

Instructions For Removing Welded Air Tubes (A1, L1-L2)

Tools required: Oxy-acetylene torch, Sawz-all™, or hacksaw, 1/8" Allen (hex-key) wrench

Parts supplied:

- Airtube(s)
- Set-screws (1/4-20 x 1/4")
- Coupling sleeve

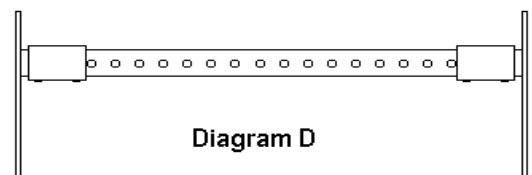
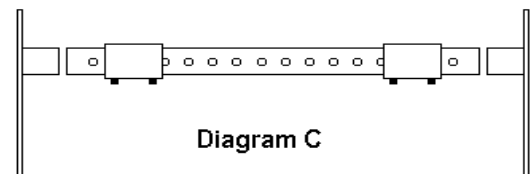
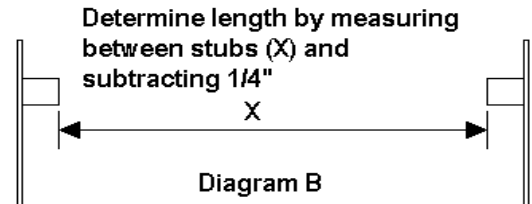
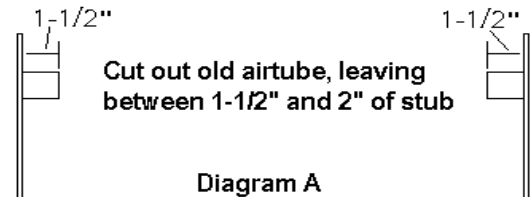
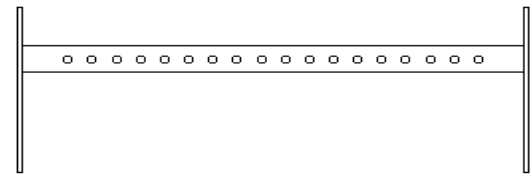
Step 1: Remove the old airtube

1. Make a mark somewhere to indicate the direction the holes of the airtubes are facing.
2. Using an oxy-acetylene torch, Sawz-all™, or hacksaw, cut out the old airtube as squarely as possible, leaving between 1-1/2" and 2" of stub. Refer to **Diagram A**.
3. De-burr the edges of the stubs so the coupling sleeves slide over easily.

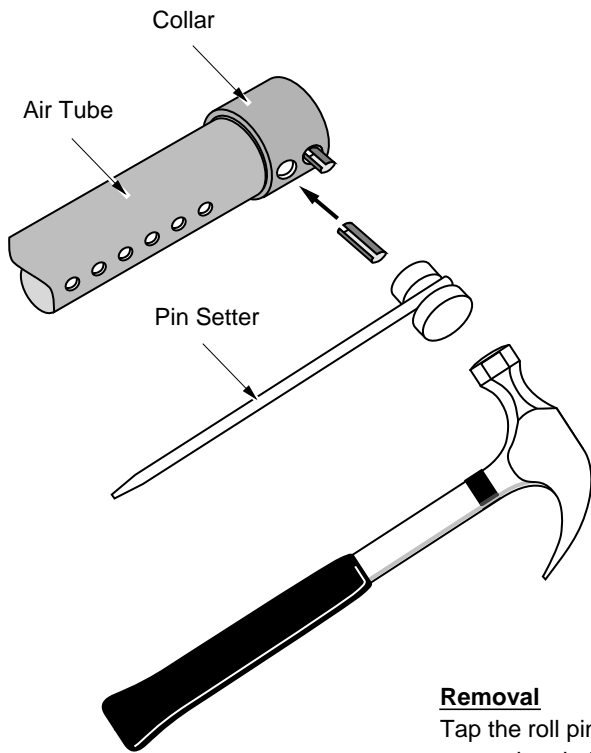
Step 2: Install the replacement tube

1. Determine the desired length of the new airtube by measuring the width between the two stubs and then subtracting 1/4". Refer to **Diagram B**.
2. De-burr the ends of the tube and slide the coupling sleeves with set-screws over each end.
3. Position the replacement airtube with the coupling sleeves installed between the stubs. Refer to **Diagram C**.
4. Slide the sleeves over the joints between the stubs and the ends of the replacement tube as evenly as possible.
5. Fasten the set-screws to secure the replacement airtube in place. Refer to **Diagram D**.

This completes the installation.



Roll Pin Installation and Removal



Installation

Make sure the holes in the collar and air tube are aligned (use the tapered end of the pin setter). Place the roll pin in the slot on the pin setter and tap into place with a hammer.

Removal

Tap the roll pin until it is flush with the collar. Then place the tapered end of the pin setter into the roll pin and tap the pin through the air tube.

