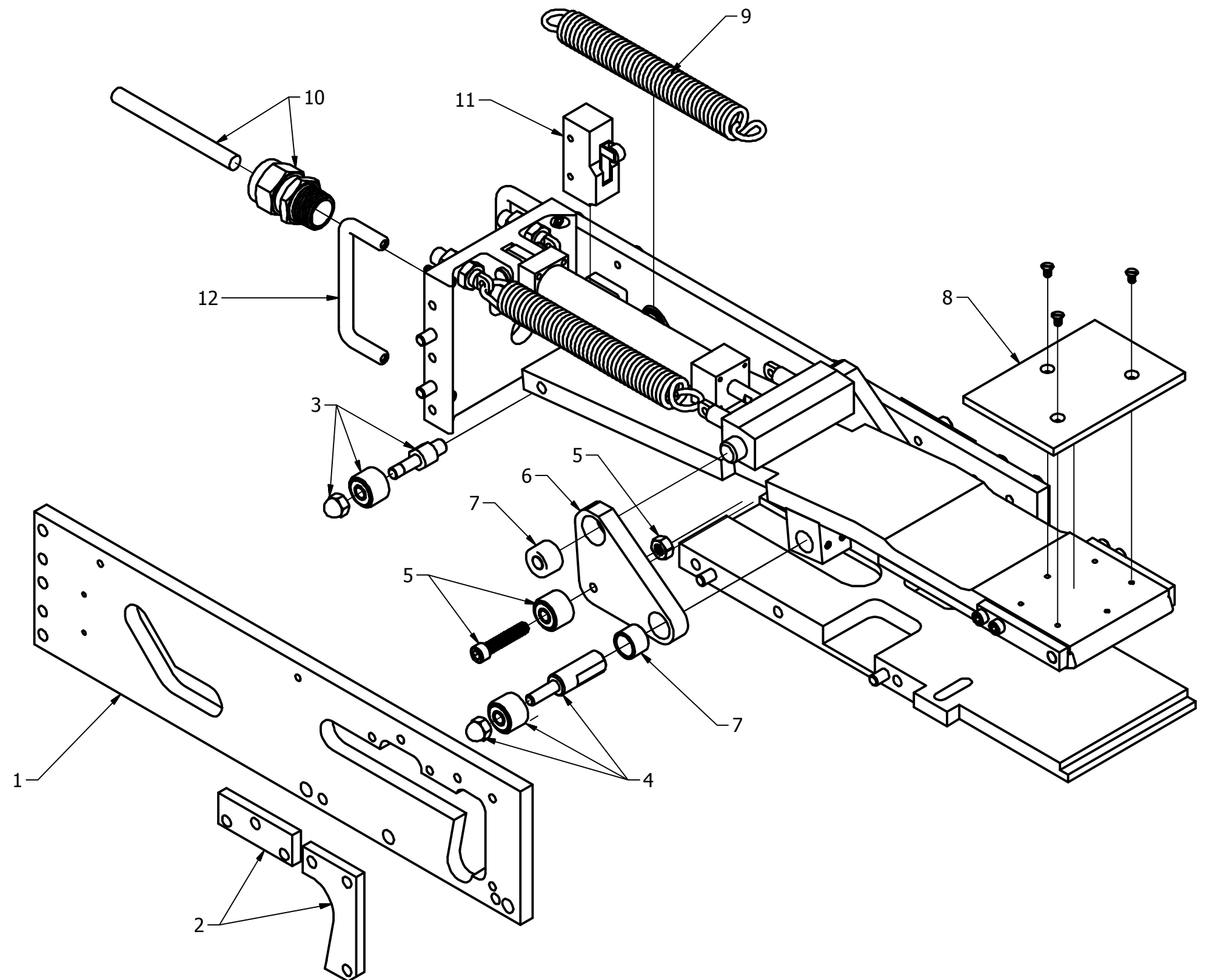



Paddle Clamp Rebuild/Upgrade

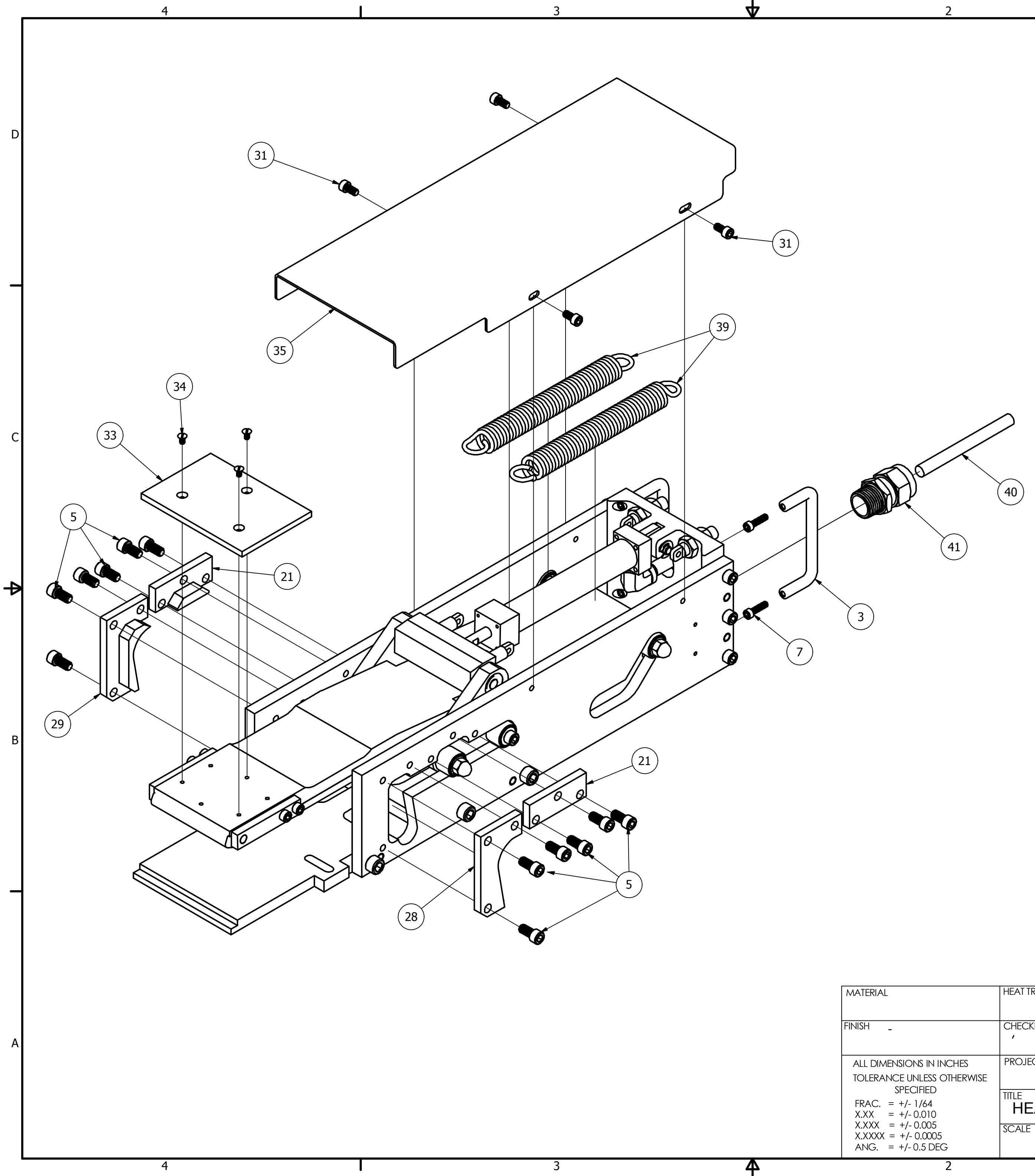
The following items are replaced or added as part of the paddle clamp rebuild.

- 1) The existing side plates are re-worked to accommodate the larger 3/4" diameter rollers.
- 2) Hardened inserts are re-worked or replaced to accommodate the larger rollers.
- 3) Rear roller studs are added to secure the larger rollers with a 1/4-20 nut.
- 4) Forward roller studs are replaced to secure the larger rollers with a 1/4-20 nut.
- 5) The middle rollers are secured using 1/4-20 bolts with a hex lock nut.
- 6) The pivot plates are replaced.
- 7) Bushings and bearings are replaced.
- 8) Aluminum jaw cover is replaced.
- 9) Both return springs are replaced.
- 10) Cable is replaced if needed.
- 11) Limit switch is replaced if needed.
- 12) Handles are replaced if needed.


Additional repairs or parts replacements not covered in the preceding list will be charged separately.
No additional work or parts will be added until customer approval.

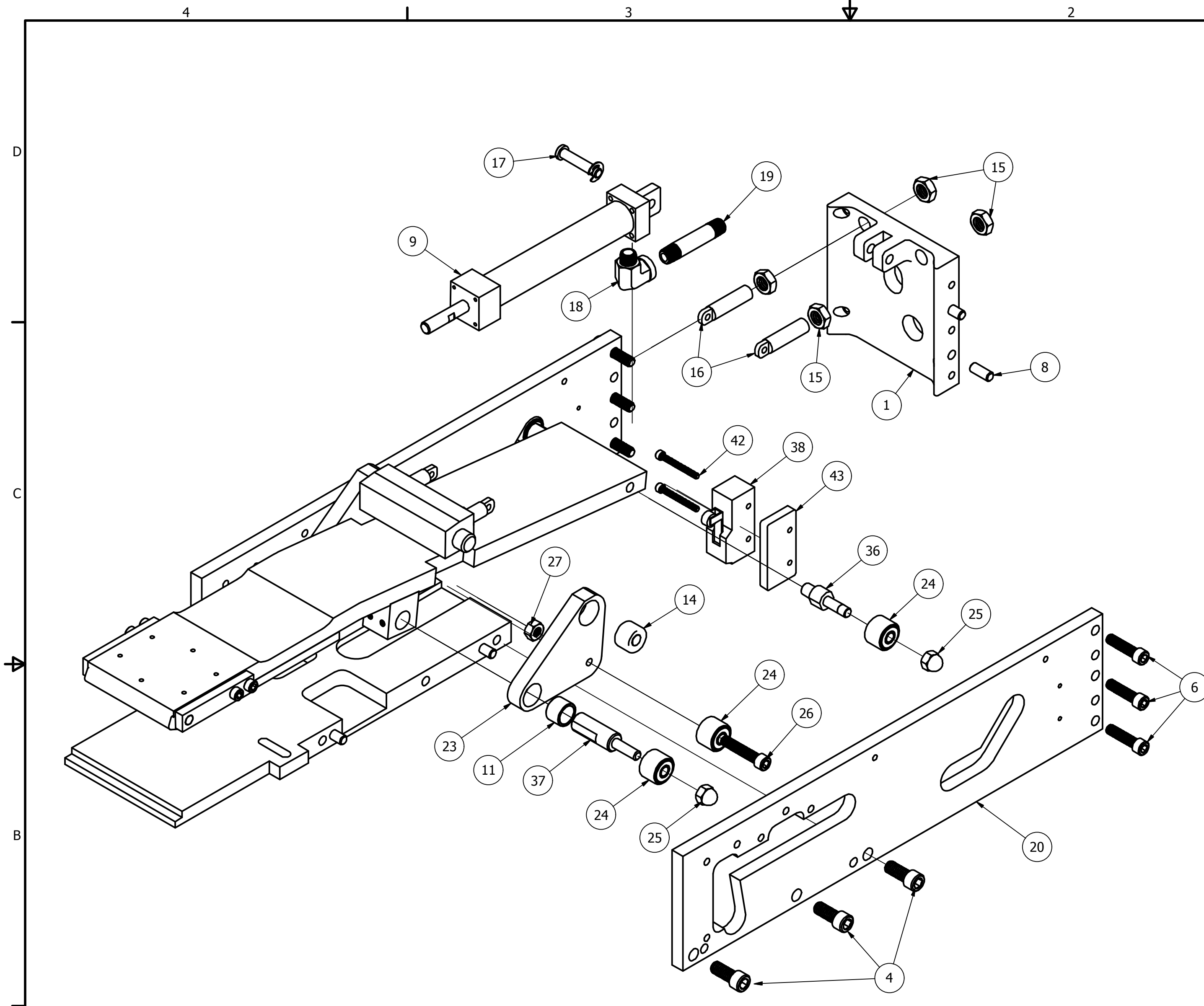


MATERIAL	HEAT TREAT	DATE	 MARATHON CUTTING DIE DIES MADE FOR THE LONG RUN 2340 Foster Ave Wheeling, IL 60090 phone: 847-398-5165 / fax: 847-398-5195 www.MarathonCuttingDie.com			
FINISH	CHECKED	DRAWN BY MikeF				
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	SCALE	REV	SIZE C	DWG. NO. SA-123183 HEAVY DUTY	SHEET 1 of 4	




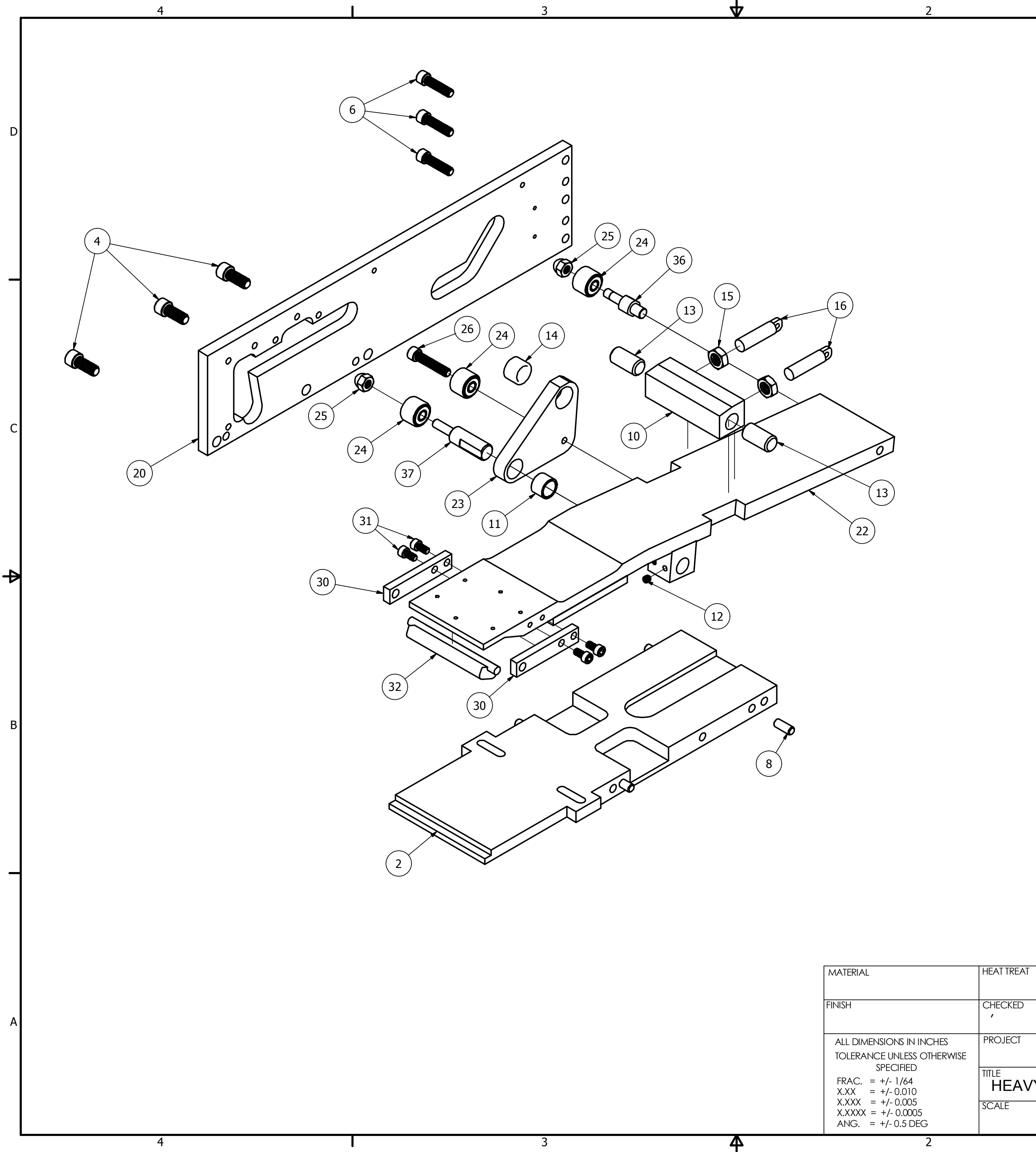
PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	PHP-31021	BACK PLATE, PADDLE CLAMP
2	1	PHP-31124	LOWER JAW
3	2	PHP-20150	HANDLE
4	6	MAR-008.00051	SOCKET HEAD CAP SCREW, 5/16-18
5	12	MAR-008.00027	SOCKET HEAD CAP SCREW, 1/4-20
6	6	MAR-008.00034	SOCKET HEAD CAP SCREW, 1/4-20
7	4	MAR-008.00055	SOCKET HEAD CAP SCREW, 8-32
8	8	MAR-010.00031	DOWEL PIN, 1/4" X 5/8"
9	1	PHP-10058	CYLINDER
10	1	PHP-31030	BLOCK
11	2	PHP-10044	SLEEVE BEARING
12	4	MAR-008.00004	SET SCREW, 10-32
13	2	PHP-10061	DOWEL PIN
14	2	PHP-10053	BEARING
15	6	MAR-008.00057	NUT
16	4	MAR-002.00015	SPRING ANCHOR
17	1	MAR-010.00032	CLEVIS PIN, 0.25" DIA
18	1	PHP-318	ELBOW, 1/8 NPT
19	1	MAR-010.00033	NIPPLE
20	2	PHP-10054HD	SIDE PLATES, PADDLE CLAMP
21	2	PHP-10043HD	INSERT ROLLER GUIDE
22	1	PHP-10050HD	TOP JAW WELDMENT
23	2	PHP-31018HD	PIVOT PLATE
24	6	MAR-009.00007	ROLLER
25	4	MAR-008.00058	CAP NUT, 1/4-20
26	2	MAR-008.00015	SOCKET HEAD SCREW
27	2	MAR-008.00005	1/4-20 NUT
28	1	PHP-10076HD	INSERT, ROLLER GUIDE
29	1	PHP-10042HD	INSERT, ROLLER GUIDE
30	2	PHP-31166	MOUNTING BLOCK
31	8	2MAR-008.00040	SOCKET HEAD SCREW, 10-32
32	1	PHP-10045	PIVOT CLAMP
33	1	PHP-30766	JAW GUARD
34	3	MAR-008.00059	FLAT HEAD SCREW, BRASS, 6-32
35	1	PHP-31019	COVER, PADDLE CLAMP
36	2	MAR-002.00017	ROLLER STUD
37	2	PHP-10048HD	FORWARD ROLLER STUD
38	1	EL-15	LIMIT SWITCH
39	2	PHP-10060	EXTENSION SPRINGS
40	1	PHP-5099	CORD, RETRACTING COIL, 2FT
41	1	RA-90251	CORD GRIP
42	2	MAR-008.00079	SOCKET HEAD SCREW, 6-32
43	1	MAR-002.00018	SPACER PLATE

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			TITLE HEAVY DUTY PADDLE CLAMP UPGRADE
SCALE		REV	DWG. NO. SA-123183 HEAVY DUTY
		SIZE C	QTY. 2 of 4
			SHEET




PARTS LIST			
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10	1	PHP-31030	BLOCK
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21	2	PHP-10043HD	INSERT ROLLER GUIDE
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23	2	PHP-31018HD	PIVOT PLATE
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	TITLE HEAVY DUTY PADDLE CLAMP UPGRADE		SHEET 3 of 4
SCALE	REV	SIZE C	DWG. NO. SA-123183 HEAVY DUTY



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	TITLE HEAVY DUTY PADDLE CLAMP UPGRADE		DWG. NO. SA-123183 HEAVY DUTY
SCALE	REV	SIZE C	