OPERATION:
To provide proper clearance for inserting and removing the work-
piece, follow these instructions:
1. Loosen nut(s) (18) and screw(s) (19) at the back of the clamping
plate (2); raise clamping plate; and place the workpiece in the V-block.
2. Place set gage (24) between workpiece and adapter liner --
(28) or (29).
3. Lower the clamping plate until the removable adapter liner (28) or
(29) touches the set gage (24).
4. Secure the set screw(s) (19) and nut(s) (18) at the back of the
clamping plate and remove set gage.
5. Attach the stop to the desired side and adjust to proper position.
Insert your drill bushing and adjust bushing clamp (17) with screw
(17A) to keep bushing from turning. The drill jig is then ready for
operation.

MAINTENANCE:
If jig becomes inoperable, disassemble as follows:
HAND OPERATED UNITS:
1. Loosen nut(s) (18) and screw(s) (19) and remove clamping plate (2)
with guide pin (15) from the jig body (1).
2. Compress locking pin (16) fully into the body casting (1) with a vise.
3. Turn lock nut (9) onto the plunger (13) as far as it will go. Then crank
(22) may be removed.
4. Remove plunger (13) and plunger cap (14). Locking pin (16) may
then be removed with spring (5) and spring slug (4).
Re-assemble as per the exploded view. After insertion of the spring
slug (4), and spring (5), insert locking pin (16) with flat facing back of
body casting (1).
Compress locking pin (16) fully in vise. Insert plunger (13) with nut (9),
plunger cap (14) and insert crank (22).
When assembled, lock nut (9) must have sufficient tension against
plunger cap (14) so that the crank (22) has no free movement.

AIR OPERATED UNITS:
1. Loosen nut(s) (18) and screw(s) (19) and remove clamping plate (2)
with guide pin (15) from the jig body (1).
2. Compress locking pin (16) fully into the body casting (1) with a vise.
3. Turn lock nut (9) onto the plunger (13) as far as it will go.
4. Remove six screws (35) from cylinder cover (33) and remove cover,
diaphragm (32), piston assembly (30), spring (37), and plunger (13)
and nut (9). Locking pin (16) may then be removed with spring (5) and
spring slug (4).
Reassemble as per exploded view. After insertion of spring slug (4)
and spring (5), insert locking pin (16) with flat facing back of body
casting (1). Compress locking pin (16) fully in a vise. Insert
(Cont. on next page)
Note 1.

AIR CYLINDER PARTS

**305 and AR-305**  
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**605 and AR-605**  

**905 and AR-905**

**Note 2.**

(Cont. from prev. page) plunger (13) with nut (9), spring (37), piston assembly (30), diaphragm (32), cylinder cover (33), and evenly and firmly tighten six screws (35). Lock nut (9) should be turned so that it lightly engages the piston rod (30).

**Note 1.** Price not shown, as replacement body castings are not available.

**Note 2.** Clamping plates are not interchangeable. If replacement is desired, the entire unit should be returned to the factory, freight charges prepaid, so that the new clamping plate can be properly fitted to your unit.

**WHEN ORDERING PARTS, INDICATE PART NUMBER, MODEL NUMBER AND PRICE.**

When jig is disassembled, check each part for wear or damage. Replacement parts are available for immediate shipment from factory stock, or you may order through your local Heinrich distributor.

(Cont. from prev. page)