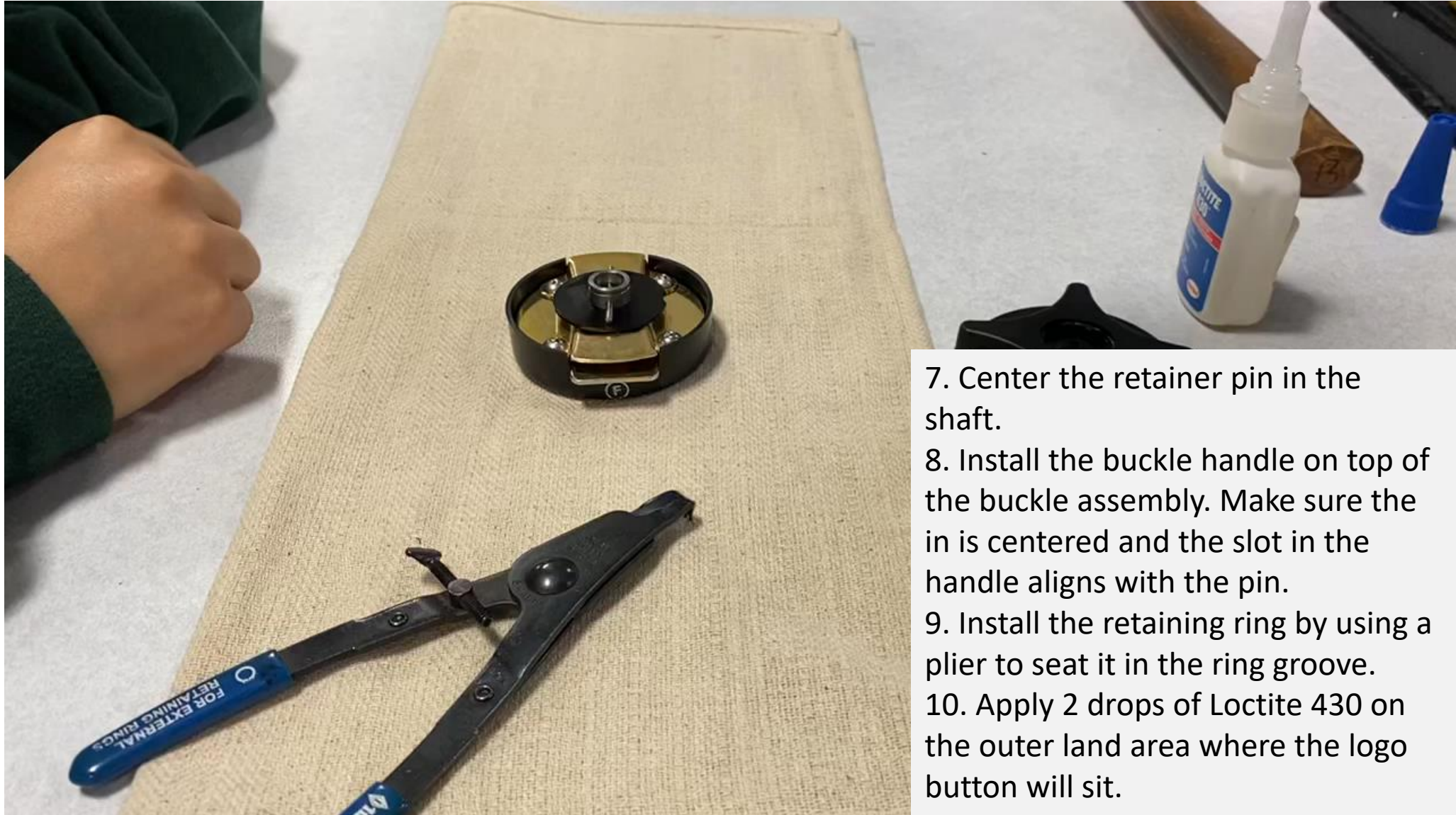


1. Pry the logo button free from the buckle. Pierce the middle of the button and try to damage the button as little as possible so that it can be used again.
2. Use an external retaining ring pliers to remove the retaining ring.
3. Examine the four screws to determine the head type.
4. If the screws are Torx head type, use a T15 Torx bit to remove one screw and replace with a new Hex head screw using a 3/32" hex drive bit.
5. Torque the screw to 15 to 25 in-lbs.
6. Repeat this step for each of the four screws.



7. Center the retainer pin in the shaft.

8. Install the buckle handle on top of the buckle assembly. Make sure the pin is centered and the slot in the handle aligns with the pin.

9. Install the retaining ring by using a plier to seat it in the ring groove.

10. Apply 2 drops of Loctite 430 on the outer land area where the logo button will sit.





11. Put the buckle in an arbor press. Put the logo button on the center of the buckle.

12. Hold a 7/16" (11 mm) socket in place on the button. Use arbor press or equivalent tool to press the button in place on the buckle.



13. Rotate the buckle handle fully clockwise and release. Make sure the handle should freely self-center.

14. Repeat in the counter-clockwise direction. Repeat alternating directions for a total of 3 times minimum in each direction.

15. Insert a belt clip and shake the unit. Make sure the belt clip stays in the buckle and does not fall out.

16. Hold the buckle up so that the clip is vertical. Rotate the buckle clockwise to allow the clip to release.

18. Repeat releasing the belt clip by rotating the handle counter-clockwise