DOG REPAIR PROCEDURES
(APPLICATION: GENERALLY ALL DOG SETS)

1. TOOLS

   - Rubber Hammer
   - Hammer
   - Punch
   - 3/16" Alan Keys (some dogs)
   - Silicone (black for nylon dog handles)
   - Locktite 243
   - Utility Knife

2. HANDLE REMOVAL

In order to remove and replace your door dog handles, follow these steps, using the drawings for your respective dog set available online at www.theamtstore.com. Two examples are shown for the D250 Nylon Left and D150 Nylon Right in Section 4.

   a. Pin Removal - Use a punch to remove the 3/16" split pin from the outer dog handle.

   b. Outside Handle - Once the pin has been removed, unscrew the outer handle in a counter-clockwise direction until it is removed.

   c. Outside Solid Washer - Check if the outside solid washer is intact and not damaged. If it is, replace it with a new washer (see parts listing in Section 5). If the outer solid dog washer is attached to the door with urethane, DO NOT remove it. The seal is sufficient.

   d. Inner Handle - The inner dog handle can now be removed from the dog bushing along with the inside 1-hole washer. Assembly will consist of the handle, 1-hole washer and dog shaft that can be pulled out.

   e. 2-Hole Washer - The 2-hole dog washer that is attached to the inside sheet can be left in place.

   f. Disassemble the new Dog assembly. Refer to the diagrams in Section 4 if necessary or download the appropriate diagram for dog set from www.theamtstore.com.

3. HANDLE ASSEMBLY

   a. Insert the new dog complete with shaft through the center bushing, with the inside spacer on the dog shaft and the limiter pin is engaged in the hole in the dog spacer. Ensure that the dog turns 45° when installed in the 2-hole washer.

   b. Screw the outside handle on the shaft until it sits snug against the outer dog rosette. The split pin hole in the shaft should line up with the hole in the dog handle. Use a hammer to punch the split pin through the hole.

   c. Seal the split pin on both sides with black silicone.

4.   INSTALLATION DIAGRAM

Assemblies for dog sets are generally the same for most nylon and aluminum dog sets with some exceptions. Common differences include the thickness of the inside dog handle, aluminum 2-hole washer, thinner inner 1-hole washer, bushing length and shaft type.

There is no left and right handedness in the build of the dog handles. All left and right dog sets are exactly the same, with only an adjustment of the 2-hole washer at the time of installation. See Figure 1 and 2 for a D250 nylon left dog and a D150 aluminum right dog.

Although part numbers are listed, these are subject to change without notice. Ensure that you check www.theamtstore.com for updated information.
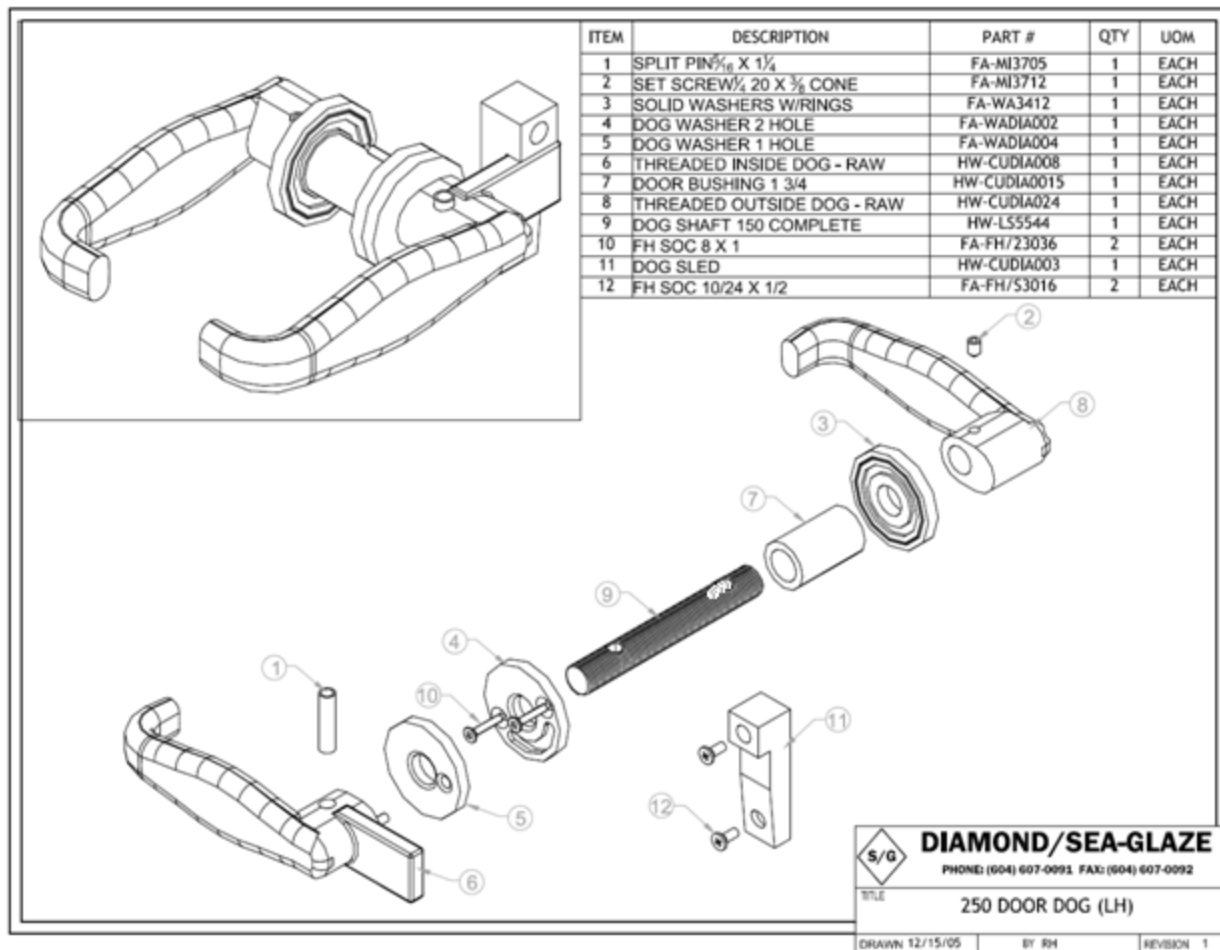

ITEM	DESCRIPTION	PART #	QTY	UOM
1	SPLIT PIN 3/16 X 1 1/4	FA-MI3705	1	EACH
2	SET SCREW 1/4 20 X 3/8 CONE	FA-MI3712	1	EACH
3	SOLID WASHERS W/RINGS	FA-WA3412	1	EACH
4	DOG WASHER 2 HOLE	FA-WADIA002	1	EACH
5	DOG WASHER 1 HOLE	FA-WADIA004	1	EACH
6	THREADED INSIDE DOG – RAW	HW-CUDIA008	1	EACH
7	DOOR BUSHING 1 3/4	HW-CUDIA0015	1	EACH
8	THREADED OUTSIDE DOG – RAW	HW-CUDIA024	1	EACH
9	DOG SHAFT 150 COMPLETE	HW-LS5544	1	EACH
10	FH SOC 8 X 1	FA-FH/23036	2	EACH
11	DOG SLED	HW-CUDIA003	1	EACH
12	FH SOC 10/24 X 1/2	FA-FH/S3016	2	EACH

DIAMOND/SEA-GLAZE
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TITLE
250 DOOR DOG (LH)
DRAWN 12/15/05   BY RH   REVISION 1

Figure 1: D250 Nylon Dog, Left Hand

ITEM	DESCRIPTION	PART #	QTY	UOM
1	SPLIT PIN⁵⁄₁₆ X 1¼	FA-MI3705	1	EACH
2	SET SCREW¼ 20 X ⅜ CONE	FA-MI3712	1	EACH
3	SOLID WASHERS W/RINGS	FA-WA3412	1	EACH
4	DOG WASHER 2 HOLE	FA-WADIA002	1	EACH
5	DOG WASHER 1 HOLE	FA-WADIA004	1	EACH
6	ALUMINUM INSIDE DOG (RAW)	HW-LS5526	1	EACH
	DSG LABOUR MACHINE SHOP	SV-LB400	1	EACH
7	DOOR BUSHING 1 7/16	HW-CUDIA0016	1	EACH
8	ALUMINUM OUTSIDE DOG (RAW)	HW-LS5527	1	EACH
	DSG LABOUR MACHINE SHOP	SV-LB400	1	EACH
9	DOG SHAFT 150 COMPLETE	HW-LS6019	1	EACH
10	DOG SLED	HW-CUDIA003	1	EACH

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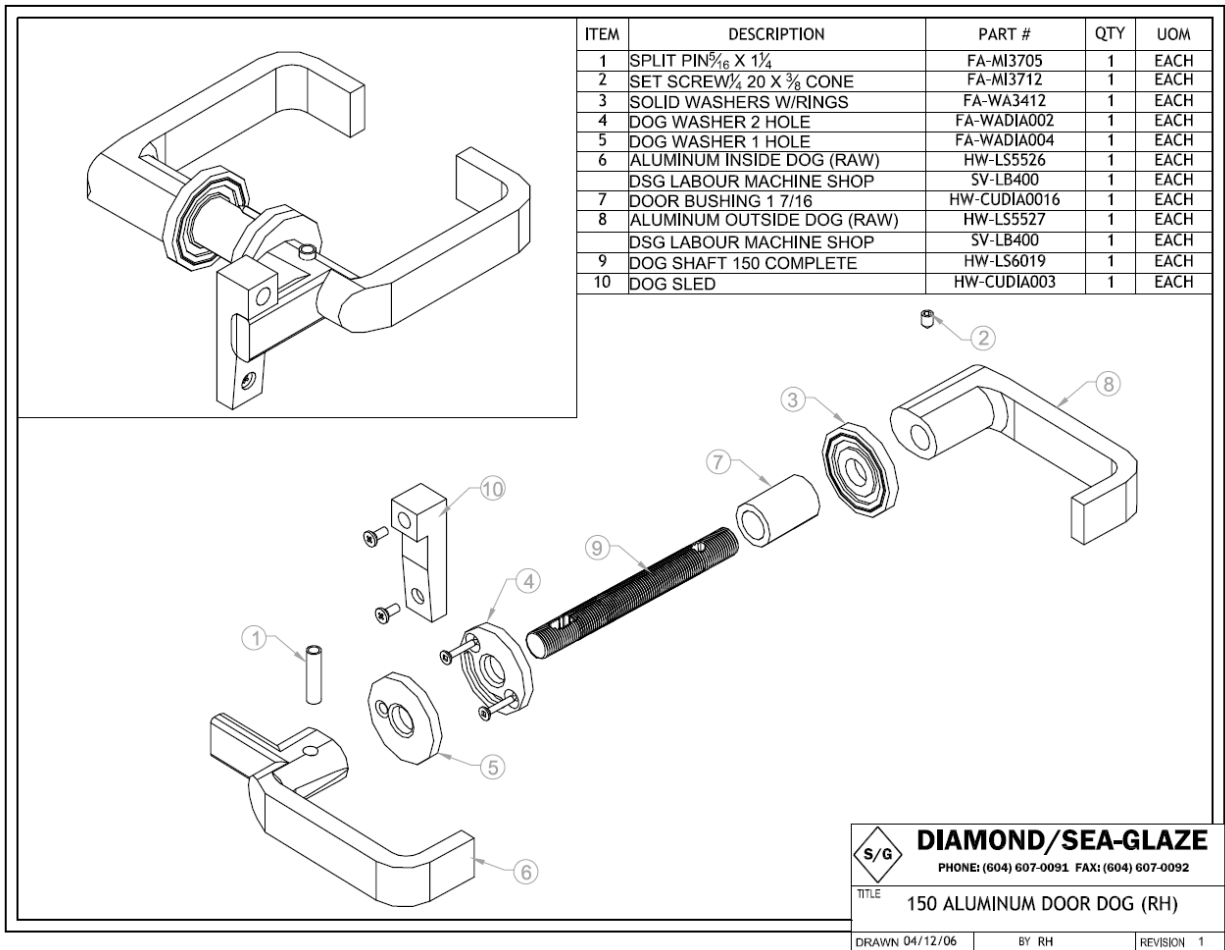TITLE: 150 ALUMINUM DOOR DOG (RH)
DRAWN 04/12/06   BY RH   REVISION 1

Figure 2: D150 Aluminum Dog, Right Hand

5. MAINTENANCE AND REPLACEMENT PARTS

Nylon dogs do not have replacements parts since it is easier and more cost effective to replace the entire nylon dog set. Although, some parts are available since they are common between aluminum and nylon dogs.

Parts and handles are available for all aluminum dog sets.

Check the compatibility listings as well as all the dog handle parts at www.theamtstore.com.

6.   PARTS LIST

D150 Series: Standard Dog Handle Parts and Sets

Description	Part Number	Notes / Checked
Dog Set, Nylon 6/6, Black, D150 Series (Default and Standard)	HW-LS5523	
Dog Set, Buffed Aluminum, D150 Series	HW-LS5598	
Dog Set, Milled Aluminum, D150 Series	HW-LS5530	
Dog Set, Polished Aluminum, D150 Series	HW-LS5602	
Dog Set, Painted Aluminum, D150 Series	HW-LS5600	*Custom finish option, see color chart.*

D250 Series: Standard Dog Handle Parts and Sets

Description	Part Number	Notes / Checked
Dog Set, Nylon 6/6, Black, D250/D575 Series (Default and Standard)	HW-LS5524	
Dog Set, Buffed Aluminum, D250 Series	HW-LS5528	
Dog Set, Milled Aluminum, D250 Series	HW-LS5606	
Dog Set, Polished Aluminum, D250 Series	HW-LS5618	
Dog Set, Painted Aluminum, D250 Series	HW-LS5612	*Custom finish option, see color chart.*

D575 Series: Standard Dog Handle Parts and Sets

Description	Part Number	Notes / Checked
Dog Set, Nylon 6/6, Black, D575 Series (Default and Standard)	HW-LS5524	*Note: Same as D250*
Dog Set, Buffed Aluminum, D575 Series	HW-LS5638	
Dog Set, Milled Aluminum, D575 Series	HW-LS5596	
Dog Set, Polished Aluminum, D575 Series	HW-LS5640	
Dog Set, Painted Aluminum, D575 Series	HW-LS5639	*Custom finish option, see color chart.*

Exterior Handle Replacement

Description	Part Number	Notes / Checked
Dog Handle Only, Exterior, Nylon 6/6, Black	HW-CUDIA024	*Fits all D150, D200, D250, D575 doors.*
Dog Handle Only, Exterior, Buffed Aluminum	HW-LS5552	
Dog Handle Only, Exterior, Milled Aluminum	HW-LS5943	
Dog Handle Only, Exterior, Polished Aluminum	HW-LS6044	
Dog Handle Only, Exterior, Painted Aluminum	Custom Request	*Custom finish option, see color chart.*

Interior Handle Replacement
There is a vast array of interior handles, please check online to determine your handle requirements.

Description	Part Number	Notes / Checked
Check at www.theamtstore.com		

Miscellaneous Parts

Description	Part Number	Notes / Checked
Split Pin, 1/8" x 1", Attaches Exterior Handle to Shaft	FA-MI3706	
Dog Sled Kit, All Dogs & Blind Dogs	HW-CUDIA003	
Washer, Nylon, 1 Hole, Black	FA-WADIA004	
Washer, Nylon, 2 Hole, c/w 2 @ 8x1 FH-S, Black	FA-WADIA002	
Washer, Solid Nylon, With 2 Rings ("O"), Black	FA-WA3412	