Turret Reinforcement Kit
12-862009-000

Packaging

1 ea. 12-862009-000 Moving Turret Reinforcement Kit
    2 ea.   11-002066-001 Hex Head Screw 5/16-18 x 1-1/2"
    2 ea.   11-170009-001 Self Locking Nut 5/16-18
    1 ea.   11-170010-001 Self Locking Nut 5/16-24
    4 ea.   11-190012-001 Washer 5/16
    1 ea.   12-150003-000 Turret Frame Support
    1 ea.   12-150006-000 Carriage Bolt 3/8-16 x 4"
    2 ea.   12-150014-000 Spacer .750 x .313 x .275
    2 ea.   12-150015-000 Coupling Nut 3/8-16 x 1-1/8"
    1 ea.   12-150016-000 Carriage Bolt 3/8-16 x 3-1/2"
    1 ea.   12-900017-000 Instruction Sheet

Tools Required

- 5/8" wrench or socket
- 5/16" wrench
- Drill gun with 5/16" drill bit
- C-clamp
- 1/2" wrench
- 9/16" wrench
- 3/16" Allen wrench
- Bar clamp or large nylon tie

Installation Procedure

1. Remove power to pinsetter.

⚠ *WARNING! Remove power to the pinsetter by turning off the circuit breaker and unplugging the main power cord to the electrical box.*

2. With an empty turret, manually cycle the pinsetter to 280 degrees.

3. Using a 3/16" Allen wrench, remove the turret bottom protector (P/N 12-150187-000).

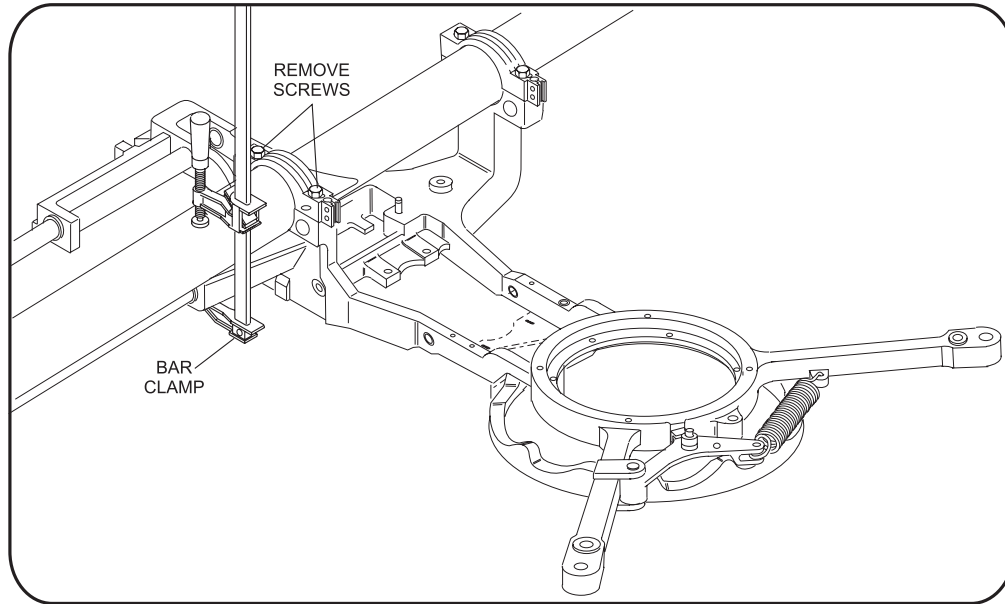4. Using a bar clamp or large nylon tie, clamp the turret frame to the main cross shaft. Refer to *Figure 1*.

REMOVE
SCREWS

BAR
CLAMP

Figure 1

5. For pinsetters series below #12844, remove internal wrenching nut (P/N 12-150191-000). Replace with provided 5/16-24 self locking nut (P/N 11-170010-001). Pinsetter series #12844 and above requires no change; 5/16-24 self locking nut should already be installed.

6. Remove 3/8-16 x 4" hex head screw (P/N 11-005360-001) and 3/8-16 x 3" hex head screw (P/N 11-005356-001) that secure the turret frame and cap to the pinsetter frame.

7. Install turret frame support plate (P/N 12-150003-000). Secure with provided 3/16-16 x 4" carriage bolt (P/N 12-150006-000), 3/16-16 x 3-1/2" carriage bolt (P/N 12-150016-000) and 3/8-16 x 1-1/8" coupling nuts (P/N 12-150015-000). The head of the bolts should be secured with flat edge against the support plate. Refer to *Figure 2*.
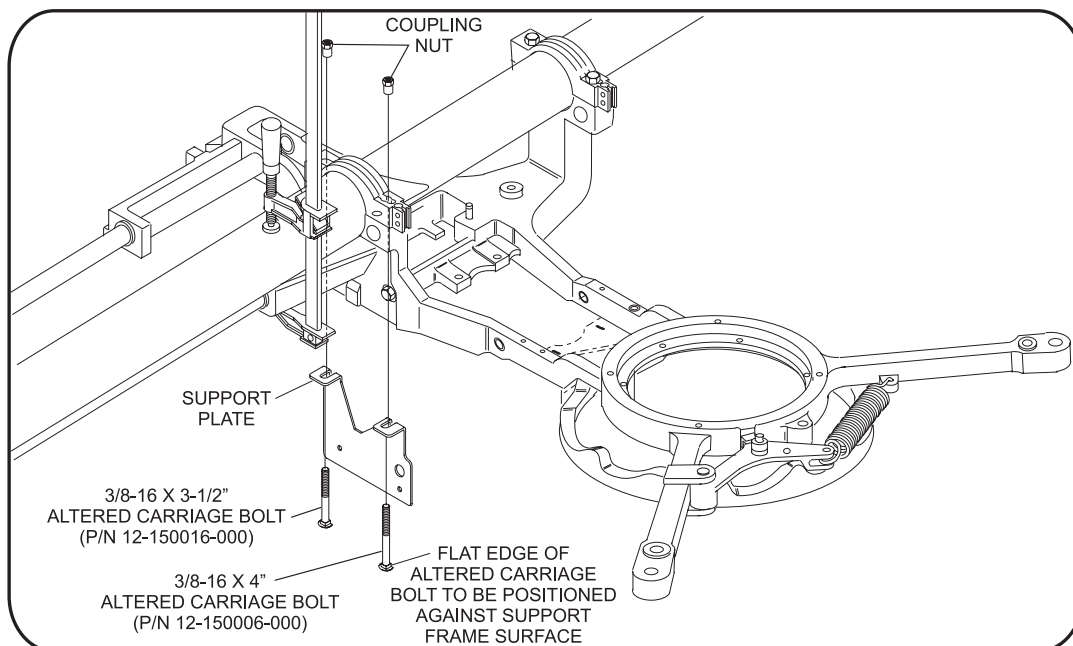

COUPLING
NUT

SUPPORT
PLATE

3/8-16 X 3-1/2"
ALTERED CARRIAGE BOLT
(P/N 12-150016-000)

3/8-16 X 4"
ALTERED CARRIAGE BOLT
(P/N 12-150006-000)

FLAT EDGE OF
ALTERED CARRIAGE
BOLT TO BE POSITIONED
AGAINST SUPPORT
FRAME SURFACE

Figure 2

8. Using c-clamp, secure the bottom of the support plate in position. Refer to *Figure 3*.

C-CLAMP

USE SUPPORT PLATE
AS TEMPLATE TO DRILL
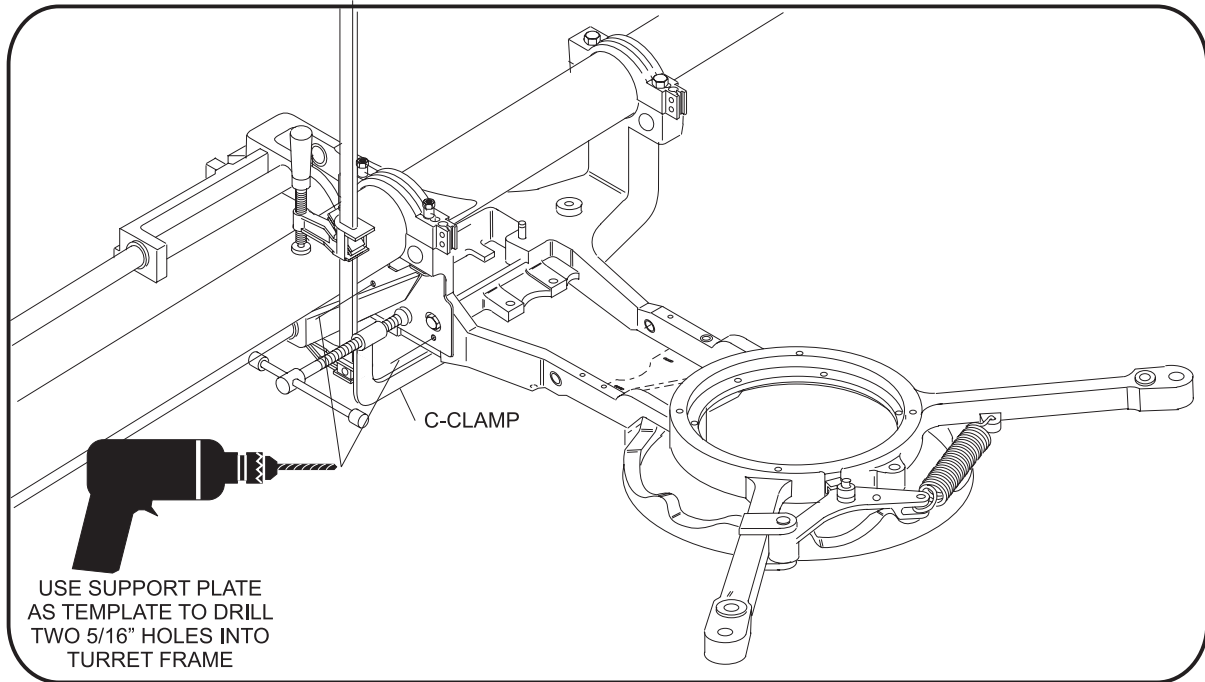TWO 5/16" HOLES INTO
TURRET FRAME

Figure 3

9. Using the new support plate as a template, carefully drill two 5/16" holes into the turret frame. Be sure to keep the drill, level and straight. Refer to *Figure 3*.

i   *NOTE: Different turret frame castings may affect how the support plate fits. Secure the plate as tight as possible to the frame to guarantee a straight and level drill line.*

10. Once holes are drilled, place an aluminum spacer (P/N 12-150014-000) between the turret frame and support plate. Thread the 5/16-18 hex head screw (P/N 11-002066-001) through the plate, spacer and washer. Secure the screw with another 5/16 washer and 5/16-18 self locking nut (P/N 11-170009-001). Refer to *Figure 4*.
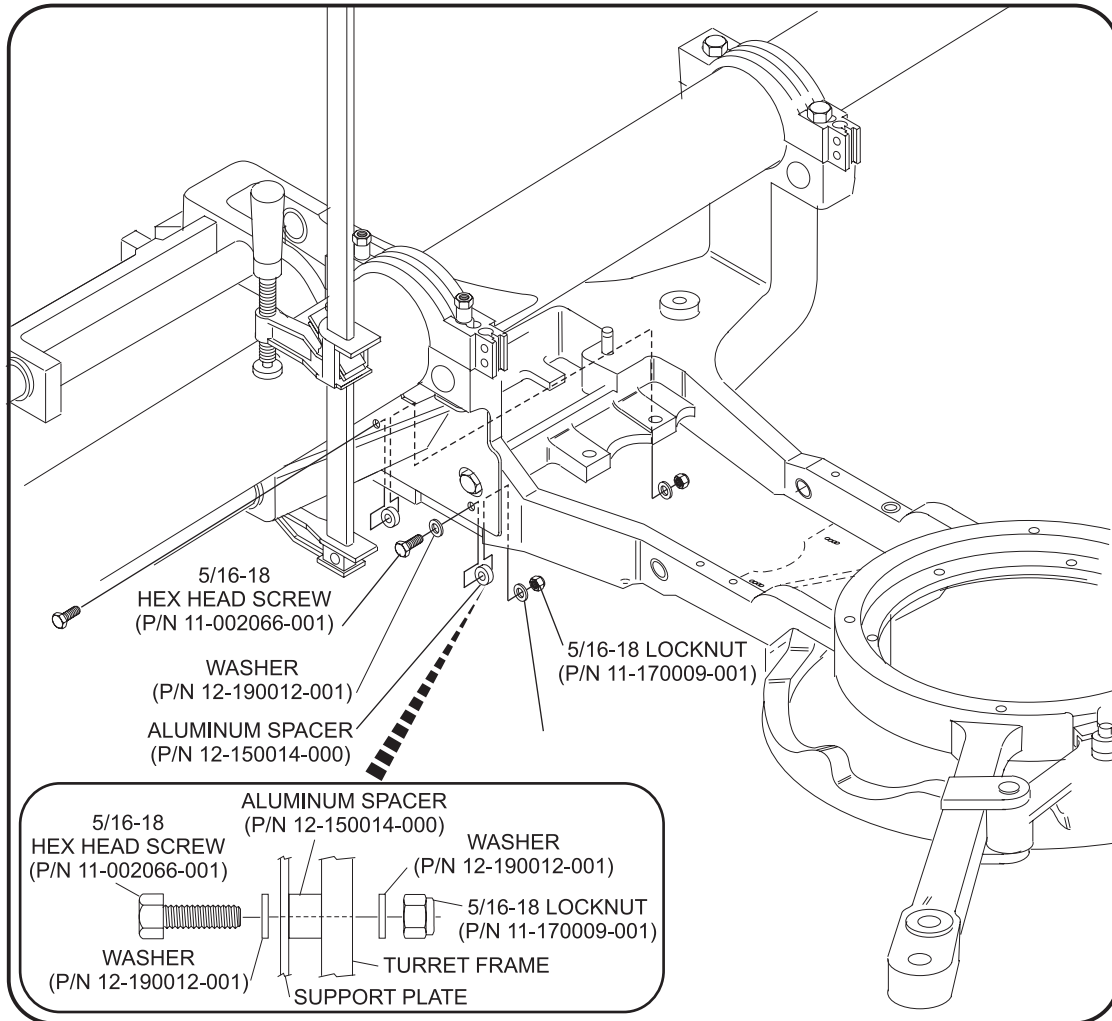

5/16-18
HEX HEAD SCREW
(P/N 11-002066-001)

WASHER
(P/N 12-190012-001)

ALUMINUM SPACER
(P/N 12-150014-000)

5/16-18 LOCKNUT
(P/N 11-170009-001)

ALUMINUM SPACER
(P/N 12-150014-000)

5/16-18
HEX HEAD SCREW
(P/N 11-002066-001)

WASHER
(P/N 12-190012-001)

5/16-18 LOCKNUT
(P/N 11-170009-001)

WASHER
(P/N 12-190012-001)

TURRET FRAME

SUPPORT PLATE

Figure 4

11. Verify all the hardware is secure, remove the all clamps and replace the turret bottom protector.

12. The Turret Reinforcement Kit is now installed. Restore power to the pinsetter.