Improper use of this tool can result in serious bodily injury! This manual contains important information about product function and safety. Please read and understand this manual BEFORE operating the tool. Please keep this manual available for other users and owners before they use the tool. This manual should be stored in a safe place.
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Limited Warranty

Flexco warrants to the original purchaser that this product is free from defects in material and workmanship, and agrees to repair or replace, at Flexco’s option, any defective product within 1 year from the date of purchase. This warranty is not transferable. It only covers damage resulting from defects in material or workmanship, and it does not cover conditions or malfunctions resulting from normal wear, neglect, abuse, accident or repairs attempted or made by other than our regional repair center or authorized warranty service center. Drive rod and O-rings are considered normally wearing parts.

To obtain warranty service, return the product at your expense together with proof of purchase to Flexco or a Flexco authorized distributor.
# System Components

## Hydraulic Multi-Rivet Driving System

<table>
<thead>
<tr>
<th>Hydraulic Multi-Rivet Driver</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Top handle</td>
<td>5. 5-prong driver head assembly (includes sleeve, spring, shoulder bolts, and 5-prong driver)</td>
</tr>
<tr>
<td>2. Trigger handle</td>
<td>6. High pressure in: 3/8” Female coupling</td>
</tr>
<tr>
<td>3. Side handle</td>
<td>7. Low pressure return: 1/2” Male coupling</td>
</tr>
<tr>
<td>4. 5-prong driver</td>
<td></td>
</tr>
</tbody>
</table>
System Components

<table>
<thead>
<tr>
<th>MSRT Applicator Tool for Hydraulic Rivet Driving</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Applicator tool base</td>
</tr>
<tr>
<td>2. Stepped anvil – end plate</td>
</tr>
<tr>
<td>3. Stepped anvil – middle plate</td>
</tr>
<tr>
<td>4. Steel guide block</td>
</tr>
<tr>
<td>5. Guide block locator</td>
</tr>
<tr>
<td>6. Clamp bar</td>
</tr>
</tbody>
</table>
Hydraulic Multi-Rivet Driving System

System Components

**Flexco® SR™ Rivet Hinged Fastening System**
1. Fastener Strips
2. Hinge Pin
3. Collated Rivets with Washers

**Protective Equipment**
1. Safety Glasses
2. Gloves
3. Hearing Protection

**Power Source**
Immediate Need Power Pack
– For mobility throughout the mine

OR

Power Take-off Unit (PTO)
– For diverting hydraulic power from your conveyor at the mine
Hydraulic Multi-Rivet Driving System

Introduction

Role of Rivet Driver

The Hydraulic Multi Rivet Driver is designed to be used with Flexco® SR™ Rivet Hinged Fasteners as well as Flexco® BR™ Rivet Solid Plate Fastener. This tool also requires the use of steel guide blocks, the 5 rivet pattern: item code: 42167. In addition, the use of Rapid Loader™ rivets with washers is required.

Precision Built

FLEXCO tools are precision-built tools designed for precise, high volume rivet driving. These tools will deliver efficient, dependable service when used correctly and with care. As with any fine power tool, for best performance, the manufacturer’s instructions must be followed. Please study this manual before operating the tool and understand the safety warnings and cautions. The instructions on installation, operation, and maintenance should be read carefully, and the manual kept for reference.

Installation of Side Handle

1. Place and adjust proper handle orientations: left or right handed
2. Tighten the bolt with washer using M6 hex key
3. Make sure the side handle has been installed firmly

Hydraulic Tool Specifications

<table>
<thead>
<tr>
<th>Specification</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Overall weight</td>
<td>11.8 kg, 26 lb</td>
</tr>
<tr>
<td>Overall dimensions</td>
<td>533 mm x 152 mm, (21”x 6”)</td>
</tr>
<tr>
<td>Working pressure</td>
<td>110 bar, 11 Mpa, 1600 psi</td>
</tr>
<tr>
<td>Max. pressure</td>
<td>124 bar, 12.4 Mpa, 1800 psi</td>
</tr>
<tr>
<td>Oil flow</td>
<td>15-25 L/m, 4-6.6 GPM</td>
</tr>
<tr>
<td>Impact rate</td>
<td>1300-1500 BPM</td>
</tr>
<tr>
<td>Coupling</td>
<td>ISO 16028 complaint couplings, flat face quick release coupling</td>
</tr>
<tr>
<td></td>
<td>High pressure in: Female ¼” body size</td>
</tr>
<tr>
<td></td>
<td>Low pressure return: Male ½” body size</td>
</tr>
<tr>
<td>Max. hose length</td>
<td>10 meters, 30 feet</td>
</tr>
<tr>
<td></td>
<td>High pressure hose (smaller hose OD), each end has factory installed male and female 3/8” body size couplings</td>
</tr>
<tr>
<td></td>
<td>Low pressure return hose (larger hose OD), each end has factory installed male and female ½” body size couplings</td>
</tr>
<tr>
<td>Side handle</td>
<td>Optional</td>
</tr>
<tr>
<td>Noise level</td>
<td>115 dB</td>
</tr>
</tbody>
</table>
General Safety Rules – Save These Instructions

Signal words

"DANGER" indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury. The signal word is limited to the most extreme situations.

"WARNING" indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

"CAUTION" indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury. It may also be used to alert against unsafe practices.

International Safety Symbol

⚠️

This international safety symbol is used to identify and call attention to specific safety matters.

Safety Information

To Avoid Severe Personal Injury or Property Damage, read carefully and understand the following Safety Precautions.

1. WORK AREA SAFETY

⚠️ DANGER

Do not allow bystander, visitor, or children in work area during tool operation.

⚠️ WARNING

Store tools outside the reach of children and untrained persons. Tools are dangerous in the hands of unskilled users.

⚠️ CAUTION

Keep work area clean and well lit. Clutter and dark areas invite accidents.

2. PERSONAL PROTECTIVE EQUIPMENT

⚠️ WARNING

EYE PROTECTION which conforms to ANSI specifications and provides protection against flying particles both from the FRONT and SIDE should ALWAYS be worn by the operator and others in the work area. Eye protection is required to guard against flying debris, which could cause severe eye injury.

The employer and/or user must ensure that proper eye protection is worn. Eye protection equipment must conform to the requirements of the American National Standards Institute, ANSI Z87.1 and provide both frontal and side protection. NOTE: Non-side shielded spectacles and face shields alone do not provide adequate protection.

⚠️ CAUTION

HEARING PROTECTION will be required in some environments. For example, the working area may include exposure to noise level which can lead to hearing damage. The employer and user must ensure that any necessary hearing protection is provided and used by the operator and others in the work area.
Hydraulic Multi-Rivet Driving System

General Safety Rules

⚠️ CAUTION

HEAD PROTECTION – Some environments will require the use of head protection equipment. When required, the employer and user must ensure that head protection conforming to ANSI Z89.1 is issued.

FOOT PROTECTION – Safety footwear should always be worn. Operators must be protected against falling tools, stepping on nails and rivets, and slippery conditions.

HAND PROTECTION – Safety gloves should always be worn against hot surfaces and other sharp objects.

3. PERSONAL SAFETY

⚠️ WARNING

Hydraulic powered tools can vibrate in use. Vibration, repetitive motions or uncomfortable positions may be harmful to your hands and arms. Stop using any tool if discomfort, tingling feeling or pain occurs. Seek medical advice before resuming use.

Do not overreach. Keep proper footing and balance at all times to enable better control of the tool in unexpected situations.

Never alter or remove safety devices.

Do not use in explosive environments as this may result in serious personal injury.

Always handle the tool with care: 1.) Never engage in horseplay; 2.) Never pull the trigger unless 5 prong driver has been inserted into guide block, which is located in the MSRT steel tool; 3.) Keep others a safe distance from the tool while tool is in operation as accidental actuation may occur, possibly causing injury.

4.) Never place a hand or any part of body in discharge area of tool; 5.) Never point tool at anyone; 6.) Do not pull the trigger or depress the contact tripper as accidental actuation may occur, possibly causing injury.

Use this tool and 5 Prong Driver only for Flexco Multi Rivet: 1.) Make sure the 5 prong driver is well-maintained, not worn out and of the proper size; 2.) A worn 5 prong driver will also cause increased working time.

Do not operate the equipment if you are: 1.) Taking medication, feeling drowsy, feeling unwell or feeling tired; 2.) Under the influence of drugs or alcohol; 3.) Experiencing pain in hands, feet, lower back, or other parts of your body hurt or are injured. Failure to observe this precaution can result serious injury or even death.

Do not touch the machine with your bare hands: 1.) The oil tank may become hot under continuous running; 2.) Tools may become hot under continuous use, make sure to wear safety gloves before any contact with the tools. Failure to observe this precaution can result in burn injuries.

When lending someone the equipment, make sure the safety instructions have been thoroughly read and fully understood by the person who is going to use the equipment.

4. HYDRAULIC SAFETY

⚠️ DANGER

This hydraulic tool is only designed to be used to install certain Flexco rivet fasteners. DO NOT operate this hydraulic tool when: 1.) Part of the tool or whole tool has been drenched in water or seawater; 2.) The power source exceeds the oil flow and pressure range prescribed; 3.) Operating with oil temperature below 10°C or over 100°C; 4.) The driver is different from prescribed.
General Safety Rules

**DANGER**

Avoid Blank Hammering/Avoid Dry Firing:
1) Operating the equipment horizontally may cause the driver to suddenly fly out; 2) Excessive blank hammering is considered equipment abuse and may cause equipment damage. Failure to observe precautions can result in personal injury and tool damage.

Never clamp or tape the trigger or contact trip in an actuated position.

Do not operate rivet driver unless it is engaged inside of steel guide block.

**WARNING**

At the beginning of each shift, conduct a TOOL OPERATION CHECK: 1) Remove all fasteners from tool before performing tool operation check; 2) Do not use if there is any oil leakage from hoses or tool itself; 3) Do not use if there are any cracks or damage to the tool; 4) Do not use if the safety controls are not functional.

Be especially cautious around high pressure gas: 1) High pressure gas is held inside the accumulator of the hydraulic tool; 2) Do not loosen the accumulator cap nut unless it is necessary for maintenance. Failure to observe this precaution can result serious injury.

A whipping hydraulic hose can cause severe injuries: 1) De-pressure the hydraulic system before loosening the connection of a hydraulic hose; 2) Tighten the nuts on the connections of the hydraulic hoses to the required torque; 3) Check that the hydraulic hose and the connections are not damaged.

Spilled hydraulic oil can cause burns, accidents due to slippery conditions, and will also harm the environment: 1) Take care of all spilled oil and handle it according to your safety and environmental regulations; 2) Never dismount the hydraulic machine when the hydraulic oil is hot; 3) Avoid getting hydraulic oil on your hands; 4) Always use protective gloves when working with hydraulic oil; 5) Wash hands after contact with hydraulic oil.

When using the machine to perform work-related activities, you may experience discomfort in the hands, arms, shoulders, neck, or other parts of the body: 1) Adopt a comfortable posture while maintaining secure footing and avoid awkward off-balanced postures; 2) Changing posture during extended tasks may help avoid discomfort and fatigue; 3) In case of persistent or recurring symptoms, consult a qualified health professional.

Do not drive rivets on top of other rivets.

Always use tool with steel guide blocks.

Never use this tool in a manner that could cause a fastener to be directed toward the user or others in the work area.

Do not store tools in a cold weather environment to prevent frost or ice formation on the tool’s operating valves and mechanisms that could cause tool failure.

Do not use the tool as a hammer.

Never leave a tool unattended with the hoses attached.

**CAUTION**

Always carry the tool by a handle.

Do not alter or modify this tool from the original design or function without approval from FLEXCO.

Always be aware that misuse and improper handling of this tool can cause injury to yourself and others.
Hydraulic Multi-Rivet Driving System

General Safety Rules

5. MAINTENANCE SAFETY

⚠️ DANGER
Always disconnect hydraulic hoses at tool and electricity supply at power pack when servicing the tool or before making adjustments.

⚠️ CAUTION
REPLACEMENT PARTS:
FLEXCO replacement parts are recommended.
Do not use modified parts or parts which will not give equivalent performance to the original equipment.
Hydraulic Multi-Rivet Driving System

Operational Instructions

Guidelines

1. When using hydraulic power units not manufactured by Flexco, make sure the operating pressure of the power unit is in the range of 1300-1840 psi and oil flow is in the range 4-6 gpm.

2. When connecting and disconnecting couplings, make sure dirt, dust, and other foreign substances do not enter or attach to coupling and hoses.

3. Make sure the power unit is OFF when connecting the hydraulic tool to the power unit.

4. If the oil temperature is below 10°C, warm up the hydraulic tool before operating.

5. Do not trip over the hydraulic hoses.

6. Make sure there are no jobsite obstacles.

7. Failure to store the hydraulic tool horizontally after operating can cause injury by sudden falling of the tool.

8. Be cautious not to injure your back while lifting the hydraulic tool.

9. In case of sudden hydraulic hose breakage STOP the power unit IMMEDIATELY.

10. Replace with new hoses when they are worn or when oil exudes from them.

11. When couplers detach, a small amount of oil may slip out. Make sure that surrounding area does not get drenched in oil.

12. To prevent dirt from entering the quick release couplings, and possibly damaging the driver or power pack unit, be sure to clip couplings together after disconnecting driver.

13. When detached from power source, attach two hoses to each other.

14. When frequently attached and detached to the power unit, hydraulic oil will decrease accordingly. Always check the hydraulic oil level before operating and refill if necessary.

15. STOP the power unit IMMEDIATELY if the hydraulic tool does not stop after releasing the trigger lever.
Hydraulic Multi-Rivet Driving System

Set-Up Procedure

1. Hook up the hydraulic hoses.
   a. First attach low pressure hose coupling (larger coupling body size), then the high pressure coupling at tool.

2. Connect hydraulic power pack to power source 380VAC/660 VAC, 3 phases, 50Hz.
   **WARNING:** Make sure the power source is not energized and follow proper Lock Out Tag Out procedures.

3. Turn on the power source.

4. Inspect gauges when tool is in idle mode. The pressure gauge should read 500-700 PSI. If the pressure gauge shows no pressure, turn off the power source immediately. Examine the power source connect with correct wiring.
Fastener Installation

NOTE: The following instructions are for SR” installation. For steps specific to BR” installation, please follow instructions included with BR fastener strips.

1. Square belt using centerline method. Cut belt at least 4” (100 mm) behind old splice using Flexco 900 Cutter or Electric Belt Cutter. We also recommend skiving the belt with an FSK2 Skiver.

2. Measure belt thickness from cut edge using gauge or tape measure. Measure belt thickness after skiving. Use the rivet selection guide to the right to select the correct size SR/BR rivets with washers for your belt thickness.

3. Insert belt end into fastener strip; center belt in strip. Look through viewports; belt ends should be tight against belt stops. Tighten clamp bar to secure belt.

4. Set all fastener top plates hitting one fastener at a time on the front scalloped edge portion of fastener. Repeat to ensure fasteners are set firmly against top of belt.

5. Use the steel guide blocks designed for use with this tool.

6. Load guide blocks with Rapid Loader™ Collated Rivets with washers. WARNING: Without washers, misfires will occur. If a shorter strip is needed, break off extra rivets by bending strip at checkpoint.

---

**RIVET SELECTION CHART**

<table>
<thead>
<tr>
<th>FASTENER SIZE</th>
<th>BELT THICKNESS RANGE</th>
<th>RIVET SIZE</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>SR” RIVET HINGED</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>R5</td>
<td>7/32-5/16</td>
<td>6-8</td>
</tr>
<tr>
<td></td>
<td>9/32-3/8</td>
<td>7-10</td>
</tr>
<tr>
<td></td>
<td>11/32-7/16</td>
<td>9-11</td>
</tr>
<tr>
<td></td>
<td>13/32-7/16</td>
<td>10.5-11</td>
</tr>
<tr>
<td>R5-1/2 &amp; R6LP</td>
<td>5/16-11/32</td>
<td>8-9</td>
</tr>
<tr>
<td></td>
<td>5/16-13/32</td>
<td>8-10.5</td>
</tr>
<tr>
<td></td>
<td>3/8-15/32</td>
<td>10-12</td>
</tr>
<tr>
<td></td>
<td>7/16-17/32</td>
<td>11-13.5</td>
</tr>
<tr>
<td></td>
<td>1/2-19/32</td>
<td>13-15</td>
</tr>
<tr>
<td></td>
<td>9/16-21/32</td>
<td>14-16.5</td>
</tr>
<tr>
<td></td>
<td>5/8-23/32</td>
<td>16-18</td>
</tr>
<tr>
<td>R6</td>
<td>13/32-7/16</td>
<td>9-11</td>
</tr>
<tr>
<td></td>
<td>13/32-1/2</td>
<td>10.5-13</td>
</tr>
<tr>
<td></td>
<td>15/32-9/16</td>
<td>12-14</td>
</tr>
<tr>
<td></td>
<td>17/32-5/8</td>
<td>13.5-16</td>
</tr>
<tr>
<td></td>
<td>19/32-11/16</td>
<td>15-17</td>
</tr>
<tr>
<td>R8</td>
<td>13/32-7/16</td>
<td>10.5-11</td>
</tr>
<tr>
<td></td>
<td>13/32-1/2</td>
<td>10.5-13</td>
</tr>
<tr>
<td></td>
<td>15/32-9/16</td>
<td>12-14</td>
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<td></td>
<td>17/32-5/8</td>
<td>13.5-16</td>
</tr>
<tr>
<td></td>
<td>19/32-11/16</td>
<td>15-17</td>
</tr>
<tr>
<td>R9</td>
<td>19/32-11/16</td>
<td>16-17</td>
</tr>
<tr>
<td></td>
<td>21/32-3/4</td>
<td>16.5-19</td>
</tr>
<tr>
<td></td>
<td>23/32-13/16</td>
<td>18-21</td>
</tr>
<tr>
<td></td>
<td>25/32-7/8</td>
<td>20-22</td>
</tr>
<tr>
<td></td>
<td>27/32-15/16</td>
<td>21-24</td>
</tr>
</tbody>
</table>

**BR” RIVET SOLID PLATE**

| BR10 | 7/32-5/16 | 6-8 | SRA |
|      | 9/32-3/8 | 7.95 | SRB |
|      | 11/32-7/16 | 9-11 | SRC |
|      | 13/32-1/2 | 10-13 | SRC/D |
|      | 15/32-9/16 | 12-14 | SRD |
|      | 17/32-5/8 | 13.5-16 | SRE |
|      | 19/32-11/16 | 15-17 | SRF |

* Applies to RAR6LP only.
** Use with 3/4” diameter hinge pin.
7. Using a hammer, hit the Rapid Loader™ Collated Rivets to release all rivets from plastic. Remove plastic from guide block and discard.

8. Turn ON the power pack.

9. Locate and orient the 5 prong driver pattern to steel guide block.

10. Insert the driver nose directly into the counter bore of the guide block. Press the tool firmly and completely into the guide block. Pull the trigger to drive the rivet for about 5 seconds.

11. ① Drive one full block on both ends of fastener strip. ② Drive one full block in the center of the fastener strip. ③ On both sides, split the difference between the middle and end and drive one full block. ④ Drive remaining rivets. If rivet is not fully driven into fastener, drive the rivet for additional 2-3 seconds. If fastener plate is distorted, reduce trigger time until rivet is properly driven into fastener.

12. Remove guide block(s) and make sure rivets are completely set. Hammer any loose rivets into fasteners to properly set rivets.

13. Repeat steps 1-11 on other belt end. Bring belt ends together and insert hinge pin. Notch trailing edge of belt only. Splice is complete.
Hydraulic Multi-Rivet Driving System

Maintenance Instructions

Replacement Parts:
FLEXCO replacement parts are recommended. Do not use modified parts or parts which will not give equivalent performance to the original equipment.

Operating Pressure:
90-110bar, 9-11Mpa, or 1300-1600psi
Select the operating pressure within this range for best fastener performance. DO NOT EXCEED THIS RECOMMENDED OPERATING PRESSURE. Do not exceed recommended maximum operating pressure as tool wear will be greatly increased. Refer to “HYDRAULIC TOOL SPECIFICATIONS” on page 6 for setting the correct operating pressure for the tool.

Filter:
Dirt or other foreign objects in the closed hydraulic circuit are major causes of wear in hydraulic tools. A filter will help to get the best performance and minimum wear from the tool. The filter must have adequate flow capacity for the specific installation. The filter has to be kept clean to be effective in providing clean hydraulic oil to the tool. Consult the manufacturer’s instructions on proper maintenance of your filter. A dirty and clogged filter will cause a pressure drop which will reduce the tool’s performance.

Periodic Maintenance:

<table>
<thead>
<tr>
<th>Maintenance items</th>
<th>Operating hours</th>
</tr>
</thead>
<tbody>
<tr>
<td>Nitrogen gas recharge in accumulator</td>
<td>300 hours or every year</td>
</tr>
<tr>
<td>Replace accumulator diaphragm</td>
<td>500 hours or every two years</td>
</tr>
<tr>
<td>Replace valve rod O-ring</td>
<td>500 hours or every two years</td>
</tr>
<tr>
<td>Replace U-cup packing</td>
<td>500 hours or every two years</td>
</tr>
<tr>
<td>Replace all O-ring</td>
<td>Every 3 years</td>
</tr>
</tbody>
</table>

NOTE: All maintenance items to be completed by dealer.
## Trouble Shooting

<table>
<thead>
<tr>
<th>Problem</th>
<th>Cause</th>
<th>Correction</th>
</tr>
</thead>
</table>
| Grip the trigger lever but does not start | 1. Power unit is in off position  
2. Hoses are not connected  
3. Couplings are not connected properly  
4. Relief valve pressure set too low  
5. High pressure side and oil return side was connected inversely  
6. Incorrect power connection to motor | 1. Turn on power unit  
2. Connect hoses  
3. Check if couplings have been connected properly  
4. Adjust pressure to 1300-1840psi  
5. High pressure hose connects to the top hose of the hydraulic tool  
6. Check proper motor cable connection, voltage and phases |
| Functioning but weak hammering or low speed | 1. Low oil flow rate from power unit  
2. Relief valve pressure set too low  
3. Back pressure is too high | 1. Check electric motor cable connection, voltage and phases  
2. Adjust pressure to 1300-1840psi  
3. Use bigger diameter hose for return hose |
| Hammering in normal speed, but weak hammering | 1. Low accumulator gas pressure  
2. Damage of accumulator diaphragm | 1. Refill Nitrogen gas (565.5psi) by dealer  
2. Replace diaphragm by dealer |
| Strong hammering and in high speed | 1. High oil flow rate from power unit | 1. Check electric motor cable connection, voltage and phases |
| Hydraulic tool stops activating during operation | 1. Couplings are not connected  
2. Trigger handle damage | 1. Check coupling connection  
2. Replace trigger handle |
| Oil leakage from trigger | 1. Damage, wear or hardened O ring | 1. Replace O ring by dealer |
| Profuse oil leakage from piston front end | 1. Damage of U cup packing  
2. Scratch or damage of piston rod | 1. Replace U cup packing by dealer  
2. Replace piston rod by dealer |
| 5 prong driver is nearly coming off | 1. Bent or damaged shoulder bolt retainers | 1. Replace shoulder bolts |
| Push sleeve is nearly coming off | 1. Bent or damaged shoulder bolt retainers  
2. Damaged push sleeve | 1. Replace shoulder bolts  
2. Replace push sleeve |
| Release trigger handle but hydraulic tool does not stop | 1. Foreign substance is caught inside the tool | 1. Disassemble, clean and adjust by dealer |
Installing 5-Prong Driver

1. CAUTION: Always detach both hydraulic hoses. Safety gloves should always be worn. Machined slots at push sleeve have sharp edges, handle carefully.

2. Remove both 3/8” shoulder bolts with 1/2” wrench for lock nut and 3/16” Hex key. Note: Keep the shoulder bolts and lock nuts for new driver re-installation.

3. Slide out and remove 5 prong driver and push sleeve. Note: Hold onto the push sleeve, it will become loose as shoulder bolts are removed. Please keep shoulder bolts, lock nuts, wrench and hex key in safe place for reinstallation.

4. DO NOT remove internal spring from housing.
Installing 5-Prong Driver

5. Align new 5 prong driver flats with machined flat slots in push sleeve.
   **Note:** Orient 5 prong driver shown in above right-hand picture. Two prongs face the hydraulic hoses.

6. Gradually align flats on 5 prong driver and push the sleeve together matching the shoulder bolt hole locations. Then push the new 5 prong driver and sleeve inward and re-install the shoulder bolt in hole.

7. Align machined (flats) 3/8” shoulder bolt to the push sleeve; push the 3/8” shoulder bolt through.
8. Align and push the second machined 3/8” shoulder bolt through at second bolt location.

9. Tighten both 3/8” shoulder bolts and lock nuts with wrench and hex key.

10. Check and verify the driver orientation and push sleeve.
    Note: Double check the orientation of 5 prong driver, the two prongs should be facing hydraulic hoses. PUSH and verify the push sleeve is free to be pushed inward.