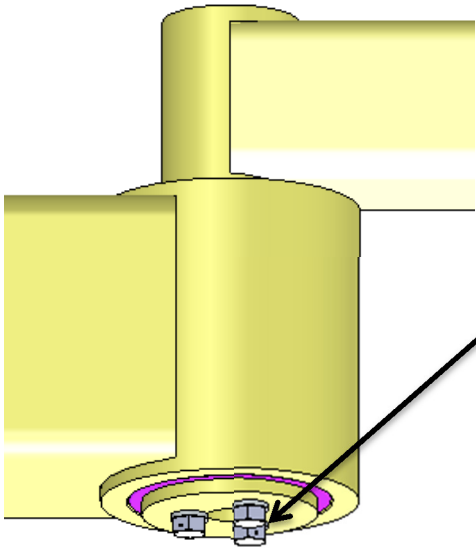
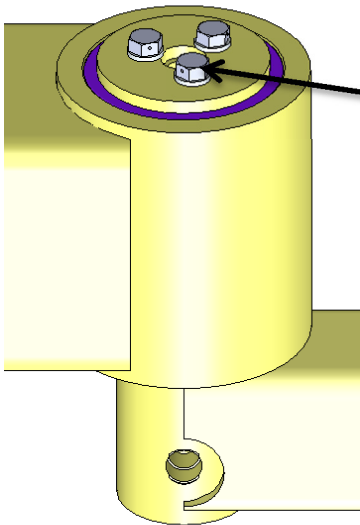


Modify AJ from Overslung to Underslung 2nd Arm:

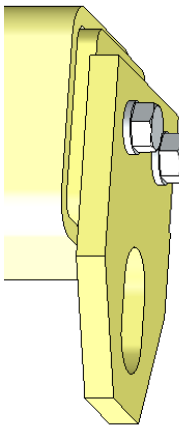
1. Turn off air pressure to the unit and lock-out tag-out according to company procedure.
2. Disconnect air hose from fitting at the base and end of the middle joint pin.
3. Support the 2nd arm with a forklift, or something comparable in the middle of the arm.
 - a. Secure the arm to the forks, or lift slings evenly.
4. Support the 2nd arm from falling during removal.
5. Remove the wires & Hex Head bolts. Remove end cap.
6. May need to hammer MJ shaft to remove. Use soft face hammer.
7. Insert 2nd arm with arm down. Making sure bearings are fully seated in 1st arm bearing housing.
8. Hammer center of 2nd arm shaft to install. Use soft face hammer.
9. Re-install end cap, Hex Head bolts and wires into top of shaft.
10. Remove Hex Head bolts, Flip bracket, so that the slotted hole is down. Reinstall Hex Head bolts.
11. Connect pneumatic hose to Middle Joint shaft fitting securely. Apply small amount of thread sealer during install.
12. Verify hoses, fittings schematics clear the arm when rotating.
13. Turn on air pressure to unit. Verify leak free connections.



5. Remove the wires & fasteners. Remove end cap.



9. Re-install end cap, fasteners and wires into top of shaft.



10. Remove Hex Head bolts, Flip bracket, so that the slotted hole is down. Reinstall Hex Head bolts.