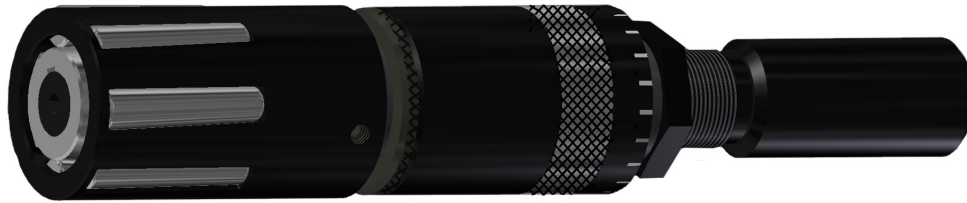


5408 and 5409 Series Roll, Mandrel and Cage Replacement Instructions



Roll replacement

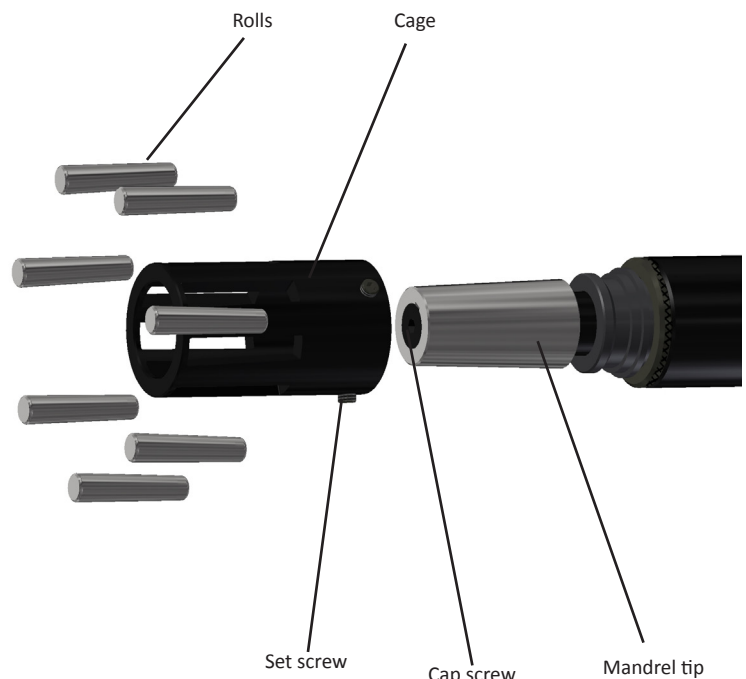
To replace the rolls on your 5408 or 5409 series tool, follow these instructions:

1. Loosen the three cage set screws using a 3/32" hex wrench.
2. Pull the cage forward. The cage and rolls will move simultaneously as they are pulled forward. Rolls will be loose and removable at this point.
3. Replace rolls. ****ALWAYS REPLACE THE ENTIRE SET OF ROLLS.****
4. With new rolls in place, push cage/rolls backwards into place and tighten set screws using a 3/32" size hex wrench.

Cage replacement

To replace the cage on your 5408 or 5409 Series tool, follow these instructions:

1. Follow steps 1 & 2 as listed in "Roll replacement" instructions above.
2. With rolls removed, check the cage cavities for signs of wear. If you see any, replace the cage to ensure the best performance of the tool.
3. With cage replaced, follow step 3 (if needed) as listed in "Roll replacement" instructions above, and reassemble tool following step 4.



Mandrel replacement

To replace the mandrel on your 5408 or 5409 series tool, follow these instructions:

1. Follow steps 1 & 2 as listed in "Roll replacement" instructions above.
2. Use 1/4" size hex wrench to remove the cap screw from mandrel tip.
3. Slide mandrel off of the shank. Be careful to watch for key that holds the mandrel in place on the shank.
4. Replace the mandrel, remembering to also replace the key into the shank.
5. Screw cap screw back into end of mandrel with 1/4" size hex wrench.
6. Follow steps 3 & 4 (if needed) as listed in "Roll replacement" instructions above to reassemble tool to operational state.

