

## CHANGE THE SWING DIRECTION ON A DK20SP

### FROM SWINGING TO THE RIGHT TO SWINGING TO THE LEFT

The following instructions are on the ability to change the direction of swinging the top head from swinging to the right to swinging to the left. This kit includes the parts needed to perform this modification. You will **NOT** need to change any wiring nor drill or tap holes. **(No machining required)**

#### KIT INCLUDES:

- (1) Machined black plastic box cover with (2) added holes
- (1) Black steel spacer bar
- (2) 6-32 x 2" socket head cap screws w/washers and lock washers

#### TOOLS NEEDED:

- 7/64 Allen Key Wrench
- 3/16 Allen Key Wrench
- Small standard flat blade screwdriver

#### INSTRUCTIONS:



Remove the cover from the rear pivot switch box by removing the corner slotted screws. **(Save these screws, you will need these later)**



Remove the rear pivot switch box itself from the silver metal stop collar by removing the (2) slotted screws located inside the black plastic box. **(Allow the black switch box to hang after removing)**

3.



Locate the black switch box cover that came with the kit onto the switch box. You want the (2) holes to be on the **LEFT** side of the box. **(see picture)** Then reattach the (4) corner screws that you had removed in step #1.

4.



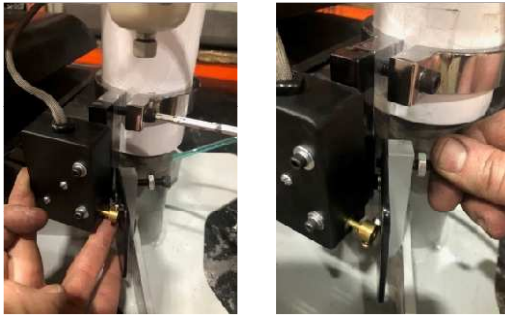
Insert the (2) 6-32 x 2" socket screws into the two holes in the cover. Then slide on the black spacer bar that came in the kit to the exiting screws out the back. Carefully align the black switch box with spacer bar and exiting 6-32 x 2" screws to the tapped holes in the silver stop collar. Using the 7/64 Allen Key wrench to slowly tighten both screws. **(Tighten screws until the screws start to bend the black cover)**

5.



Locate the stop screw/nut on the base stop bar. Unscrew the stop screw from the stop bar and reattach to the stop bar from the backside of the stop bar as shown. You may need to use the 3/16 Allen Key Wrench to loosen the stop screw.

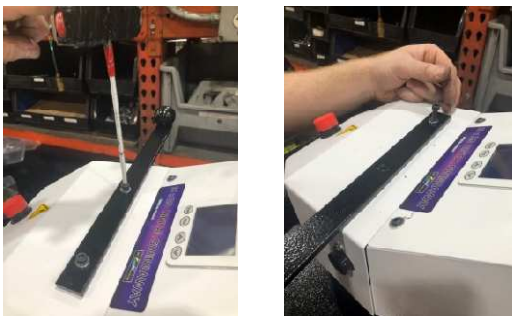
6.



Use the 3/16 Allen Key Wrench to loosen the silver stop collar clamping screw until the stop collar is free to slide up and down on the top white head pipe. Then lift the stop collar/ black switch box up and over the bottom base stop bar and locate the unit in FRONT of the base stop bar. **(see picture)**

**Make sure the heater block is aligned to the bottom table.** Then tighten the stop collar at a position that the brass plunger rod from the rear pivot switch box is depressed (pushed in) Then proceed to tighten the stop collar clamping screw. Double check to make sure the heater block is aligned with the bottom table and then adjust the stop screw in the base stop bar so it makes contact with the stop collar. Once you feel you have it all in the right position, swing the top head outward and then back until it stops, check to make sure the heater block is still aligned with the bottom table. Adjust the stop screw if need to.

7.



Next you need swap the black handle from the LEFT side of the machine to the RIGHT side of the machine. Remove the (2) screws that attach the handle to the top white hood and then re position the black handle so it is now facing the RIGHT side. Reattach the (2) screws and tighten.

#### **TROUBLE SHOOTING:**

If after performing this change in swinging modification the machine does not activate after pressing the black activation buttons, check to make sure that when you swing the machine over and it hits the stop, the brass rod from the rear pivot switch box is depressed enough to close the two mini lever switches in side. If either one or both of these switches are not depressed, the machine will not activate and press. You will need to adjust stop screw and or stop collar to insure it works properly. Please call the factory at 1-800-525-6766 and ask for technical support if you run into any problems.

