

Sheet1

Replacement of the Shear Key, G08022-1. Refer to Diagram 8: Working Table pg 96 in Manual.

1. Remove two M6 bolts (#7) from #34
And scroll the cross-feed screw (#24) out of
The nut (#5).



2. When the screw is clear of the The nut, rotate
the keyway to the down position And slide the
screw out of the gear sleeve (#23).



3. With the keyway facing down, the key will be
Left inside the gear sleeve at the 6 o'clock position.



4. Remove the key (#22). Rotate the gear (#23) to
the 12 o'clock position to make removal easier.
Use a punch through the hole In the top of the
Gear sleeve if necessary.

