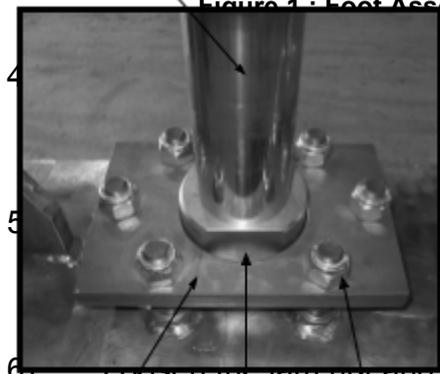


Start by lowering the top jaw on the Chris Cutter all the way down. If there is excessive grease on the guides it may be beneficial to remove it prior to adjusting the guides.

- 1) Before loosening any of the guide bolts, inspect the position of the top jaw. It needs to be true to the bottom jaw and centered under the upper hydraulic cylinder(s).
 - The rod foot needs to be centered within the hold down plate. (see figure 1)
 - The top teeth should be directly aligned above the bottom teeth. It may be helpful to take a mirror and look down the length of the teeth to verify that they are in line.
- 2) In most cases the jaw will naturally seek the correct alignment and so the objective is to not to move the top jaw while tightening the side guides. If the top jaw is out of alignment then take a measurement of how much so that it can be moved back into position with the guide adjusters.
- 3) The retaining bolts may appear to be loose. Do not over tighten the retaining bolts shown in figure 1. The maximum torque is 2 ft-lbs. This system is designed to allow the rod end to adjust to any misalignment with the top jaw.

Hydraulic Cylinder Rod

Figure 1: Foot Assembly



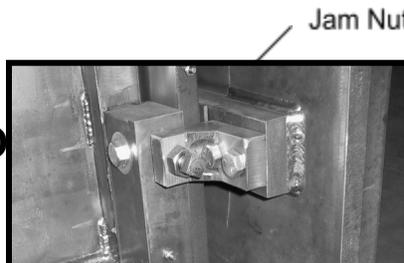
4) Inspect the side guides. It is typical that only one side may have a gap between the side guide and the top jaw. You may need feeler gages to check for a gap or not.

5) Measure the most gap by loosening the three 5/8in retaining bolts on the side guide. They do not need to be real loose. Just a

6) Loosen the jam nut and turn the square head keeper bolt clockwise to tighten the side guide. **DO NOT OVERTIGHTEN. 10 FT-LBS MAXIMUM.** Check to be certain that the teeth are still aligned top and bottom and that the rod foot is still centered in the hold down plate. Tighten the jam nut.

- 7) Repeat the above process on the remaining side guides.
- 8) Grease the guides prior to using the machine

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Square Head Keeper Bolt

