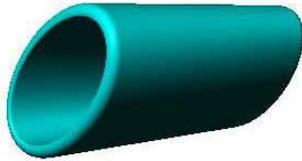
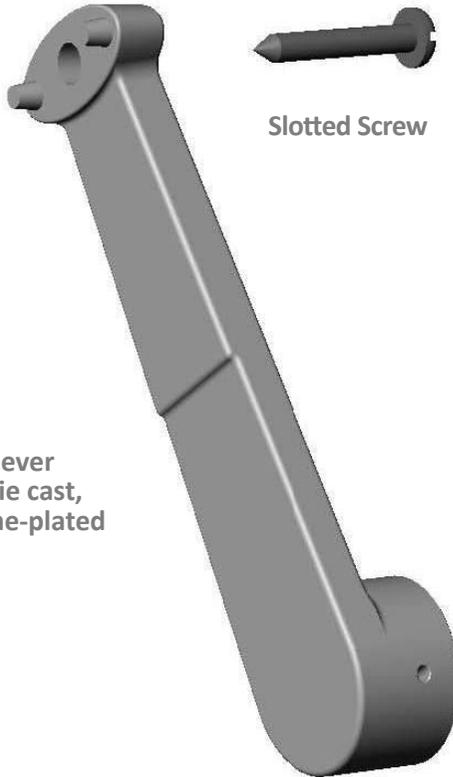




Cap
Plastic or cast iron,
chrome-plated



Handle
Plastic or cast iron,
chrome-plated



Door lever
Zinc die cast,
chrome-plated



Slotted Screw

Clamping pin \varnothing 2.2 mm

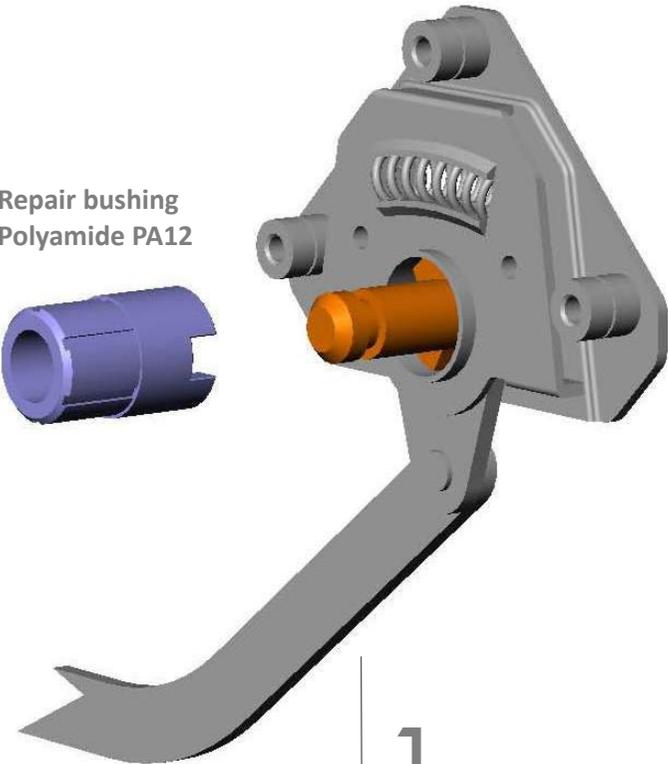


Repair bushing
Polyamide PA12

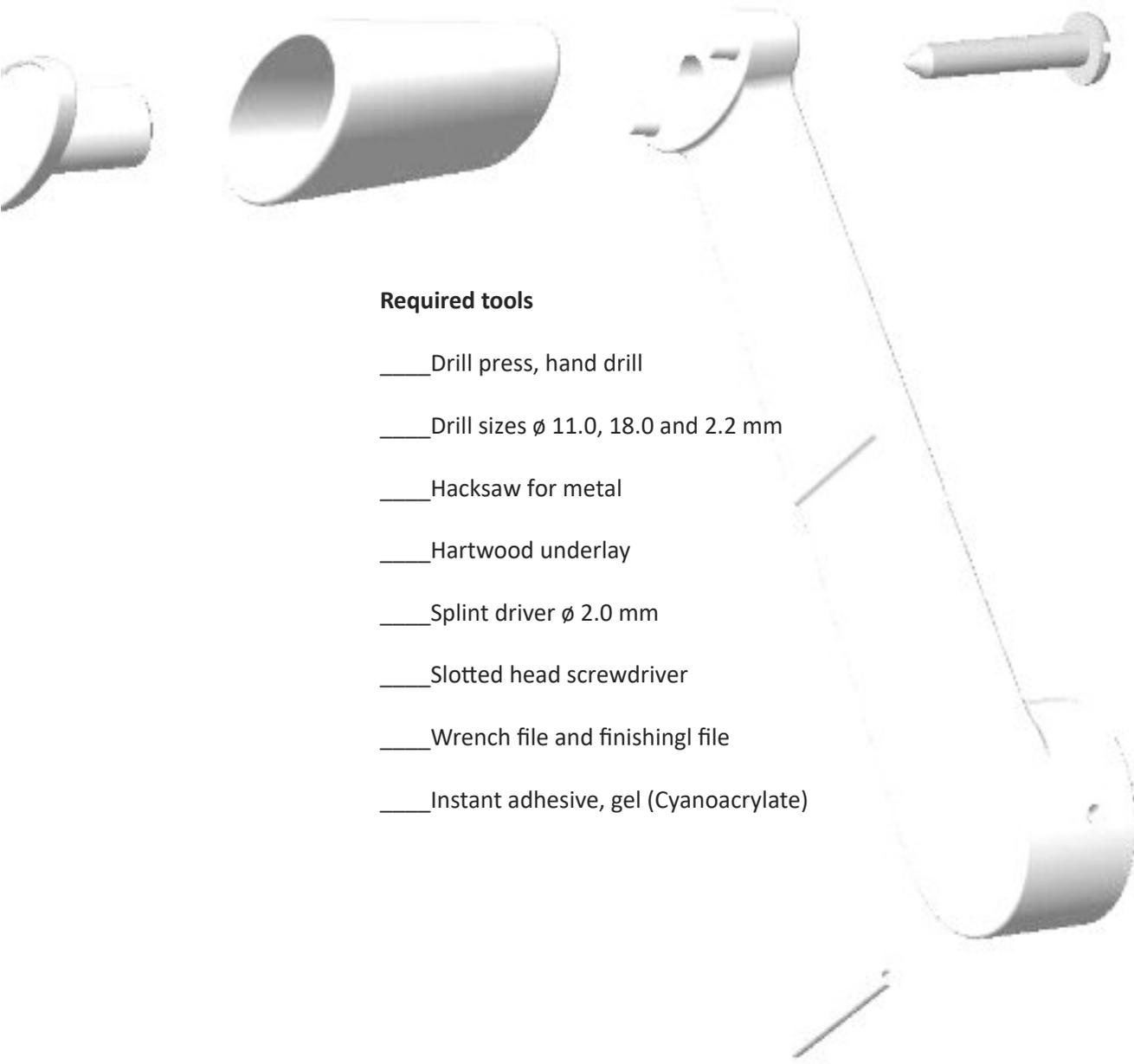


Fitting mounted on door side

Fixed bolt with spring-loaded
handle nut (orange)



1 Parts



Required tools

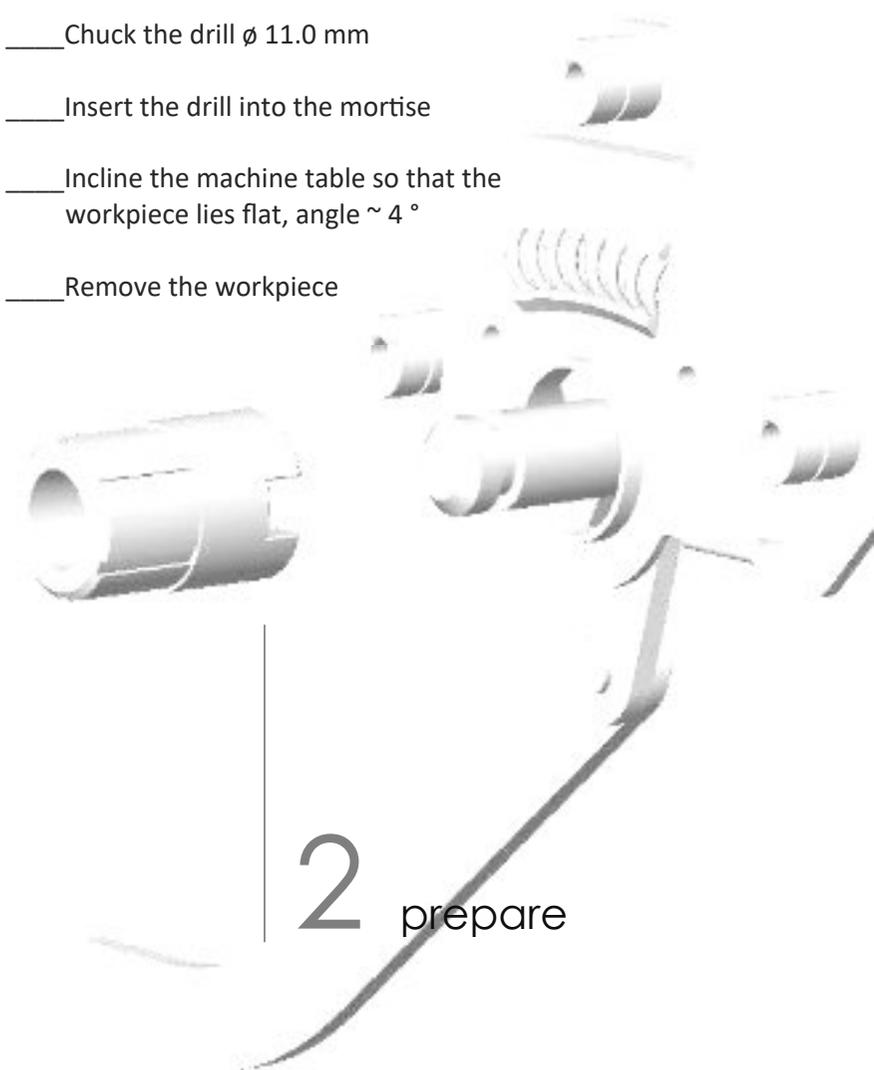
- ___ Drill press, hand drill
- ___ Drill sizes \varnothing 11.0, 18.0 and 2.2 mm
- ___ Hacksaw for metal
- ___ Hartwood underlay
- ___ Splint driver \varnothing 2.0 mm
- ___ Slotted head screwdriver
- ___ Wrench file and finishingl file
- ___ Instant adhesive, gel (Cyanoacrylate)

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

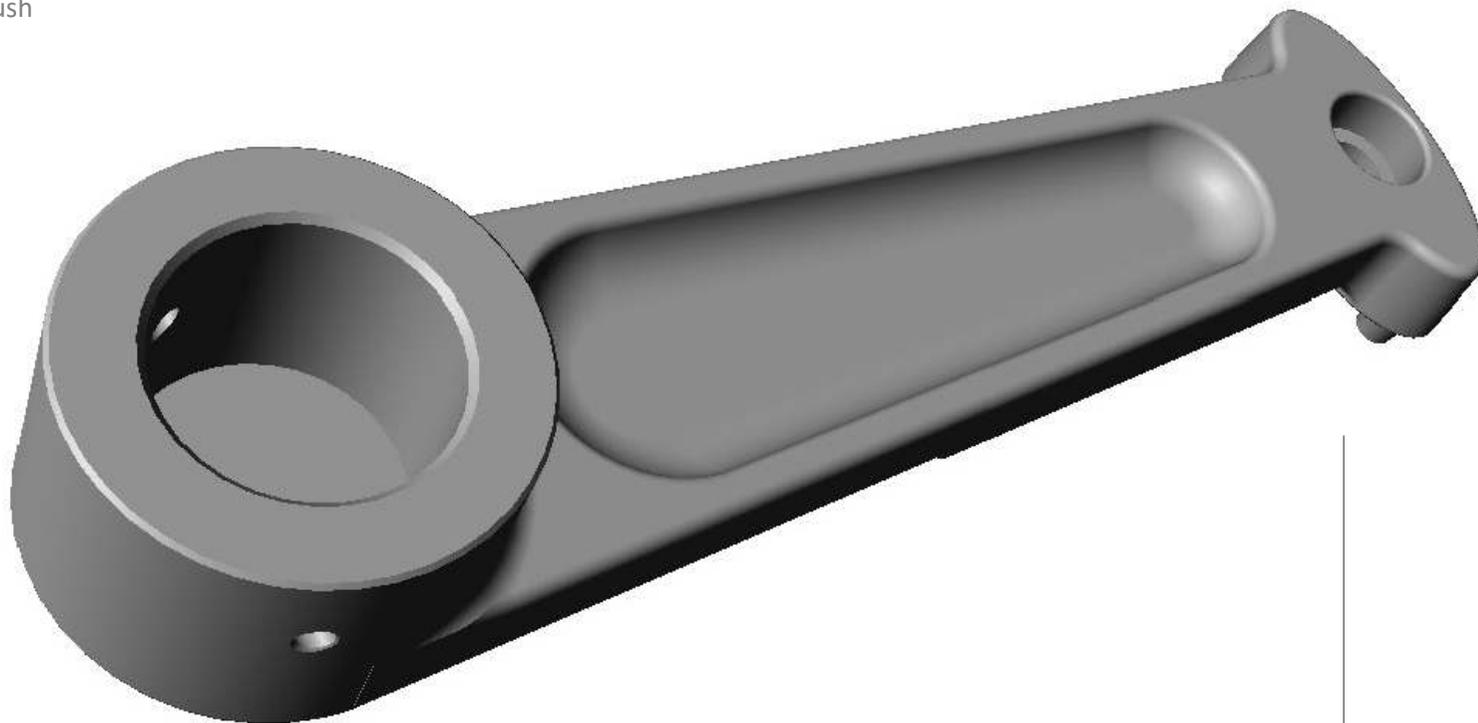


____ **cut off the damaged tenons**

tighten the lever with wooden shims

cut off protruding tenons

file flush



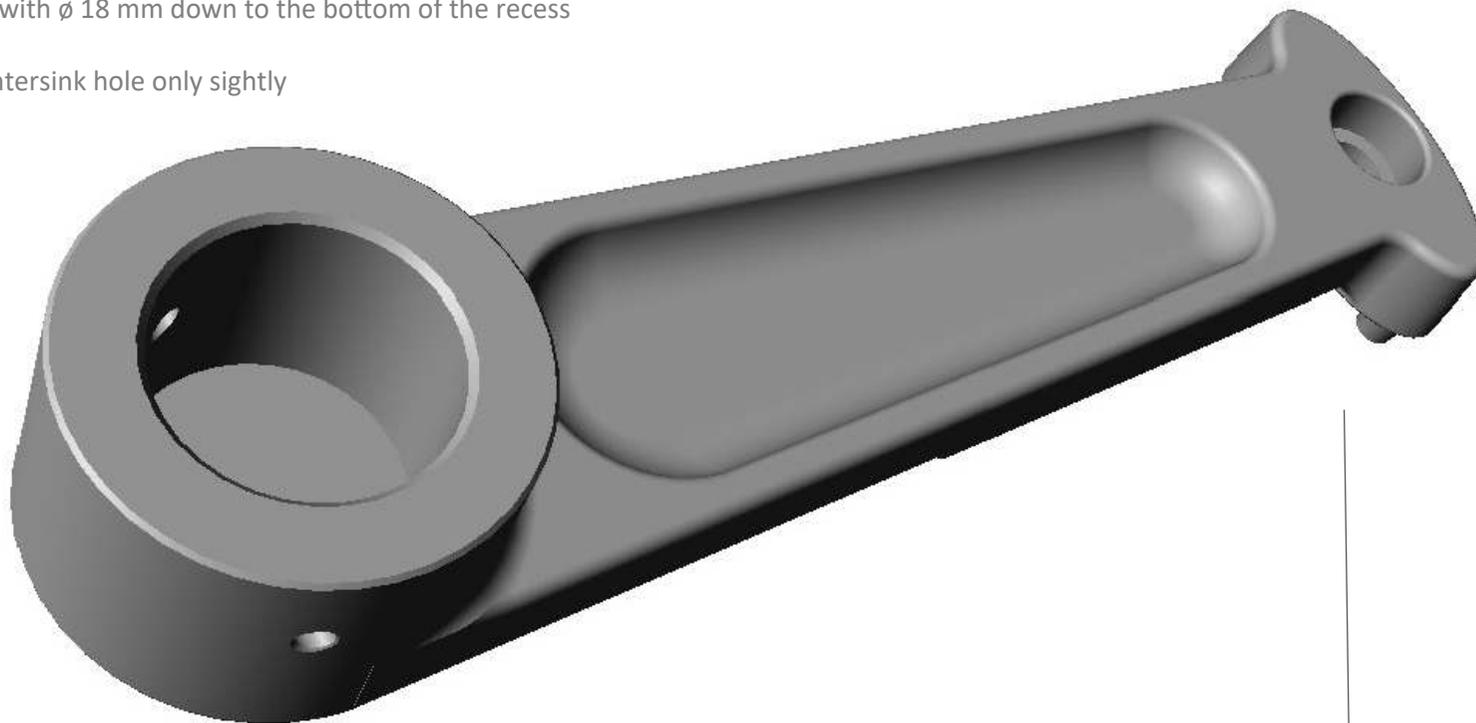
___ Bore out the peg hole

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.

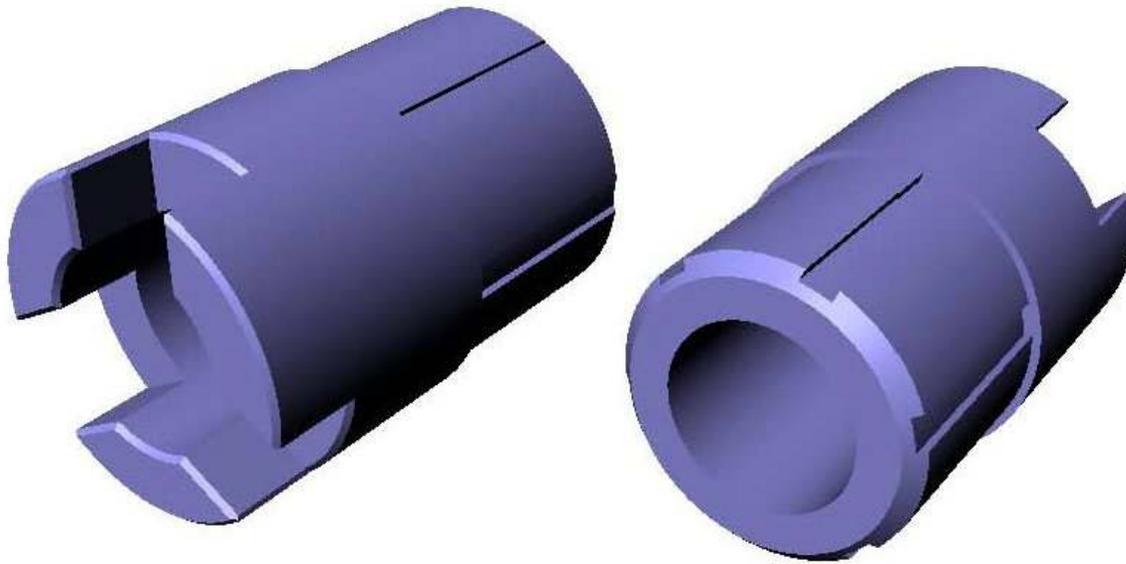
The 3D file in STL format [p1800_doorlever_socket_fix.stl](#)

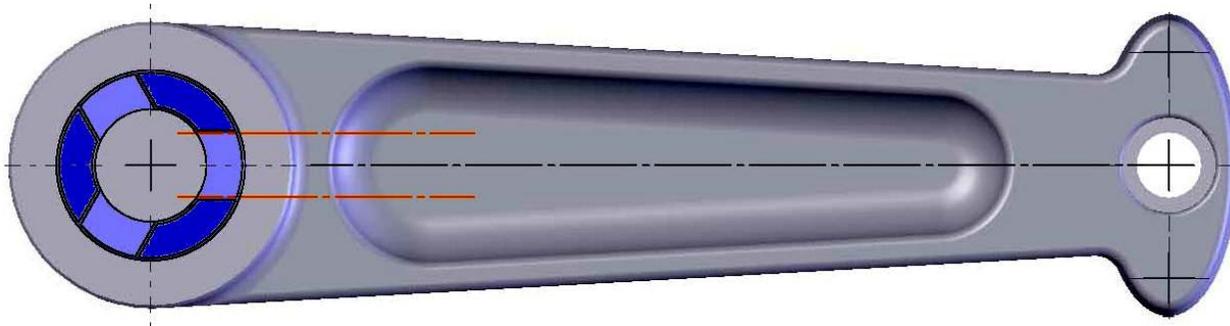
can be downloaded here <https://www.v18000.org>

Upload this file to an online 3D production center.

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

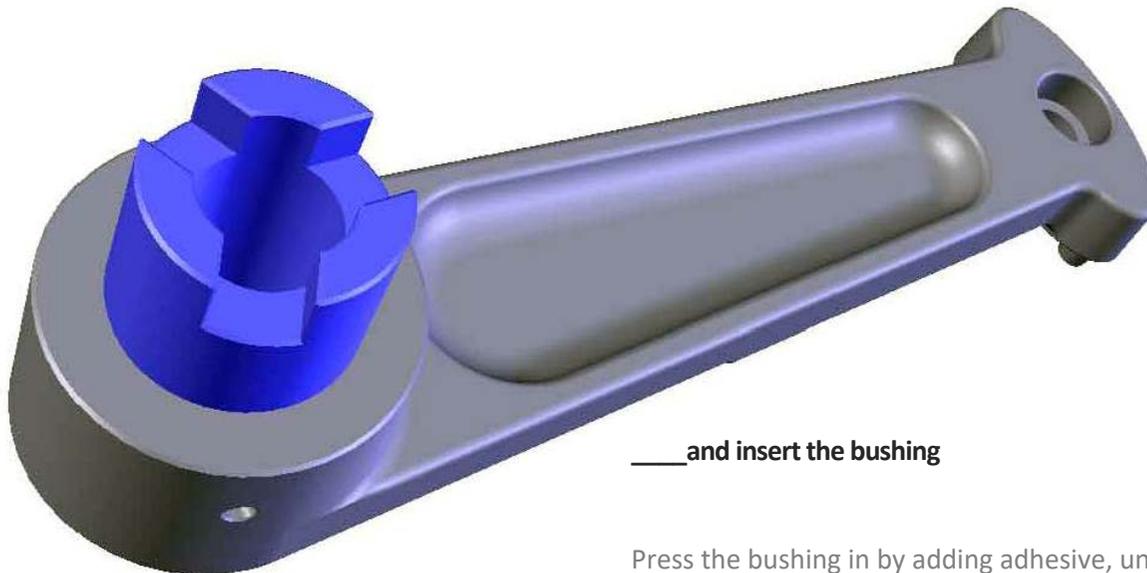
Select Polyamide/Nylon PA12 as printing material and enter the desired quantity. The quote is displayed immediately.





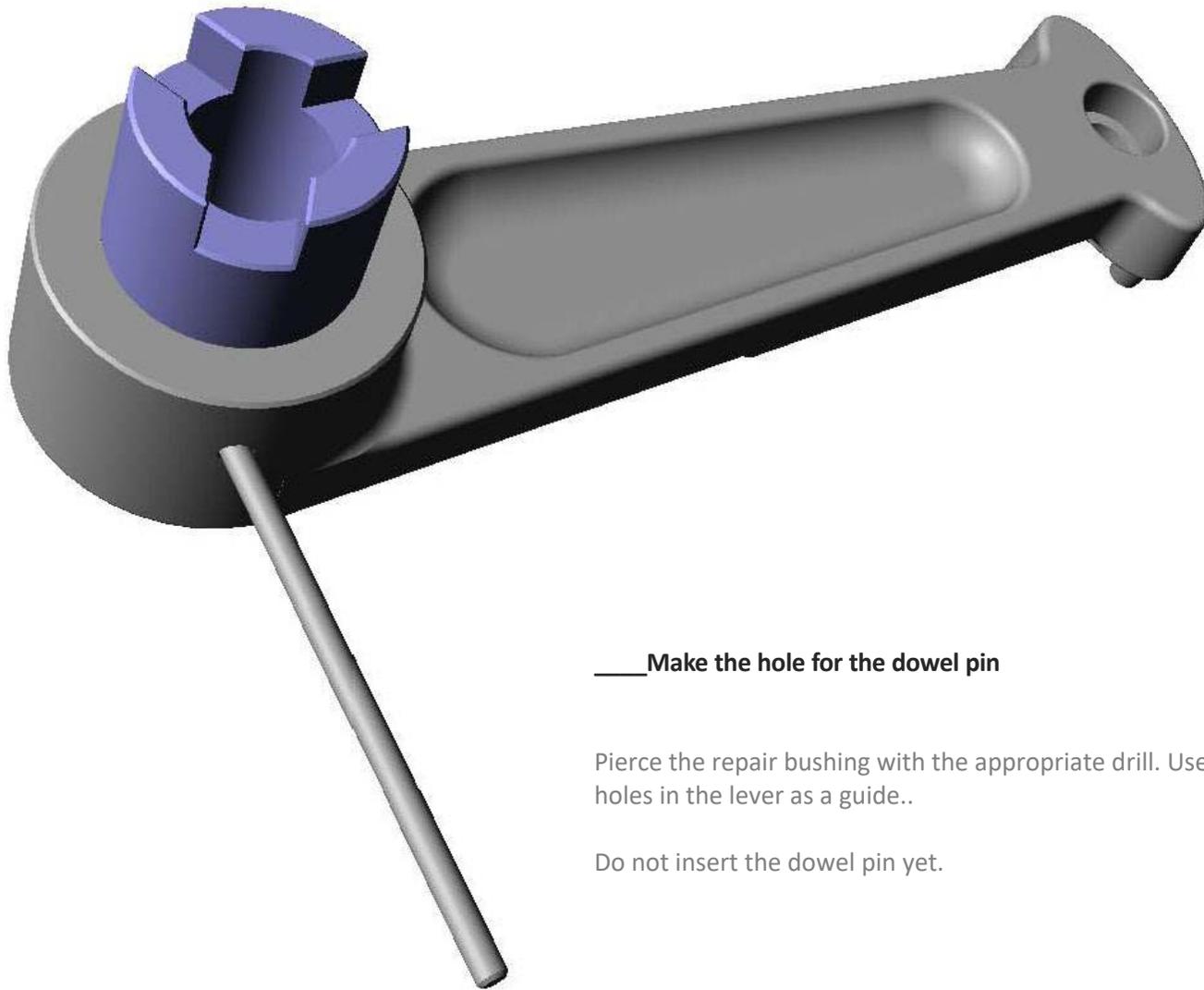
___ **Align the repair bushing ...**

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

Translation: Harry Hope © 08_2021

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V 1.1

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