INSTRUCTIONS

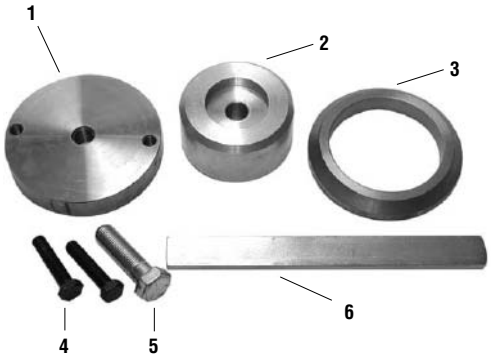
#577281 IBA Claw Rework Tool (complete)

This kit is designed to rework all models of IBA Top Unloading Claws, Bou-Matic Standard/Bou-Matic Standard Style Claws that use IBA Window Gasket (IBA code 946262) and IBA Window (IBA code 946263)

Claw Rework Tool (complete)

The Claw Rework Tool is intended to help reshape the above listed milking claws which have become damaged from repeated banging against concrete and curbs. This tool comes complete with the stainless steel bar punch (#577280).

 # 577281 ..... **Each**



Replacement Parts for Claw Rework Tool
(complete) #577281

	REF	IBA CODE	DESCRIPTION
REPLACEMENT PARTS	1	946270	Main block
	2	946271	Aluminum body
	3	946272	Push-off ring
	4	946273	5/16" x 1 1/2" Bolt - grade 8
	5	946274	1/2" x 3/4" Bolt
	6	577280	SS Bar punch claw tool

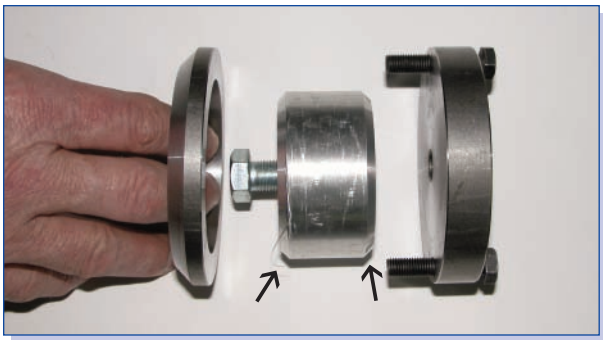


FIGURE 1.
Assemble the different components as shown in the picture of the Claw Reworking Tool.

NOTE: The Aluminum Body (2) that gets inserted inside the claw has a beveled edge on both sides. This is intended for reshaping claw barrels. With the aluminum material it is intended to take the abuse rather than use a harder material which would possibly remove some of the material in the claw when reworking claw barrels. The beveled end of the tool Push-Off Ring (3) must be facing the claw when in use and as noted in photo. Also, the Bolt (5) will fit into the center of the Main Block (1). Screw the Bolt into the center of the Main Block to secure the Aluminum Body tightly to the Main Block.

FIGURE 2.
The Stainless Steel Bar Punch Claw Tool (6) is used to start to reshape the bottom of the Claw Barrel, especially where the damage is severe and to the point where it would be difficult to insert the Aluminum Body (2). The more effort you make to get the opening in better condition using the Bar Punch Claw Tool the less wear and tear of the Aluminum Body, which correctly reshapes the round shape ID of the claw barrel for the proper insertion of window with gasket.

NOTE: One end of the Bar Punch Claw Tool is curved as noted with the arrow. This curvature is the same as the curvature of the barrel of the milking claw. Only this end should be used to reshape the barrel of the milking claw.

FIGURE 3.
Provide good support for the barrel of the milking claw and with the help of the Stainless Steel Bar Punch Claw Tool (2) and a hammer, carefully reshape the damaged area of the claw barrel.

FIGURE 4.
The Claw Rework Tool assembled and ready to be used. In this picture the tool is aligned with the milking claw in a way that it will be inserted for the purpose of reshaping the barrel of the claw.

FIGURE 5.
Carefully align the assembled Claw Rework Tool with the Claw Barrel. **Make sure that the Aluminum Body (2) is aligned straight with the Claw Barrel.** If not, it can prematurely damage the Aluminum Body. With the use of a hydraulic press, apply force to the Claw Rework Tool until the Aluminum Body slides into the Claw Barrel and stops at the interior window/gasket edge of the Claw Barrel.

FIGURE 6.
To remove the Claw Rework Tool, use the 2 Bolts (4) and a wrench and with clockwise movement of the wrench, continue to screw in the two bolts driving the Push-Off Ring (3) toward the Claw Barrel, forcing the Aluminum Body to be released from inside the Claw Barrel. You can now flip claw over and rework the other side or rework another claw.

Reworking your claws can extend the useful years and avoid premature replacement.