

CM Base Modification for New Frame Stands

This procedure is highly recommended to be performed by KLOPP technicians at our manufacturing facility.

This procedure requires the use of an end mill or drill press, with a counter bore. You CANNOT perform this modification with a handheld drill.

It is vitally important to verify all specified dimensions to avoid damaging the Base (for example by drilling through the bottom). You must also secure the Base so that it does not move during the drilling process, which can also damage the Base. The cost of a new Base is \$91.75*, and new frame stands are \$9.00 each*.

The next page is an engineering diagram with the specific depths and dimensions.

*Price as of April 2019. Prices subject to change without notice.

CM BASE MODIFICATION FOR NEW FRAME STANDS

In a drill press or milling machine use a counter bore with a pilot diameter of .220" and a body diameter of .330", to increase the depth of the pocket in which the Frame Stand seats, to .940" as shown in the drawing below. Secure the base firmly while drilling, to avoid lifting which could cause the counter bore to pull through the bottom of the base which would make your base unuseable.

