Setting Application Torque

1. Determine initial clutch setting from torque chart below.

2. Loosen the torque adjustment screws. Rotate the adjustment ring using the face spanner wrench to the desired setting and then retighten the torque adjustment screws. Do not use the set screw in the slot on the backside of the housing for torque adjustment. Tighten set screws to 8-10 lb-in. Over tightening is not necessary and will strip the screws or possibly damage the housing body.

3. For optimum results, check setting with a torque wrench and FIX-0115* or FIX-0138.

*For use with DBJ closure

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Recommended Maintenance
For CHF38-035 Chuck

Disassemble, clean, and replace all wearing parts in the headset every 7000 hours of machine run time.

- See rebuild instructions for detailed information on disassembly and assembly of Warner headsets.

- Dependent upon machine speed and washdown procedure, some environments may require more frequent rebuilds.

- CHF38-035 chucks cannot be submerged in water. Proper cleaning procedures for the chucks include wipe down operations or foaming. If necessary chucks can be taken apart, cleaned and rebuilt.

- Chucks can be greased if needed using lubrication hole in chuck and needle fitting on grease gun. Do not over grease as this will cause the chucks to stick.

Note: CHF38-037 and later model chucks may be submerged in water or COP/CIP cleaners. No re-greasing is required.
Installing Clutch

Remove handle. Set aside finger, three socket head cap screws and lock washers. See figure 3.

Remove screen. Set aside screen, 4 screws, and 4 lock washers. See figure 4.

Install screen, 4 lock washers, and 4 screws onto new unit. It may be necessary to widen original holes on screen. See figure 5.

Install finger onto new unit. See figure 6.

*Depending on previous equipment a longer finger may be necessary.
To set torque loosen the two set screws using 3mm Hex wrench. Tighten set screws to 8-10 lb-in. Over tightening is not necessary and will strip the screws or possibly damage the housing body. See figure 7.

Align visual marking with desired setting. Using a face spanner wrench (YTL2-0002). Then tighten down set screws. See figure 8.

Remove turret cover from top of machine. See figure 9.

Remove the two bolts that hold the unit to the machine. Set the bolts aside for later use. See figure 10.
Remove old unit from the machine. See figure 11.

Install new unit onto the machine. Use original two bolts to secure unit from Figure 15. See figure 12.

Adjust gear position where necessary using 3mm Hex wrench. Apply proper food grade lubricant to gears. See figure 13.

Clutch installation is now complete. Install remainder of clutches in the same manner. Adjust clutch torque and machine turret height as needed. See figure 14.
Remove snap ring from bottom plate. See figure 15.

Remove screws from bottom plate using 3/16” (3mm) hex wrench. Remove bottom plate from unit. See figure 16.

Remove set screw on the backside of housing using 3mm hex wrench. See figure 17.

Using spanner wrenches (YTL3-0008) and rubber mallet separate clutch from top adapter. See figure 18.
Remove clutch from top adapter. See figure 19.

Remove gear from shaft using 3mm Hex wrench. See figure 20.

Remove retaining ring from shaft. See figure 21.

Remove shims from shaft. See figure 22.
Remove shaft from top plate. See figure 23.

Replace the two bearings in the top plate. Replace bearing in bottom plate. See figure 24.

Install shaft with adapter onto top plate. See figure 25.

Install shims onto shaft. See figure 26.
Install retaining ring onto shaft. See figure 27.

Install gear onto top of shaft using 3mm Hex wrench. See figure 28.

Install clutch onto adapter. See figure 29.

Using spanner wrenches (YTL3-0008) and rubber mallet tighten down clutch onto adapter. See figure 30.
Install set screw on back side of housing using 3mm hex wrench. Tighten set screws to 8-10 lb-in. Over tightening is not necessary and will strip the screws or possibly damage the housing body. See figure 31.

Install bottom plate over shaft of clutch. Install screws using 3/16” hex wrench onto bolts to hold plate in place. See figure 32.

Install snap ring over shaft of clutch. See figure 33.
Clutch Rebuild Procedure

Place unit into vice. Using FIX-0019 and 1 1/8” or 28mm” socket wrench remove nut from top of housing. See figure 34.

Remove the two set screws from housing of unit using a 3mm hex wrench. See figure 35.

Move adjustable end plate until spring and pin are visible. Remove pin and spring from housing. See figure 36.

Pull magnet stack away from housing. Set magnet stack aside. See figure 37.
Remove three cap screws from top of housing using 3mm hex wrench. Remove black driver magnet from housing. See figure 38.

Remove spacer from magnet stack. See figure 39.

Remove hysteresis magnet from magnet stack. See figure 40.

Remove adjustable end plate with black driver magnet from shaft. See figure 41.
Remove spacer and grease seal. See figure 42.

Remove O-ring from shaft. See figure 43.

Remove seal from top of housing. See figure 44.

Using an arbor press remove bearing from inside of housing. See figure 45.
You will now have all of the pieces shown in the picture to the right. Clean all pieces and replace parts as needed. Use an alcohol based cleaning solvent to clean the black driver magnets. Do not use anything abrasive when wiping the black driver magnets. Use a Scotch Brite deburr wheel to polish the hysteresis magnet. See figure 46.

Turn housing over. Press new bearing in housing using FIX-0002 and an arbor press. See figure 47.

Put in new seal. See figure 48.

Install end cap with black driver magnet into housing. Be sure to line up holes for set screws. See figure 49.
Reinstall three cap screws on top of housing using 3mm hex wrench. See figure 50.

Place grease seal over spacer. See figure 51.

Install o-ring into groove of shaft. See figure 52.

Slide spacer with grease seal onto shaft. See figure 53.
Once the spacer is placed on the shaft. Apply thin layer of grease to the seal. See figure 54.

Apply thin layer of grease to black driver magnet that is attached to the adjustable end plate. See figure 55.

Slide adjustable end plate and magnet onto shaft. See figure 56.

Slide hysteresis magnet onto shaft so that it rests on the black driver magnet. See figure 57.
Install spacer onto shaft. See figure 58.

Apply thin layer of grease to black driver magnet inside housing. See figure 59.

Place magnet stack inside of housing. Line up the hole on the adjustable end plate with one of the set screw holes on the housing. Be careful as the magnets will attract together and snap into place. See figure 60.

Place small spring inside of the aligned holes. Then place pin, flat side up, into the hole. See figure 61.
Press down on pin with allen wrench and place spanner wrench (YTL2-0002) onto adjustable end plate. Turn the allen wrench and the spanner wrench at the same time to lock pin into place. See figure 62.

Turn adjustable end plate until witness mark falls between the O and 5 torque markings. See figure 63.

Install the two set screws onto front of housing using 3mm hex wrench. Do not tighten down yet. See figure 64.

Place unit back into the vice. Apply Blue loctite to the thread of the nut. Using FIX-0019 and 1 1/8” or 28mm socket wrench reinstall the nut. Torque nut down to 45 ft. lb. See figure 65.
Using spanner wrench (YTL2-0002) adjust to desired torque setting. See figure 66.

Tighten down set screws using 3mm hex wrench. Tighten set screws to 8-10 lb-in. Over tightening is not necessary and will strip the screws or possibly damage the housing body. Reinstall unit. See figure 67.
CHF38-035
Exploded View for Chuck Rebuild

Use Loctite on this Connection

Grease Here (4 Hole Locations)
CHF38-037 & Later Models
Exploded View for Chuck Rebuild
(non-grease chuck)
On-site Service Support
Warner Electric Capping Headsets

On-site service support is available for installation of new Warner headsets, rebuild support of existing Warner headsets, training, etc. Our factory-trained and certified service department with over 50 years combined experience can help prevent costly delays and down time of your capping operation.

**Precision Tork is the ONLY Service Group that is factory authorized to work on the Warner Electric headsets.**

**Services Provided:**
- Installation of new equipment
- Machine audits and troubleshooting
- Service and repair of filling and capping equipment
- Consulting: New Installations-existing issues for filling and capping
- Develop new design for efficient production
- Assist with planning of preventative maintenance programs
- Operator and mechanical training
- Highly qualified trained field engineers ready to work on the following bottling equipment:
  - Alcoa
  - Zalkin
  - Fowler
  - AROL

**Precision Tork Service Benefits:**
- We manufacture the headsets!
- Most up-to-date designs available only through Precision Tork.
- Our service technicians are trained to rebuild your headsets to their existing revision level OR upgrade them to the latest technology.
- Component parts and rebuild kits on hand so you do not incur downtime.
- Coming soon...secure website for headset information and parts ordering with a credit card.

**To schedule a certified Warner Service Technician**
**contact Melissa Bottke at 1-888-350-1891**
Trouble Shooting

• **Proper Operation:** Before cap comes out of chuck the chuck should reach a stall point. At that point cap will be completely tightened on bottle. It is important to have proper turret height and clutch torque adjustment for this to occur.

• **Loose Caps**
  • Torque setting on clutch to low; increase torque setting on clutch
  • Turret position set to high while cap is being screwed onto bottle
  • Cap will be pulled from chuck before properly tightened. To correct, lower turret of machine.

• **Bottle Damage**
  • Can result if turret is set to low.
  • Chuck will cause cap to be crushed onto bottle.
  • To correct raise turret of machine.

• **Sticky Chuck Float**
  • For proper operation, chuck must float up and down approximately 0.2 inches.
  • If grease is washed out of chuck and chuck becomes dry, re-greasing chuck will become necessary.
  • Chuck should move easily in and out without hang ups.

Information for Ordering Spare Parts

It is important to stock spare parts on hand to avoid unnecessary downtime. Warner recommends that you stock at least two spare headsets per machine and a few bearing and magnet rebuild kits so that you have the necessary parts on hand if you need them.

How to order spare parts – required information:
1. Purchase Order Number.
2. Warner headset model number/part number OR serial number (only on models manufactured July 2007 and later).
3. Warner Component or Kit Part Number.
4. Preferred distributor to order from.

All orders will be routed through local distribution. Pricing and lead-time can be quoted by calling the Manufacturing Facility at (888) 350-1891.
Warranty

Warner Electric LLC warrants that it will repair or replace (whichever it deems advisable) any product manufactured and sold by it which proves to be defective in material or workmanship within a period of one (1) year from the date of original purchase for consumer, commercial or industrial use.

This warranty extends only to the original purchaser and is not transferable or assignable without Warner Electric LLC's prior consent.

Warranty service can be obtained in the U.S.A. by returning any defective product, transportation charges prepaid, to the appropriate Warner Electric LLC factory. Additional warranty information may be obtained by writing the Customer Satisfaction Department, Warner Electric LLC, 449 Gardner Street, South Beloit, Illinois 61080, or by calling 815-389-3771.

A purchase receipt or other proof of original purchase will be required before warranty service is rendered. If found defective under the terms of this warranty, repair or replacement will be made, without charge, together with a refund for transportation costs. If found not to be defective, you will be notified and, with your consent, the item will be repaired or replaced and returned to you at your expense.

This warranty covers normal use and does not cover damage or defect which results from alteration, accident, neglect, or improper installation, operation, or maintenance.

Some states do not allow limitation on how long an implied warranty lasts, so the above limitation may not apply to you.

Warner Electric LLC's obligation under this warranty is limited to the repair or replacement of the defective product and in no event shall Warner Electric LLC be liable for consequential, indirect, or incidental damages of any kind incurred by reason of the manufacture, sale or use of any defective product. Warner Electric LLC neither assumes nor authorizes any other person to give any other warranty or to assume any other obligation or liability on its behalf.

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