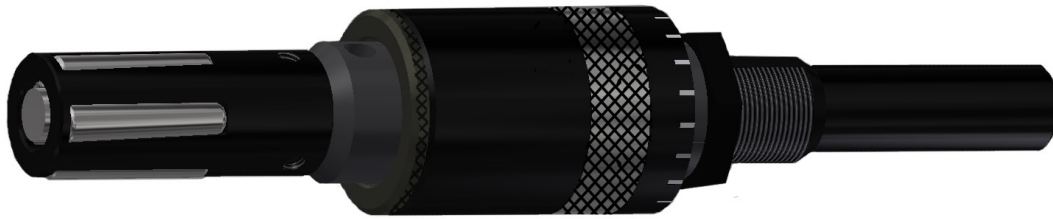


5433 and 5444 Series Roll, Mandrel and Cage Replacement Instructions



Roll replacement:

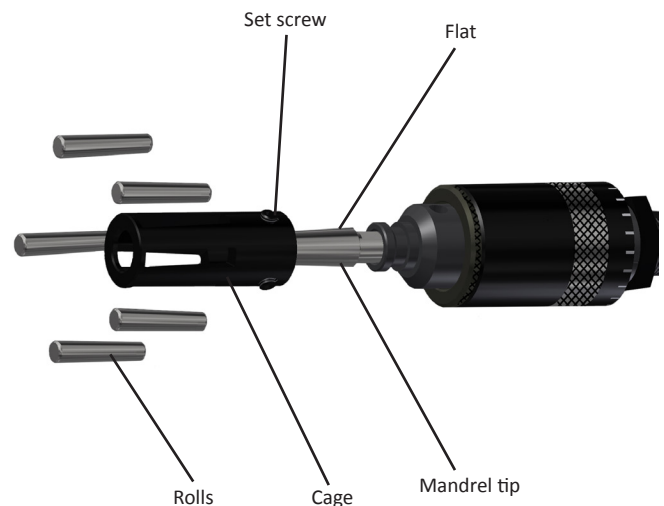
To replace the rolls on your 5433 or 5444 series tool, follow these instructions:

1. Loosen the three set screws using a 5/64" size hex wrench.
2. Pull the cage forward. The cage and rolls will move simultaneously as they are pulled forward. Rolls will be loose and removable at this point.
3. Replace rolls. ****ALWAYS REPLACE THE ENTIRE SET OF ROLLS.****
4. With new rolls in place, push cage backwards into place and tighten set screws with 5/64" size hex wrench.

Cage replacement:

To replace the cage on your 5433 or 5444 series tool, follow these instructions:

1. Follow steps 1 & 2 as listed in "Roll replacement" instructions above.
2. With rolls removed, check the cage cavities for signs of wear. If you see any, replace the cage to ensure the best performance of the tool.
3. With cage replaced, follow step 3 (if needed) as listed in "Roll replacement" instructions above, and reassemble tool following step 4.



Mandrel replacement:

To replace the mandrel on your 5433 or 5444 series tool, follow these instructions:

1. Follow steps 1 & 2 as listed in "Roll replacement" instructions above.
2. With rolls and cage removed, check the mandrel for signs of wear. If you see any, replace the mandrel to ensure the best performance of the tool.
3. Use an open end wrench or, for best results, a pair of small, adjustable, narrow nose "vice grip" style pliers on the mandrel "flat" to remove the mandrel tip, and replace using same wrench.
For 5433 series tools, use a 1/4" wrench.
For 5444 series tools, use a 3/8" wrench.
4. With mandrel replaced, follow steps 2 & 3 (if needed) as listed in "Roll replacement" instructions above to reassemble tool to operational state.