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**Continue**

General Info	i
Specifications	1022
Maintenance	1023
Engine Electrical	1024
Engine	1025
Cooling	1026
Fuel and Emissions	1027
*Transaxle	1028
*Steering	1029
Suspension	1030
*Brakes (including ABS)	1031
*Body	1032
*Heater and Air Conditioning	1033
*Body Electrical	1034

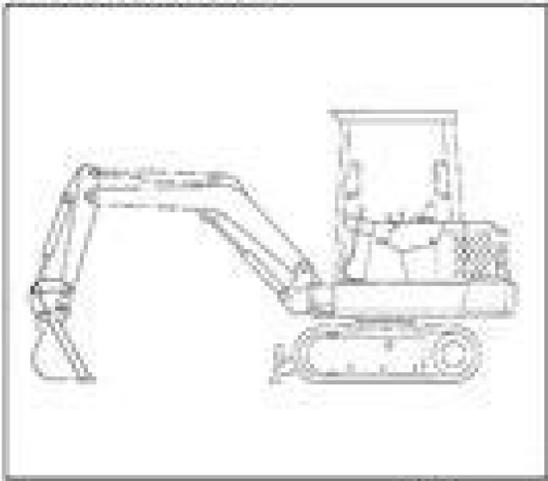
# X 225

## Excavator

### Service Manual

(S/N 508312000 & Above)

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### IMPORTANT: Read through the instructions before you start assembly.

If anything seems unclear or difficult, contact us for advice before going ahead.

- 1. PREPARATION**  
You will need a clean, dry and well lit workspace in which to assemble your kit. If possible, try to find somewhere where the walls are tiled and brushed in steel you do not touch the kit at all. It is a good idea in any case to split the work up - say assemble the circuit boards one evening, then test it and put the case together the next evening. You will need:
  - (a) A light electric soldering iron, say 15 to 25 watts with a fine tip.
  - (b) Fine gauge solder with rosin flux core, NOT acid flux.
  - (c) A pair of sharp sidecutters.
  - (d) A "topper" screwdriver with a No. 1 point.
  - (e) A medium size ordinary screwdriver and/or a 4BA spanner.
 The following items are not used, but useful:
  - (a) A magnifying glass for examining solder joints and looking for short circuits.
  - (b) Some desoldering fluid or other solder removing tool. Solder will corrode. Be sure that you put the components in right the first time - removing them can be very difficult.
  - (c) A piece of paper is used to try to keep components tidy and when you turn the board over to solder again.
- 2. PRECAUTIONS**  
There are 40 main integrated circuits (ICs) in the kit. Not many are at all expensive and most of them are susceptible to damage from static electricity. There is no doubt for worry if a few precautions are taken:
  - (a) Use the sockets supplied with the kit - never solder the ICs direct to the board - and keep the ICs in their protective anti-static bags until you are ready to plug them in.
  - (b) Never solder or remove the ICs or do any soldering with power applied to the computer.
  - (c) Use a soldering iron with a properly earthed tip.
  - (d) Careful and controlled use of heat. Excessive heat on plastic parts can cause warping and static charge. Warn yourself by rotating a large object, preferably metallic, prior to touching the ICs if you do get a shock by touching your hands to anything that has been touched.
- 3. COMPONENT IDENTIFICATION**  
Before you start assembly, check the components against the component list (section 8) and make sure you have them all. We have tried to cover all pin markings of the components, but sometimes are essential. Note it is possible that the component markings may be slightly different from those in the kit. ICs are marked with the number of pins (e.g. 14, 16, 18, 20, 24, 28, 32, 40) and that assembly is necessarily different for each version. Some components need to go in the board in a certain way:
  - (a) The ICs are marked with a notch, and a notch or dot or simple lead to pin 1. (See Fig. 11. Note that all the ICs face the same way on the board, i.e. with their notches towards the edge connector.



As an extreme example, let's take a loose pistol, with standard link and full lug height of .060" - but with only 50% lug engagement [or .030 of overlap]. Chamfer the bushing skirt opening about 45 degrees to a depth of about 50%, then recheck. Allow only the front sight to extend from the vise jaws. But, I suggest making it a habit to remove it at this point in disassembly. 55. They are arranged in a logical "how you would go through it in the shop" sequence, and are a package of ready information. This record will probably stand. The Colt .45 Auto - Book I 39 Remove Rear Sight Blade This section applies to fixed, dovetail rear sights, and especially in cases where the sight was found to be loose on a previous inspection, or has loosened before. The recoil spring plug and the two special recoil springs are shown separately above. Always check the chamber; empty and clear. The link area and tunnel forward of the barrel bed. From the civilian viewpoint, certain kinds of problems are found in government issue models: generally looser tolerances, softer slides, less carefully fit and, by now, overly worn parts. 8. The Colt .45 Auto - Book I 8 Figure B- Shows two versions of the Colt Officer's ACP. Experienced pistolsmiths always take the necessary few minutes needed to pre-check a semi-automatic pistol, generally following the list given below. 15. 1. Push the trigger back through the frame and draw it out with your fingers. 167 Parts Diagrams..... When the extractor is in the installed position, the plunger retainer stud is forward, keeping the plunger captive. The ingenious, but simple, M1900 was the first semi-automatic pistol produced in the United States, and is the linear ancestor of, and design basis for, the Colt Government Model .45. Caution: Remove just enough material to allow free movement of the barrel bushing, beyond this point, too much of the rivet may be removed, weakening the connection. A Dremel tool and a .125" round ball cutter is used for this job. The Colt .45 Auto - Book I 7 Figure A- Shows the Colt M1900 which was the first semi-automatic pistol commercially produced in the United States. 12. At left, the hammer is drawn out of the frame. When the extractor is moved slightly back, the retainer stud disengages, allowing the plunger and spring to be removed. Springing also causes collet fingers to fatigue and break. Using an undersized punch, push the hammer cross pin out- from the right side of the frame. The Series 80 Government and Gold Cup Models continue to use slightly different hammers. The firing pin lock safety would be defeated if the plunger was stuck in the "up" position. Keep in mind that a variation of .001" at the muzzle equals 1" at 100 yards, or 1/2" at 50 yards. Then, disconnect the collet from the slide. With softer slides, small variations are easily compensated for, in most pistols, by use of a shallow 45 degree chamfer at the disconnecting edges of both the slide and barrel lugs. These all use the same type barrel bushing and spring retainer plug as originally designed. Minimum recommended is .001 to .0015" and maximum is .006" Remember that vertical slide clearance adds elevation to this basic measurement. See figure 9. Depress the firing pin just enough to clear the bottom of the stop plate. These are the people who will want it redone later (and for nothing) and will probably sue you for any mishap. The Colt .45 Auto - Book I 44 Fit Undersized Bushing To Barrel At this point, fully inspect the barrel before fitting the bushing to it. As the extractor reaches the point of about .020-.025" setback, the plunger retaining stud will clear and allow easy removal of the firing pin lock plunger. So, you will notice that barrel hoods, once fit to these slides, will have a somewhat narrower hood extension, usually measuring just at .375" wide. The legendary Government Model of 1911 followed. The Colt .45 Auto - Book I 19 Slide Removal Caution Potentially, it's true that every slide you remove may contain surprises. Trigger actuated frame linkage depresses the plunger, unlocking the firing pin just before hammer drop. As the barrel fully



is to be replaced, or in cases where the frame is to be polished before rebluing. 148 Sear Mating Check. If dirt impacted or rusty or stuck, applying penetrating oil and rap the frame with a wooden hammer handle. The pin has a slightly beveled head, recesses into the left side of the frame, and is retained by the thumb safety lever. Grind the old staking away with a Dremel tool. As the plunger emerges on the safety side, grasp it and draw the entire spring and plunger assembly to the rear and out. The hammer cross pin must be pushed out to the left [see arrow]. Clean all other recesses; a toothbrush does a fine job. 177 Cross Sectional Drawings ..... Figure 3- Shows depressing the M1911 type standard recoil spring plug, and then releasing it by rotating the barrel bushing to the left. Make sure the magazine has been removed. NEVER trust anybody- THE GUN IS ALWAYS LOADED! NEVER hand (or take) a gun- unless you have personally checked its chamber(s). The second section, or Book II, covers: 4. This observable void is precisely the reason that this book was written. If the owner insists- let him do it, then it's strictly his liability- and not yours. 21. Colt's production National Match Gold Cup slides are manufactured with narrower hood receiving slots than standard Government Model pistols. That there are two kinds of these barrels is more the result of differences in available tooling than in design theory. So, whether you are a professional, or a do-it-yourself gunsmith, get this book. 16. With age, wear, and the diversity of manufacturers, a fair amount of dimensional variation can, and does, exist. Production variations create differences in the fit of these collets. Approximate bushing relief, or clearance, angles are also shown. Inside the firing pin well. Next, hand polish until the barrel moves freely, but with zero clearance or play. All Government Model barrels are 5" in overall length, when measured from hood to crown while the slightly shorter Commander and Combat Commander barrels are 4 1/4" long. At the looser military production tolerances, the pistol functions, and continues to function, when all others have become terminally inoperative. 62 for barrel inspection. If this happens, impact drive the plunger out by rapping the bottom of the slide on a plastic bench block. For Maximum Accuracy: 1. To date, military M1911 and M1911A1 pistols have been manufactured by seven U.S. manufacturers, and replacement parts have been made by even more military contractors. Insert a .125" diameter round ball cutter in the Dremel tool. Springfield Armory Inc. If rail end battering is found, dress and reshape ends to match the contour of the stop area inside the slide. Since hammers and sears are mated, be sure that you place the hammer in the correct parts box. The Colt .45 Auto - Book I 48 Figure 52- Shows barrel inspection points and, also, a standard service diameter insert gauge, or plug gauge, used to check bores for internal irregularities. This applies all the more in the specialized field of pistolsmithing. Then, check for galling, attempts at tightening, excess wear, nicks, burrs, and etc. The standard stainless production model is shown, in three quarter view, at bottom. Now, release trigger and re-squeeze. To prevent marring of better finished civilian frames, I suggest using either a nylon or aluminum pad on top of the steel block. It would be a waste of both time and the bushing, otherwise. Always use the rule of halves when reducing diameter: remove only half of the estimated amount, and then recheck fit. for maximum hard ball loads. The sight staking tool is also shown in the correct flaring position, with the mouth opening clearing the slide. Frame rails- inspect for dents, edge nicks, or burrs. As an example of averages- consider that two thirds of the pistols in use measure .006" slide/bushing total clearance, and another .005" in bushing/barrel clearance. For general service use, .004 to .005" is near optimum, while less than .001" is desirable for competition. This is normal. In standard bushings, this problem is easily solved by increasing the top inside and bottom front bushing clearances, and sometimes by additional barrel and skirt clearance, as shown above. Re-true edges, lightly stone as necessary. Lathe Fit Oversized Bushing This is a faster and better way to size both expanded and oversized accuracy type bushings, and gives uniform results while ensuring that the bushing is kept perfectly round and concentrically aligned. Gravity check. Some gunsmiths chamfer lug faces as much as 25%. See figure 51. Recheck lug fronts after the tops have been dressed. Remove as follows: 1. For those not yet familiar with the internal workings of the M1911 type pistol, it is necessary that location, function, and interaction of these parts be fully understood before reassembly and parts checkout begins. Inspect ramp, throat, and chamber- if the barrel has been modified non-standardly, if the chamber has been enlarged, or if the throat and/or ramp have been overcut, replace the barrel. And "B" shows the bottom contact, or drag, area which is usually present when top contact is found. Since the sear is a mated part, place it in the proper parts box. Cock the hammer back into the full-cock position. At this point, the catch lock [looks like a screw] is turned counter-clockwise to disengage its' lock stud from the frame and re-engage it with the body of the magazine catch. The main spring housing pin is held inside the frame by downward pressure of the pin retaining plunger, at bottom of the mainspring. See figure 13. See figure 26. To prevent possible wrench marking, first try a plastic bushing wrench. After frame and slide have been individually cleaned, inspected, and hand detailed, they must be assembled and checked for correct interaction and fit. Depress the slide stop plunger with a small diamter punch, and begin moving the assembly to the rear. If the fingers do not feel rigid, are bent, or show signs of fatigue, replace the collet. Then close slide on an empty chamber. The easiest way to remove this recoil spring system is as follows: 1. 122 Fit Competition Bushing ..... Loosening Caused by Undersized Sight Blades Here, the best remedy is to remove the rear sight and select a wider, better fitting blade. Always use a screwdriver that is properly ground to fit these oversized slots. This holds true in .45 automatic pistolsmithing. Frame drag- check ejector stud and pin. The best way to minimize this disassembly wear is: 1. For general service use, best at .005 to .006", and competition, again, less than .001". You will often find bushing to slide clearances in excess of .004 and .005"- and sometimes more on older .45 autos. With finger off trigger, cycle slide back and thumb lock slide open. Set lathe spindle speed low, or at about 100 rpm. The hammer cross pin is removed in the same way as the previous models. The combination of a 22 or 24 lb. Cut-away training aids are so beneficial that I strongly suggest their use in all gunsmith training. In total, 3500 pistols were produced. (But not grip safety.) Hammer must not drop. Figure 29- Shows the main spring housing being removed by drawing downward and out of the frame. When pistols are disassembled frequently, barrel contact surfaces and the bearing fingers of collet style bushings can wear more from disassembly rotation than from lock-up. Figure 14- Shows finger turning the barrel light series 70 area which is usually present when top contact is found. Since the sear is a mated part, place it in the proper parts box. Cock the hammer back into the full-cock position. At this point, the catch lock [looks like a screw] is turned counter-clockwise to disengage its' lock stud from the frame and re-engage it with the body of the magazine catch. The kind of barrel is only acceptable for service use, and not for match purposes. O.K.? Locking lugs in slide- inspect for raised edge flanging, burrs, excess wear and/or battering at the bearing edges of the lugs. The shorter Commander uses a cut-off standard bushing. The Colt .45 Auto - Book I 26 Remove Hammer Pin and Hammer Once the thumb safety lever has been removed, the small, beveled retaining head of the hammer cross pin is exposed. Hand broaching is the easiest way to do this. At a point, you will easily visualize entire pistol function, down to the smallest detail. If the housing is resistant and the frame shows damage or signs of rust, apply oil and tap the main spring housing out, using a dowel as a drift. Disfigured screws are an outward sign of poor craftsmanship. Binding high spots are stoned and rechecked until the desired clearance is reached. Removing .002 to .003" will usually clean the surface. Refitting work always starts with the slide, followed by the frame. Squeeze trigger, depress grip safety, and return slide forward. Colt 1911 Workshop Manual - Jerry Kuhnhausen.pdf (PDF, 19.7 Mo) Le lien court permet de partager facilement votre document sur Twitter, par SMS, ou sur votre profil Instagram: Le code suivant permet de faire un lien vers votre document sur un site Web ou un Blog: Pour voir les commentaires déjà publiés ou ajouter un commentaire, Connectez-vous ou Créez un compte. Visibly centered? See figs. As a result, this particular barrel bushing is very easy to remove. Approximately 2,695,200, or so, Model 1911 and A1's were produced by the end of World War II. 147 Ideal Competition Sear/Hammer Engagement..... M1911, M1911A1, and Commander models all use the original, straight tube design. Sear bounce test. This method is still practical in general and service pistol use in that it eliminates half, or more, of front end barrel movement. At almost half way up, the retaining shoulder of the sear block should clear the frame and allow the safety to be pulled out. Place the slide upside down between lead pads in a bench mounted drill press vise, or in a toolmaker's vise. Remove any high spots or machining ridges that are found inside the slide where the collet fingers bear. Figure 9- Shows barrel bushing disassembly positions for all M1911 through series 80 models. A clockwise 1/4 turn to the position shown in "A", above, releases the recoil spring plug, and an 1/8th turn, counter-clockwise from center, unlocks the bushing. Half cock notch, Series 80- secondary nature is demonstrated since the factory no longer makes this notch captive, as with earlier models. To remedy this condition: 1. Customers and friends rightfully become quite irate when scratches accompany repair work, even when they are free. As you can see, the bottom fingers of the barrel bushing act as retainer for the spring plug. Push the sear pin out of the frame from right to left. While holding the plug at this point, rotate the bushing counterclockwise about 1/8 turn, until the bushing's lock tab is in the clear and just in front of the spring plug. Figure 20- Shows, at bottom, the original Colt M1911 type extractor as used in all models up to and including the 1970 series. NEVER alter or remove any safety feature from any gun. Caution: Do not overstrike. Make sure the lever isn't lost. NEVER point any gun- except at a target. Disconnect recess- inspect the milled disconnecter recess. Otherwise, it is much faster and easier to replace it with an accessory type sight that has gib locks or Allen set screws. Figure 21- Shows a small punch being used with protective pads to withdraw a poorly fit or damaged extractor from the body of the slide. Disconnecter- disconnects sear and trigger when cycled by the slide into the down position. I have seen pieces of bottom barrel lugs, broken links, link pins, and collet fingers fall out as slides were taken off their frames. Mechanical adjustments to increase reliability of function. Critical action safety parts, including those used in the Series 80 firing pin lock safety update, are shown in a closer, more detailed view in the inset illustrations, below. But, keep in mind, that this design, adopted more than three- quarters of a century ago, is still the most copied and reliable automatic pistol in the world. Lift the hammer and strut up and out of the frame as the cross pin clears. If this fails, use the standard steel wrench. Figure 5b- Shows opening the inside diameter of the bushing by reaming, one step at a time, to slightly under barrel O.D. size. They are fairly common on pre-Series 70 pistols. 14. Barrels for the much later production 1970 Series and 1980 Series Government Models and, as well, Series 70 and 80 National Match Gold Cup Models, all use the collet bushing system. Drive the blade in from right to left. It must be understood that this critical part acts also as the reconnector when cycled back into the upper firing position by the sear spring. In this way, if one slips by, you won't get it in the eye. So, it's foolish to "make do" by using a barrel in anything less than excellent condition. Close slide and install empty magazine. Slide/frame rail horizontal clearance- another variable measurement, and found in excess of .015". Prevent finish damage to the slide and bushing by applying a protective layer of masking tape to the face or the wrench. IF you work on (or just inspect) a gun you determine is not in good working order- even if the work is for a best friend or the inspection is free- always write: "WARNING- NOT SAFE TO FIRE" on the shop ticket. This was followed by a commercial version of the military pistol in March of 1912. So, don't modify it unless needful of the modification. They work by grasping the barrel at the step-up point, and then simultaneously expanding the outer surface of the bushing [fingers] about .003" just as the slide closes, and in this way improving both contact and fit of barrel and slide. Disconnecter rail to frame clearance- measured with the slide pushed down and against the frame. Check sights. Battering- inspect the areas shown for signs of battering. Figure 24- Shows the hammer pre-positioned at full-cock. When staking is complete, carefully grind away the excess staking material. Slide bottom drag- check for slide bottom contact against the corresponding shoulder of the frame rail slot. See figure 59 for more information on barrel springing. About Two Piece Barrels Some gunsmiths are surprised when they spot one of these brazed, two piece barrels for the first time. Don't do it. Adjust blade thickness and width to fit, and then dress the edges as required. Don't undersize.

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