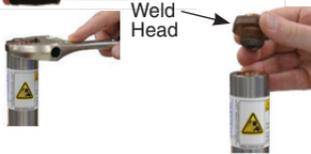


# SXZR Pin Replacement Procedure

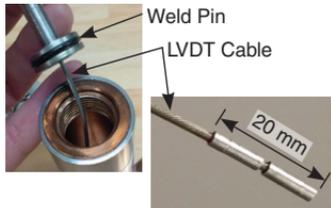
- 1** Remove the air and water services from the system.



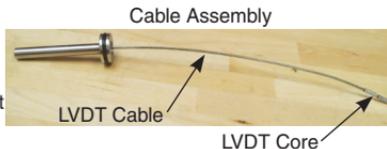
- 2** Unthread and remove the Weld Head.



- 3** Gently remove the used Weld Pin and LVDT Cable Assembly from the weld body. Slightly twisting the weld pin while pulling may help the cable find its way out.

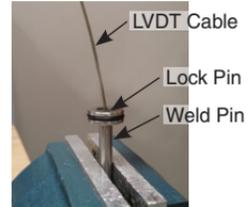


- 4** Inspect the Cable Assembly and ensure that the Cable has no kinks or bends, and the Core is intact and in correct position.



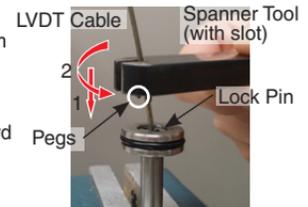
- 5** If the LVDT Cable Assembly and Lock Pin are in good shape, they can be disassembled and reused with a new Weld Pin. Install the used Weld Pin upside down in a vise and continue with step 6 below.

If the Weld Pin and LVDT Cable Assembly are being replaced as a whole assembly, go to step 12.



- 6** Use the Spanner Tool provided to unthread the Lock Pin from the bottom of the old Weld Pin [2].

Remove the LVDT Cable Assembly and Lock Pin, and set them aside for future use. Discard the used Weld Pin.



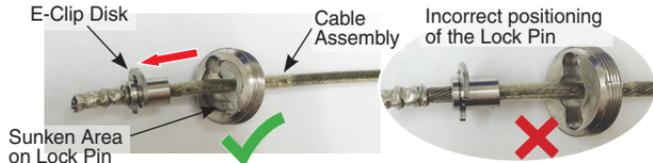
- 7** Place the new Weld Pin upside down into the vise. A soft jaw vise is recommended.



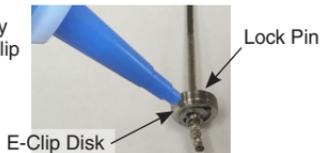
- 8** Check that the Use By date on Loctite 243 has not passed and shake well. Apply the Loctite to the threads of the new Weld Pin.



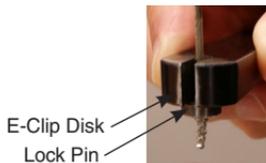
**9** Slide the Lock Pin (sunken side first) onto the Cable Assembly. Ensure that the E-Clip Disc fits properly into the sunken area of the Lock Pin.



**10** Orient the Cable Assembly downward so that the E-Clip Disk stays seated into the sunken area of the Lock Pin. Then, apply Loctite 243 to the threads of the Lock Pin.



**11** Use the Spanner Tool to insert the Lock Pin into the Weld Pin. Be careful not to cross the threads. Wipe off any excess Loctite.



**Note:** To keep all the components in place, keep the cable under tension by gently pulling its other end with your other hand.

**Very Important:** After the procedure, check that the Lock Pin and the LVDT Cable are tight and do not move or rotate relative to the Weld Pin. The Lock Pin must sit flush or below the base of the pin. The cable should have no play.



**12** Apply Magnalube-G grease to lubricate the O-Ring on the new Weld Pin.



**13** Gently insert and fully slide the LVDT Cable Assembly through the hole in the bottom center of the Weld Body, until the Weld Pin properly sits inside the Weld Body.

During this process, slightly twisting the cable [1] or using needle nose pliers [2] may help to gently guide the LVDT Cable Assembly through the hole.



**14** Ensure that the Weld Pin moves freely up and down inside the Weld Body (with no constraint from the LVDT Cable Assembly), then attach and tighten the Weld Head.

