


## Head Bolt Replacement

<p>1. Remove head bolt from ram and head assembly. Remove the set screw in the bolt first if possible. Using a 2 ¼" socket and impact wrench or breaker bar, remove the bolt. This will probably require heating the bolt threads with a torch from below the head.</p>	
<p>2. Clean the area and wipe out the inside with a rag soaked in penetrating oil. Clean the threads as well, make sure there is no debris in threaded area.</p>	
<p>3. Install the new bolt. <b>BE SURE IT IS NOT CROSS THREADED!</b> Run the bolt in until the head starts to have some friction on the plates as it pivots on the ram assembly.</p>	
<p>4. Drill a 3/16" pocket in the head plate through the hole in the top of the bolt head. Install the set screw with loc-tite, or equivalent, medium strength thread locking fluid.</p>	