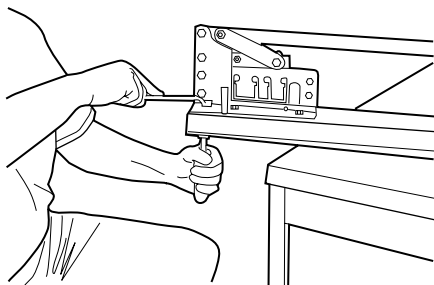
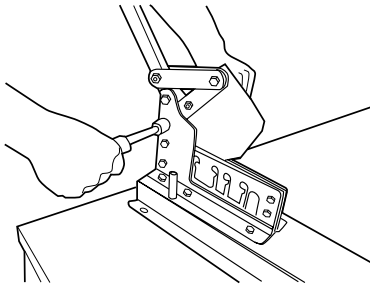


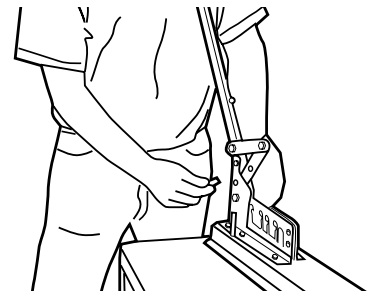
# SRC24A Blade Replacement Instructions



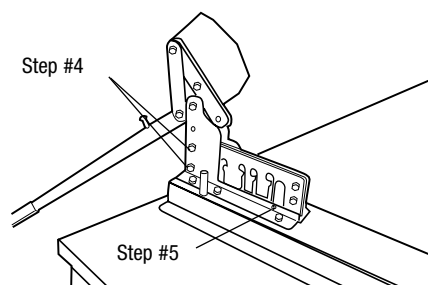
**Step #1:** Loosen, but do not remove the (6) 1/4-28 x .550" long bolts that fasten the die housing to base. (Hex head and locknut wrench size is 7/16".)



**Step #2:** Lift the handle to its fully open position. Loosen the bottom 5/16-24 x 1-1/4 long bolt that fastens the blade support to the side brackets. (Hex head and locknut wrench size is 1/2".)

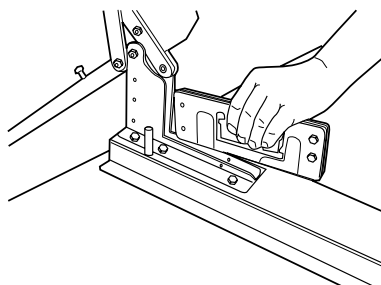


**Step #3:** While resting handle on shoulder, remove the bottom 5/16-24 x 1-1/4 long bolt that fastens the blade support to the side brackets. Removal of this bolt will allow the handle to swing open farther and expose the cutting blade.



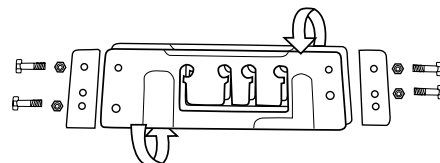
**Step #4:** Remove the (2) 1/4-28 x 1-3/32" long hex bolts (Hex head and locknut wrench size is 7/16").

**Step #5:** Remove the (2) socket head cap screws from the die side housings. (The hex wrench size is 5/32") The die assembly should slide out freely.



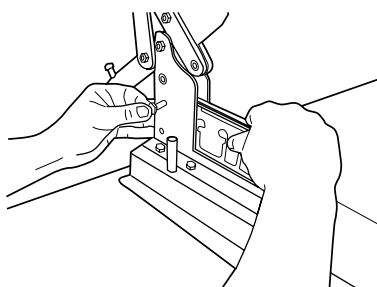
**Step #6:** Note: The back die spacer, now free, may drop out of the bottom of tool.

Remove the (2) remaining 1/4-28 x 7/8" long hex bolts from the die assembly and clean out any scrap material, dirt & old spacers. (Hex head and locknut wrench size is 7/16")

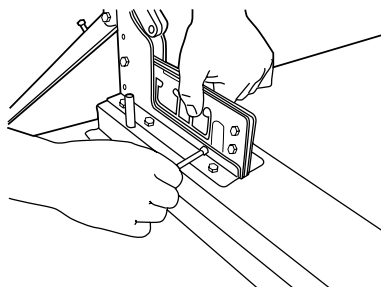


**Step #7:** Visually inspect the dies inside cutting edges for wear. If wear is detected, reverse the die mounting sides to position a fresh cutting edge to the inside. Place one of the new spacers between dies.

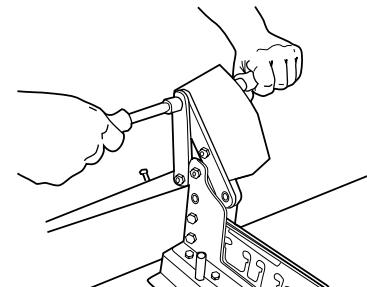
**Note:** Make sure the spacer holes line up with the die holes. The outer edge of spacer should be flush with the die edge. Insert the (2) 1/4-28 x 7/8" long hex bolts in the same holes as removed in step #6. The bolts can be installed in either direction but must be left loose at this time. (The hex head and locknut wrench size is 7/16".)



**Step #8:** Insert the back spacer and visually align with die holes. Hold the dies tightly together with hand pressure. Slide the die assembly between the housings and align with housing holes. Install the (2) 1/4-28 x 1-3/32" long hex bolts. The bolts can be installed in either direction but must be left loose at this time.

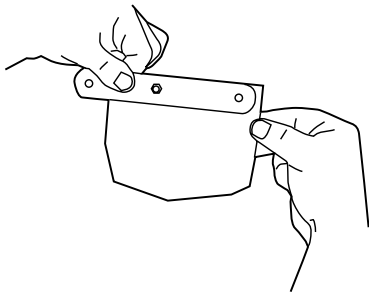


**Step #9:** Install and tighten the (2) socket head cap screws that are located on the housing sides and were removed in step #5. (Hex wrench size is 5/32") The die assembly may need to be lifted up to help align these holes.

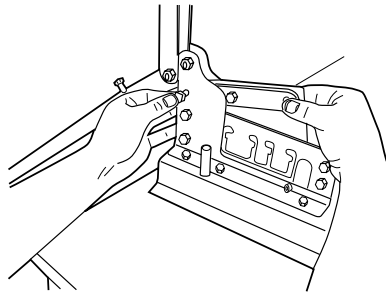


## Blade Replacement:

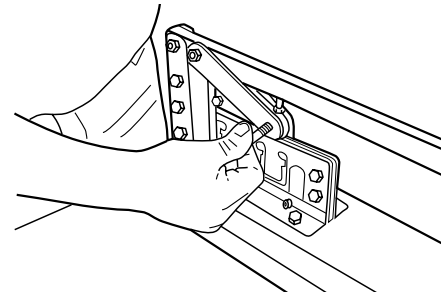
**Step #10:** Remove the (1) 5/16-24 x 1-1/2" long, hex head bolt from the blade support connecting it to the link. (Hex head and locknut wrench size is 1/2".) The opposite end of the link does not need to be removed.



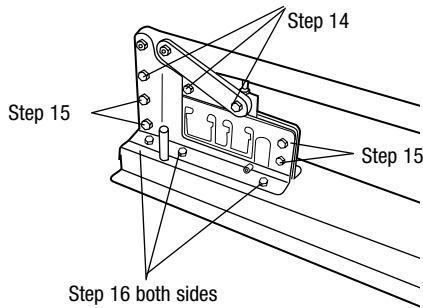
**Step #11: Before removing the next fastener note the blade support to blade orientation.**  
Remove the last (1) 1/4-28 x 7/8" long, hex bolt from the blade support. Remove the old blade and install the replacement. Re-install the same (1) 1/4-28 x 7/8" long, hex bolt through the blade and blade supports. Do not tighten at this time.



**Step #12:** Slide the blade/blade support assembly between the die housings and visually align with the lower 5/16" hole. Insert the (1) 5/16-24 x 1-1/4" long, hex head bolt. Do not tighten at this time.



**Step #13:** Move the handle until the link and blade support holes align, and insert the (1) 5/16-24 x 1-1/2" long, hex head bolt.



**Step #14:** Install the (2) 5/16" & (1) 1/4" locknuts and tighten. Note: No need to over tighten, just make them snug so the handle will move freely. (Hex head and locknut wrench size is 1/2" for the 5/16" diameter bolts and 7/16" wrench size for the 1/4" diameter bolts.)

(Hex head and locknut wrench size is 7/16")

**Step #16:** Tighten all (6) 1/4-28 x .550" long die housing to base fastening bolts. (Hex head and locknut wrench size is 7/16")

Note: It is very important that the tightening sequence from this step forward is followed to achieve proper tool adjustment and cutting clearances.

**Step #15:** Tighten all (4) 1/4-28 hex head bolts.