

Required tools

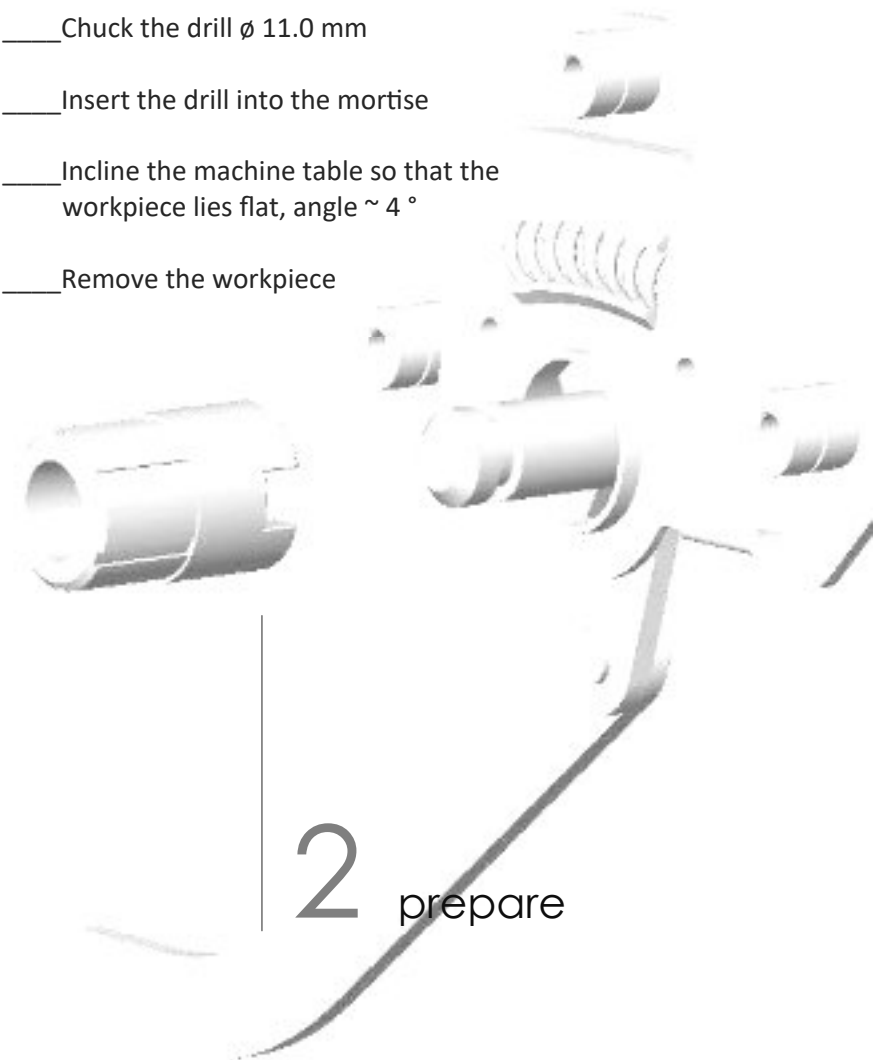
- ___ Drill press, hand drill
- ___ Drill sizes \varnothing 11.0, 18.0 and 2.2 mm
- ___ Hacksaw for metal
- ___ Hardwood underlay
- ___ Splint driver \varnothing 2.0 mm
- ___ Slotted head screwdriver
- ___ Wrench file and finishing file
- ___ Instant adhesive, gel (Cyanoacrylate)

Removing the door lever

- ___ Push the dowel pin out of the hole
- ___ Pull off the lever and unscrew the handle

Set up the drill

- ___ Chuck the drill \varnothing 11.0 mm
- ___ Insert the drill into the mortise
- ___ Incline the machine table so that the workpiece lies flat, angle $\sim 4^\circ$
- ___ Remove the workpiece

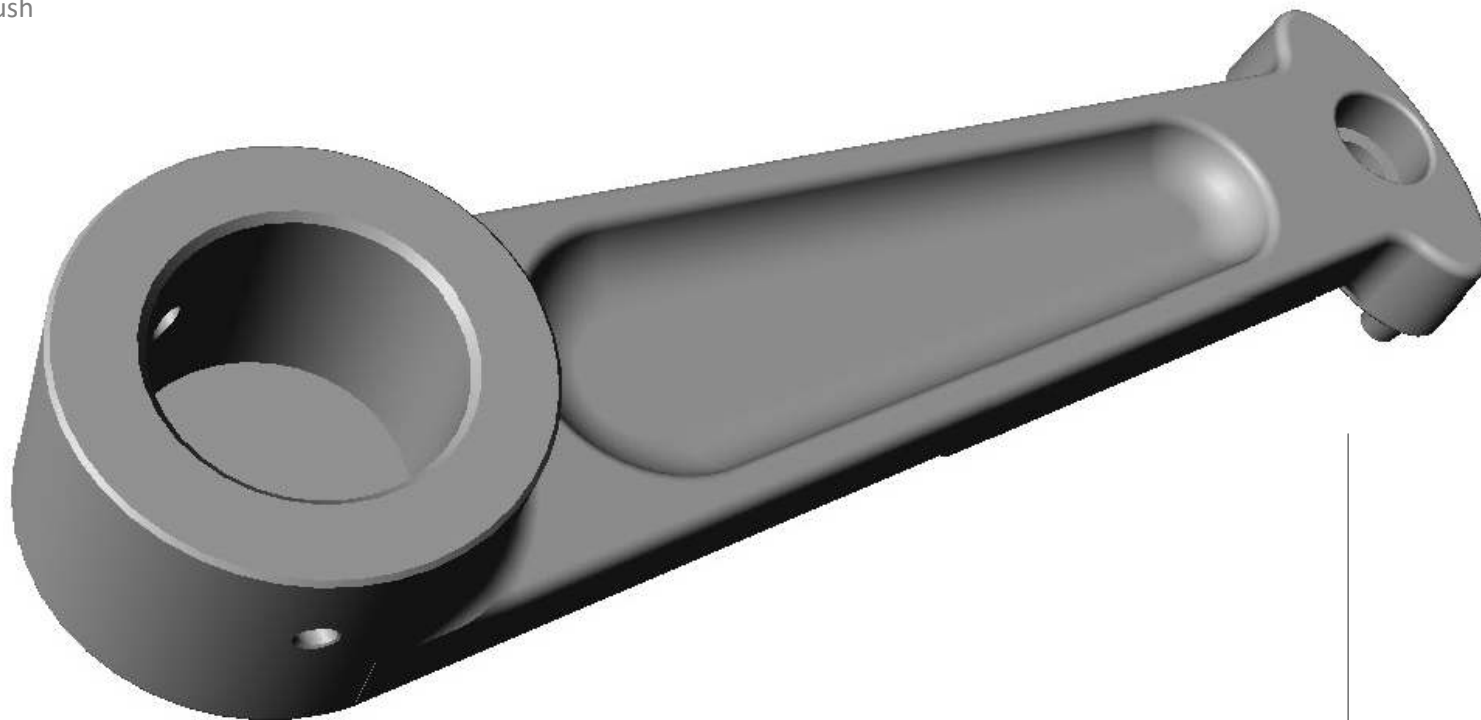


____cut off the damaged tenons

tighten the lever with wooden shims

cut off protruding tenons

file flush



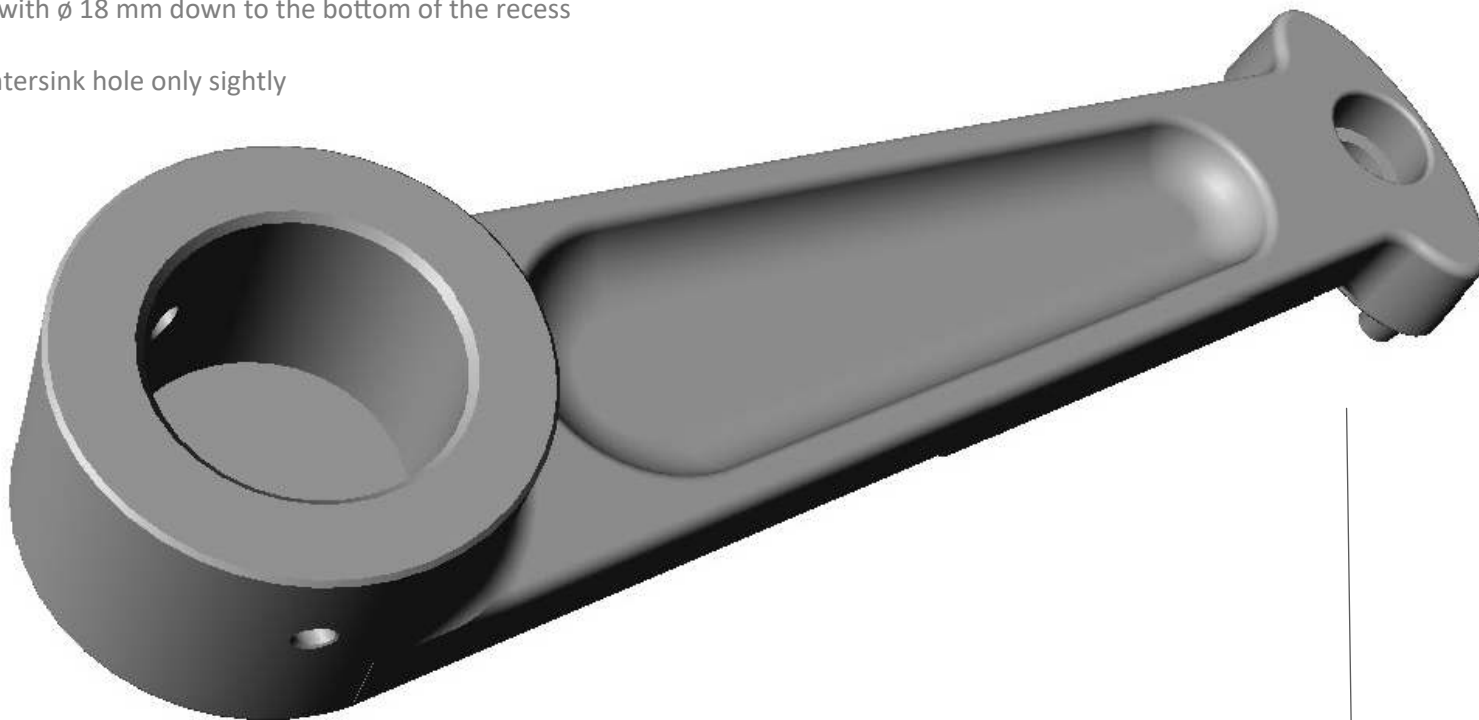
____ Bore out the peg hole

clamp the lever on the inclined machine table

use allowance to protect the surface

drill with $\varnothing 18$ mm down to the bottom of the recess

countersink hole only sightly



____ Making a repair bushing from Polyamide

The bushing is manufactured from Polyamide/Nylon PA12 using the 3D printing process.

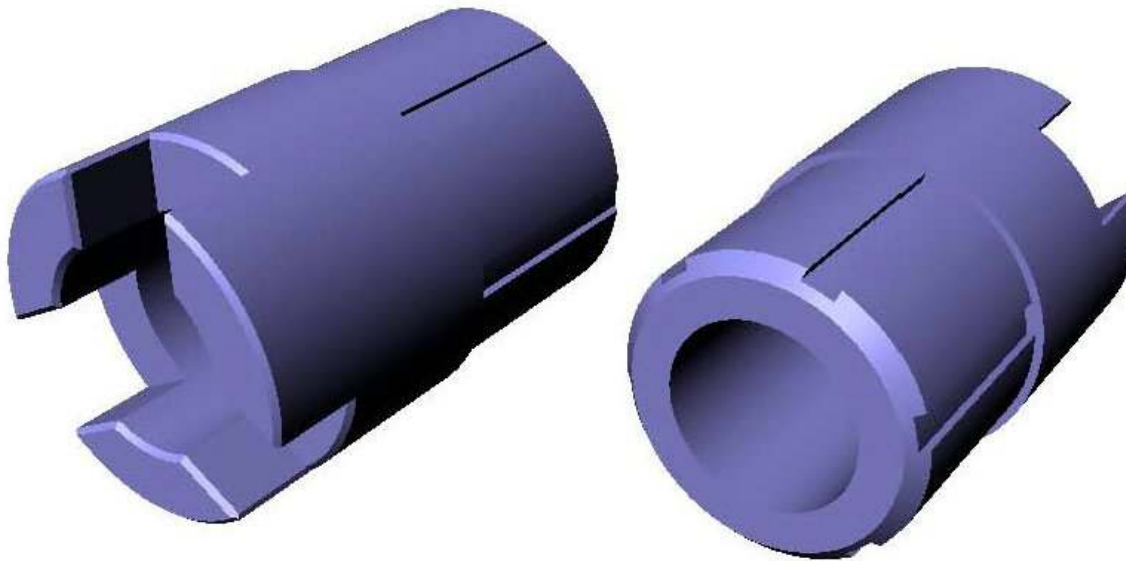
The 3D file in STL format [p1800_doorlever_socket_fix.stl](#)

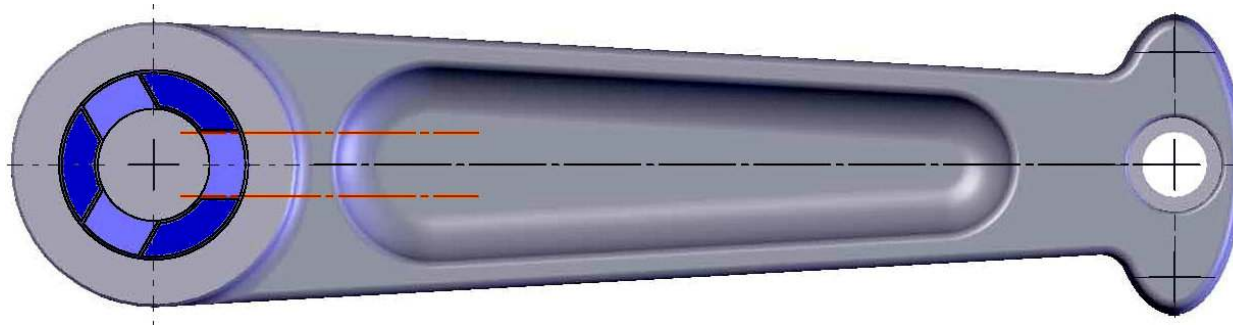
can be downloaded here <https://www.v18000.org>

Upload this file to an online 3D production center.

For example <https://www.sculpteo.com>

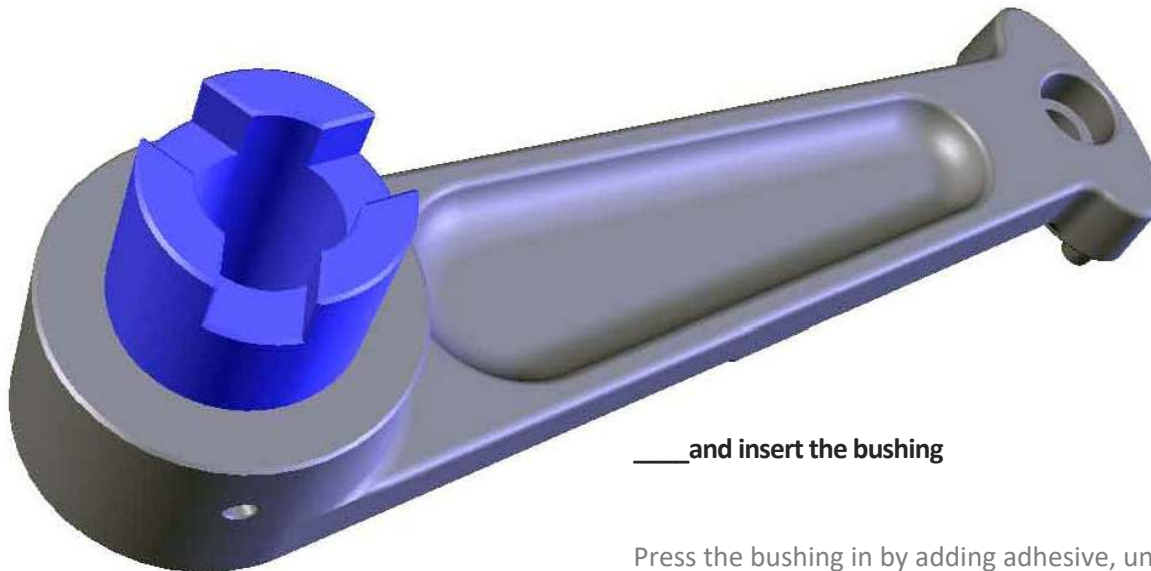
Select Polyamide/Nylon PA12 as printing material and enter the desired quantity. The quote is displayed immediately.





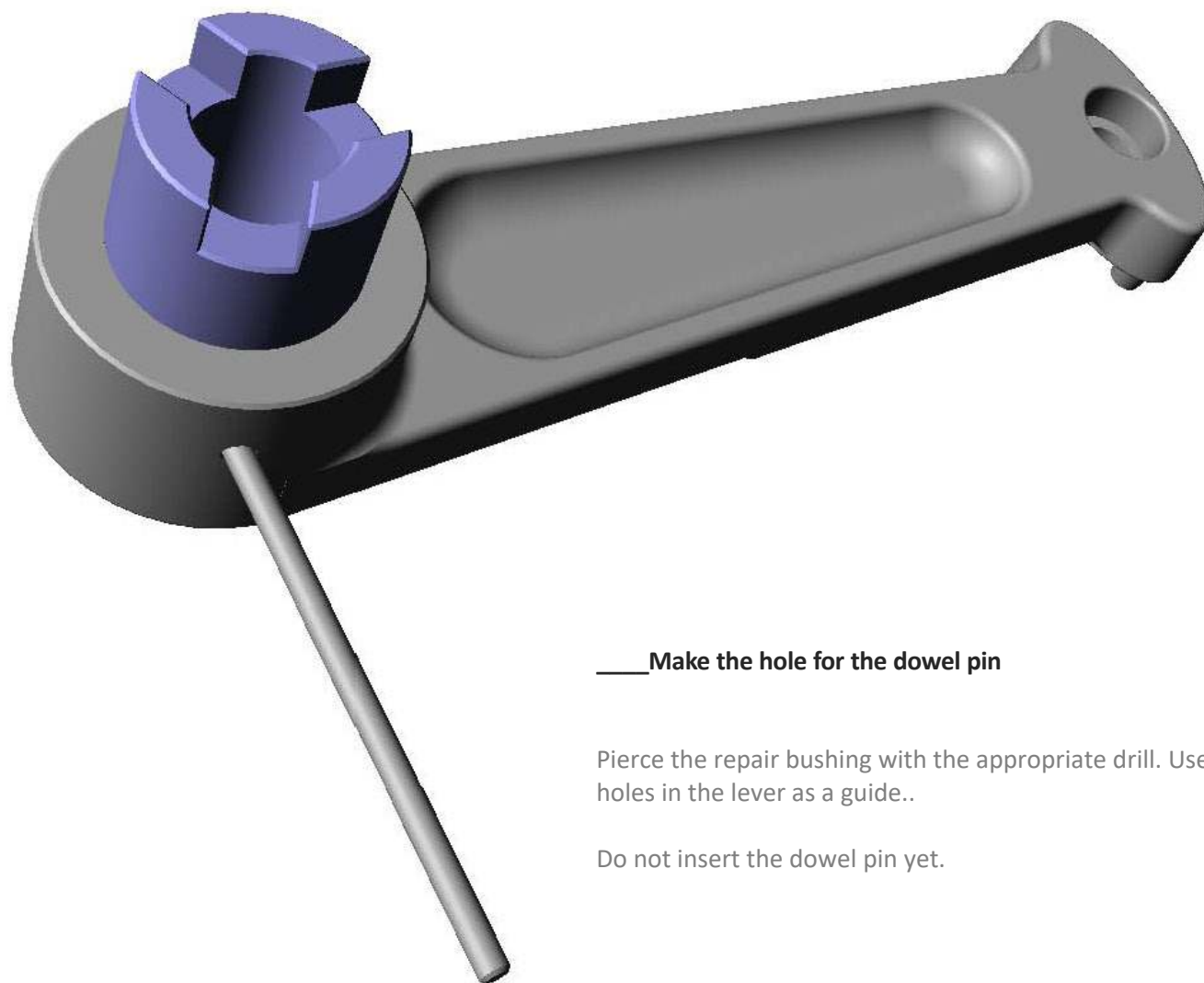
___ Align the repair bushing ...

Place the bushing on the hole so that the flanks of the right recess run parallel to the longitudinal axis of the lever.



___ and insert the bushing

Press the bushing in by adding adhesive, until the step of the pin rests on the lever.



____ **Make the hole for the dowel pin**

Pierce the repair bushing with the appropriate drill. Use the holes in the lever as a guide..

Do not insert the dowel pin yet.

____ **Mounting the door lever**

First check that the repair bushing fits properly into the fitting on the door side.

It may be necessary to rework the sprong flanks with a key file.

Then screw on the handle and cap.

Fit the complete door lever in the correct position and drive in the dowel pin.

Artwork: Lutz Reeg © 08_2021
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