

Service Procedure

CF8 Wire Clamp

Replacing Wire Clamp PN 801-1-9

Prepare CF8

To prepare the CF8 for wire clamp replacement:

1. Unplug machine power.
2. Remove the transport wheels.
3. Close station 1 (Infeed Chute Adjustment).
4. Remove all dies from stations 6 & 7.
5. Set station 6 & 7 to 700.
6. Set station 8 & 9 to 0 (zero).

Remove Wire Clamp

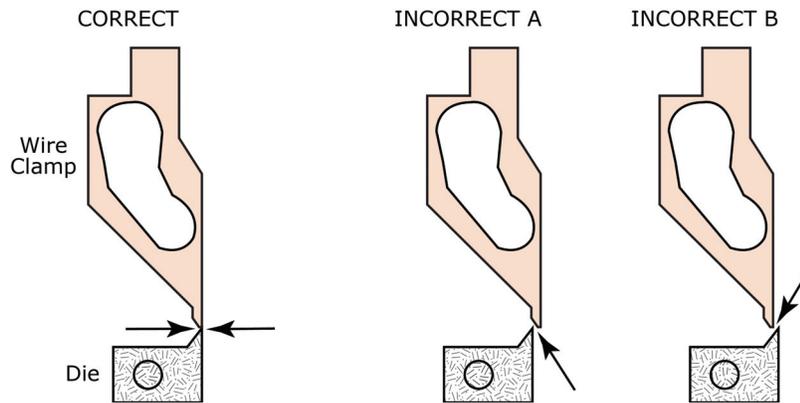
To remove the wire clamp from the CF8:

1. Using a .050" Allen wrench, loosen the set screw in crank (PN 801-1-7) in station 8 & 9.
2. Remove crank pin (PN 801-1-12).
3. Remove slide assembly (PN 801-1-200) by lifting it upward.
4. Remove 2 cap screws securing wire clamp (PN 801-1-9) to clamp support.
5. From one side, remove the small snap ring (PN G1001) that retains wire clamp pin (PN 801-1-15).
6. Slide wire clamp pin (PN 801-1-17) from roller support assembly (PN 801-1-100) and roller (PN 801-1-15).
7. Replace wire clamp (PN 801-1-9) in reverse of [Step 4](#) through [Step 6](#) (in *Remove Wire Clamp* section).

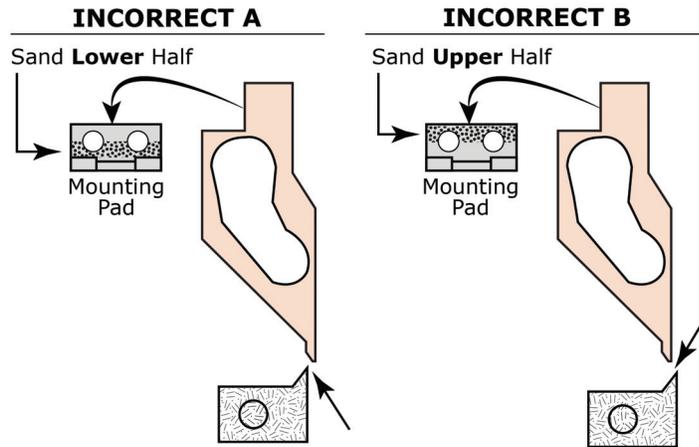
Adjust Wire Clamp-to-Die Alignment

To fine tune the alignment of the wire clamp to the die:

1. Install horizontal or modified horizontal dies of any size in stations 6 & 7.
2. Place slid assembly (PN 801-1-200) in die block.
3. Inspect wire clamp-to-die alignment. Correct alignment occurs when the wire clamp is aligned in the same plane as the die (shown below at left), as opposed to the wire clamp being offset to the right or left of the die surface.



4. If alignment is correct, skip to [Return CF8 to Operations](#). If alignment is incorrect, file specified half of the mounting pad according to the following. If alignment is similar to:
 - INCORRECT A (see below left), sand the lower half of the mounting pad to tip wire clamp inward until it becomes flush with die.
 - INCORRECT B (see below right), sand the upper half of the mounting pad to tip wire clamp outward until it becomes flush with die.



Return CF8 to Operations

To return the CF8 to its operational state:

1. Remove dies from stations 6 & 7 and lower slide to bottom of die blocks.
2. Align hole in slide with holes in crank (PN 801-1-7) and install crank pin (PN 801-1-12).
3. Center crank pin so ends of the pin do not protrude from edge of slide, and then install and tighten set screw.
4. Lubricate slide assemblies per standard manual instructions.