



COR-LOK-B type air chuck and shaft tube and valve replacement procedure:

- 1) Deflate the COR-LOK-B chuck or shaft by depressing the valve.
- 2) Remove the plain end cap (end opposite the valve, see figure 1) by removing the necessary set screws. Slide the end cap off the air chuck / shaft body. Slide off all of the aluminum segments. These steps will expose the inflating tube and tube clamps.
- 3) Remove the plugged tube end from the counter bore relief in the air chuck / shaft body from the end opposite the valve (see figure 2).
- 4) Unwind inflating tube from threaded air chuck / shaft body.
- 5) Pull the inflating tube up to raise the copper extension from the groove in the air chuck / shaft body (see figure 3).
- 6) Remove the rubber inflating tube from the copper extension. Note: the old copper extension may have a barbed fitting at the tip. The new replacement valve body with extension will not have the barbed fitting at the tip.
- 7) Measure the new, replacement inflating tube to be the same length as the old, removed inflating tube PLUS 3-4 inches.
- 8) Straighten the copper extension and remove it through the access hole in the air chuck / shaft body.
- 9) Insert new valve with copper extension into the valve seat and through the thru hole (see figure 4).
- 10) Pull the copper extension and push the valve body so that it seats completely into the valve seat (see figure 5). The valve should be slightly below the face of the end cap when properly seated.
- 11) Bend the copper extension so that it is centered in the groove in the air chuck / shaft body.
- 12) Check that the copper extension extends past the tube clamp counter bore relief.
- 13) Cut the rubber inflating tube approximately 1-1/4" in length, as shown in figure 6.
- 14) Thread the cut end of the inflating tube thru the tube clamp as shown in figure 7. Pull the clamp down approximately 1-1/2" past the cut area.
- 15) Thread the cut end of the inflating tube thru the plastic sleeve as shown in figure 8. Pull the plastic sleeve down past the cut area.
- 16) Work the tube clamp back over the plastic sleeve and place it around the middle of the plastic sleeve as shown in figure 9. Please note, it is extremely important to use the plastic sleeve. The tubing will fail if the plastic sleeve is not in place.
- 17) Cut the rubber inflating tube at the end to "square it off", as shown in figure 10.
- 18) Slide the rubber inflating tube / plastic sleeve and clamp assembly on to the copper extension, into the inside diameter of the rubber inflating tube.
- 19) Bend the copper extension down and check that the clamp is aligned properly with the counter bore relief. The clamp should be aligned to fit into the counter bore relief.
- 20) Lift the clamp and use end nippers to close the ears on the tubing clamp.
- 21) Bend the copper extension down and insert the clamp into the counter bore relief.
- 22) Wind inflating tube around the body of the air chuck / shaft, into the spiral groove. Inflating tube should be wound loosely around the body of the air chuck / shaft. Do not stretch the inflating tube during the winding process.
- 23) After the rubber inflating tube is wound completely to the plain end (end opposite the valve) mark the rubber inflating tube where the counter bore relief lines up to the rubber inflating tube.
- 24) Follow steps 13-16 for the plain /plugged end of the rubber inflating tube.
- 25) Insert the rubber plug into the end of the rubber inflating tube.
- 26) Cut the rubber inflating tube at the end to "square it off", as shown in figure 10.
- 27) Use end nippers to close ears on the tubing clamp.
- 28) Insert inflating tube / plastic sleeve / clamp and rubber plug assembly into the counter bore relief.
- 29) Reassemble the interlocking segments onto the body of the air chuck / shaft. Be sure the keyed segment(s) line up with the keyway in the end cap.
- 30) Reassemble the end cap onto the plain end (end opposite the valve end) of the air chuck / shaft.
- 31) Insert all end cap screws and tighten.
- 32) Inflate to test.

DRAWN	7/3/2012	CONVERTER ACCESSORY CORPORATION		
Mark				
CHECKED		TITLE		
QA		COR-LOK-B REPAIR INSTRUCTIONS		
MFG				
APPROVED				
		SIZE	DWG NO	REV
		C	27609-100	
		SCALE		SHEET 1 OF 1