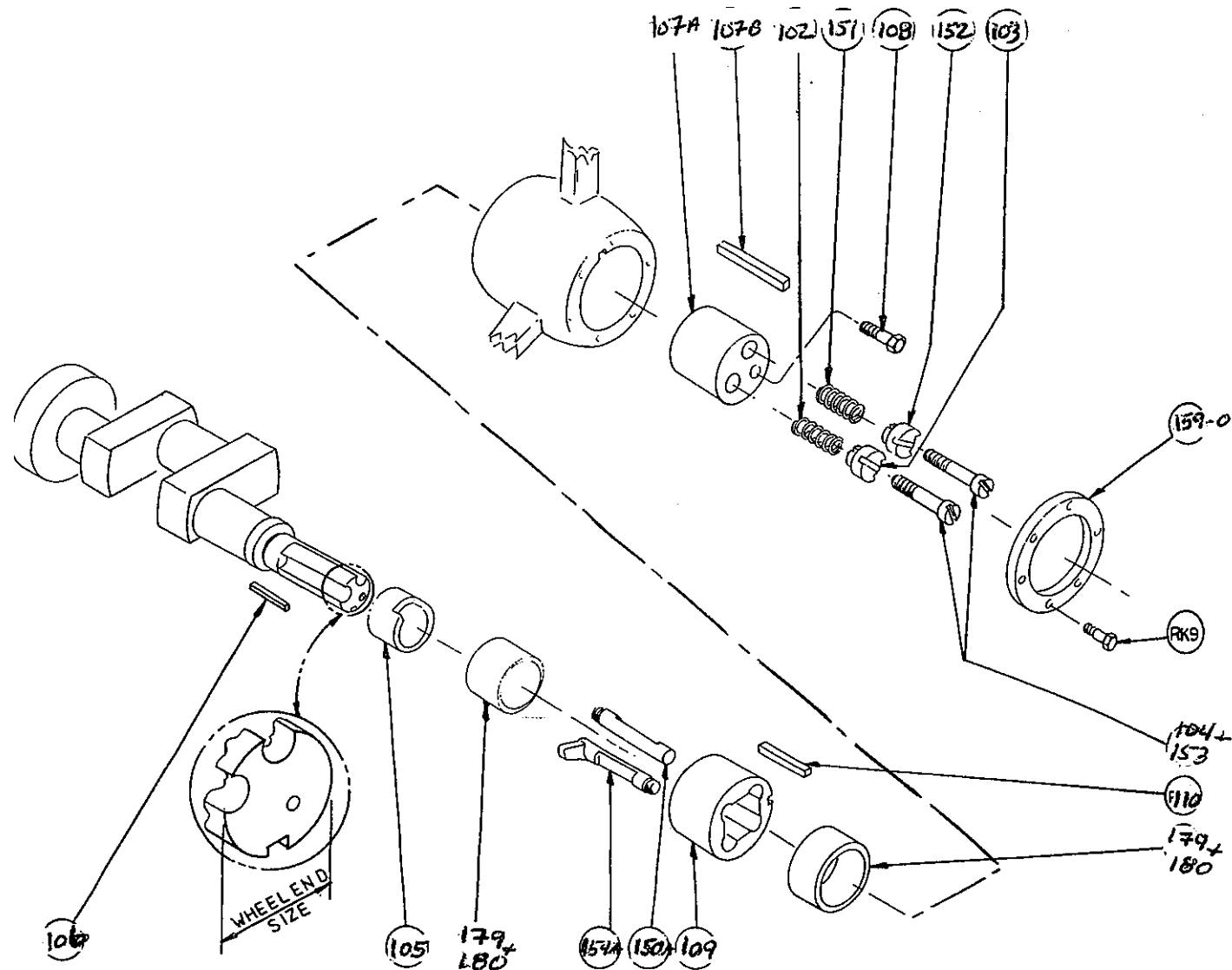
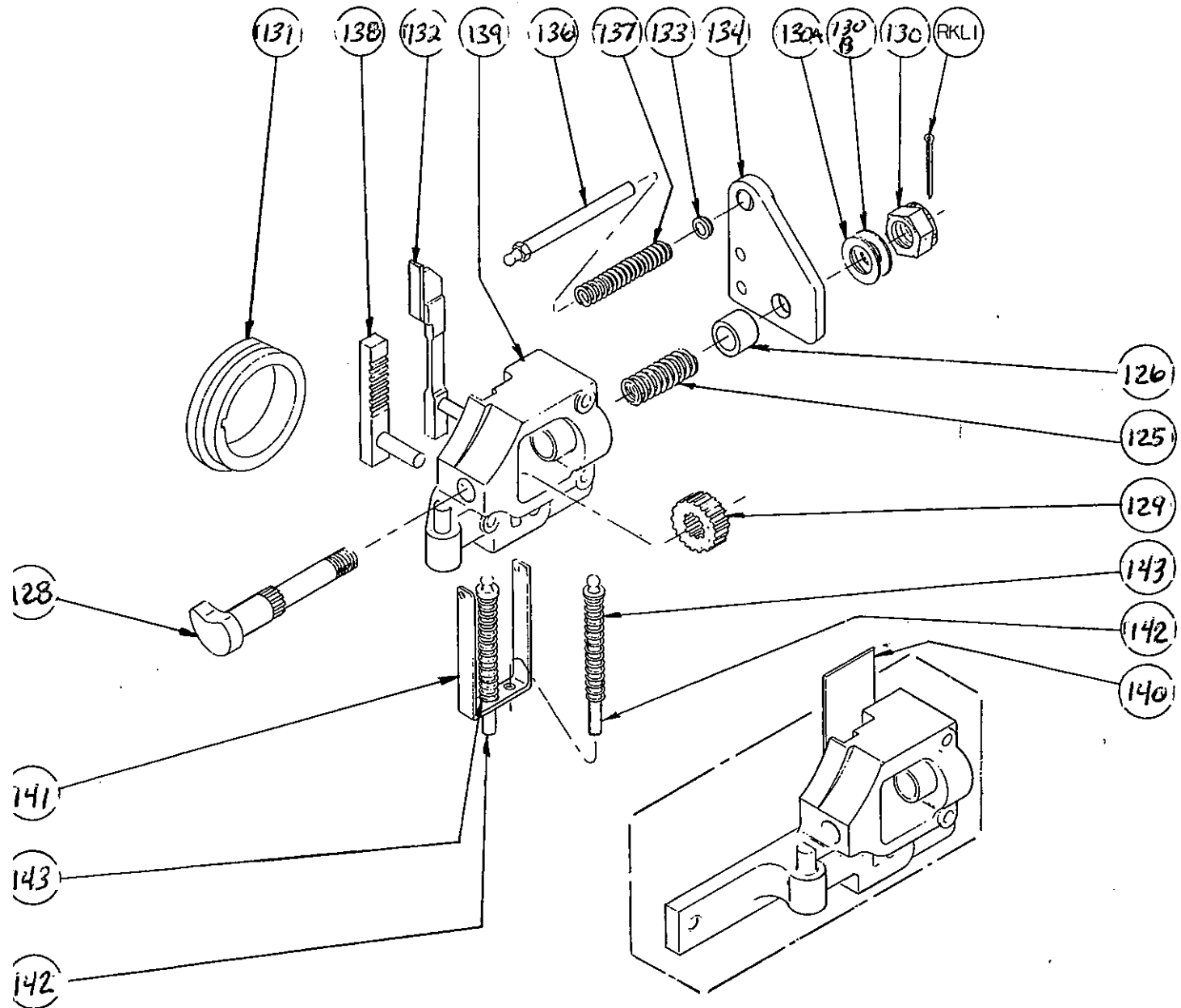
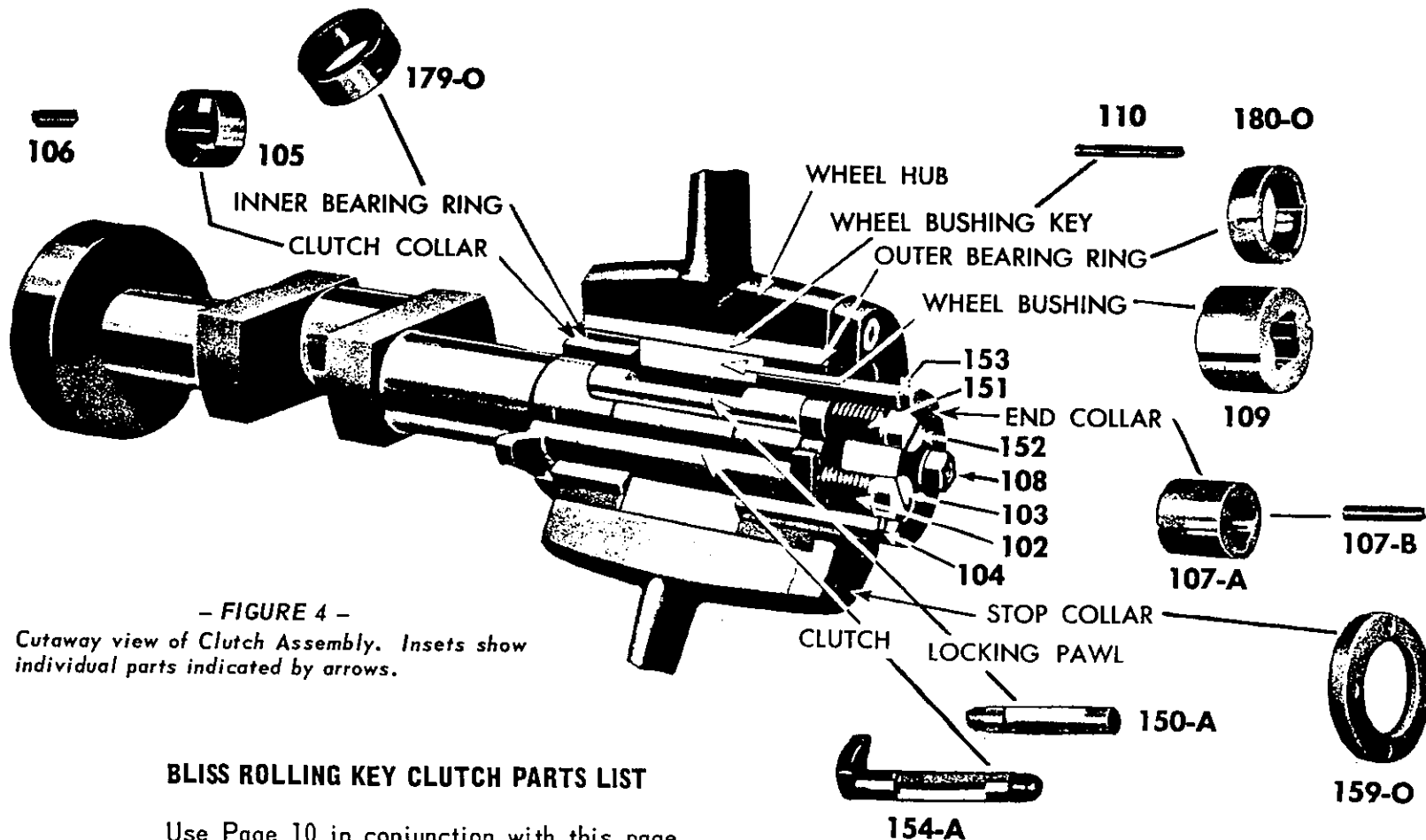


**TYPE ROLLING KEY CLUTCH**



**TYPE SINGLE TRIP LATCH BRACKET**





- FIGURE 4 -  
Cutaway view of Clutch Assembly. Insets show individual parts indicated by arrows.

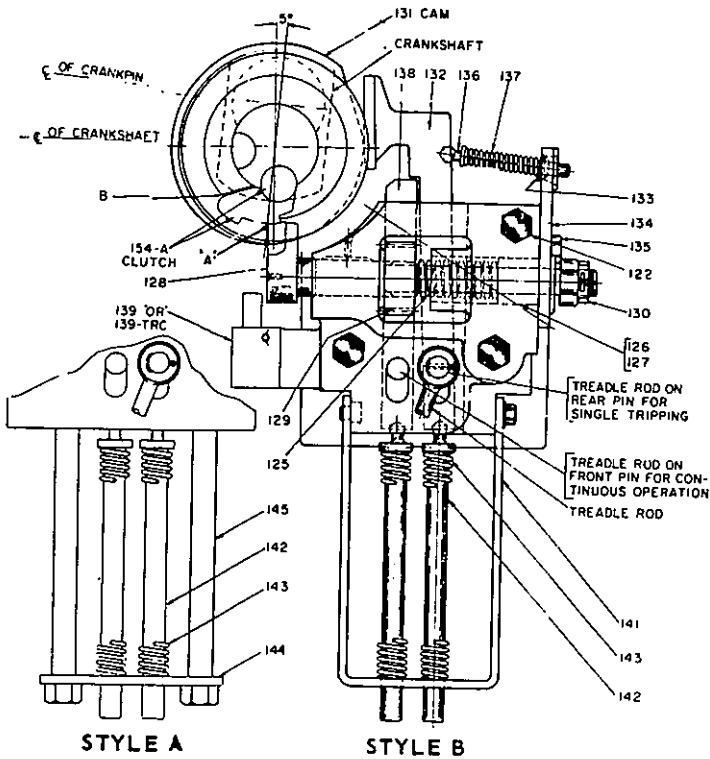
**BLISS ROLLING KEY CLUTCH PARTS LIST**

Use Page 10 in conjunction with this page for presses equipped with oil retaining bearing rings.

102	CLUTCH SPRING, RIGHT HAND WOUND, BLACK	150-A	FULL LENGTH LOCKING PAWL
103	CLUTCH SPRING PLUG	151	LOCKING PAWL SPRING, LEFT HAND WOUND
104	CLUTCH SPRING PLUG SCREW	152	LOCKING PAWL PLUG
105	CLUTCH COLLAR	153	LOCKING PAWL PLUG SCREWS
106	CLUTCH COLLAR KEY	154-A	COMBINATION CLUTCH
107-A	END COLLAR	159-O	STOP COLLAR
107-B	END COLLAR KEY	179-O	INNER BEARING RING
108	END COLLAR SCREW	179-A	INNER BEARING RING SCREWS
109	WHEEL BUSHING	180-O	OUTER BEARING RING
110	WHEEL BUSHING KEY		

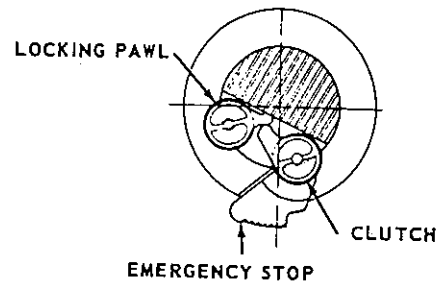
# BLISS ROLLING KEY CLUTCH

## SINGLE TRIPPING LATCH BRACKET



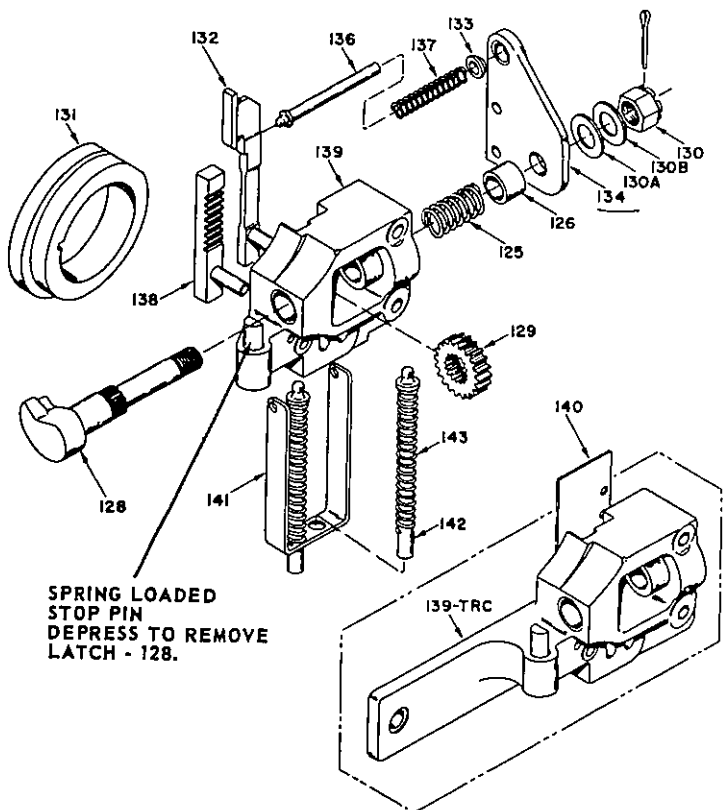
- FIGURE 5 -

The drawing illustrates at "A" the correct relation of the clutch hook and latch to each other after proper disengagement of the clutch has taken place. The crankpin of the crankshaft should stop approximately 5° back of top center under these circumstances. In the position shown the clutch head should not be locked tight but should have several thousandths clearance between the back of the head and the clutch collar and shaft. (See "B")



- FIGURE 6 -

Correct position of clutch and locking pawl in relation to each other.



- FIGURE 7 -

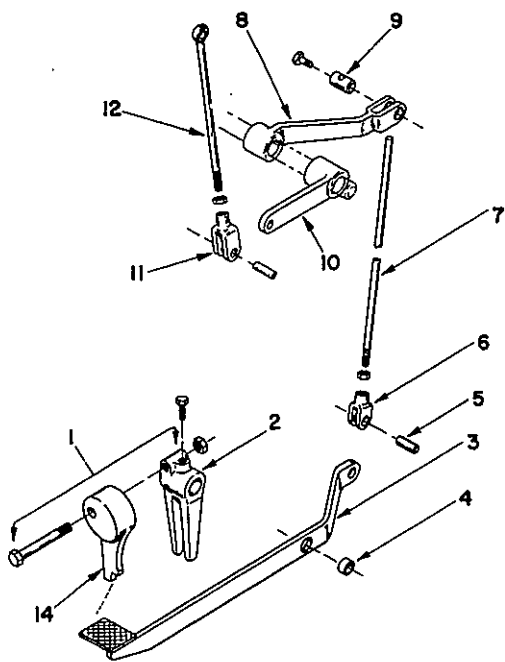
Parts for Single Tripping Latch Bracket.

### PARTS LIST FOR LATCH BRACKET

122	LATCH BRACKET SCREWS
125	LATCH BUFFER SPRING
126	LATCH BUSHING
128	LATCH
129	LATCH PINION
130	LATCH NUT
130A	NEOPRENE WASHER
130B	STEEL WASHER
131	THROWOUT CAM
132	TRIGGER
133	TRIGGER ENGAGING SPRING WASHER
134	END PLATE
135	END PLATE SCREW
136	TRIGGER ENGAGING SPRING PIN
137	TRIGGER ENGAGING SPRING
138	LATCH OPERATING RACK
139	SINGLE TRIP LATCH BRACKET WITHOUT TAIL
139-TRC	SINGLE TRIP LATCH BRACKET WITH TAIL
140	TRIGGER AND RACK RETAINING PLATE
141	BAIL
142	RETURN SPRING PINS
143	RETURN SPRINGS
144	RETURN SPRING YOKE
145	RETURN SPRING YOKE SCREW

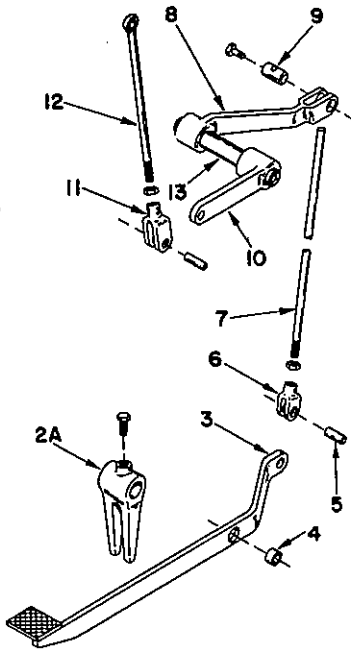
# BLISS ROLLING KEY CLUTCH

## FOOT TREADLES



- FIGURE 10 -

Treadle for Press with Releasing Brake.



- FIGURE 11 -

Treadle for Standard Press.

### PARTS LIST

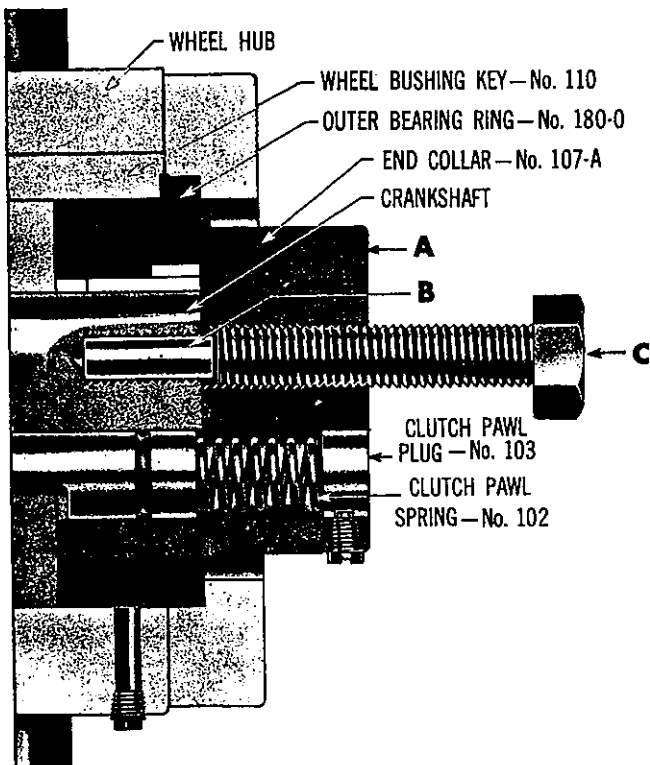
- |    |                       |
|----|-----------------------|
| 1  | TREADLE LOCK ASSEMBLY |
| 2  | TREADLE LOCK GUIDE    |
| 2A | TREADLE GUIDE         |
| 3  | TREADLE               |
| 4  | TREADLE BUSHING       |
| 5  | TREADLE FORK PIN      |
| 6  | TREADLE FORK          |
| 7  | LOWER TREADLE ROD     |
| 8  | INSIDE TREADLE LEVER  |
| 9  | TREADLE ROD CLAMP     |
| 10 | OUTSIDE LATCH LEVER   |
| 11 | LATCH ROD FORK        |
| 12 | LATCH ROD             |
| 13 | LATCH LEVER SWITCH    |
| 14 | TREADLE LOCK          |

### REMOVAL OF END COLLAR

#### WARNING - Support Gear or Flywheel.

1. Remove the end collar screw #108 and lockwasher from end collar. (See Figure 12.)
2. Insert a 3/8" diameter dowel (B) as a protector plug in the threaded hole in the end of crankshaft as shown.
3. Remove clutch and pawl plugs and springs.
4. Screw cap screw "C" in threaded hole of end collar until it contacts plug "B".
5. Continue turning cap screw until end collar has been removed from bushing.

**NOTE:** The threaded hole in the end collar is larger in diameter than the threaded hole in the crankshaft, thus acting as a clearance hole for the cap screw.



Plug "B" is to protect the thread in the hole in the end of the crankshaft. It should be of sufficient length to reach the bottom of the threaded hole and to extend 1/8" to 1/4" beyond the shaft end as shown.