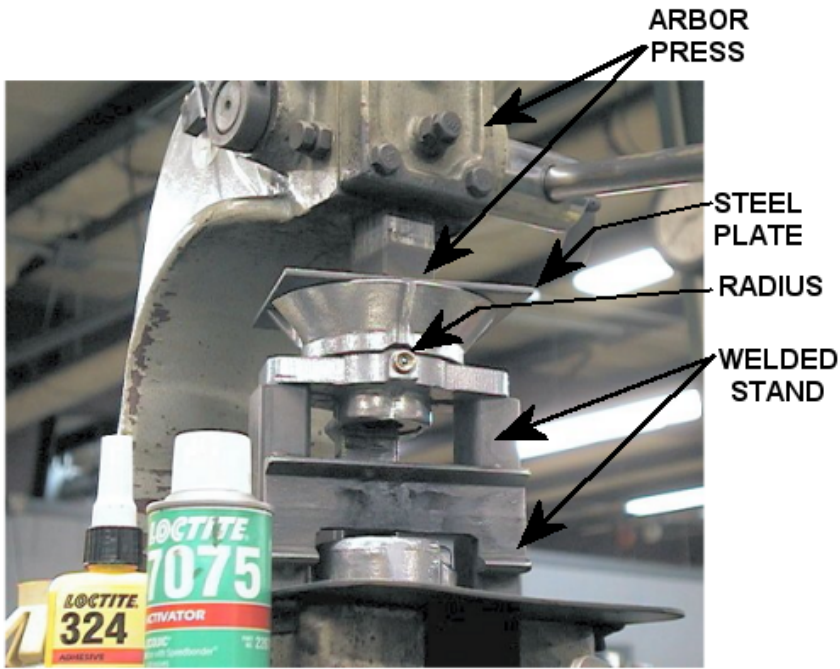


INSTALLATION GUIDE-LINES FOR EE340013 CHOKE GUARD

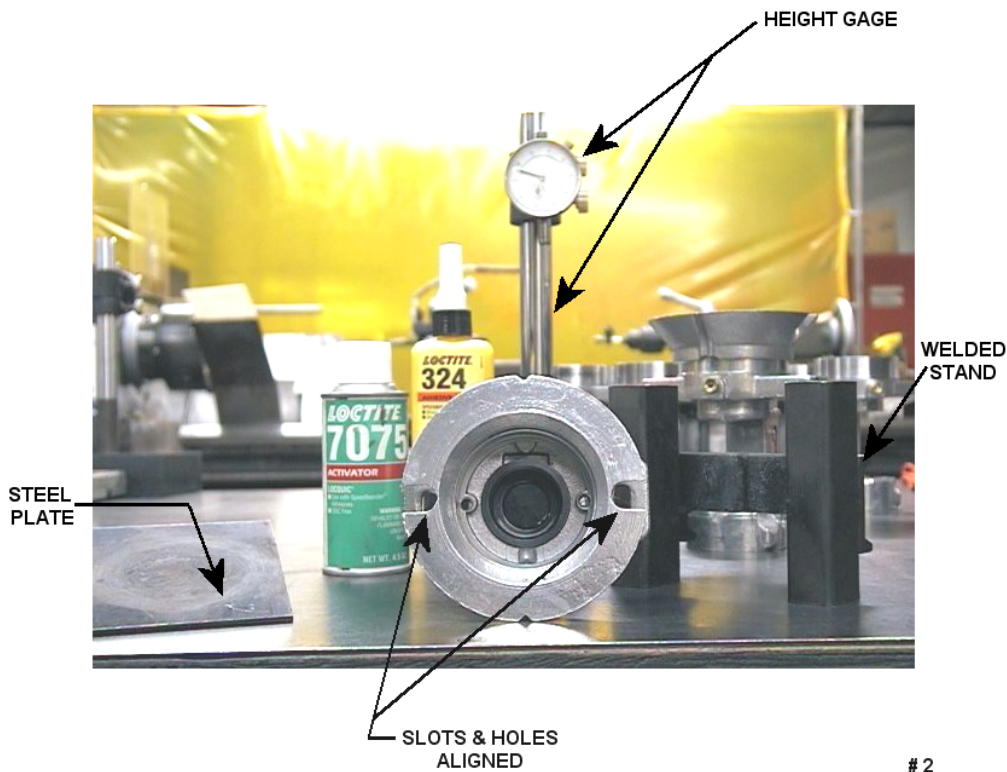
1. Remove Dust Ring
2. Clean the area of the housing to accept the choke guard (also deburr, if needed).
3. Apply Loctite #324 onto the outside surface of housing (where the choke guard will be pressed onto the housing).
4. Spray Loctite Activator #707 on inside of choke guard (at spindle housing contact area).
5. Looking through the two slots of the guard, align the slots with the two screw holes of the spindle housing. (Illustration #2). **Important!** Orient the guard so that the small milled “Radius” and the wider “Notch” are aligned properly (Radius over the grease fitting and the notch over the spindle housing neck) (Illustration #1 Radius), (Illustration #3 Notch).
6. Place spindle housing onto the welded stand (Illustrations #1, #2 & #3)
7. Place the steel plate (Illustrations #1, #2 & #3) centered on the choke guard.
8. Center the housing, guard and steel plate underneath the arbor press and press down until the guard is firmly seated as far down as it will go. (Illustration #1 & #3)
9. Check the levelness of the top of the choke guard. Check 4 places at 90° apart (near the outer edges) Epic checks with a height gage and (Illustration #2) allows a total difference of not more than 0.015” (lowest to highest point). Note: to prevent bending the housing, do any bumping with the housing still on the stand.
10. Allow 24 hours to 100% cure (if possible).
The adhesive will cure on the twister but if there is a wrap-up before 24 hours, the holding power will not be at 100% capacity.

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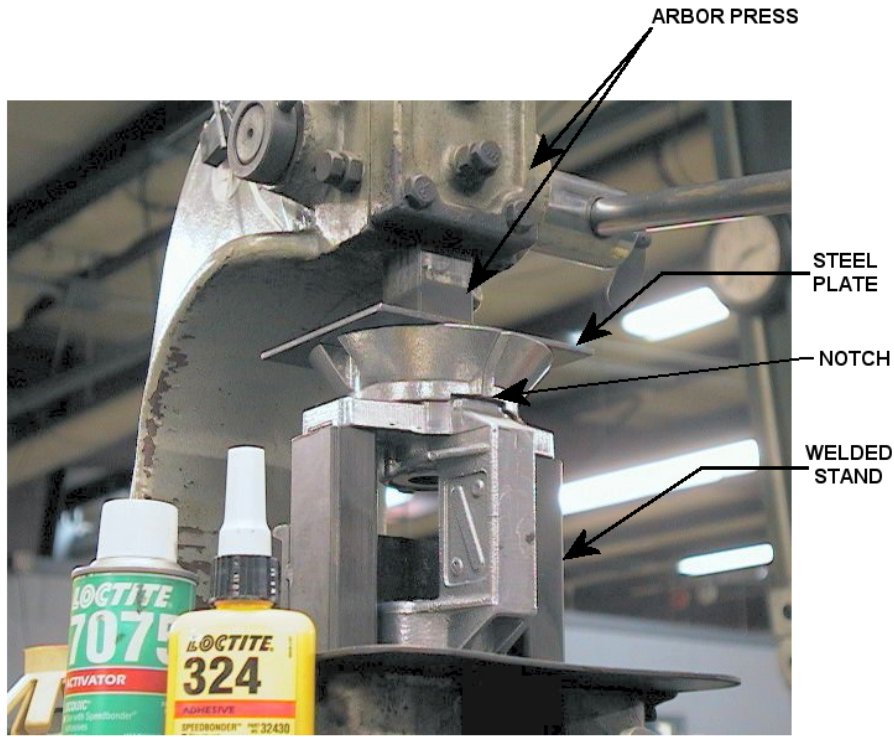


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