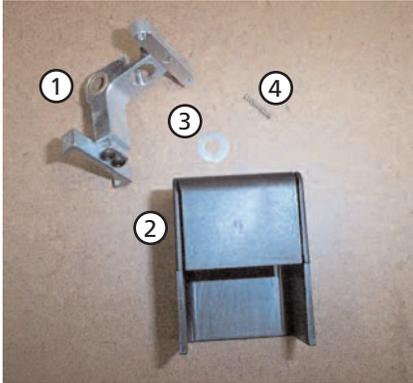


● 50-100 SOLENOID REPAIR KIT & PROCEDURE



▲
Figure 1

This procedure is specific to repairing the 50-100 "Black Solenoid" out in the field. Need for service is indicated when the solenoid fires strong then soft, and/or the actuating arm sticks and will not move freely.

PARTS INCLUDED IN KIT (Kit #50-110):

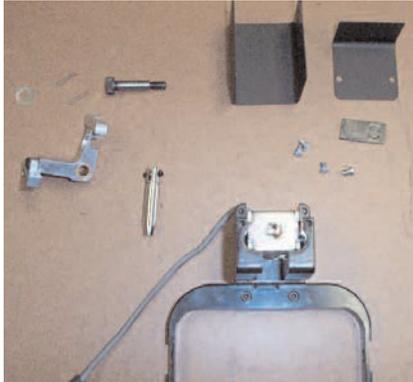
Actuator arm assembly (1), 50-109 plastic cover (2), 1 spacer (3), 2 return springs (4) — (see Figure 1)

TOOLS REQUIRED:

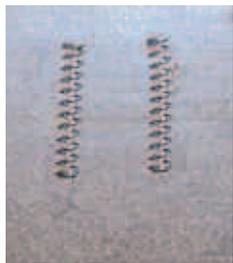
3mm Allen wrench, small screwdriver set, either a small fine file or fine grit grinding stone, clear silicone sealant

PROCEDURE:

1. Remove the solenoid from the lathe.
2. Remove the 4 screws that hold on the two-piece metal cover.
3. Remove the foam pad located on top of the plunger.
4. Remove the plunger.
5. Locate the 3mm Allen screw at the pivot point of the actuator. At the same time hold the actuator arm in place and remove the 3mm screw (see Figure 2). Be careful not to let the springs fall out. With the 3mm Allen screw removed, carefully remove the actuator arm. There will be one or two thin spacers that will come out with the arm; set them aside.



▲
Figure 2

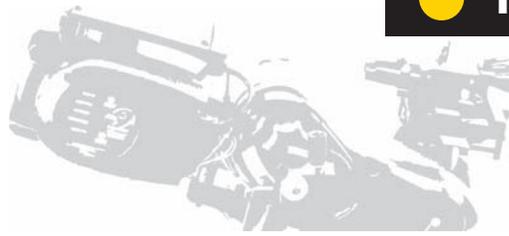


▲
Figure 3

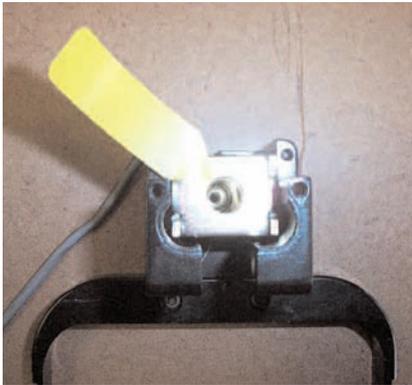


▲
Figure 4

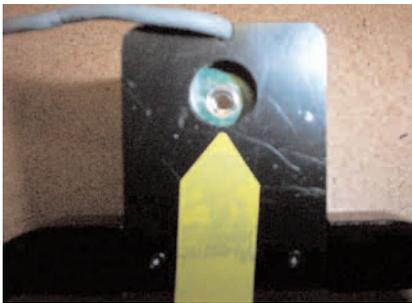
Continued on page 2



● 50-100 SOLENOID REPAIR KIT & PROCEDURE



▲
Figure 5



▲
Figure 6

6. Remove the two return springs. **DO NOT LOSE THESE SPRINGS!** Set them aside in a safe place (see Figure 3).
7. Locate the area where the actuator arm rests and inspect for debris buildup and/or rough surface that would hinder the arm from moving smoothly. Use a needle file or fine grit stone to smooth out this area. Be sure to clean out any loose debris (see Figure 4).
8. Inspect and clean out the coil cylinder (see Figure 5).

ASSEMBLY:

1. Put a small dab of silicone sealant on the end of the return springs and install them in their proper place. The silicone sealant will help hold the springs in place so they will not fall out and get lost. Extra springs are provided in the rebuild kit in case any are lost.
2. Set the replacement actuating arm in place; the springs should seat in the small indentations in the arm. Hold in place and slide the new spacer in position so that when the screw is inserted it will go through the spacer then the actuator arm. Tighten the 3mm so it is firmly in place. Actuate the arm assembly to be sure that it moves smoothly.
3. Insert the plunger and again actuate the arm to ensure free movement. If the actuating arm sticks, refer to the **Solenoid Coil Alignment Procedure**, (Technical Service Bulletin #22).
4. Install the new one piece plastic cover. **Remember to discard the foam tape** — it is not used in conjunction with the new cover.
5. If the bottom of the solenoid has a hole drilled through it exposing the coil cylinder, fill it in with silicone sealant and let it dry (see Figure 6).
6. Test the Solenoid to ensure proper function in the compensation mode.

Contact the Pro-Cut Service Department with any questions: 800-543-6618.