

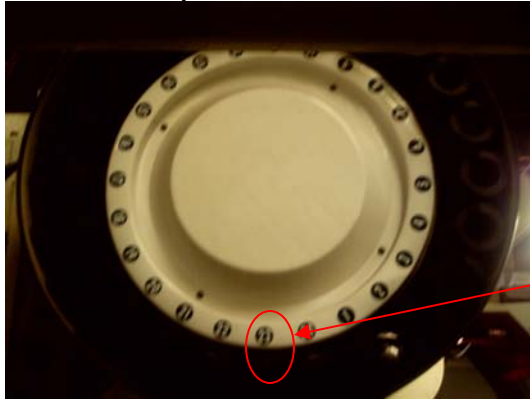
# ACER Group

Springwood Industrial, Inc.  
1062 N. Kraemer Place  
Anaheim, CA 92806  
Tel: 714-632-9701 Fax: 714-632-9730  
<http://www.acergroup.com>  
[info@acergroup.com](mailto:info@acergroup.com)

Klim Industrial, Inc.  
244 N. Randolphville Road  
Piscataway, NJ 08854  
Tel: 732-752-9100 Fax: 732-752-9101  
<http://www.acergroup.com>  
[acer\\_klim@yahoo.com](mailto:acer_klim@yahoo.com)

## Pot Change Procedure

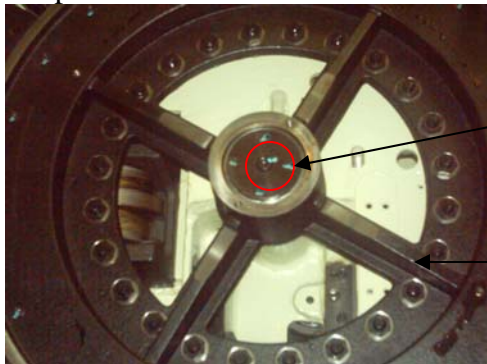
1. Mark broken pot. Loosen four hex screws. Take out the numerical acrylic cover.



Run magazine to move broken pot to bottom of magazine. Mark location.

Our broken pot is pot 23.

2. Remove the  $\frac{3}{4}$ " M10 screw on machine and replace with  $1\frac{1}{4}$ " M10 screw. Pull out pot holder **10 mm**.



Loosen the  $\frac{3}{4}$ " screw and replace with  $1\frac{1}{4}$ " screw.

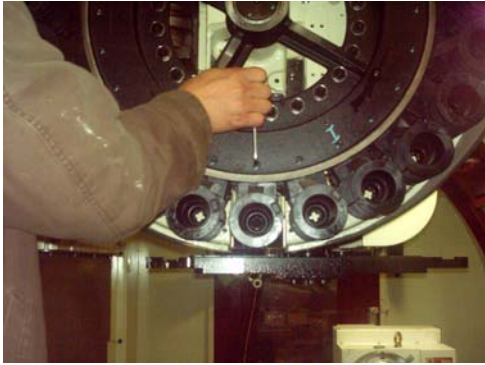
Pot holder

Do not move the 4 pieces fixing bolt.



Pull out 10 mm, use  $1\frac{1}{4}$ " screw as stopper. Pot holder won't fall down.

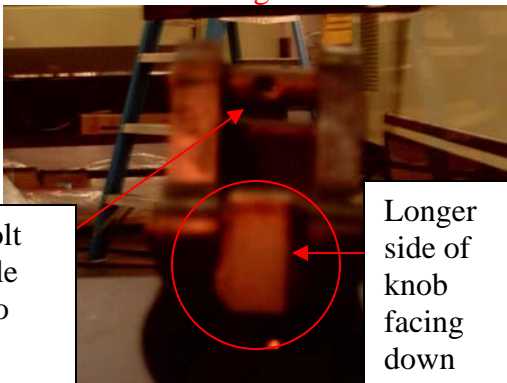
3. Loosen ball M6 screw which holds down the tool pot.



4. Push the pot forward inner side and take the pot upward, then extract it.

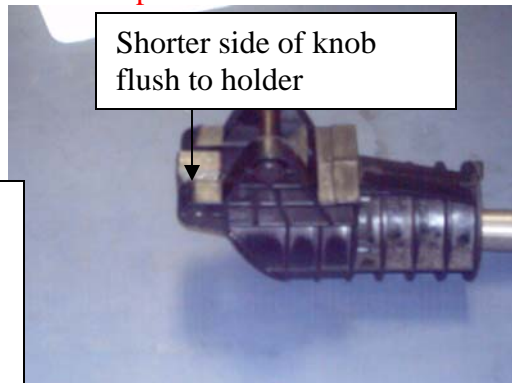


5. Make sure the fixing bolt and knob is in the correct position



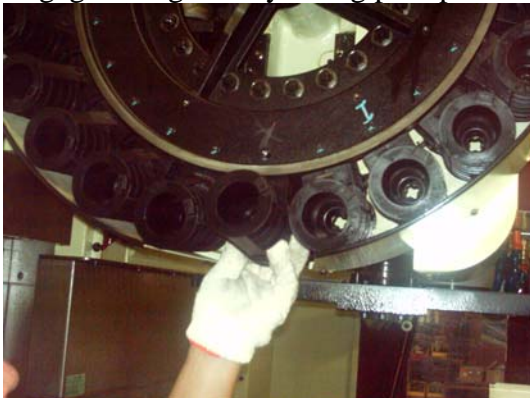
Fixing bolt  
screw hole  
parallel to  
knob

Longer  
side of  
knob  
facing  
down



Shorter side of knob  
flush to holder

6. Engage fixing bolt by tilting pot up.



7. Lock the M6 screw on new pot.

8. Push the plate to original position and lock it. Check the fixed clearance of the plate (there cannot have any clearance).



9. Check the correct angled 90 degree with the replaced pot.

