

X-Carriage HeliCoil Replacement Instructions

This document provides instructions on replacing the HeliCoils of the AMAYA x-carriage. Replacement is necessary if any of the HeliCoils come out of the x-carriage. (See the following image for HeliCoil identification).

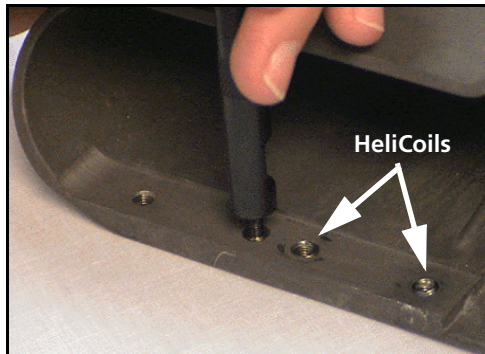


Figure 1: X-Carriage HeliCoils

HELICOIL REPLACEMENT KIT

All of the tools and parts necessary for this procedure are included in the HeliCoil Replacement kit.

- HeliCoil Insert, pn 32514, (8)
- HeliCoil Installation Tool, pn 32513, (1)
- Tang Break Off Tool, pn 32515, (1)
- Installation Instructions, pn 32547, (1)

PROCEDURE

1. If a HeliCoil has only partially come out of the x-carriage, you will need to remove it. (See the following image).

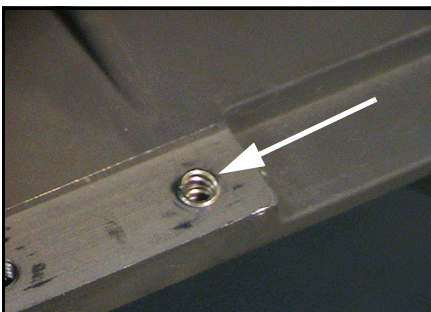


Figure 2: HeliCoil Must Be Removed

2. Using a pair of needlenose pliers, remove the HeliCoil from the hole. (See *Figure 3* and *Figure 4*).

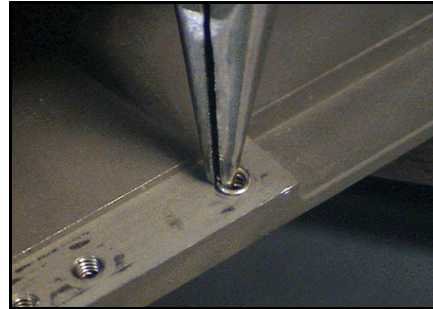


Figure 3: Hold HeliCoil with Pliers

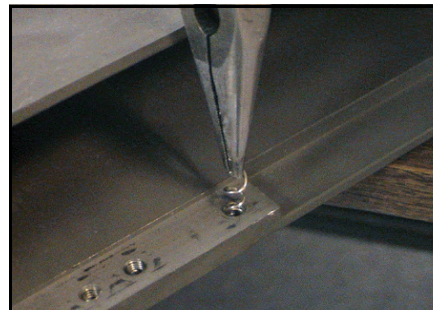


Figure 4: Remove HeliCoil

3. Locate the HeliCoil installation tool.

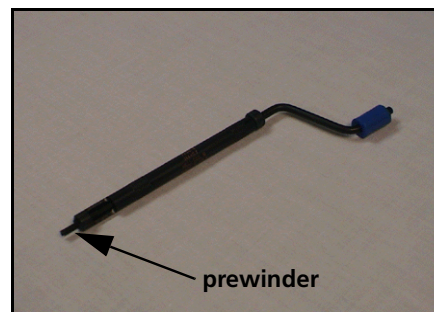


Figure 5: HeliCoil Installation Tool

4. On the HeliCoil you are about to install, locate the piece known as the tang. (See *Figure 6*).

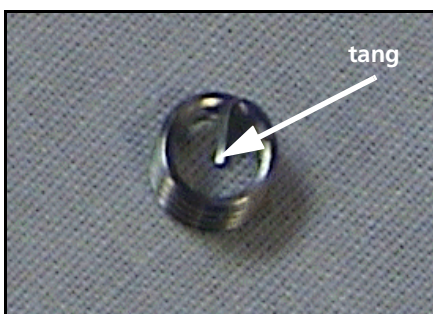


Figure 6: HeliCoil

5. Turn the handle of the HeliCoil installation tool until the end of the prewinder is visible in the opening at the end of the tool. Place a HeliCoil at the end of the prewinder (with tang on top), inserting the prewinder tip (raised part at the end of the prewinder) into the tang of the HeliCoil insert. (See *Figure 8* for a zoomed in view of this; please note the prewinder was removed from the tool for illustration purposes).

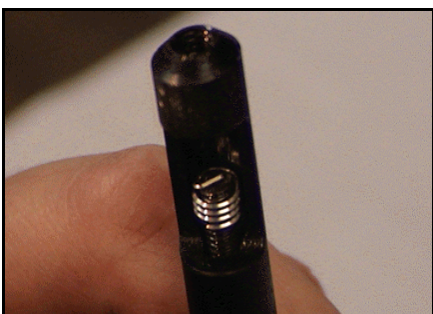


Figure 7: HeliCoil on Prewinder

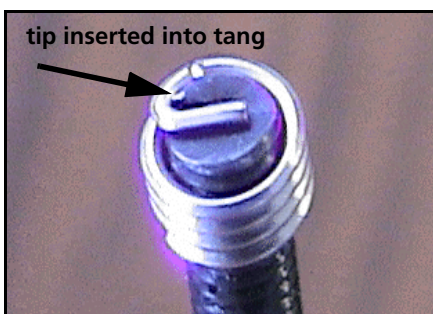


Figure 8: Zoomed in View

6. Turn the handle of the HeliCoil installation tool until the tang of the HeliCoil insert is beyond the tip of the tool one full turn.

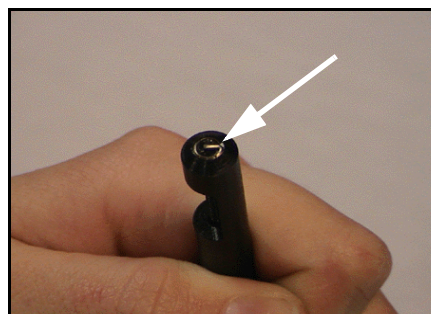


Figure 9: Tang Protruding

7. Line up the end of the HeliCoil installation tool with the hole in the x-carriage.



Figure 10: HeliCoil Tool in Place

8. Turn the handle of the HeliCoil installation tool until the HeliCoil is level with the surface of the carriage.



Figure 11: Installing HeliCoil

9. Remove the HeliCoil installation tool (turn the handle to unscrew). The following image displays the proper position of the HeliCoil.



Figure 12: Proper HeliCoil Position

10. You must now break off the tang. Locate the Tang Break Off tool.



Figure 13: Tang Break Off Tool

11. Place one end of the tang break-off tool in the assembled HeliCoil insert so that it rests on the tang of the insert.
12. Using a hammer or mallet, firmly tap the tang break off tool. This should off break the tang (the tang must be completely removed).
13. Screw one of the x-carriage thumbscrews all the way through the new HeliCoil insert to make sure the HeliCoil has been successfully installed. If the thumbscrew will not screw in, contact Melco Service.
14. The HeliCoil installation is complete.