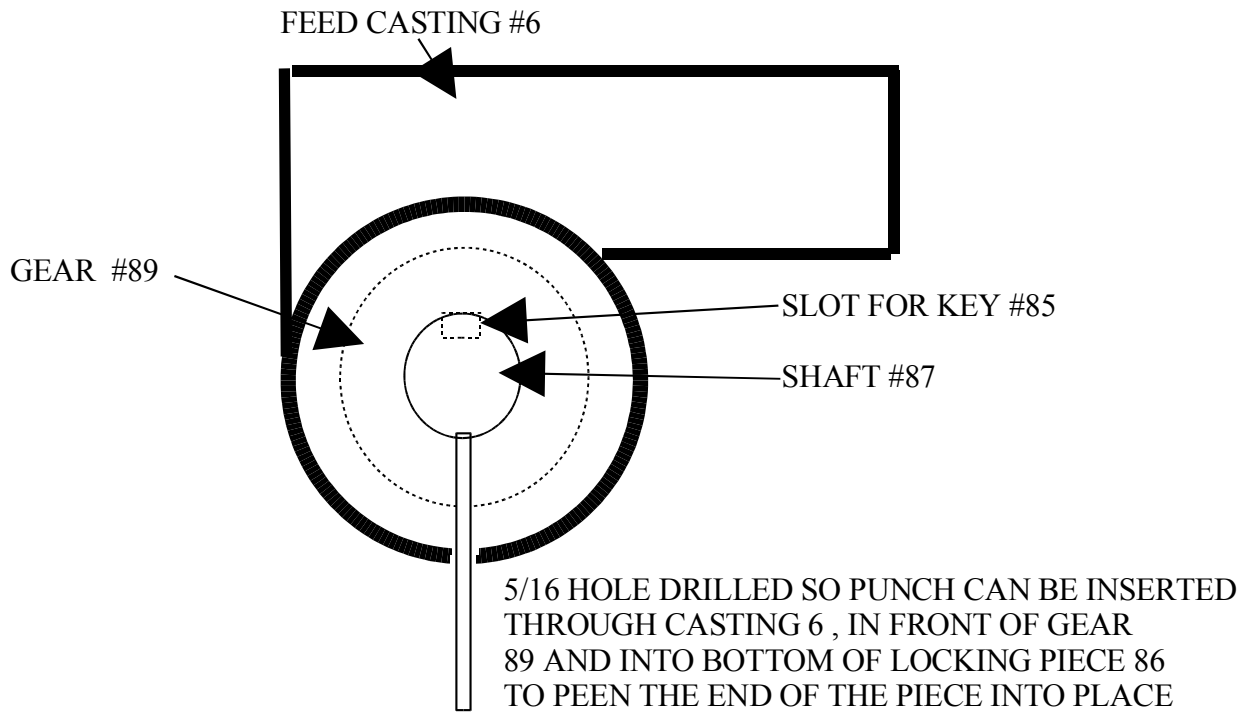
The mill fine feed locking clutch dog can be replaced in two different ways. This instruction sheet is OPTION 1. removing the mill feed handle and drilling a small access hole that will allow the installation of a new G05086 locking piece, without having to remove the entire mill feed shaft assembly. It does require snap ring pliers, a medium ball peen hammer, a small pin punch , a flaring punch and a small metal block to use as a stop to hold the locking piece in place while the shaft on the locking piece is being fixed into position. OPTION 2 would be to remove the entire feed mechanism from the side of the mill head to replace the locking piece G05086.

## **OPTION 1 PROCEDURE**

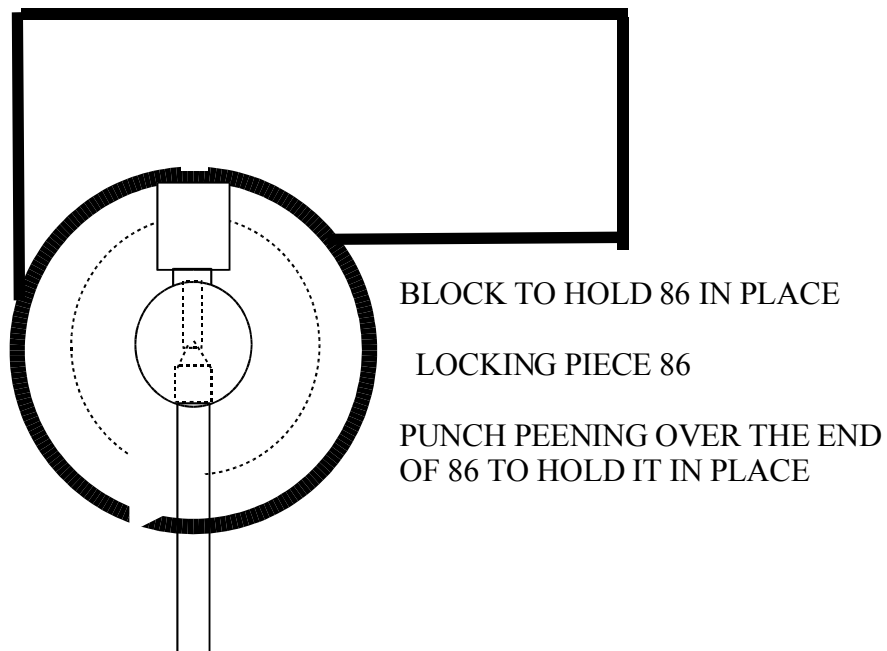
See page 90 of the owner's manual for reference to the part numbers in this procedure.

1. Remove knob 82 from the end of the fine feed locking shaft 83.
2. Remove snapping 36 from inside the feed handle casting 81.
3. Rotate the feed handle casting 81 clockwise until the grove for key 85 is facing upward.
4. Lock the spindle lock 62 and pull the feed handle casting off the main feed shaft 87.
5. Go to the bottom of the casting 92 and drill a 5/16 hole upward into the center of the casting so a punch can be inserted into the hole and it will extend upward into the hole in shaft 87 for the locking piece installation. SEE FIGURE ON THE NEXT PAGE

THE PURPOSE OF THIS HOLE IS TO BE ABLE TO PUT A SMALL PUNCH THROUGH THE HOLE AND PEEN OVER THE END OF THE NEW G05086 LOCKING PIECE WITHOUT HAVING TO REMOVE THE ENTIRE MILL FEED MECHANISM FROM THE HEAD CASTING.



6. Install piece 83 with ball and spring 20 and 84 into the end of the 87 shaft.
7. Put locking piece 86 through the side of 87 and through 84.
8. Hold 86 in place with a small piece of metal while you insert a cone pointed punch up through the hole drilled in the bottom of the feed casting and up into the end of 86.
9. Use a small hammer and peed over the hollow end of 86 to hold it into place.



10. check to make sure the locking shaft 83 will slide in and out of position.
11. Reinstall the handle casting, snapping and knob.