

fig. 1

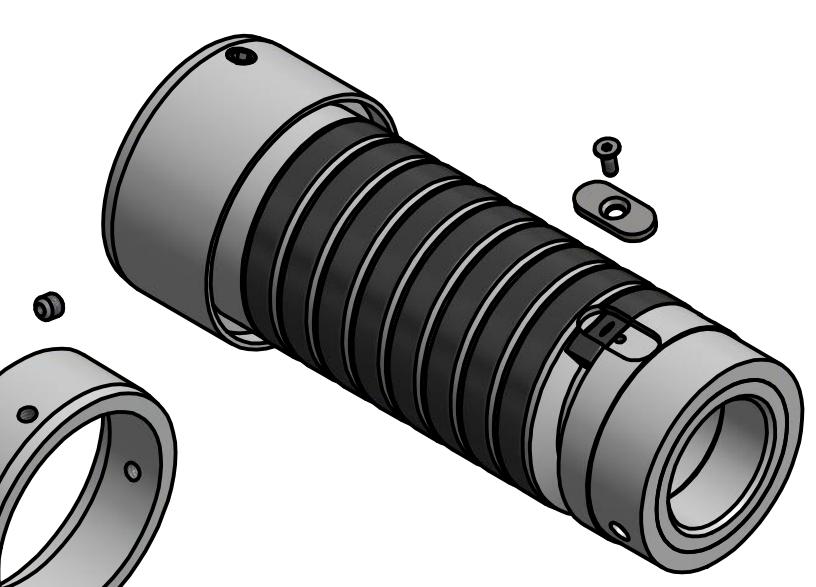


fig. 2

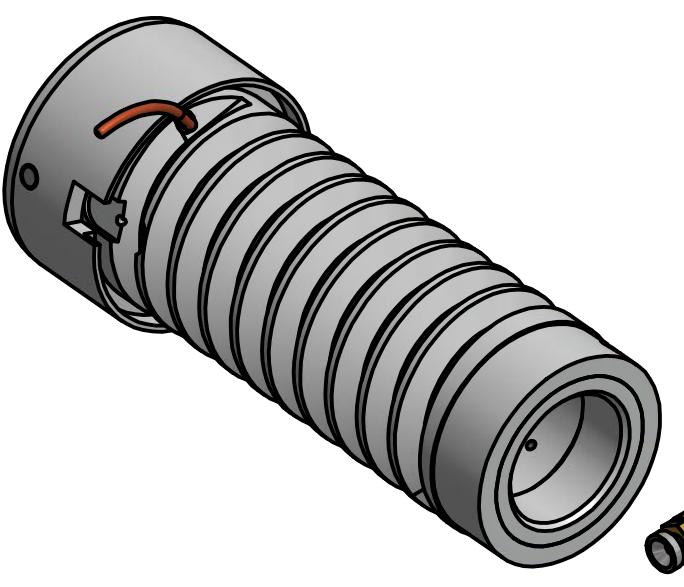


fig.3

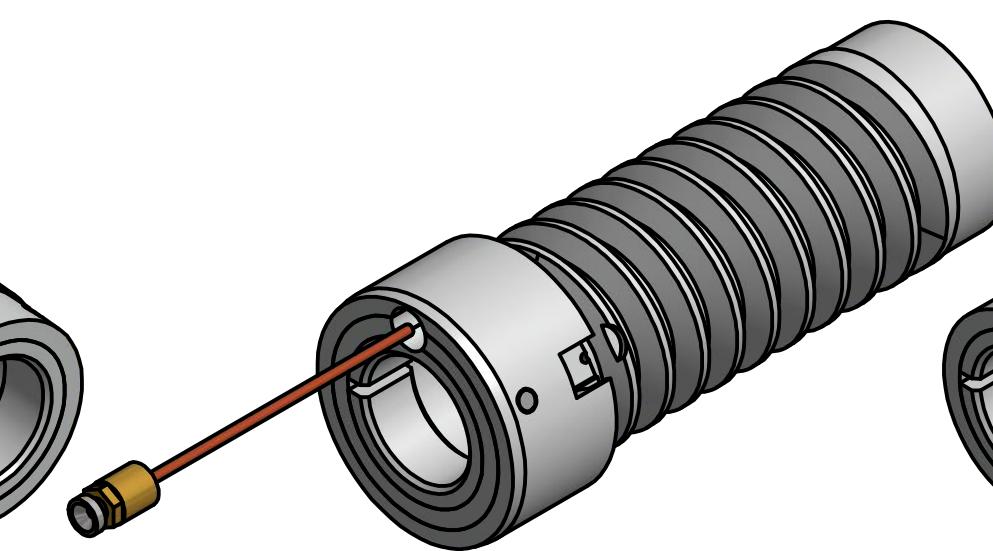


fig.4

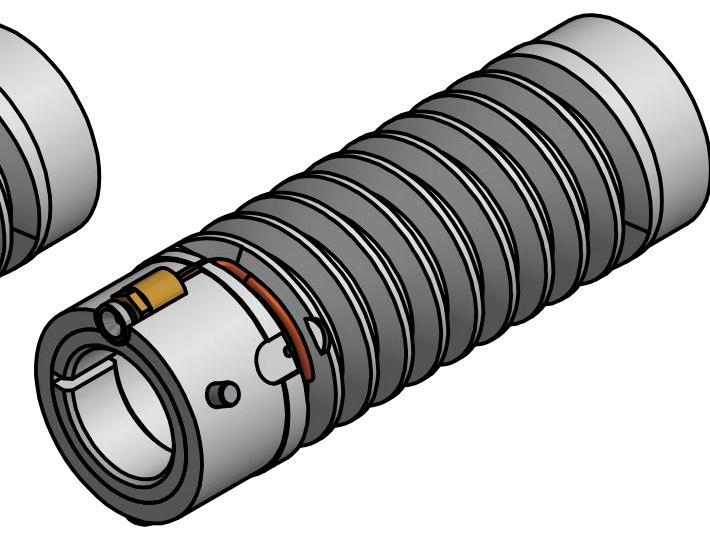


fig.5

COR-LOK-B2 type air chuck and shaft tube and valve replacement procedure:

- 1) Deflate the COR-LOK-B2 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 tab clamps.
- 3) Remove flathead screw and tab-clamp from plugged end of the inflating tube (end opposite the valve, see figure 2).
- 4) Remove inflating tube from threaded air chuck / shaft body. Remove flathead screw and tab-clamp from valve end.
- 5) Pull inflating tube up to raise copper extension from the groove in the air chuck / shaft body (see figure 3).
- 6) Remove rubber inflating tube from copper extension.
- 7) Measure new, replacement inflating tube to be the same length as the old, removed inflating tube.
- 8) Straighten the copper extension and remove through the access hole in the air chuck / shaft body.
- 9) Insert new valve with copper tube 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. Check that the copper extension extends past the tab-clamp location to ensure proper clamping.
- 12) Assemble the rubber inflating tube onto to the copper valve extension by inserting the copper extension into the inside diameter of the rubber inflating tube. Push rubber inflating tube until it is 1/4" to 1/2" past the tab-clamp location.
- 13) Reassemble the tab-clamp in the air chuck / shaft body in the tab-clamp seat on the valve end of the air chuck / shaft.
- 14) Insert the flathead screw and tighten.
- 15) 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.
- 16) Insert the rubber plug into the inflating tube approximately 3/4" to 1" deep (end opposite the valve end).
- 17) Reassemble the tab-clamp in the air chuck / shaft body in the tab-clamp seat on the plain end (opposite the valve end) of the air chuck / shaft.
- 18) Insert the flathead screw and tighten. Rubber tubing should extend 1/4" to 1/2" past the tab-clamp.
- 19) 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 caps.
- 20) Reassemble the end cap onto the plain end (opposite the valve end) of the air chuck / shaft.
- 21) Insert all end cap set screws and tighten.
- 22) Inflate to test.

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CHECKED				
QA		TITLE		
MFG				
APPROVED		COR-LOK-B2 REPAIR INSTRUCTIONS		
		SIZE C	DWG NO 27609-99	REV
		SCALE		SHEET 1 OF 1