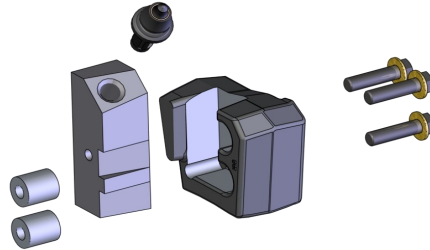


WEDGE LOCK SYSTEM SERVICE PROCEDURE



Day One:

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

250 Hours or Every Oil Change Interval:

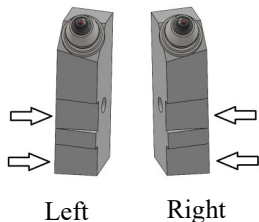
Rotate flipper paddles ½ turn if needed.

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

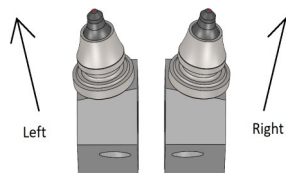
Holder Removal & Installation:

1. Remove the single bolt that goes directly into bit holder.
2. Loosen both wedge bolts two to three full turns. Tap the head of the wedge bolts with a hammer to break the wedge's bond. A pneumatic palm nailer can be used to dislodge the wedge. 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.
3. Remove bit holder from the base block and clean the base pocket thoroughly.
4. Install new bit holder (The Wedge Lock System has multiple bit holder options. If you are uncertain about the style of Wedge Lock System on your drum, 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 the wedge bolts 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 drum 8 hours to 125 foot pounds.

How to Distinguish a Right Center Holder from a Left Center Holder:



As seen from the front of the holder, a Left holder will be at full thickness on the left.



As seen from the back of the bit holder, a bit pointing left will indicate a Left holder.

* The opposite is true for End Holders