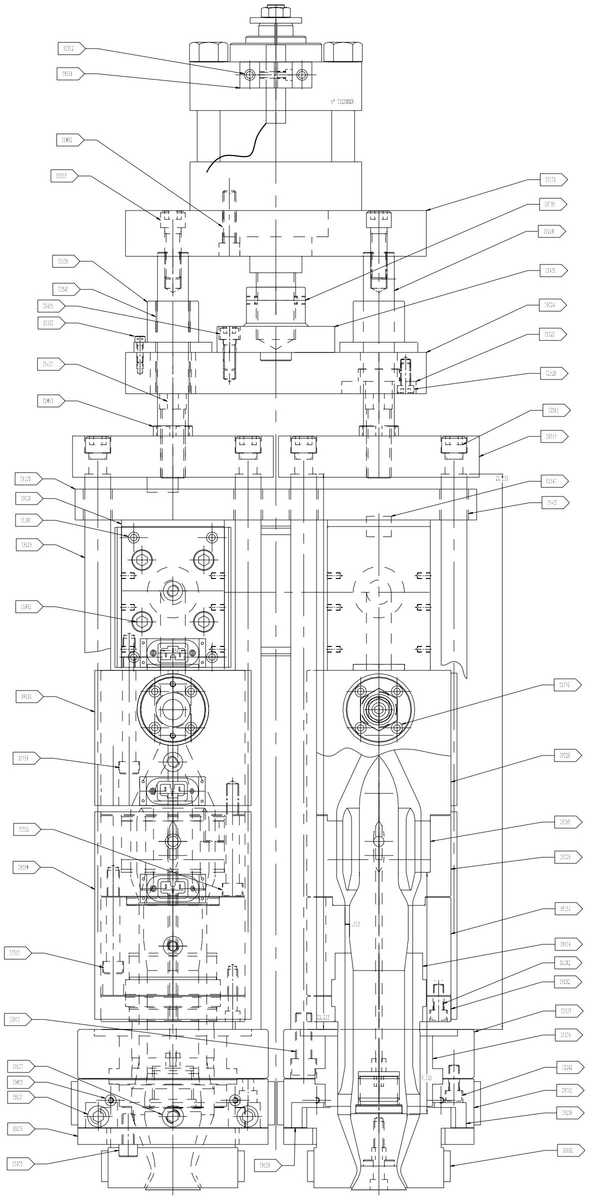
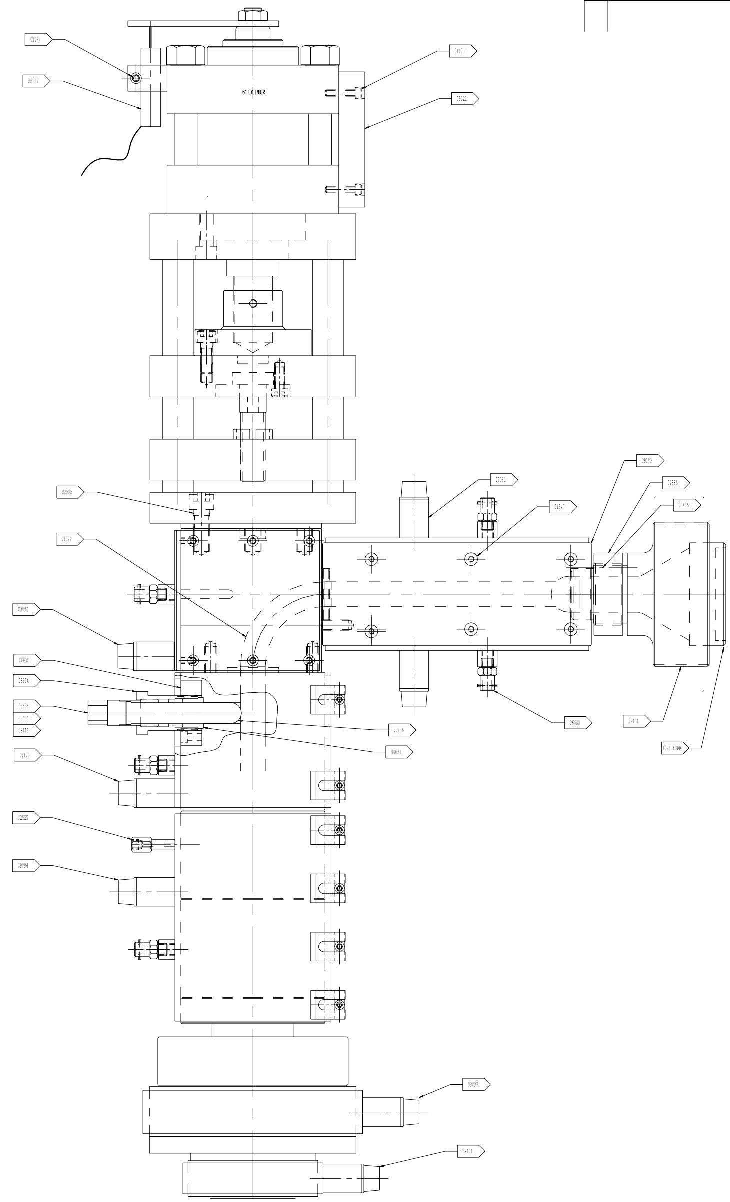
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED





HEAD DISASSEMBLY

1) REMOVE MANDREL/TIP IF DIVERGING.
2) REMOVE DIE RETAINING RING (09106).
3) REMOVE DIE ADJUSTING KEYS (09108) TO ACCESS BOLTS (01242) HOLDING DIE ADJUSTMENT BLOCK.
4) REMOVE DIE ADJUSTMENT BLOCK (09092).
5) REMOVE (4) M16 SHCS (00903) TO REMOVE LOWER MOVING PLATE (09107).
6) REMOVE BOLTS (01242) TO REMOVE RETAING RING 09102.
7) REMOVE SLIDER (09104).
8) REMOVE BOLTS (00500) TO REMOVE LOWER SPIDER HOLDER (09050).
9) REMOVE BOLTS (00521) TO REMOVE (09029) SPIDER HOLDER.
10) REMOVE (02525) SUPPORT AIR NEEDLE BEFORE SLIDING OUT SPIDER ASSEMBLY.

ASSEMBLE HEAD IN THE REVERSE ORDER.

Qual-Tech Manufacturing, Inc.
915 Southampton Road
Westfield, MA 01085

S120-200MM PE HEAD

SIZE A	DRAWN ALM	DWG NO. QTMS2-120-200MM	REV
ITEM NO. 08756	SCALE FULL	8-13-05	SHEET