

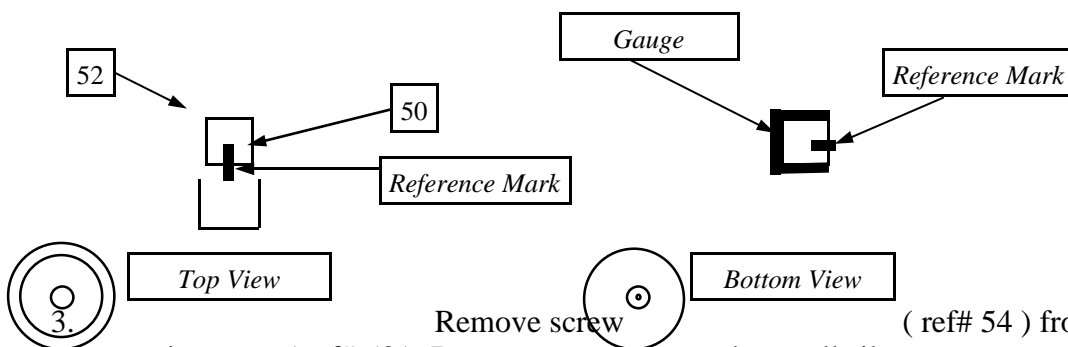
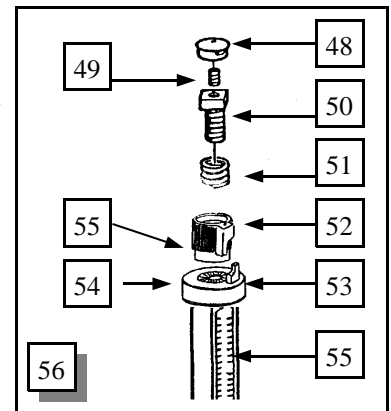
RE-CALIBRATION INSTRUCTIONS FOR FACTORY INSTALLED MICRO GAUGES

SERVICE BULLETIN BL-10

Micro gauges are pre-set at the factory and the calibration settings are Loctited to ensure a permanent setting. Re-Calibration of factory set gauges would only be required if; moving a gauge to a different canister or breakage has occurred. Micro gauges are precise measuring devices and are designed for use with one specific canister, the one it was originally installed in and calibrated to. Moving gauges from one canister to another can cause inaccurate dispenses if the calibration is not verified or re-set. Instructions provided here are for re-calibration of gauges where instruction provided in service bulletin 9, could not correct the calibration.

1. Remove the cap (ref#48) from micro knob (ref# 52).
2. Remove gauge from canister. Create a reference / alignment mark* on the inner wall of the knob assembly (ref# 52). Turn the gauge over and mark a second reference / alignment mark on the bottom.

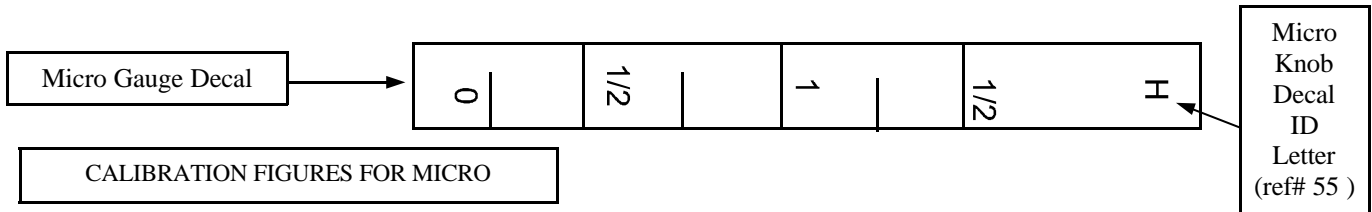
* Use *Liquid Paper (correction fluid)* or some form of part marking liquid.



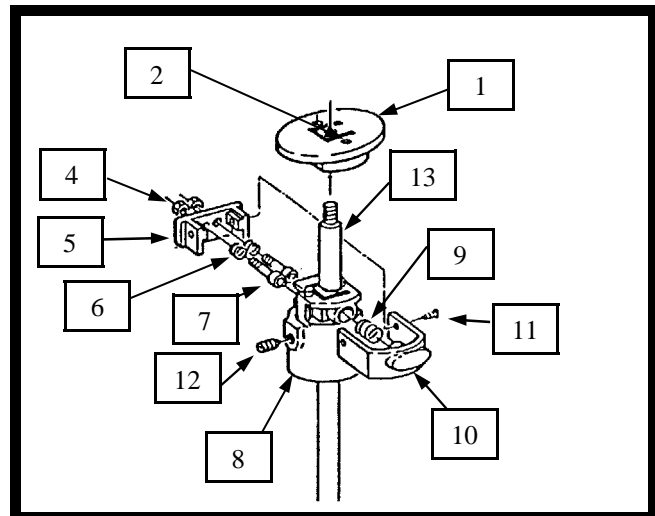
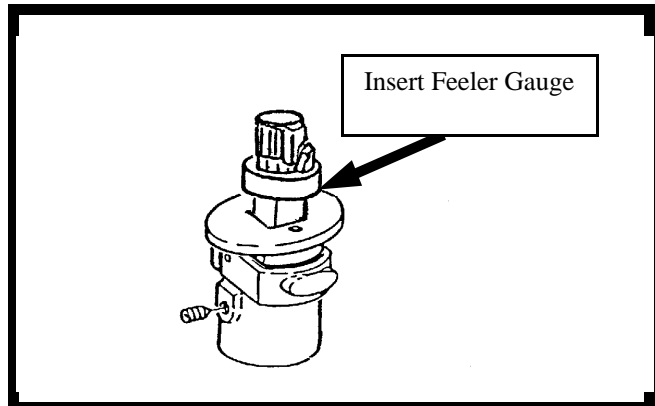
3. Remove screw (ref# 54) from the rear of of the micro-gauge pointer cap (ref# 53). Be sure to retain the small silver spacer.
 4. Place a finger in the top of micro knob (to retain spring loaded assembly) and grasp the entire micro knob assembly. Turn the gauge counter-clockwise to remove the entire knob assembly from gauge.
 5. Remove the brass screw (ref# 50) from the knob assembly. Apply a small amount of heat to help soften the Loctite. Remove setscrew (ref# 49).
 6. Re-assemble micro knob ensuring your upper markings are aligned. Wind the gauge back onto the micro knob until your lower markings are aligned and the screw (ref# 50) is approximately flush with the bottom of the uderside of gauge.
 7. Install gauge in canister and set gauge to first locking hole or position (zero "0").
- NOTE:** The left locking pin, when observed from the front or from above, will be engaged at this point. The left pin locks all numbers on the right side of gauge (ie. 0, 4, 8, 12 etc) and the right pin locks all the numbers on the left side of gauge (ie. 2, 6, 10, 14 ect.)

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8. Depending on the letter of the micro knob decal, set the micro knob to either 1/4 or 1/2, see table below. Also check table for required feeler gauge size for calibration.
9. Insert feeler gauge in the channel of gauge, between the set screw and the plunger handle.
10. Apply Loctite 271 to setscrew (ref# 2) and tighten setscrew while feeler gauge is positioned, so that the setscrew raises the plunger handle (ref# 1) up to the feeler gauge. Tighten until the feeler gauge is snug. **DO NOT** over tighten. Check and re-check the gauge locking operation to ensure operation is smooth and easy. Over tightening will prevent the locking pin (ref# 7) from engaging properly. When set correctly the locking pin should engage freely and no movement will be felt in the plunger handle with the gauge set at zero (0).
11. Continue with any remaining canisters



DECAL	MICRO-GAUGE SETTING	FEELER GAUGE SIZE
A	1/4 SHOT	0.029
B	1/4 SHOT	0.033
C	1/4 SHOT	0.015
D	1/4 SHOT	0.017
E	1/4 SHOT	0.019
F	1/4 SHOT	0.023
G	1/2 SHOT	0.015
H	1/2 SHOT	0.017
J	1/2 SHOT	0.019
J96	1 SHOT	0.019
K	1/2 SHOT	0.023
L	1 SHOT	0.019
M	1 SHOT	0.017



Loctite

To obtain information on the Loctite distributor nearest you, call;
 1-800-562-0560 (U.S.A.)
 1-800-263-5043 (Canada)

Loctite part #: 27105 (#271, .05ml)
 H.E.R.O. part #: 01-271X05