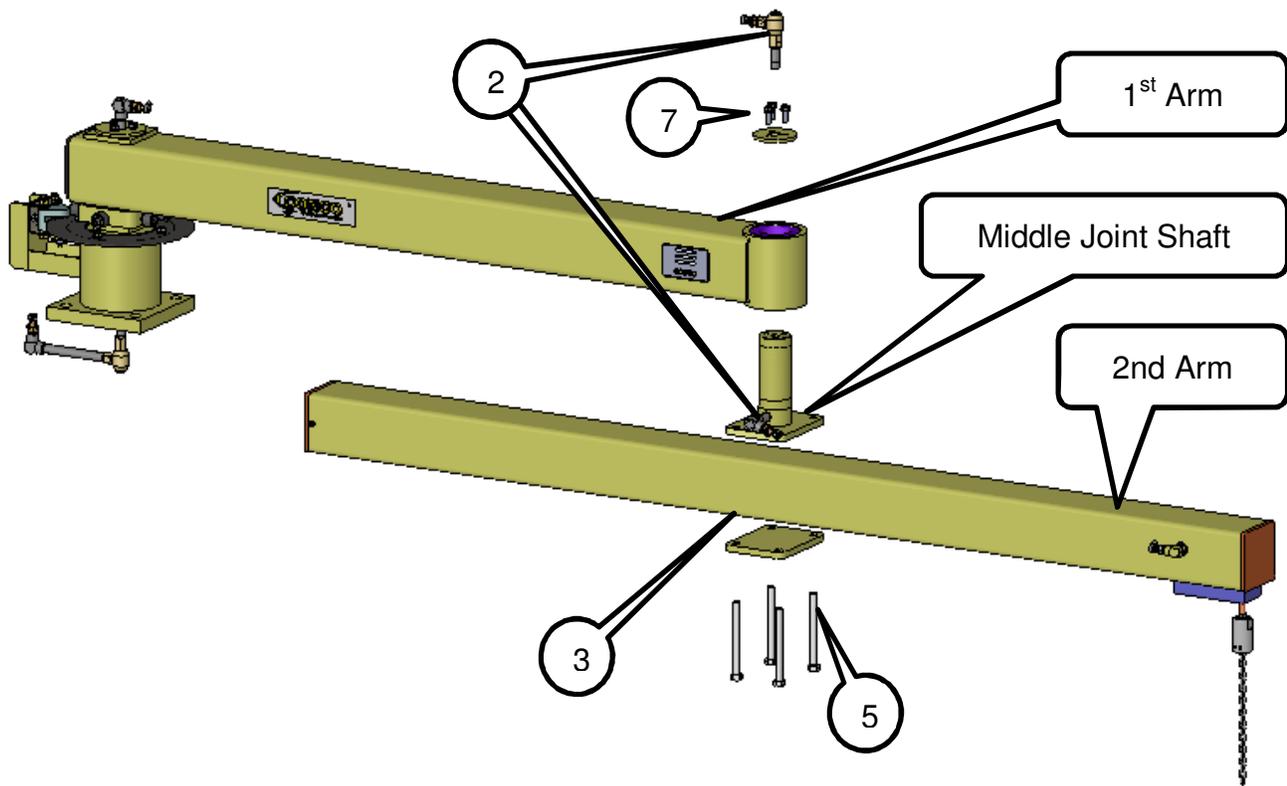


Modify AJL from Underslung to Overslung 2nd Arm:

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. Mark plate location on second arm for easier installation after removal.
4. 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.
5. Loosen & remove the wires & bolts that secure the Middle Joint Shaft to the 2nd arm.
 - a. Safely lower the 2nd arm from the connection.
6. Support the Middle Joint Shaft from falling during removal.
7. Loosen the wires & fasteners. Remove end cap.
8. May need to hammer MJ shaft to remove. Use soft face hammer
9. Insert MJ Shaft with flange facing up. Making sure bearings are fully seated in 1st arm bearing housing.
10. Hammer center of flange to install. May need bar or C-clamp to install if hammer is not successful. Use soft face hammer
11. Re-install end cap, fasteners and wires into top of shaft.
12. Raise 2nd arm into preferred mtg. position, reinstall at marked location from step #3. Connect mtg. plate, fasteners, and wiring to shaft end.
13. Connect pneumatic hose to Middle Joint shaft fitting securely. Apply small amount of thread sealer during install.
14. Verify hoses, fittings schematics clear the arm when rotating.
15. Turn on air pressure to unit. Verify leak free connections.

Disassembly Diagram:



Assembly Diagram:

