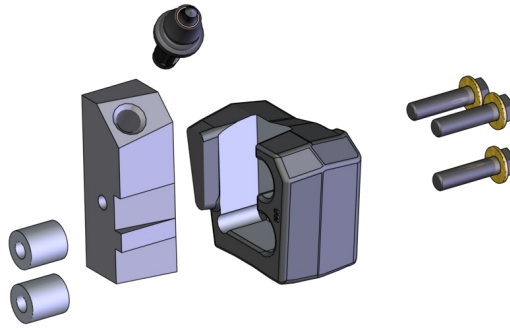




WEDGE LOCK SYSTEM SERVICE PROCEDURE



CAUTION: Wear safety glasses and other protective clothing and shoes at all times while performing service to drum.

Day One:

After running the drum 8 hours retighten bolts to 125 foot pounds.

250 Hours or Every Oil Change Interval:

Rotate flipper paddles $\frac{1}{2}$ turn if needed .

Holder Removal & Installation:

1. Remove the single bolt that goes directly into bit holder.
2. Back both wedge bolts out 2-3 full turns and then tap wedge bolts with a hammer to break wedges bond. Remove the wedges (If the wedge's bond does not break hit the bit holder in the direction of the base block and then in the direction away from the base block with a sledgehammer. Re-tap wedge bolts.)
3. Remove bit holder from the base and clean the base pocket thoroughly.
4. Install new bit holder (Many Wedge Lock Systems have multiple bit holders. If you are uncertain about the style of Wedge Lock System, please call Keystone at 317-271-6192 to verify.
5. Apply anti-seize to the area on the bit holder where the wedges will be placed. Loosely install wedges and wedge bolts with washers.
6. Install the single bolt that goes directly into bit holder and tighten bolt to 125 foot pounds
7. Tighten wedges to 125 foot pounds. (You can tap wedges with hammer at the same time as you are tightening bolt to apply more torque.)
8. Retighten all bolts after running 8 hours.