

MAGNETIC CAST CONTROL TUTORIAL



Classic Multiplier Design

Stainless steel and graphite
construction -

2.

MAGNETIC CAST CONTROL UPGRADE TUTORIAL

NB

Follow instructional
through to the end
before attempting
the upgrade.

Okuma Convector CV 45 CS



YOU WILL NEED THE FOLLOWING TOOLS:

Before MCC upgrade

3

HANDHELD DRILL

4MM DRILL BIT - MAG BOLT HOLE

8MM DRILL BIT- SIDE PLATE HOLE

7MM DRILL BIT - outer sleeve hole

Tap and dye set or

5mm hardened steel bolt to cut thread , MANUALLY

8mm hardened steel bolt to cut thread

Large screw driver to turn 5mm bolt

Spanner to turn 8mm bolt to cut thread

Cutting paste or oil helps alot when threading

Hacksaw or grinder with thin blade to cut round bar

40 GRIT SANDPAPER.

GAFFER TAPE - OPTIONAL

PRATLEY - GREY METAL TWO PART

PERMANENT MARKER



4.

Sideplate View Prior to Upgrade



Magnetic cast control
position.
Close to thumb control.

After Upgrade - Mags On full.
Turned In.



- STEP BY STEP TUTORIAL
- FOR THE DIY ANGLER
- STANDARD TOOLS USED
- No Engineering experience needed.

Modifications will differ between models.
This instructional should give you the basic idea about
magnetic brake systems and how to
manufacture them.
Aswell as install them in the larger multipliers.

**Basic assembled
MCC.**



After Magnetic cast control upgrade.

8.



9.

START

Remove left sideplate from multiplier intended for upgrade.

Remove grease from inside sideplate. Engine degreaser
Plate must be dry and clean



10.

Clean and degreased internals of sideplate.
Not much space to choose a MCC location.

8 o'clock position looks fairly clear..





FOR MORE ACURATE MEASUREMENTS TAKE FURTHER READINGS AND OBSERVATIONS.

Confirm measurement against the spool, the magnet must be in the centred in the between the spool lips to avoid any abrasion when adjusting.

The more you measure and recheck the less likely you will be to make a mistake.

12.

Make a permanent mark on spool to show position.



Mark the position you wish to drill with a permanent marker.

Make sure that the outside of the sideplate is free from obstructions ie.

13.

- Double check position.

Stainless Bumper
Rings.



YOU DONT WANT TO
DRILL THROUGH AND FIND YOU
ARE UNDER THE BASH RING OR
OUT OF POSITION.

Choose a position to drill an 8mm hole through the plate to accommodate the MCC.

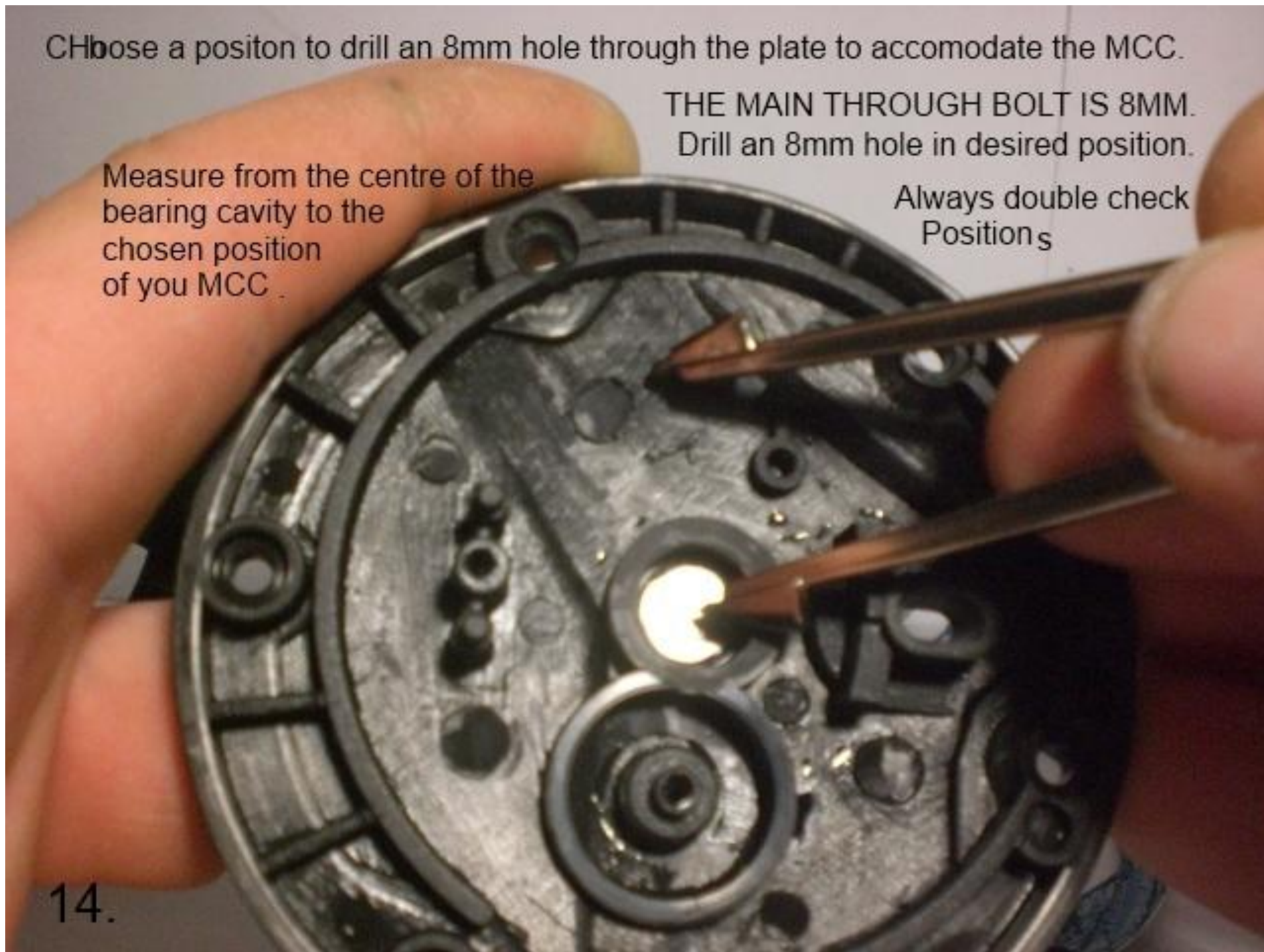
THE MAIN THROUGH BOLT IS 8MM.

Drill an 8mm hole in desired position.

Measure from the centre of the bearing cavity to the chosen position of your MCC.

Always double check Positions

14.



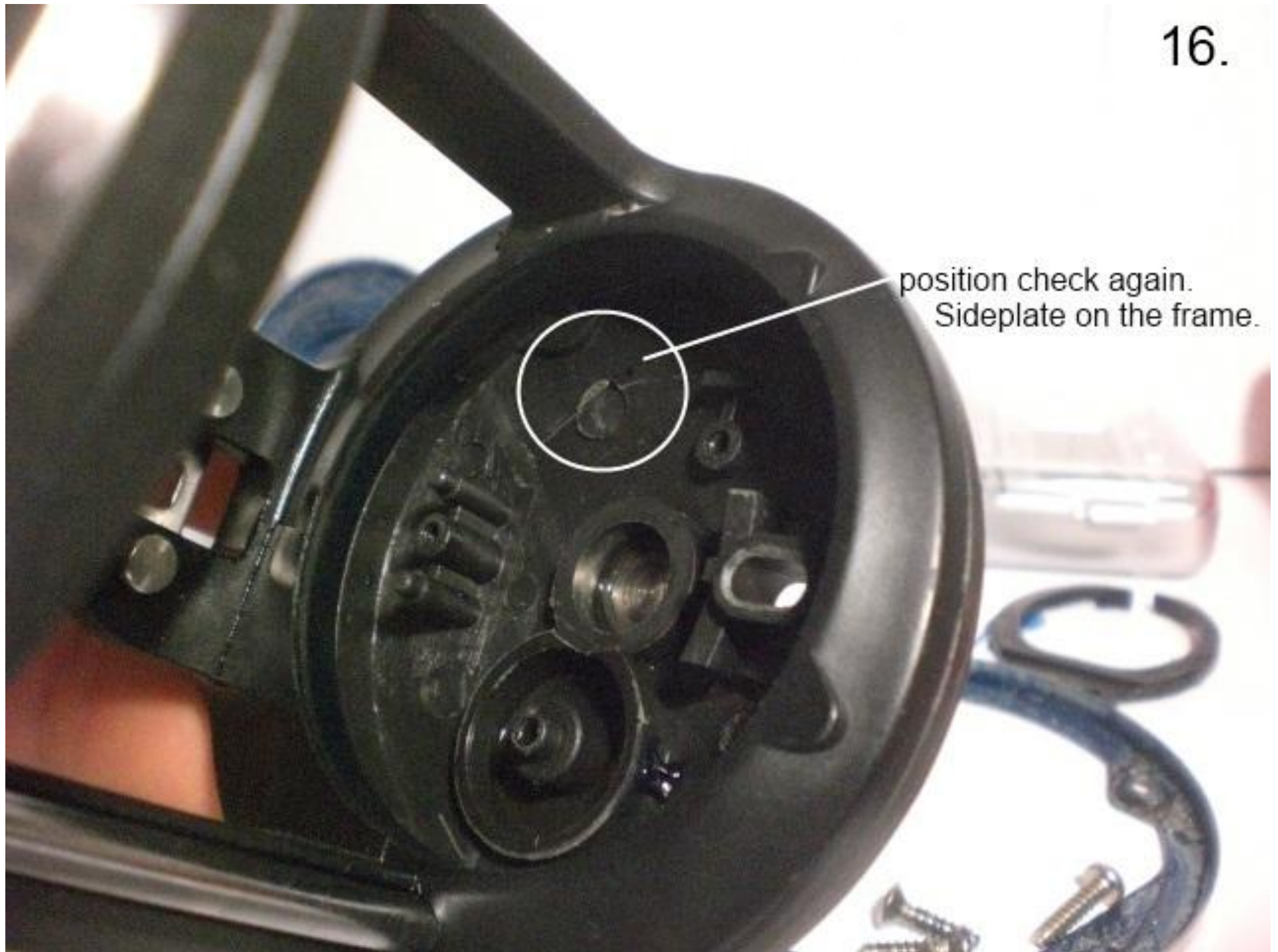
15.

Take time to access reel semi assembled after the position has been marked. Visual checks crucial.

Permanent pen mark ed position looks good with spool in place.



16.



Drilling from the inside of the sideplate , Rest the sideplate in some cardboard so it is cushioned when you drill. The drill will go through at an angle.

Drill slowly to avoid problems.

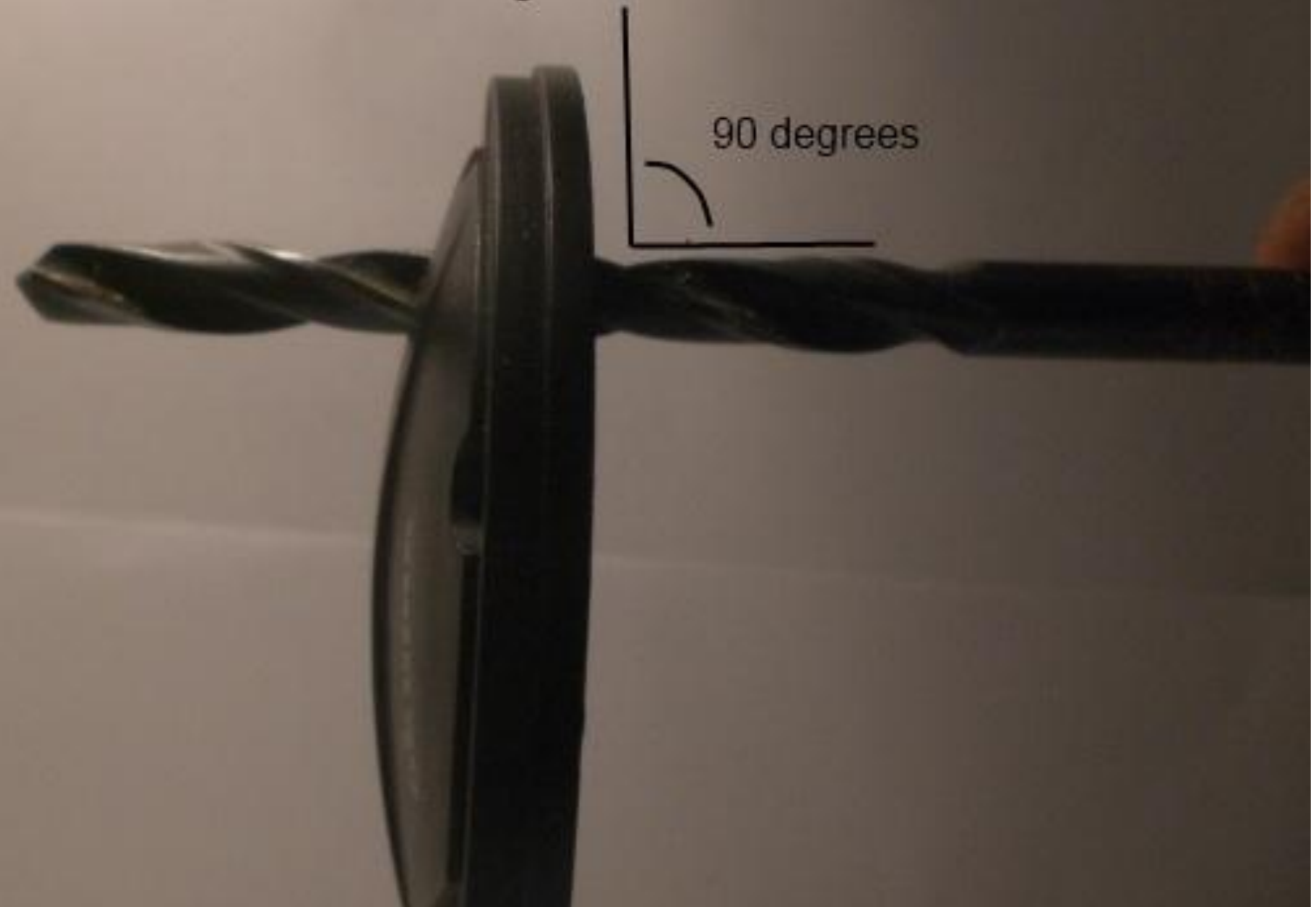
Tools needed: Standard Electric drill
Sharp 8mm drill bit

Cardboard to rest sideplate
on whilst drilling.

Drill flat down onto pen mark.
Drill bit will exit sideplate at slight angle.

Drillthrough again slowly and carefully but directing the drill bit at 90 degrees to the inside of the sideplate. this is to ensure that the MCC once made will aligned correctly and not at an angle .

Be sure to keep the hole at 8mm and dont enlarge it too much.



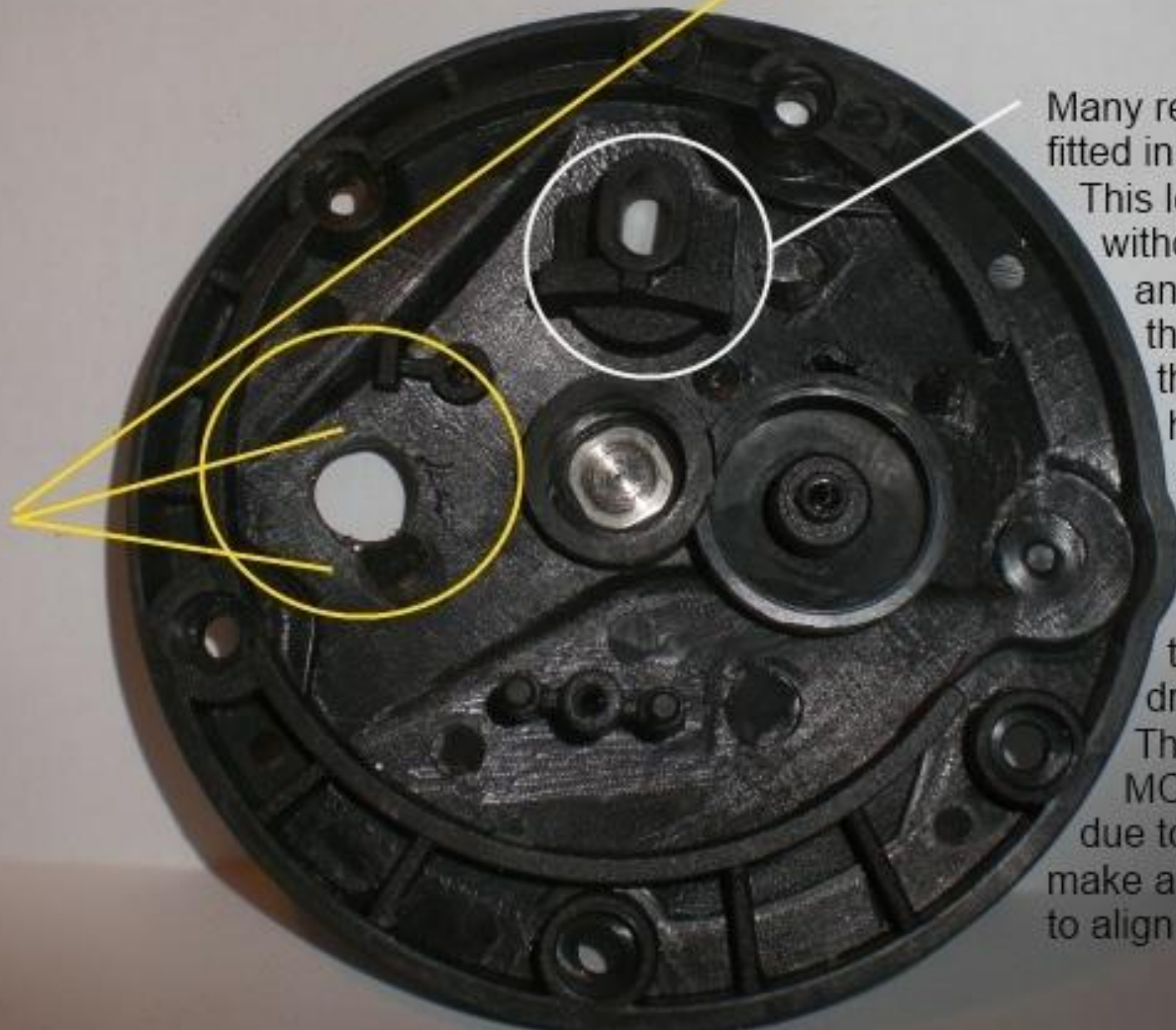
A slight gap is normal but the 8mm bit should still be fairly snug..



Good position - Away from stainless bash rings, well centred.



Internal position looks correct. Good space around hole.



Many reels get the Mcc fitted in this position. This leaves the reel without the clicker and it also leaves the reel without the option of ever having a clicker again.

The area is flattened with special bit and the oval hole drilled out to 8mm. The fitting of the MCC is then easier due to not having to make angled spacers to align the MCC.



Find your marking on the spool. Align it with the hole and check to see if you are on target.

23.



Many different reels will have many different positions. The principals are the same. Positions, check and rechecks should keep you away from mistakes.

ALWAYS ENVISION THE FINAL RESULT.

MISTAKES THAT ARE IN THE WAY ARE EASIER TO SEE.



25.

EXAMPLE

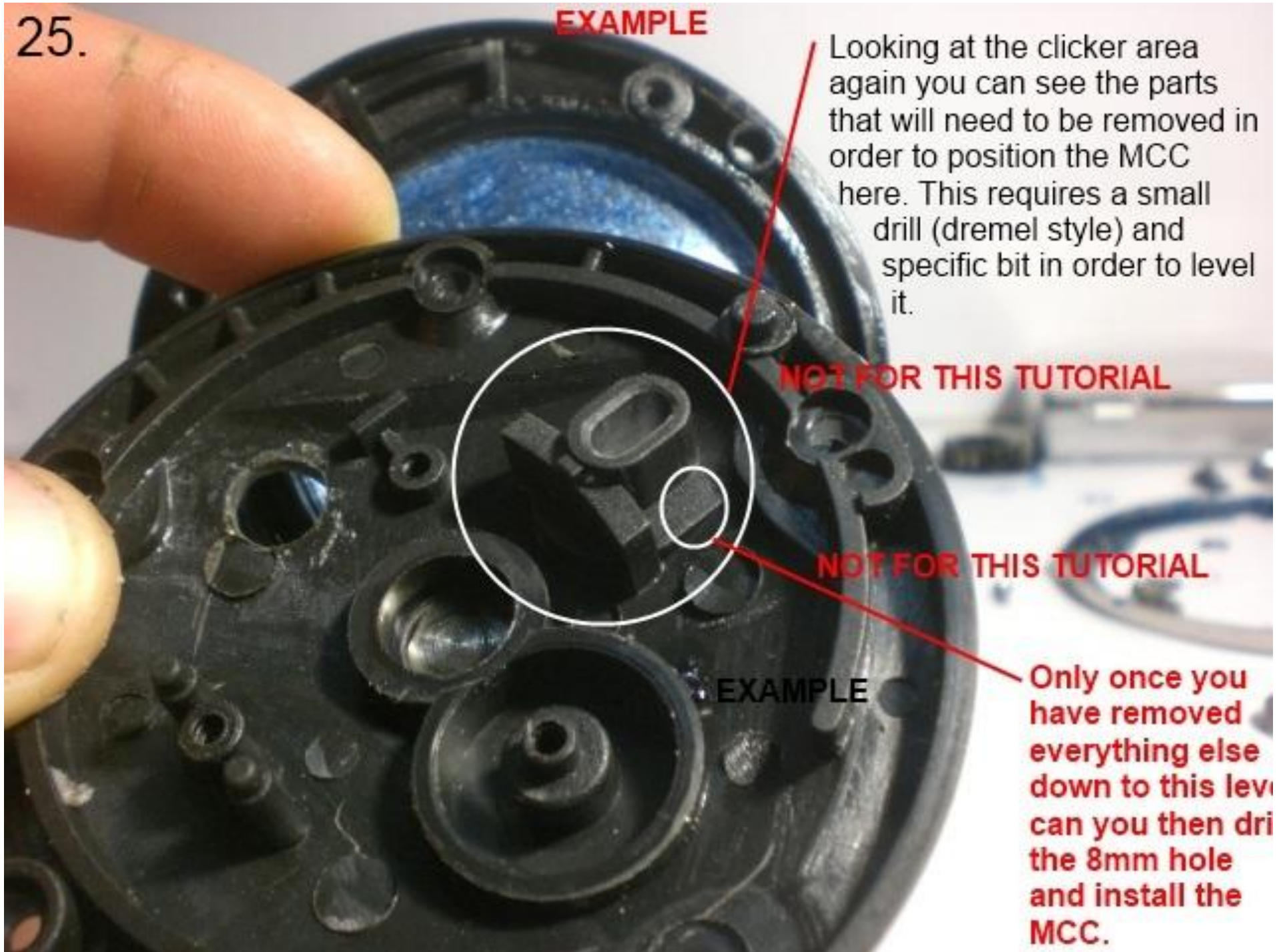
Looking at the clicker area again you can see the parts that will need to be removed in order to position the MCC here. This requires a small drill (dremel style) and specific bit in order to level it.

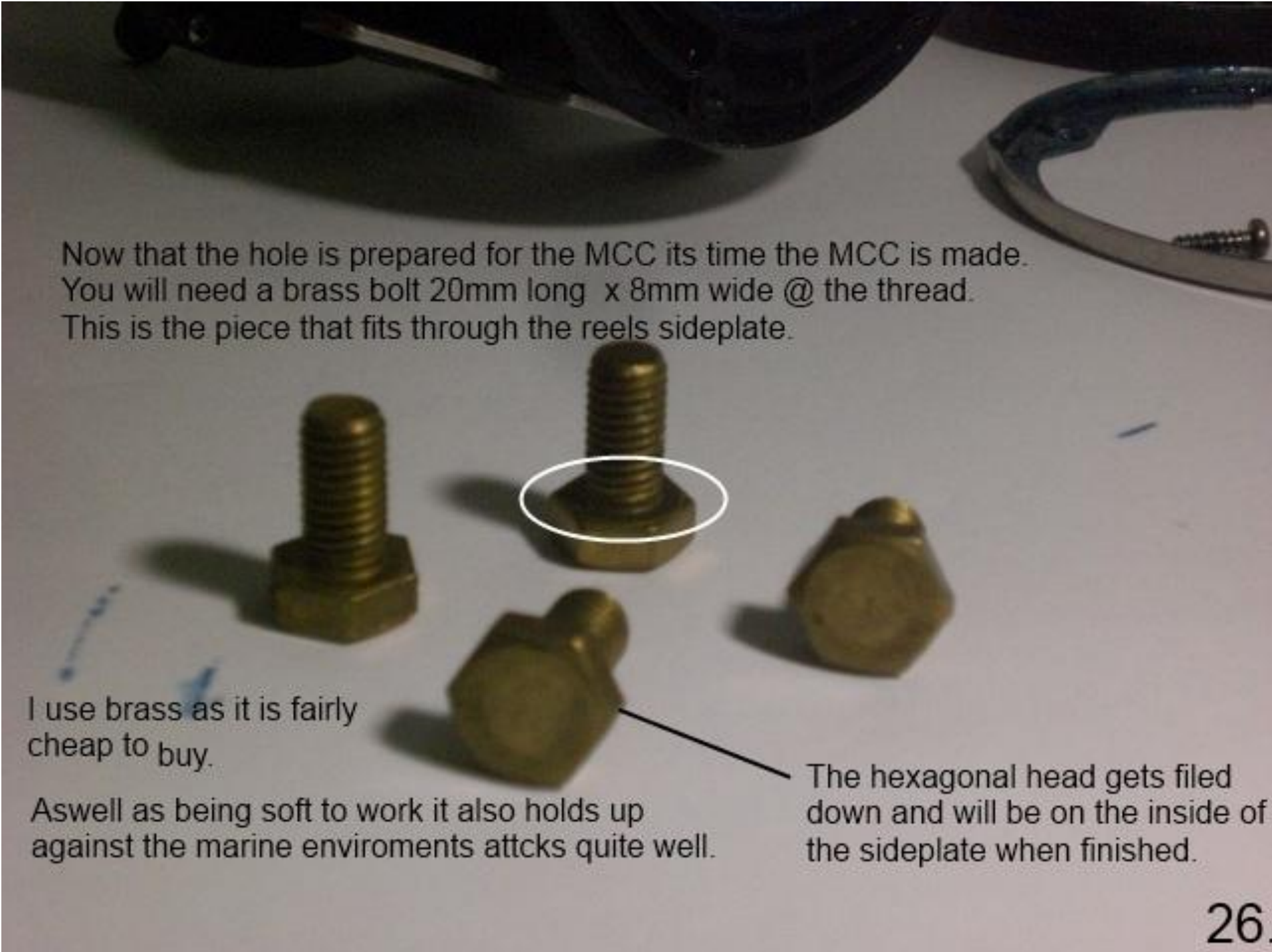
NOT FOR THIS TUTORIAL

NOT FOR THIS TUTORIAL

EXAMPLE

Only once you have removed everything else down to this level can you then drill the 8mm hole and install the MCC.





Now that the hole is prepared for the MCC its time the MCC is made.
You will need a brass bolt 20mm long x 8mm wide @ the thread.
This is the piece that fits through the reels sideplate.

I use brass as it is fairly
cheap to buy.

Aswell as being soft to work it also holds up
against the marine enviroments attcks quite well.

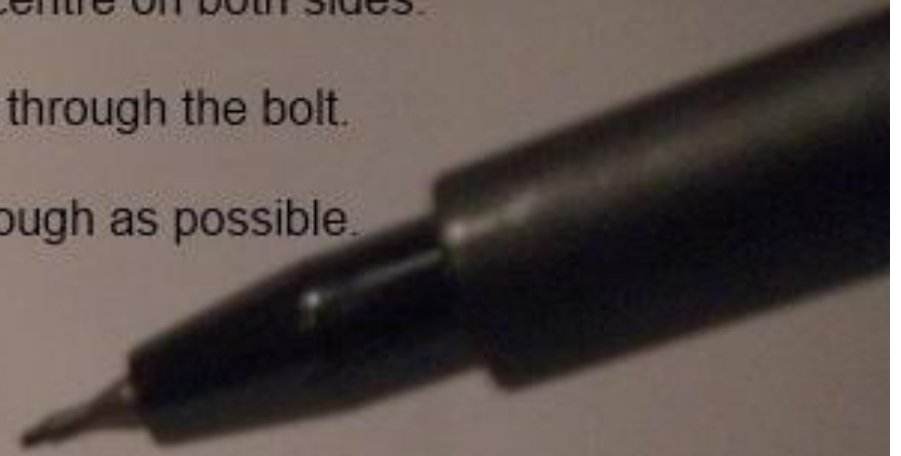
The hexagonal head gets filed
down and will be on the inside of
the sideplate when finished.

27.

Mark the bolt for drilling - centre on both sides.

You must drill a 4mm hole through the bolt.

As straight through as possible.



You will Need

Marker pen

Handheld drill

4mm metal drill bit sharp

28.



Marked - centre

29.



Marked - centre

30.

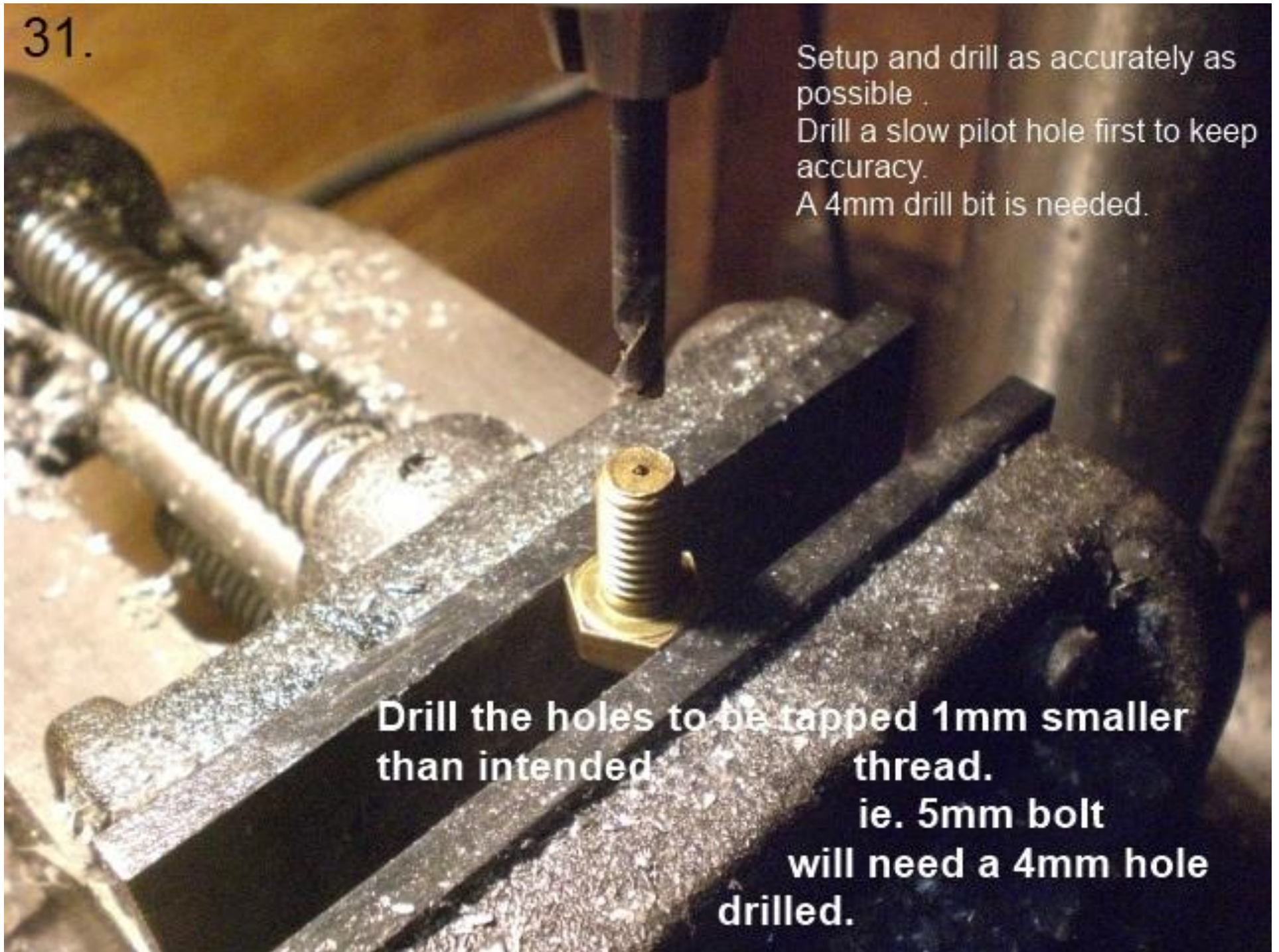


-marked centre-

31.

Setup and drill as accurately as possible.
Drill a slow pilot hole first to keep accuracy.
A 4mm drill bit is needed.

Drill the holes to be tapped 1mm smaller than intended thread.
ie. 5mm bolt will need a 4mm hole drilled.



32.

ACCURACY IS KEY. DRILL STRAIGHT AND THE MAGNET RUNS STRAIGHT.



33.

PILOT HOLE TO START. CHECK YOUR CENTRE.



34.

DRILLED THROUGH -



35.

DRILLED THROUGH
4MM DRILL BIT - METAL



36.

READY FOR CUTTING A THREAD.



37.

TAP 4MM HOLE TO SUIT 5MM STAINLESS BOLT THREAD.

M5 X 0.8

←
ALTERNATIVELY USE A 5MM
HARDENED STEEL BOLT AND
DO A SLOW MANUAL CUT.
SMALL INCREMENT TURNS AT A
TIME.



38.

**ALWAYS TRY TAP STRAIGHT DOWN THE CENTRE/HOLE.
ANGLES CREATE PROBLEMS.**



39.

A THREAD CAN BE MADE WITH A HARDENED STEEL 5MM BOLT . IT MUST BE CUT SLOWLY IN ORDER TO NOT DESTROY THE WORK PIECE OR THREAD ON THE BOLT. DONT USE THE SAME BOLT FOR THE MCC AS YOU DID FOR THE THREAD CUTTING.

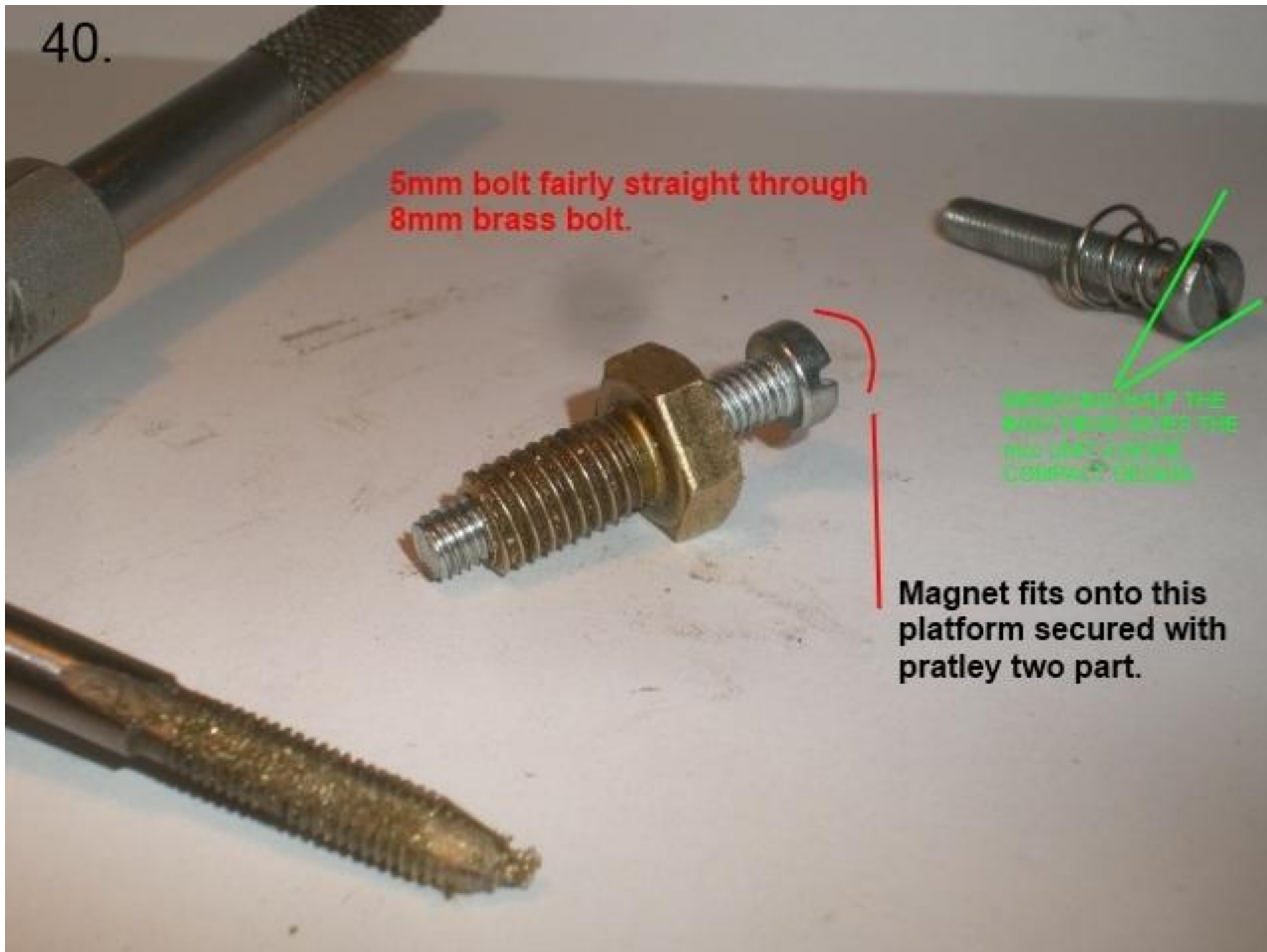


40.

5mm bolt fairly straight through
8mm brass bolt.

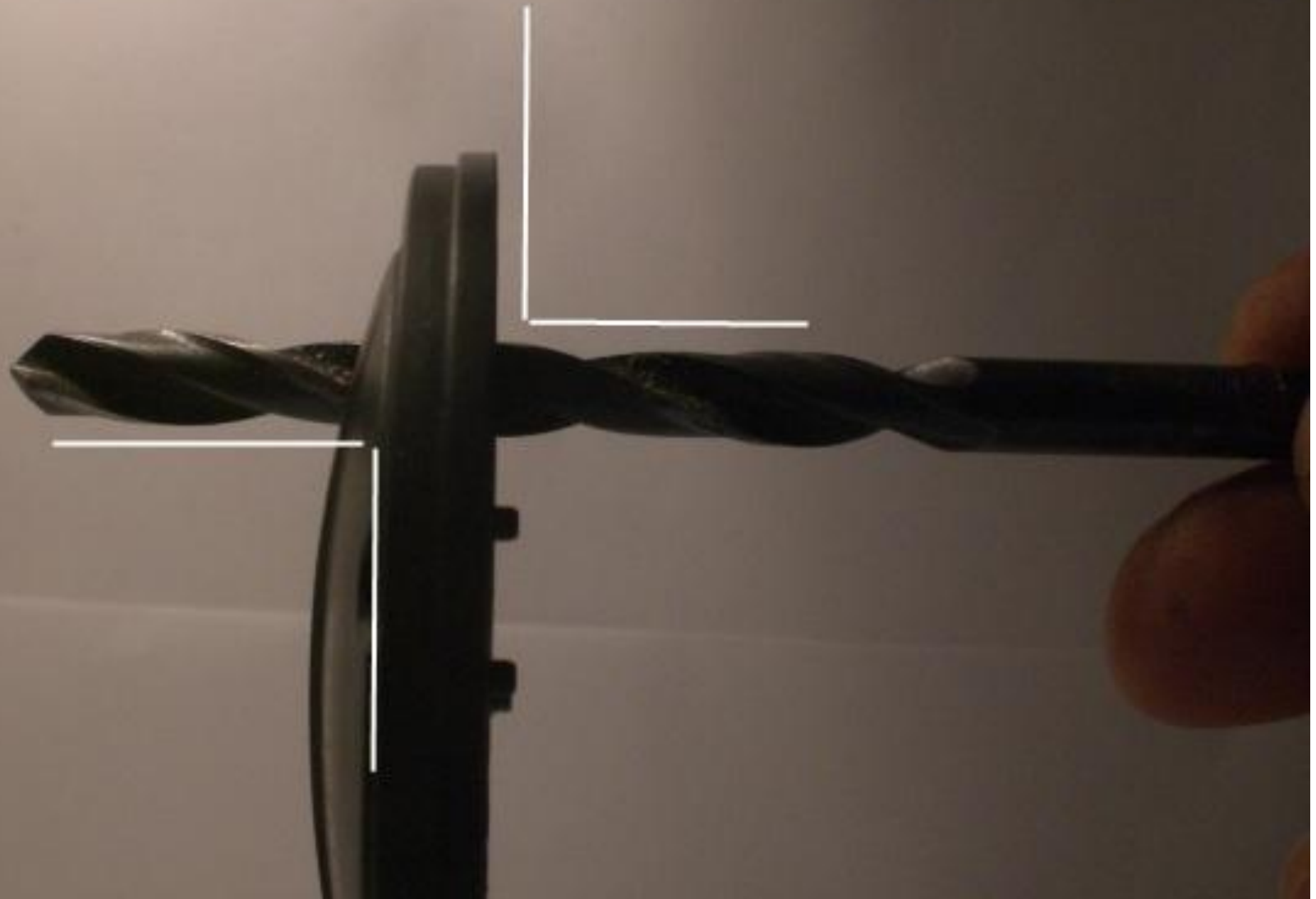
REMOVE HALF THE
BUSH & BUSH IN THE
MID LINE & FORM
COMPACT DESIGN

Magnet fits onto this
platform secured with
pratley two part.



41.

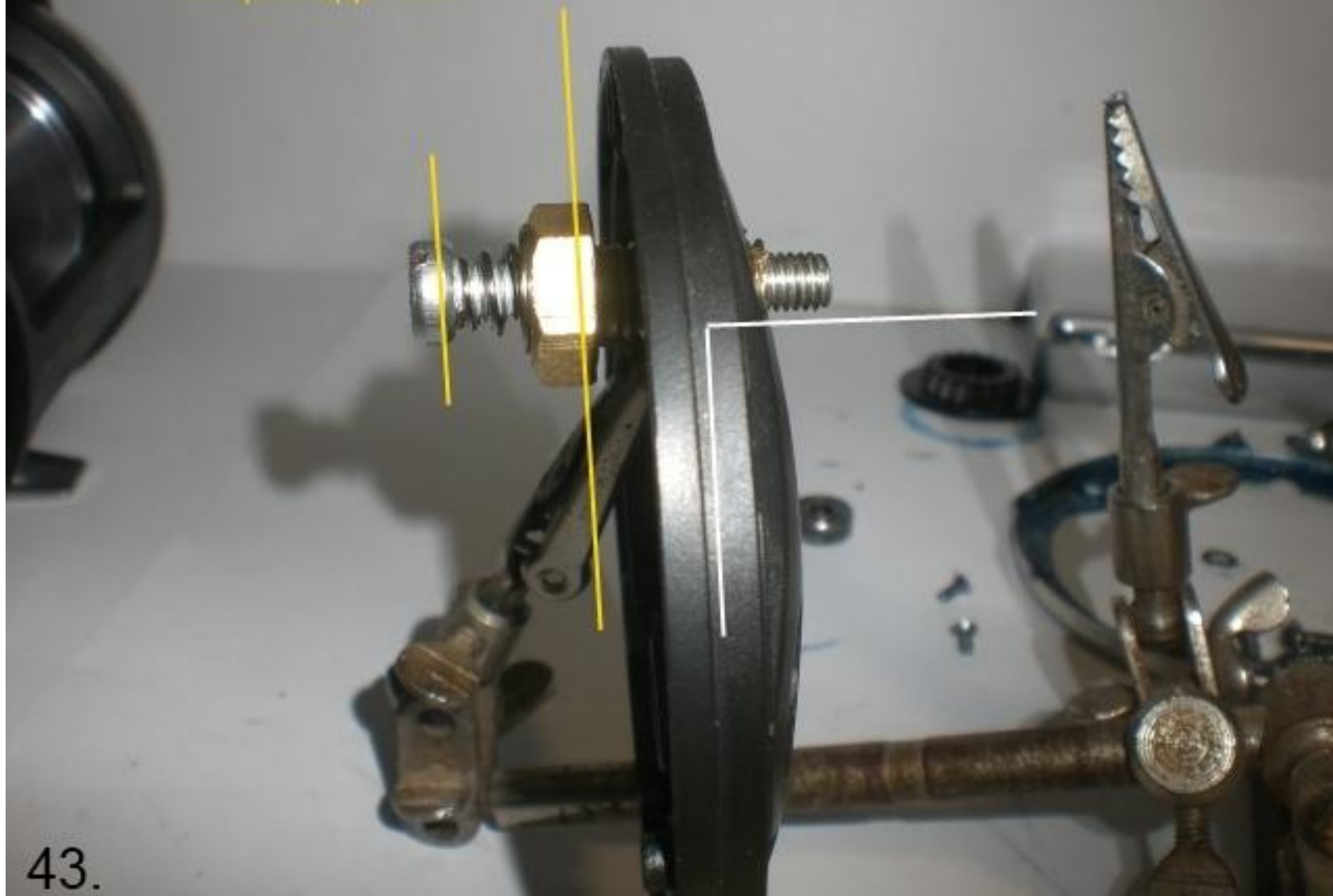
RECHECK YOUR SIDEPLATE HOLE IS ACCURATE AND STRAIGHT.



**FIT THE MCC ASSEMBLY INTO THE 8MM HOLE TO ACCESS
AND CHECK ALIGNMENT.**



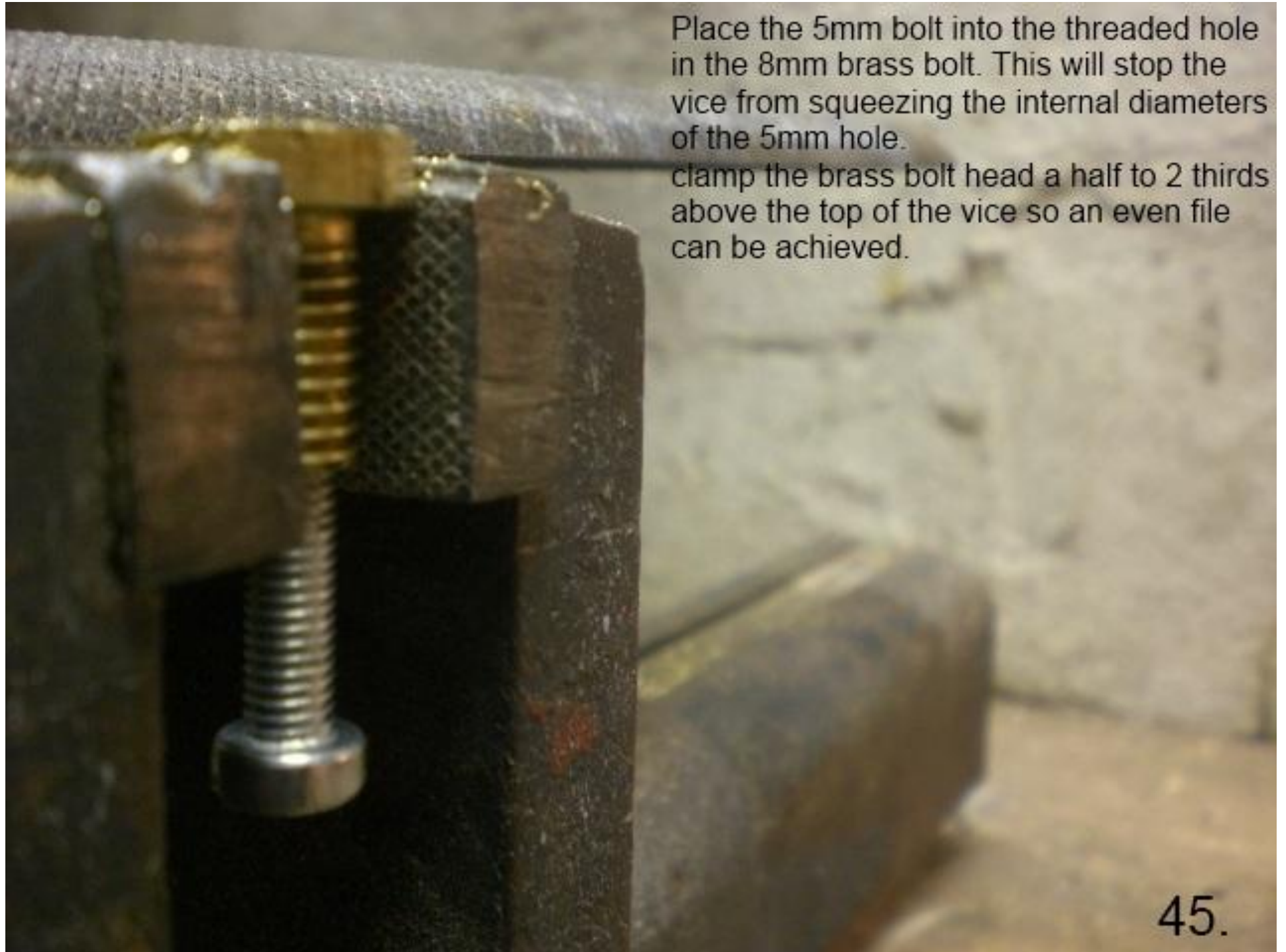
For future ref. these parts will be taken down to give the unit a more compact approach.



IF YOU ARE SATISFIED ,remove and begin the bolt head filing.

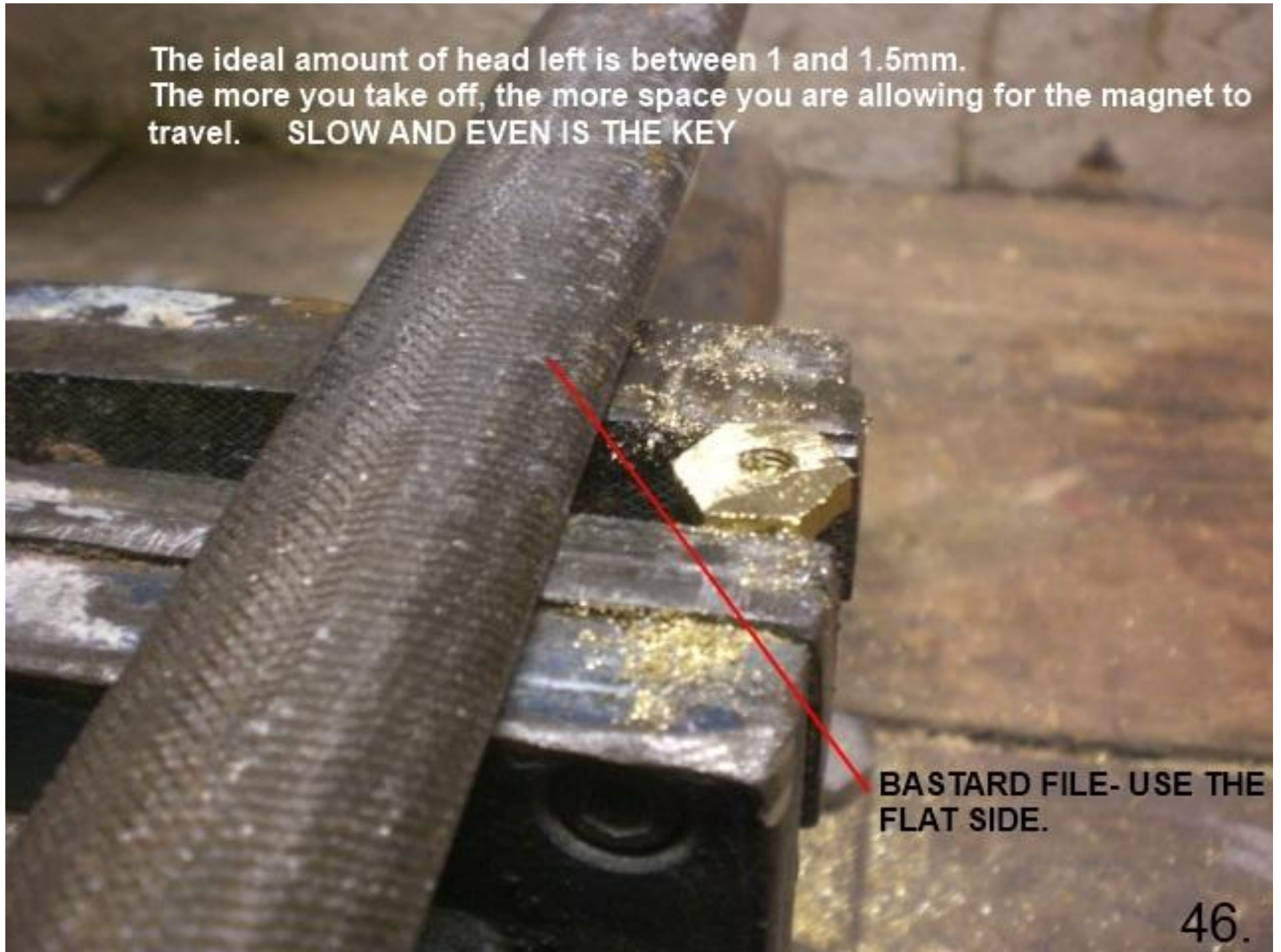
44.





Place the 5mm bolt into the threaded hole in the 8mm brass bolt. This will stop the vice from squeezing the internal diameters of the 5mm hole.
clamp the brass bolt head a half to 2 thirds above the top of the vice so an even file can be achieved.

The ideal amount of head left is between 1 and 1.5mm.
The more you take off, the more space you are allowing for the magnet to travel. **SLOW AND EVEN IS THE KEY**



**BASTARD FILE- USE THE
FLAT SIDE.**

47.

Alternatively a hole can be prepared for the bolt in a seperate bar in order to accomodate the bolt whilst it is being filed down.




Do not file to aggressively or the bolt head might get to hot and shear off when you get low down towards the shaft.



Turn the bolt out when the desired thickness has been reached.

49.



This is a 10 toothed bolt . It has been trimmed down from its original 20mm length and has had the head filed down too



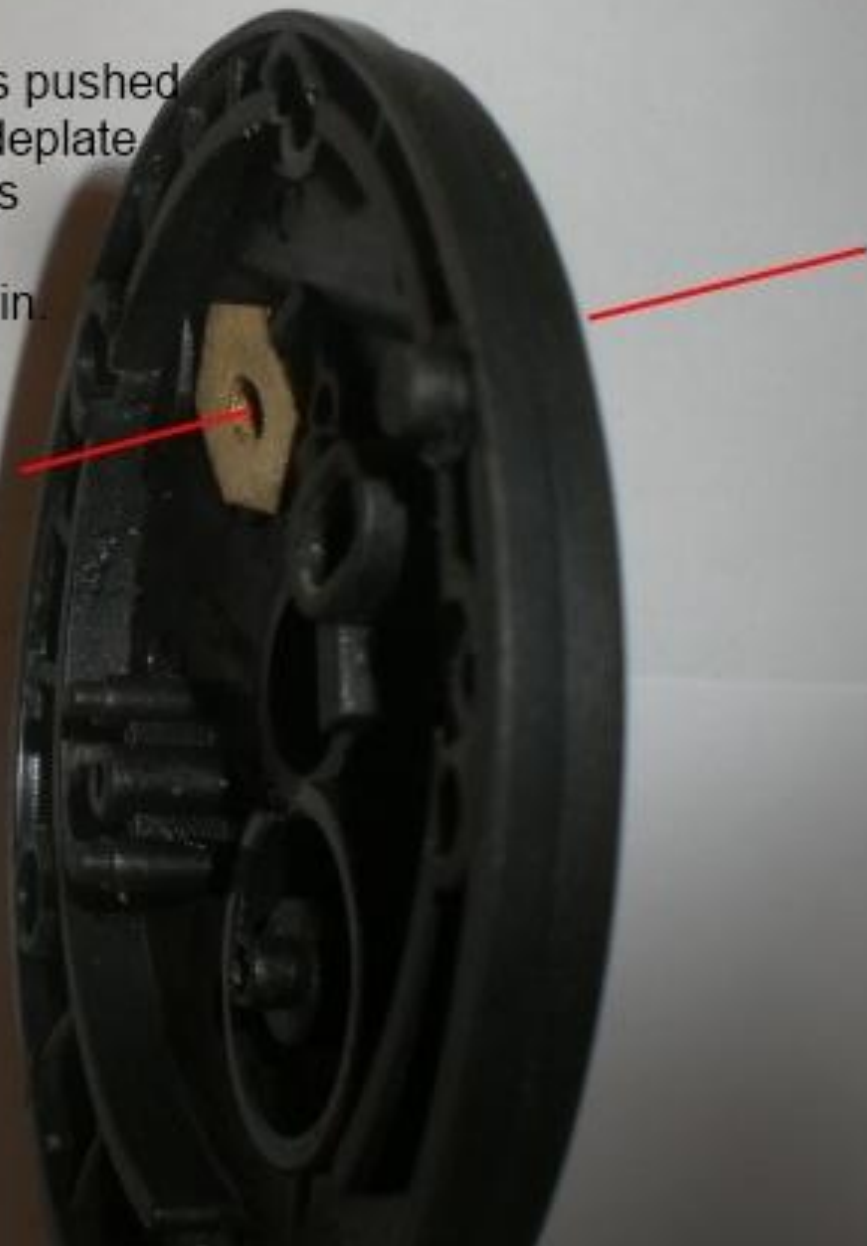
10 teeth. - Good length for your average sized multiplier.

Ready for the next step. -



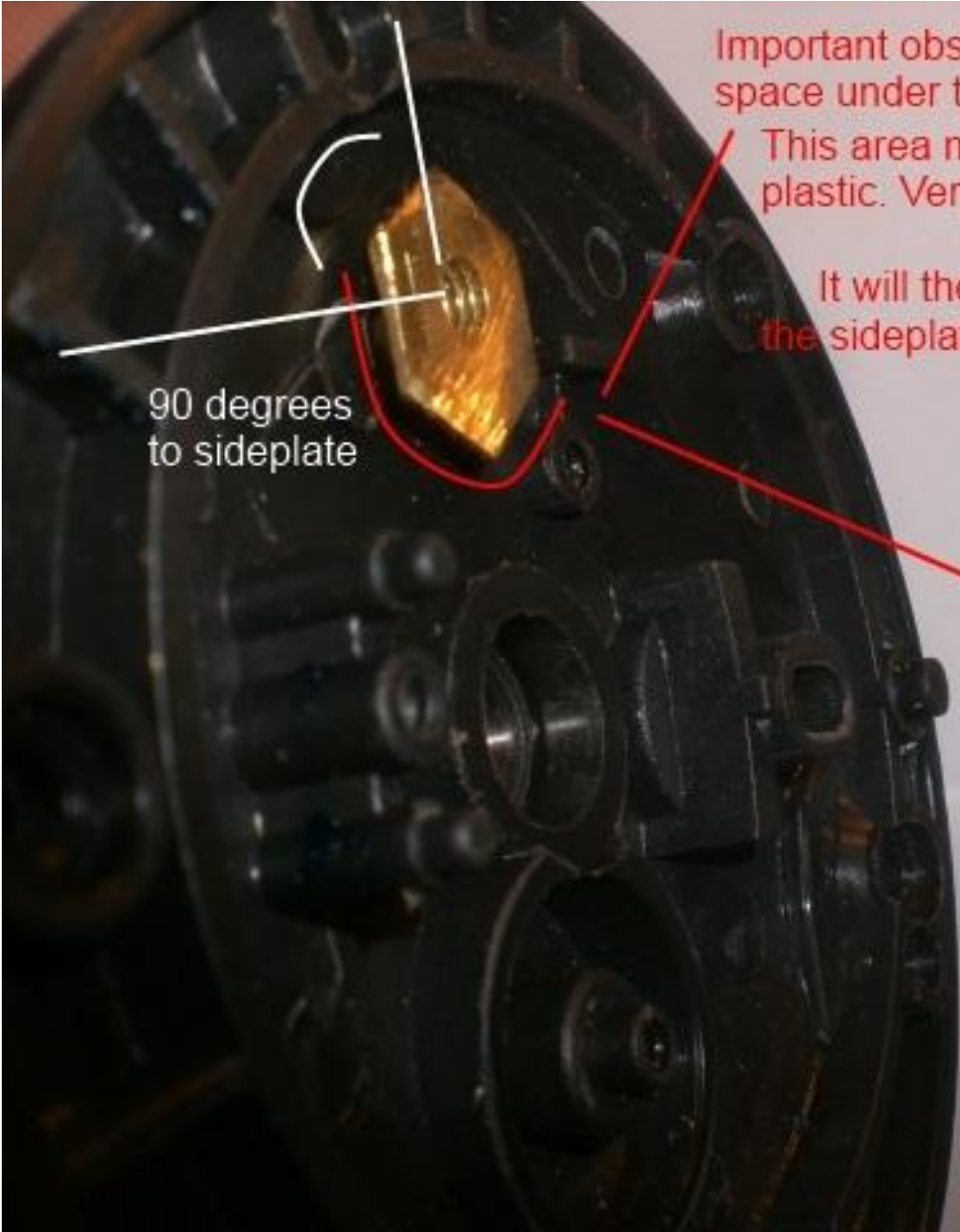
Fit the bolt into the 8mm hole.
You should notice that when it is pushed
in and is flush up against the sideplate
that it will be at an angle. This is
caused due to the angle of the
sideplate that the hole is drilled in.

It needs an angled spacer on
both sides of the side plate.



Flush to the sideplate, in a good space with no obstructions around the hexagonal bolt head.





Important observation - Note the size and shape of space under the bolt head.

This area must be filled with a spacer made from plastic. Very simple ,very easy.

It will then allow the bolt to sit straight through the sideplate and not at an angle.

90 degrees
to sideplate

The space must be noted for the spacer shape when the bolt is held through the sideplate straight and not at angle

push bolt through and visually access
for spacer angles

Visual note.



*Round plastic spacer prior to being shaped.
Note the simple angles to follow when sanding down plastic.

Use the white lines as a guide to create / shape the spacer that will fill the triangular voids

The inside spacer should be thinner than the outer spacer.

If done correctly the spacers will allow the magnet to sit and run at 90 degrees to the sideplate.

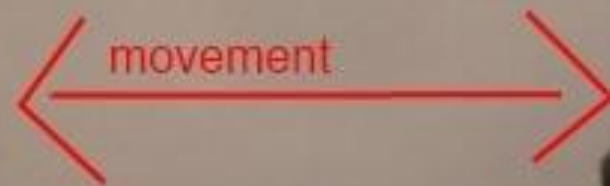


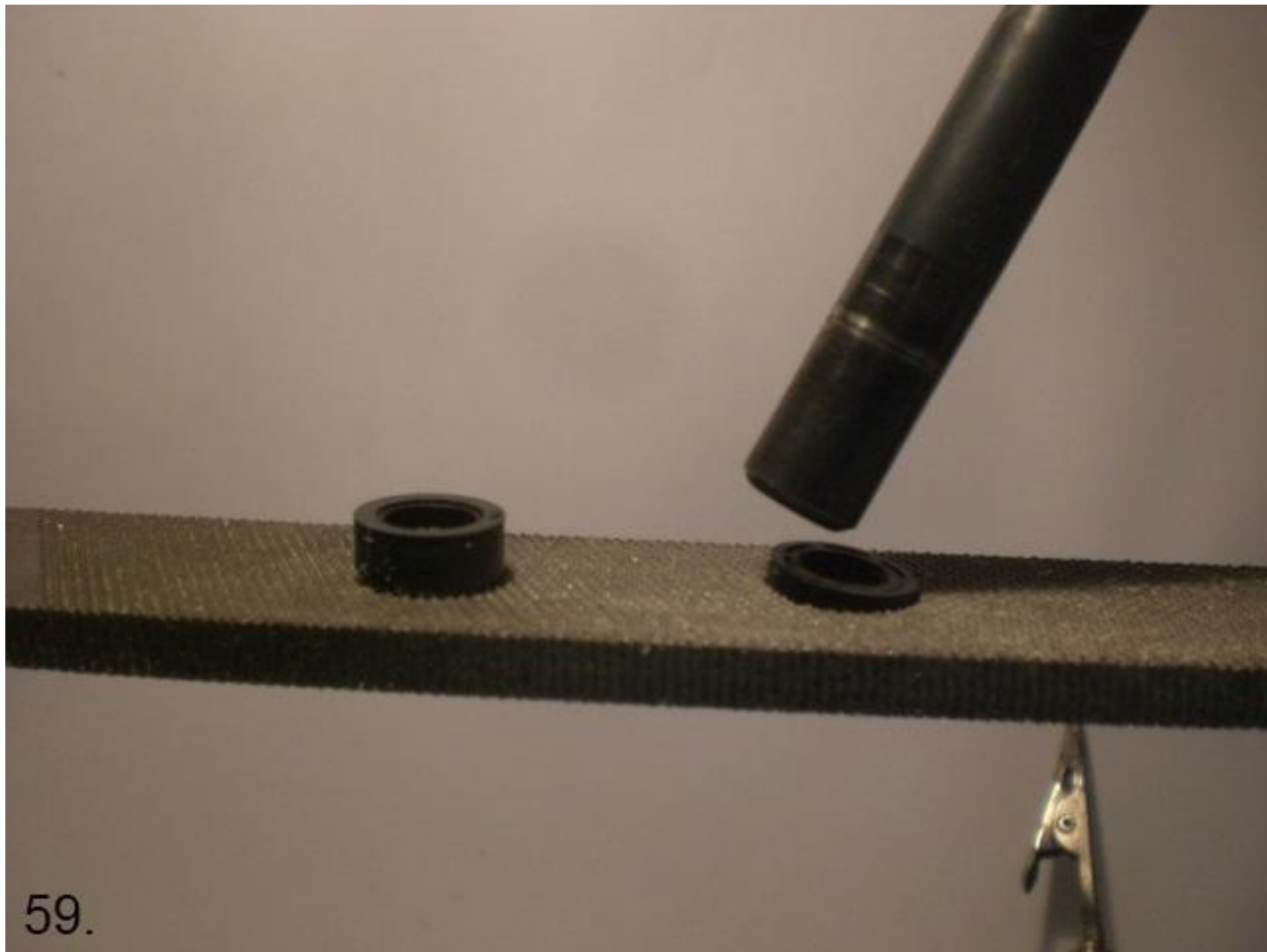
Here is how its done !



You will need 2x round 13mm x 5mm plasticwashers.
You can cut and shape from metal or plastic.

File the desired shape on a rough Bastard file.
Back and forth should do it.
Alternatively use a bench grinder.





59.





61.

62.



63.



64.



65.

Your end result will look like this .
There is a hole in the middle of this wedge already from it
being a plastic washer/spacer.

If you Dont have a hole through them you will need to drill
an 8mm hole through both.



66.

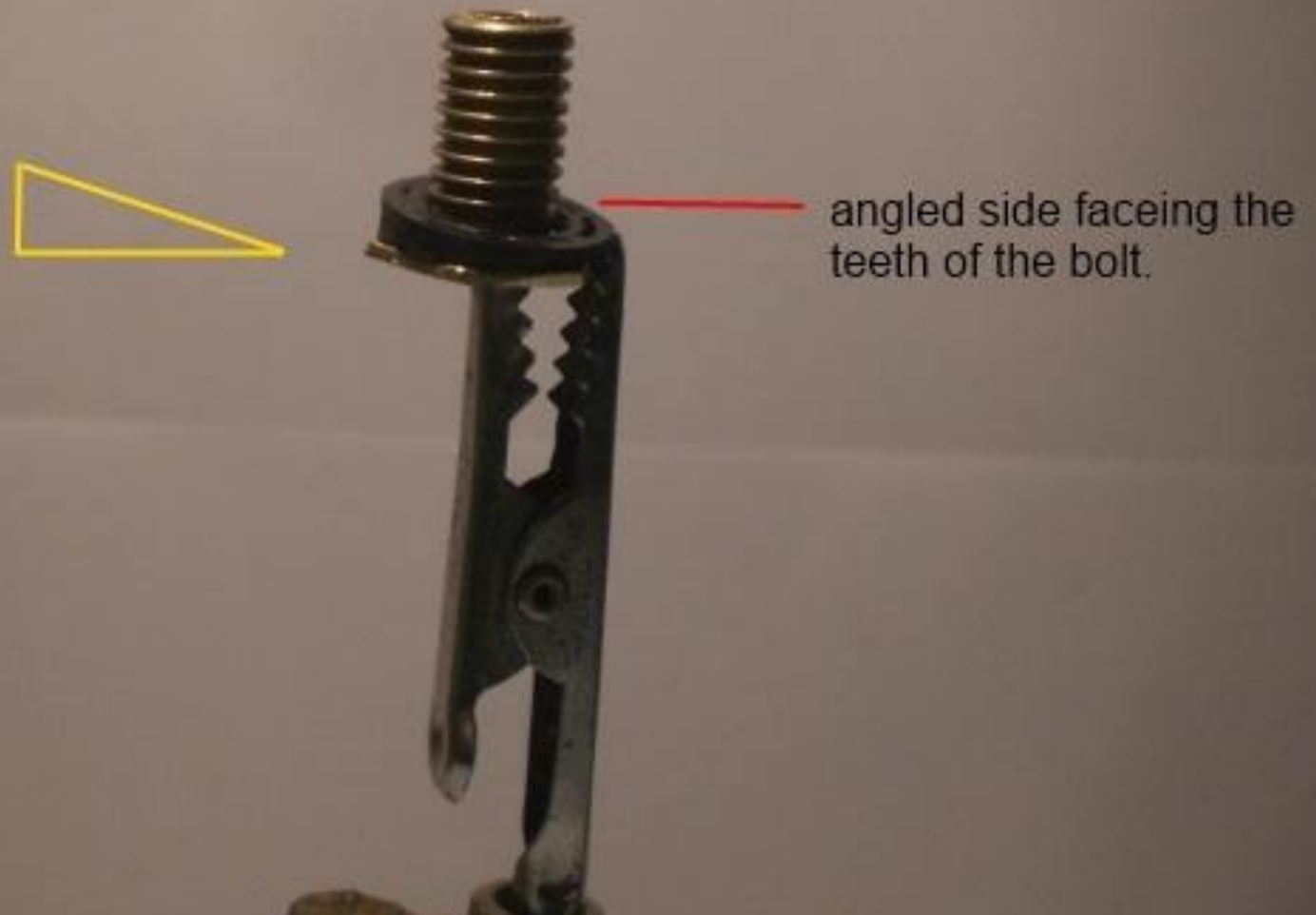
Internal spacer

external spacer

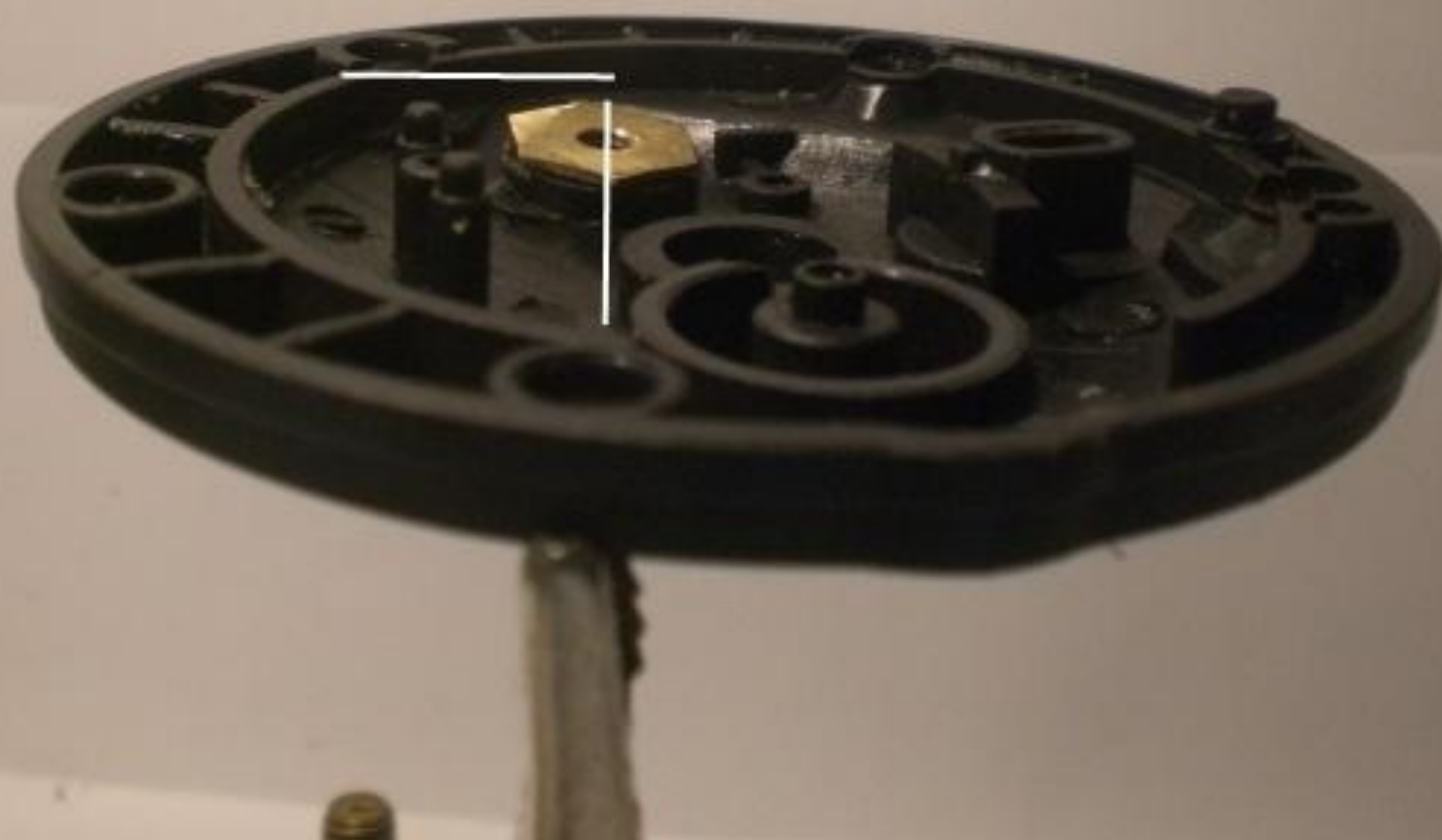


This is the brass bolt that fits through the 8mm hole.

Its been fitted with the internal spacer . It can now be pushed through the 8mm hole in the sideplate and accessed on its levelness.

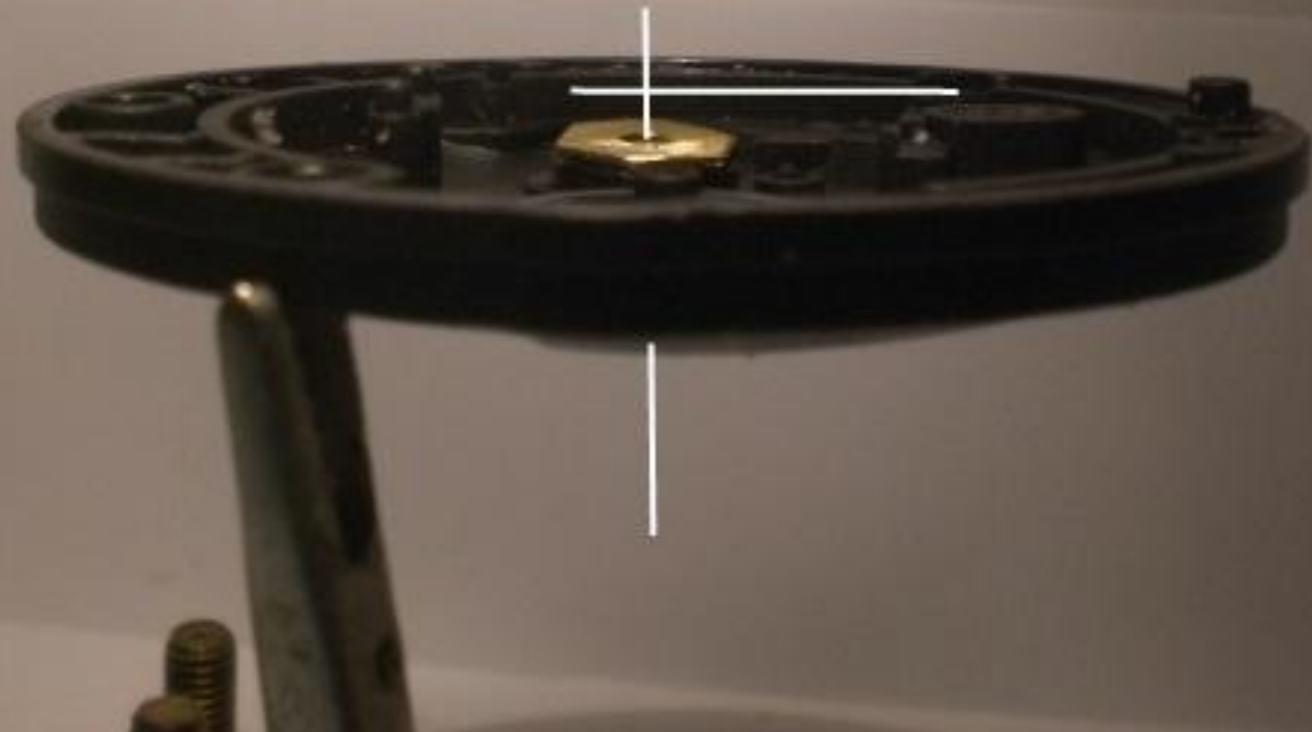


Fitted .flush and level



Spacers can be shape with brass ,alloy or plastic.
Plastic is easy and quick.

No more angle to deal with.
Spacers have worked well.

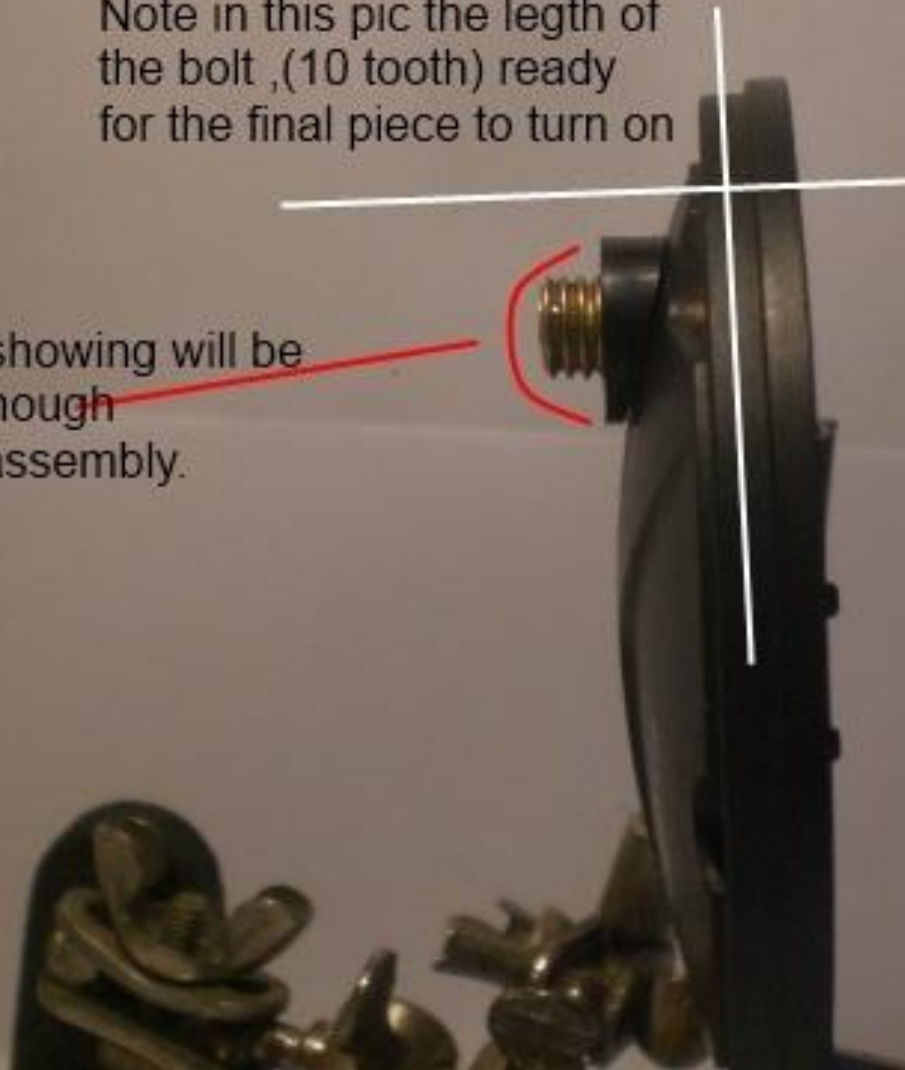


Outer spacer makes all the difference in appearance. Note the angles.

Now its getting somewhere.

Note in this pic the legth of
the bolt ,(10 tooth) ready
for the final piece to turn on

The 4 teeth showing will be
more than enough
for the final assembly.



Take a measurement of the brass teeth exposed .
Add 1.5mm on this and that will be the length of the 13mm brass round bar section you will need to cut.
It will cover the teeth and tighten the entire MCC together.



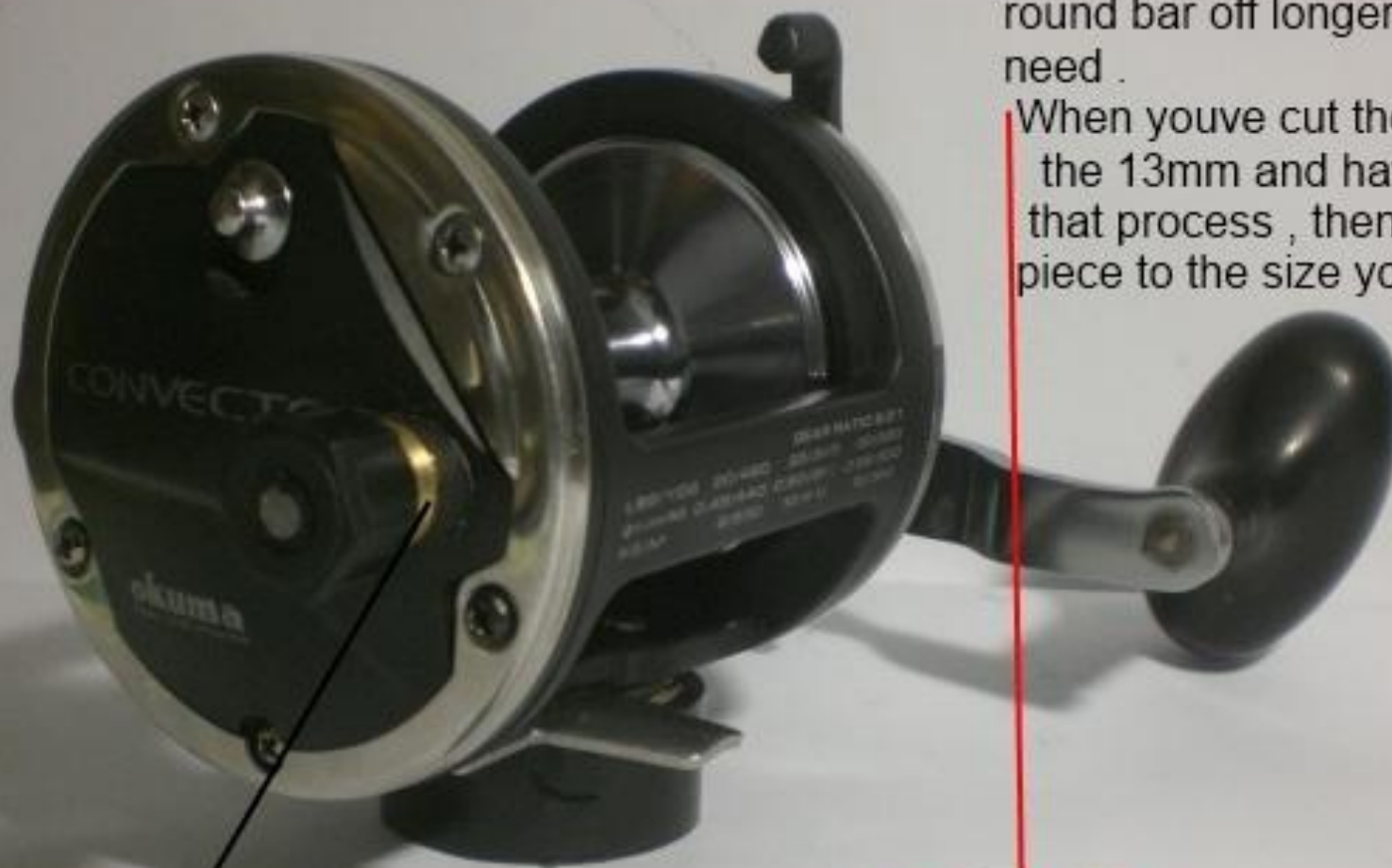
73.

It is better to first cut the 13mm round bar off longer than you need .

When youve cut the thread into the 13mm and have finished that process , then cut the piece to the size you require.

differs according to reel

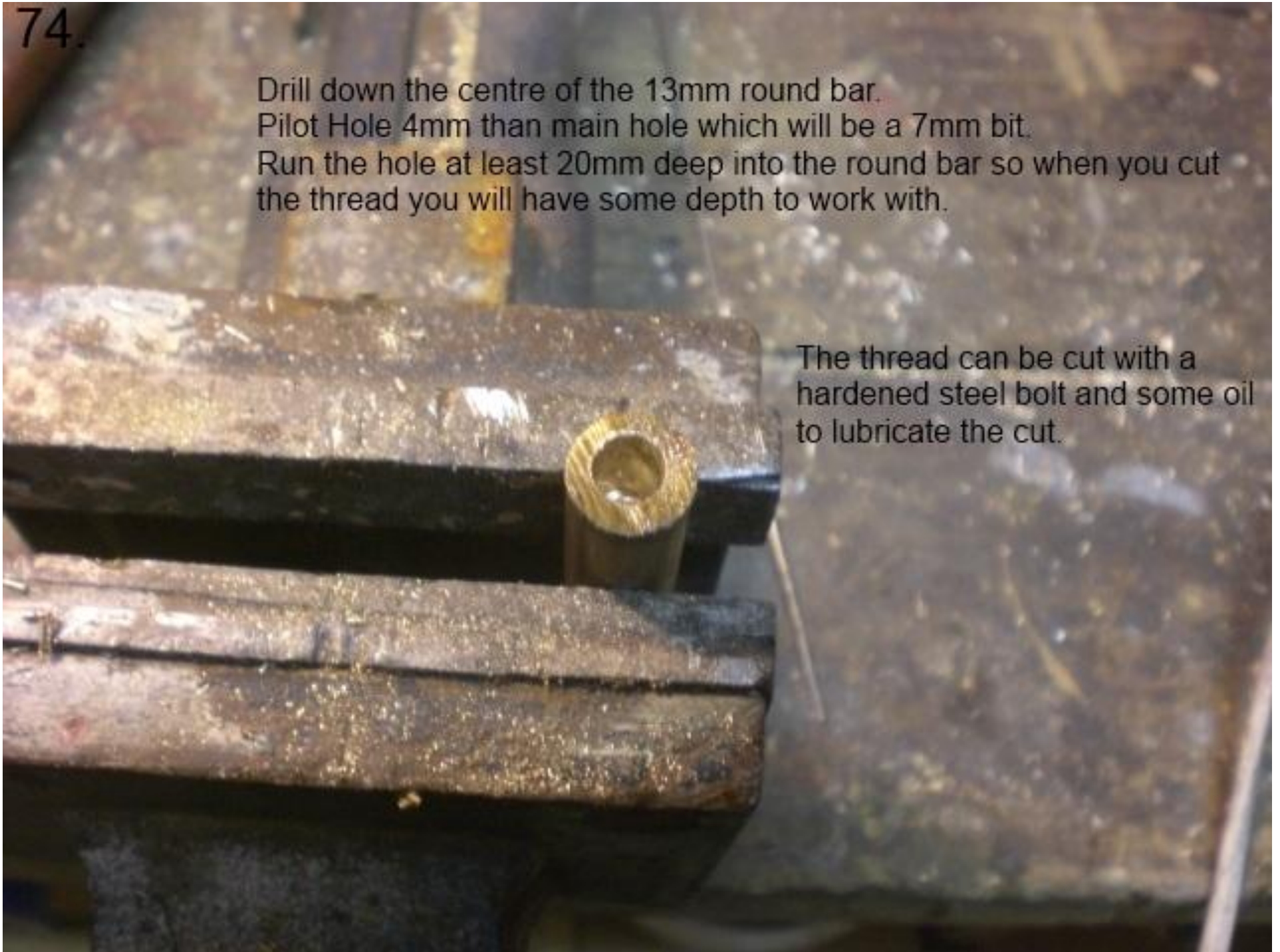
approx. cut length



74.

Drill down the centre of the 13mm round bar.
Pilot Hole 4mm than main hole which will be a 7mm bit.
Run the hole at least 20mm deep into the round bar so when you cut
the thread you will have some depth to work with.

The thread can be cut with a
hardened steel bolt and some oil
to lubricate the cut.



75.

Position the bolt straight into the 7mm hole that's in the 13mm round bar.
OIL to lubricate the cut. Take the appropriate size spanner and turn the cutting bolt precisely and incrementally.
Back and forth, Divide a full turn into 8ths or 16ths.
Small cuts will leave you with a better finish.

Every now and again turn the bolt out and clear the debris accumulated from cutting.



When cutting a thread manually ,little precise movements are key.

- Turn forward to cut 2mm

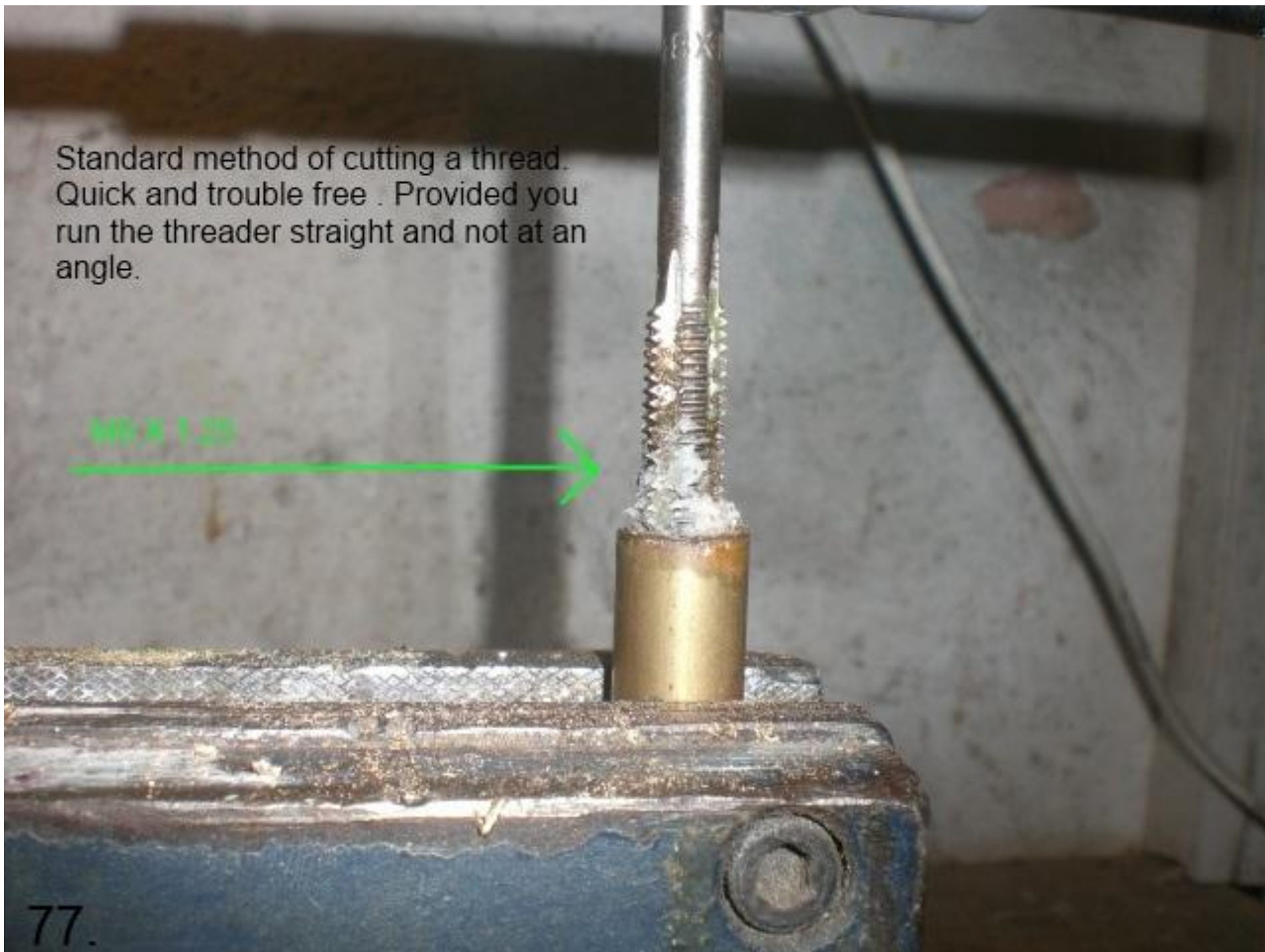
- Turn back 4mm to release

Then repeat and re-oil if you feel its getting tight.

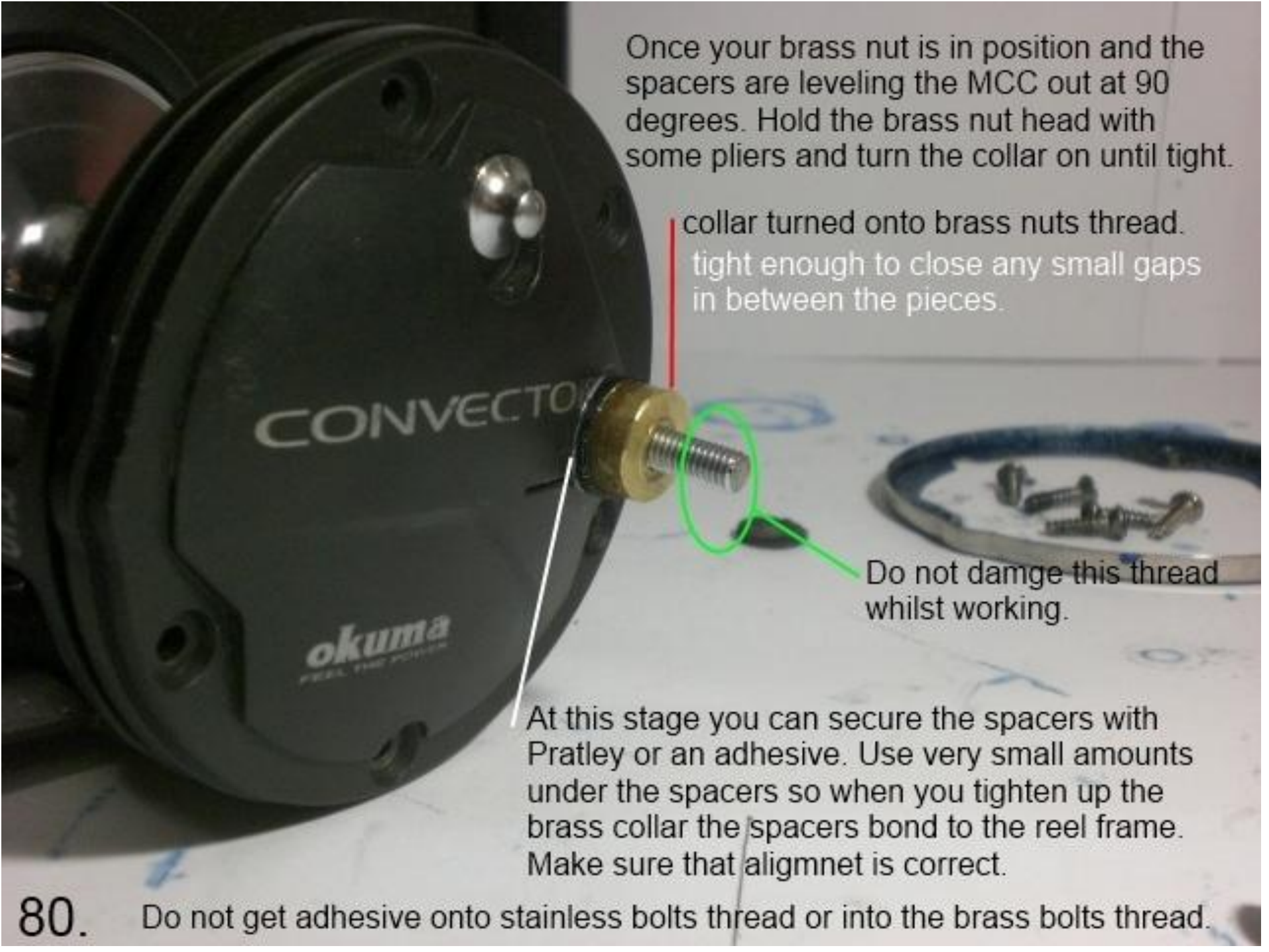
Going further
each time you cut.

Standard method of cutting a thread.
Quick and trouble free . Provided you
run the threader straight and not at an
angle.

M10 x 1.25







Once your brass nut is in position and the spacers are leveling the MCC out at 90 degrees. Hold the brass nut head with some pliers and turn the collar on until tight.

collar turned onto brass nuts thread.
tight enough to close any small gaps
in between the pieces.

Do not damage this thread
whilst working.

At this stage you can secure the spacers with Pratley or an adhesive. Use very small amounts under the spacers so when you tighten up the brass collar the spacers bond to the reel frame. Make sure that alignment is correct.

80. Do not get adhesive onto stainless bolts thread or into the brass bolts thread.

At this stage the MCC is in position and needs only the knob and the mag to work.

Check your angles again. If your unit is tilted than try and shift the spacers around in order to get the right angles.

The magnet must be level with the spool in order to operate at its most efficient capability.

Run through these checks and then remove the side plate from the reel frame. if there are any faults.

If not then move on.



Remove the bolt from the unit completely. Select a magnet that is 5mm wide x1mm or 2mm thick.

Place the magnet onto the top of the bolt head. It will stay in place due to magnetism but securing it in this position must be done with a small amount of prattley adhesive.

Some reels have very little space to operate a mag break. Grinding this bolt head down to a platform of 1mm thick will help the issue.

82.

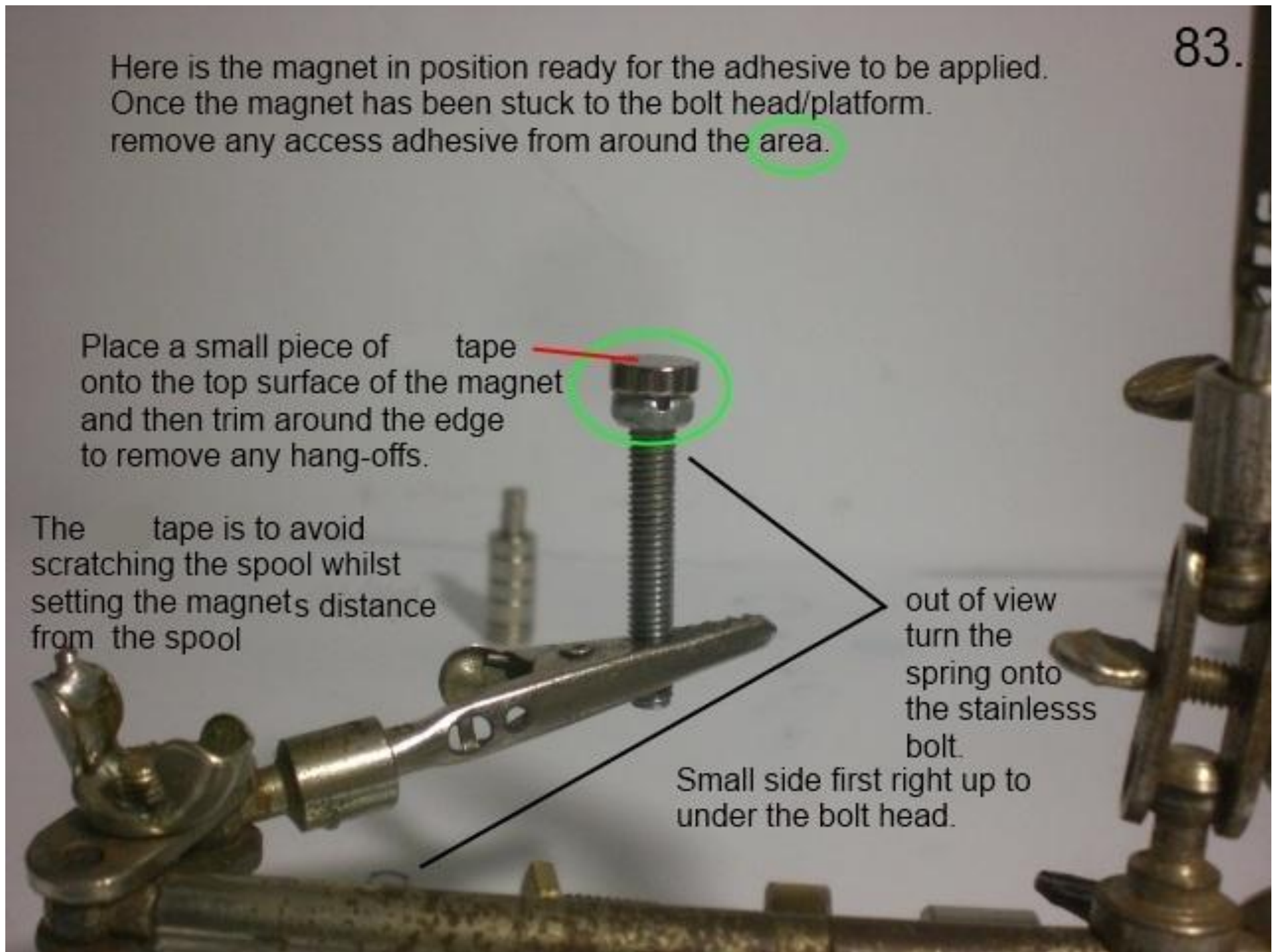


Here is the magnet in position ready for the adhesive to be applied. Once the magnet has been stuck to the bolt head/platform. remove any access adhesive from around the area.

Place a small piece of tape onto the top surface of the magnet and then trim around the edge to remove any hang-offs.

The tape is to avoid scratching the spool whilst setting the magnet's distance from the spool

out of view turn the spring onto the stainless bolt.
Small side first right up to under the bolt head.



84.

Spring is compressing against bolt head
when the mags are turned out



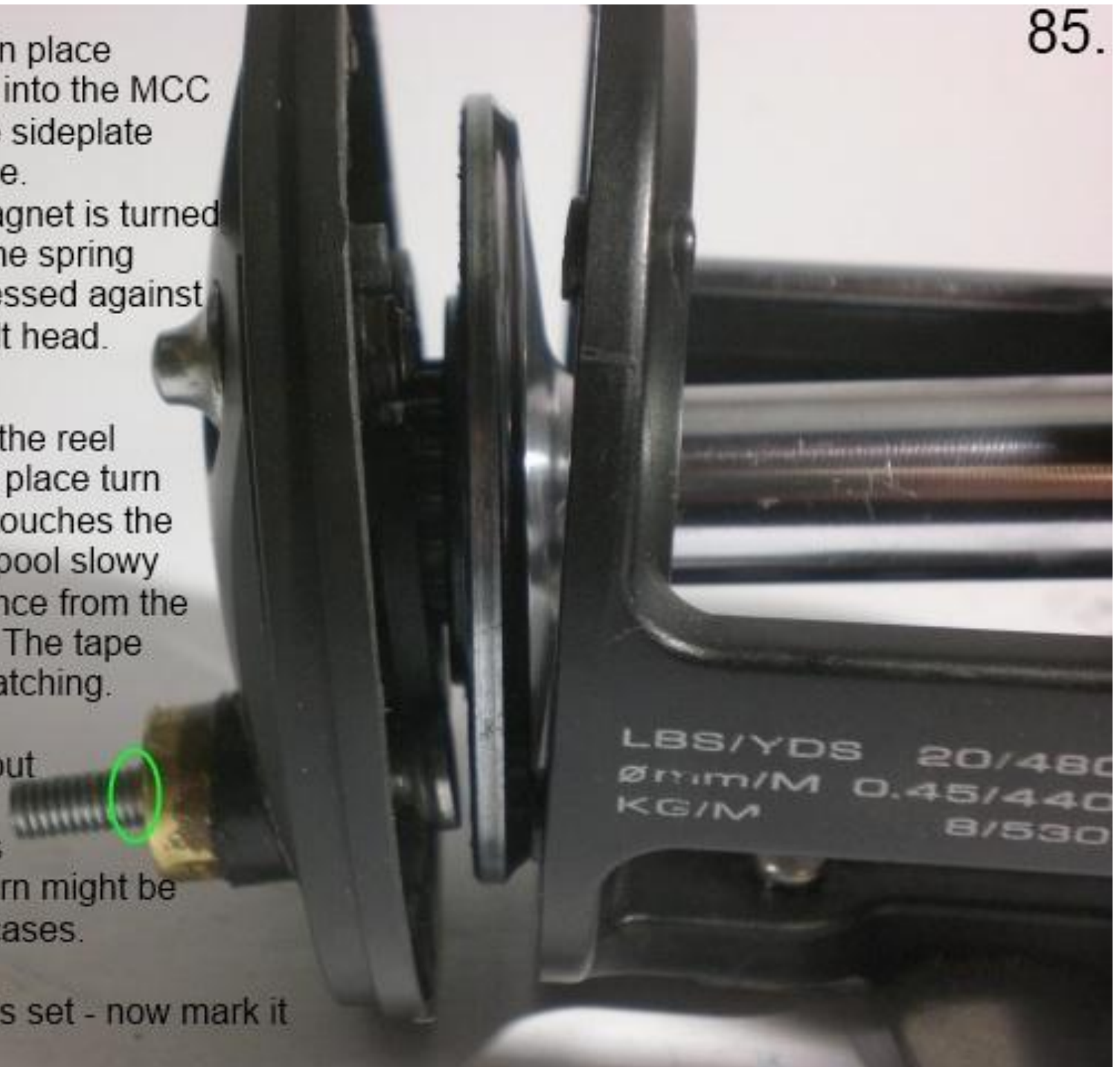
With the magnet in place run the bolt back into the MCC unit and place the sideplate onto the reel frame.

Make sure the magnet is turned all the way out. The spring should be compressed against the hexagonal bolt head.

With the plate on the reel frame and held in place turn magnet in until it touches the spool. Turn the spool slowly to feel the resistance from the magnet touching. The tape will avoid any scratching.

Make a half turn out so the magnet no longer touches the spool. A full turn might be needed in some cases.

Magnet distance is set - now mark it on the bolt.

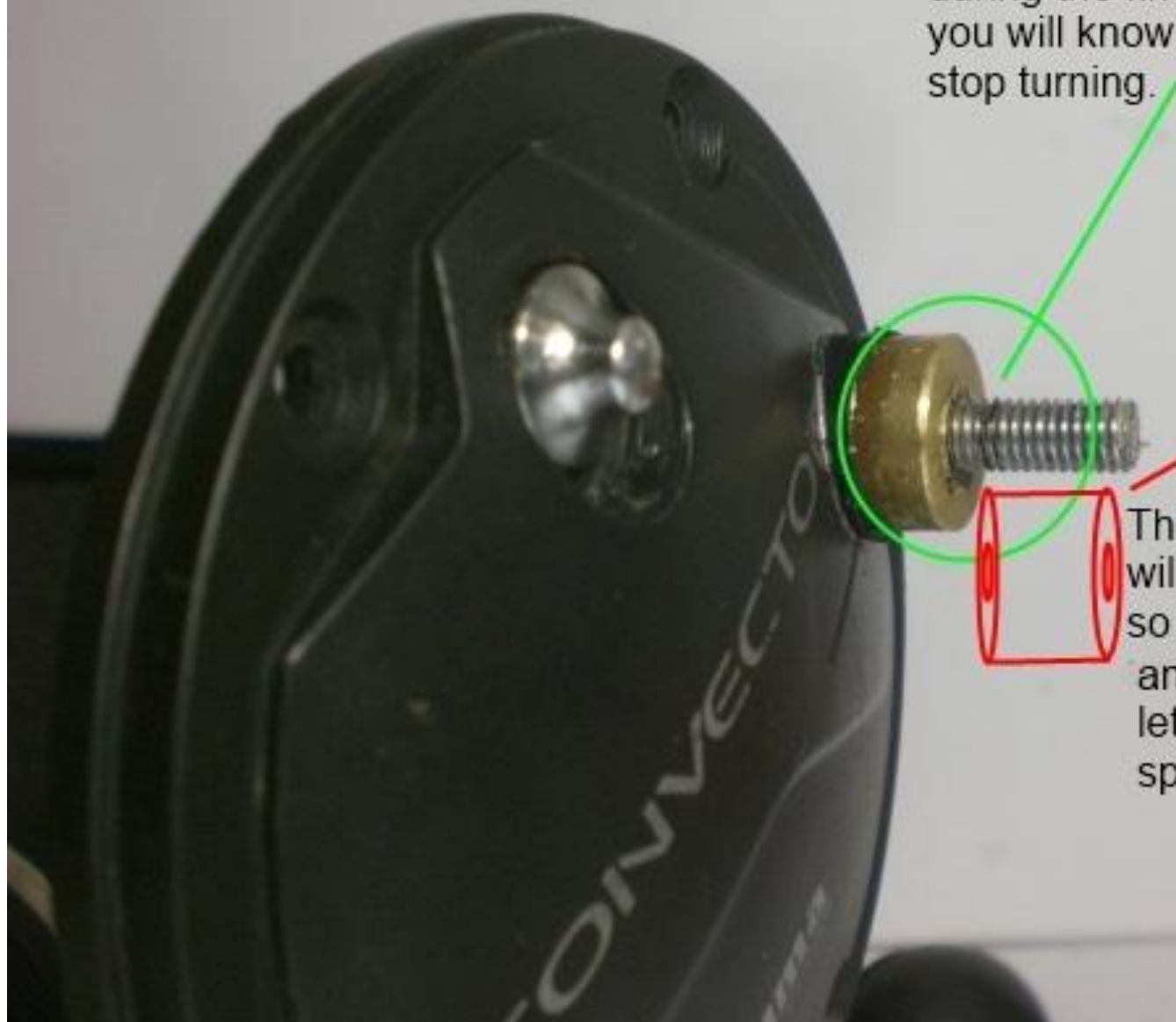


86.

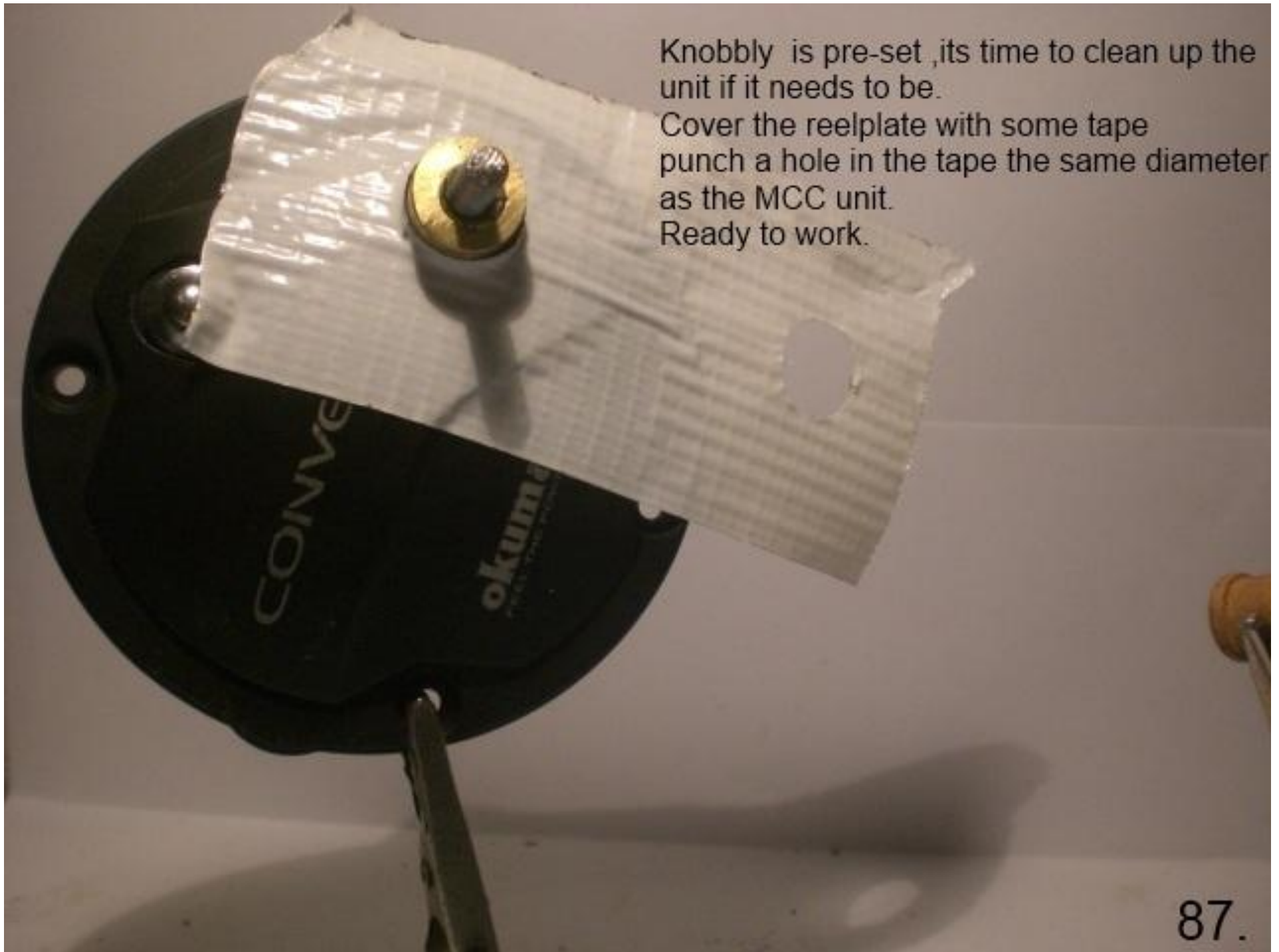
Mark the bolt with a permanent marker so when you turn the bolt in during the knobbly installation phase you will know when and where to stop turning.

imaginary knobbly

The knobbly installed will be positioned over this line so when it is turned back and forth the setting will not let the magnet scratch the spool.



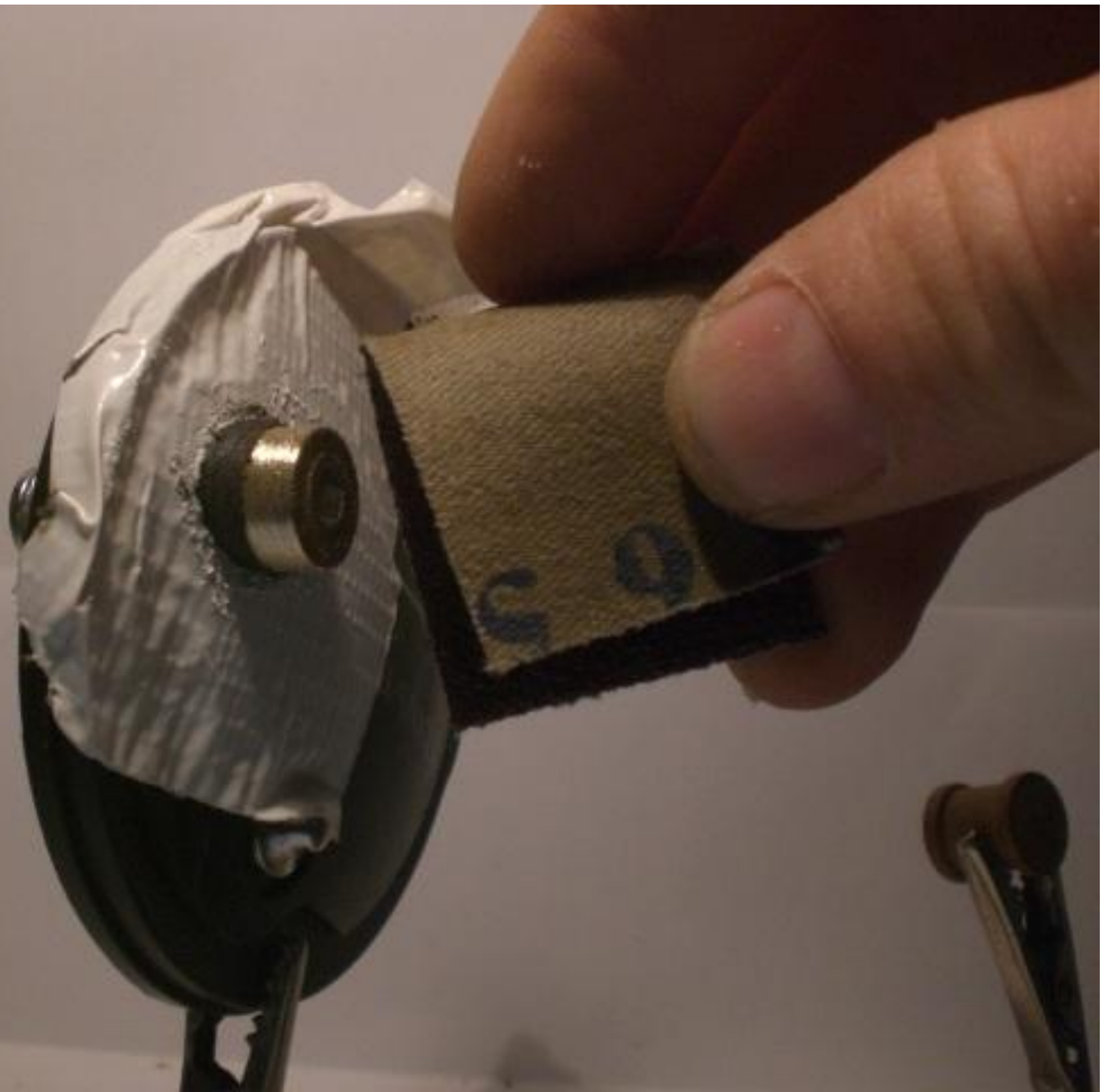
Knobbly is pre-set, its time to clean up the unit if it needs to be.
Cover the reelplate with some tape
punch a hole in the tape the same diameter
as the MCC unit.
Ready to work.



Taking some 40 grit sandpaper sand around the MCC in circular movements in order to clean and shine the material . removing any rough edges left from the previous processes



89.



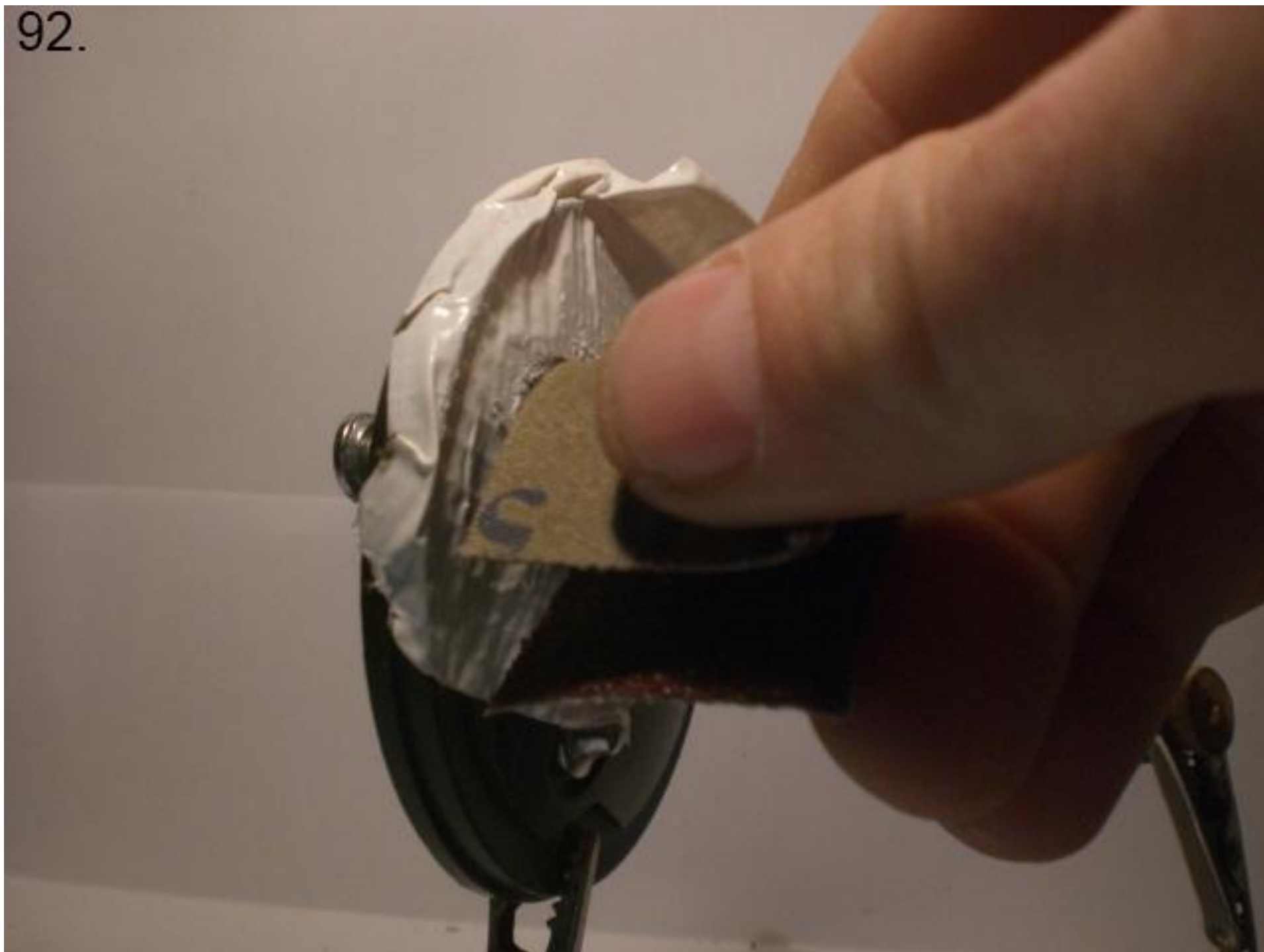
90.



91.



92.



Once it has been sand and cleaned properly remove the tape.
The unit should be looking almost complete at this stage..

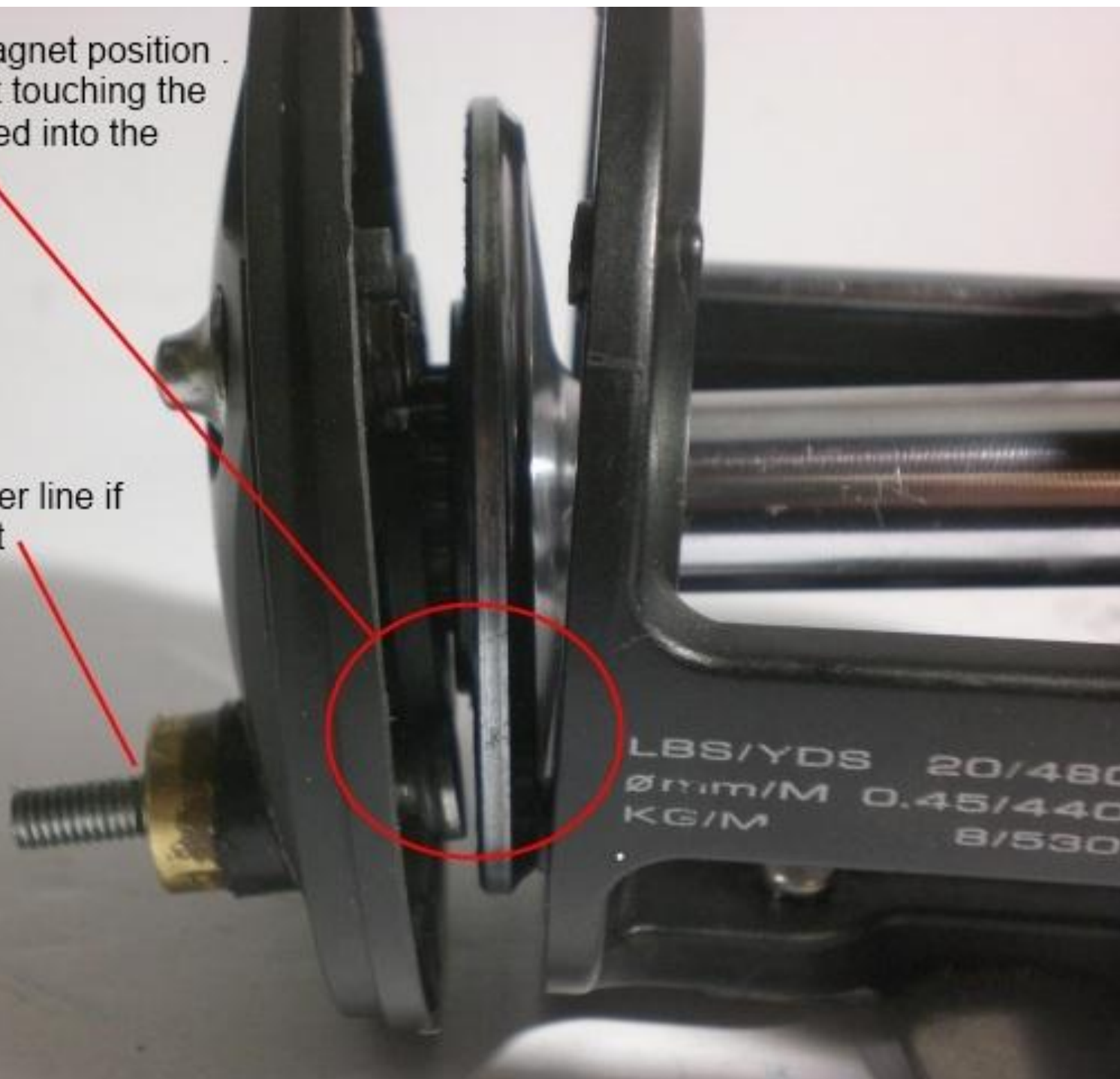


Ready for the knobbly



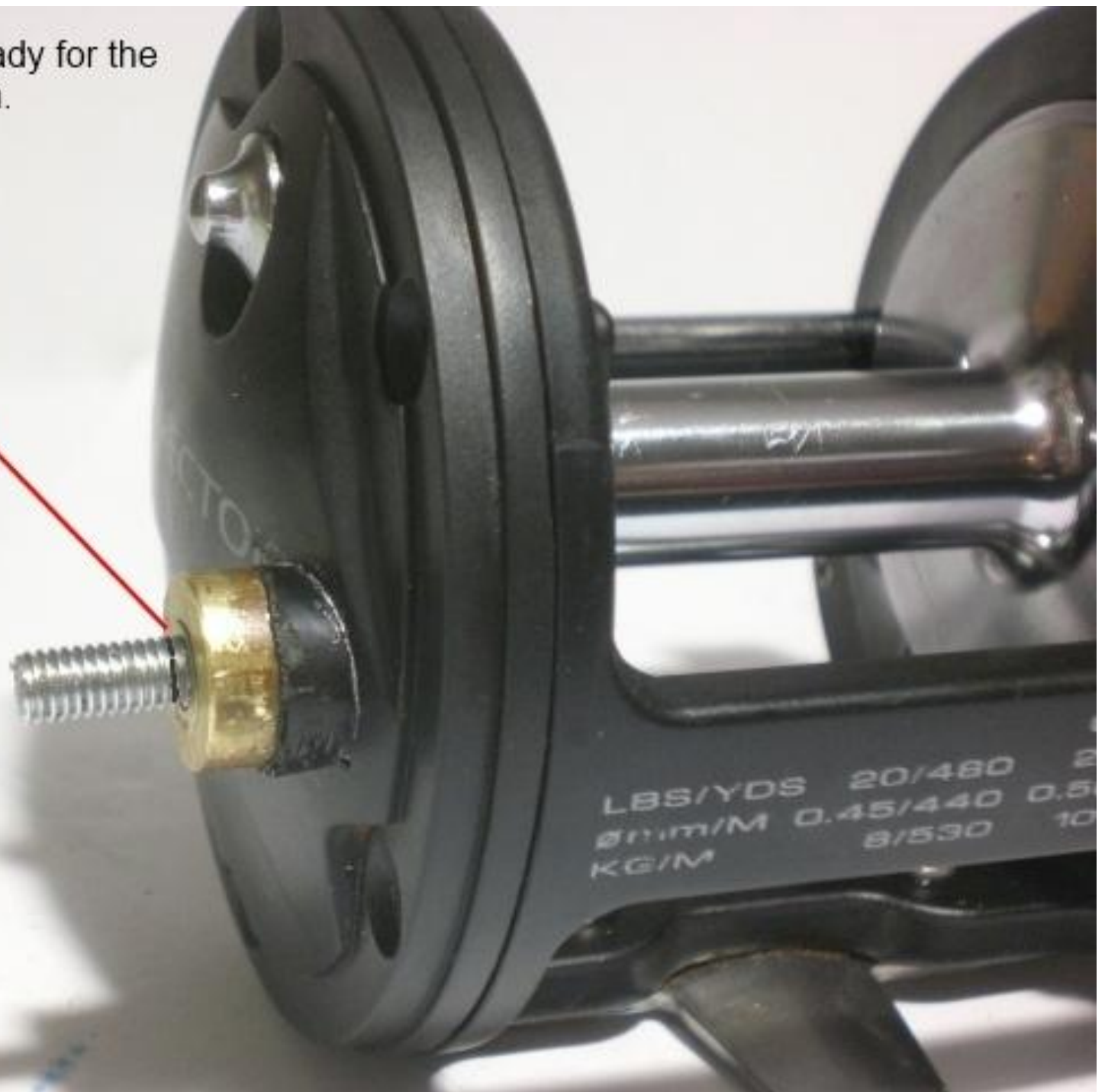
Recheck your magnet position .
Make sure its not touching the
spool when turned into the
full ON position.

Redraw your marker line if
it has become faint



In POsition and ready for the
knobbly installation.

Line mark.



RECHECK YOUR POSITION
AND SETTINGS.



LBS/YDS 20/480
Ømm/M 0.45/440
KG/M 8/530

RECHECK INTERNAL SETTINGS- VISUAL CHECKS



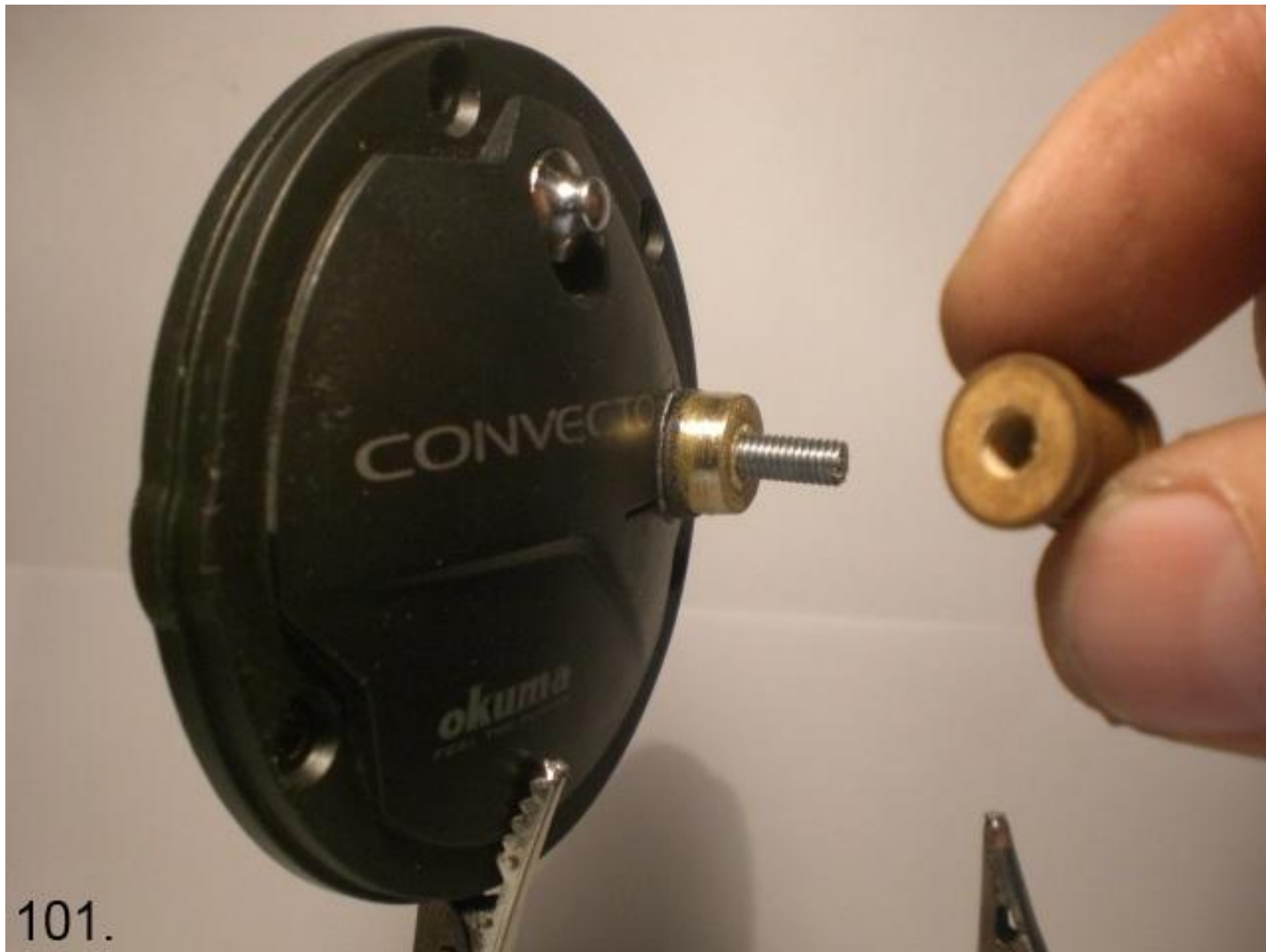


100.

the wooden bead is the basic fitting knobby.
Simply have the stainless bolt marked and turn the wooden bead
down until you cover your marker line.

If your bead is loose on the bolt then you will have to
secure it with adhesive. If it is to tight Turn another
bolt into the bead as if you are cutting a thread
into it. It should then turn on quite snugly.





101.



102.



103.



104.



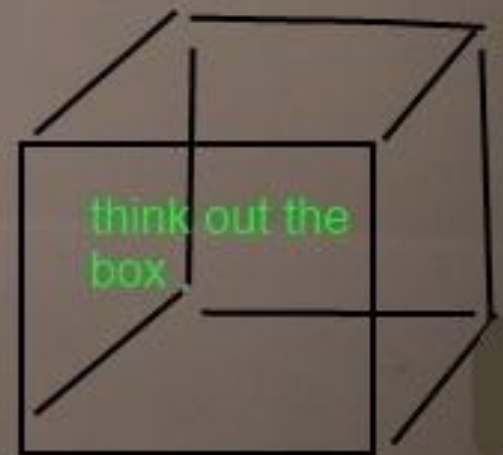
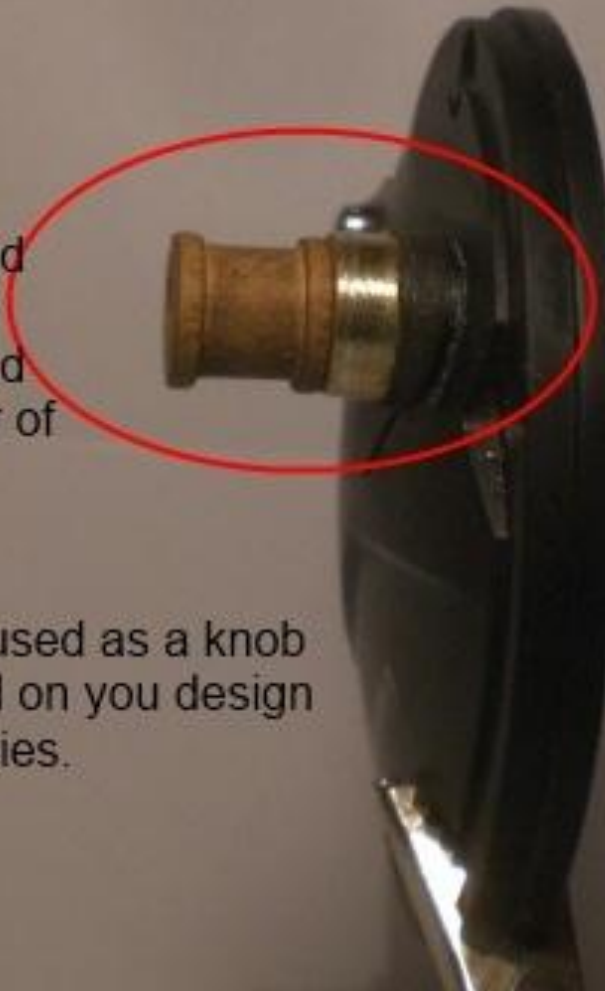
105.

straight forward and simple. Ready to fit onto the reel and go test cast.

The wooden bead can be secured with a half drop of superglue and it will still turn the magnet in and out quite well.

Shrink tubing can be used around the wooden bead in order to cover the wood and or change the colour of the knobbly.

Almost anything can be used as a knob at this point. It all depend on you design and imagination capabilities.





108.

Two parts to be used in this knobby installation process..



109.

This part will turn onto the stainless thread of the bolt that holds the magnet on its platform. It will eventually be secured with adhesive

Another explanatory angle..



This cap will fit over the T- shaped spacer to form the knobby adjuster.

110.

Turn the T-shaped spacer onto the stainless bolt end that holds the magnet on its platform. This is preparation for the knobby cap. Take note of your magnet settings as they might need to be adjusted whilst fitting this knob/cap.



Adhesive

Basic fitting idea

← Enlarged

111.



This area can be taken right down to 1mm as it is not needed to be so wide. Taking it down will allow more travel of the bolt /magnet thus giving the cap a better coverage of the brass collar.

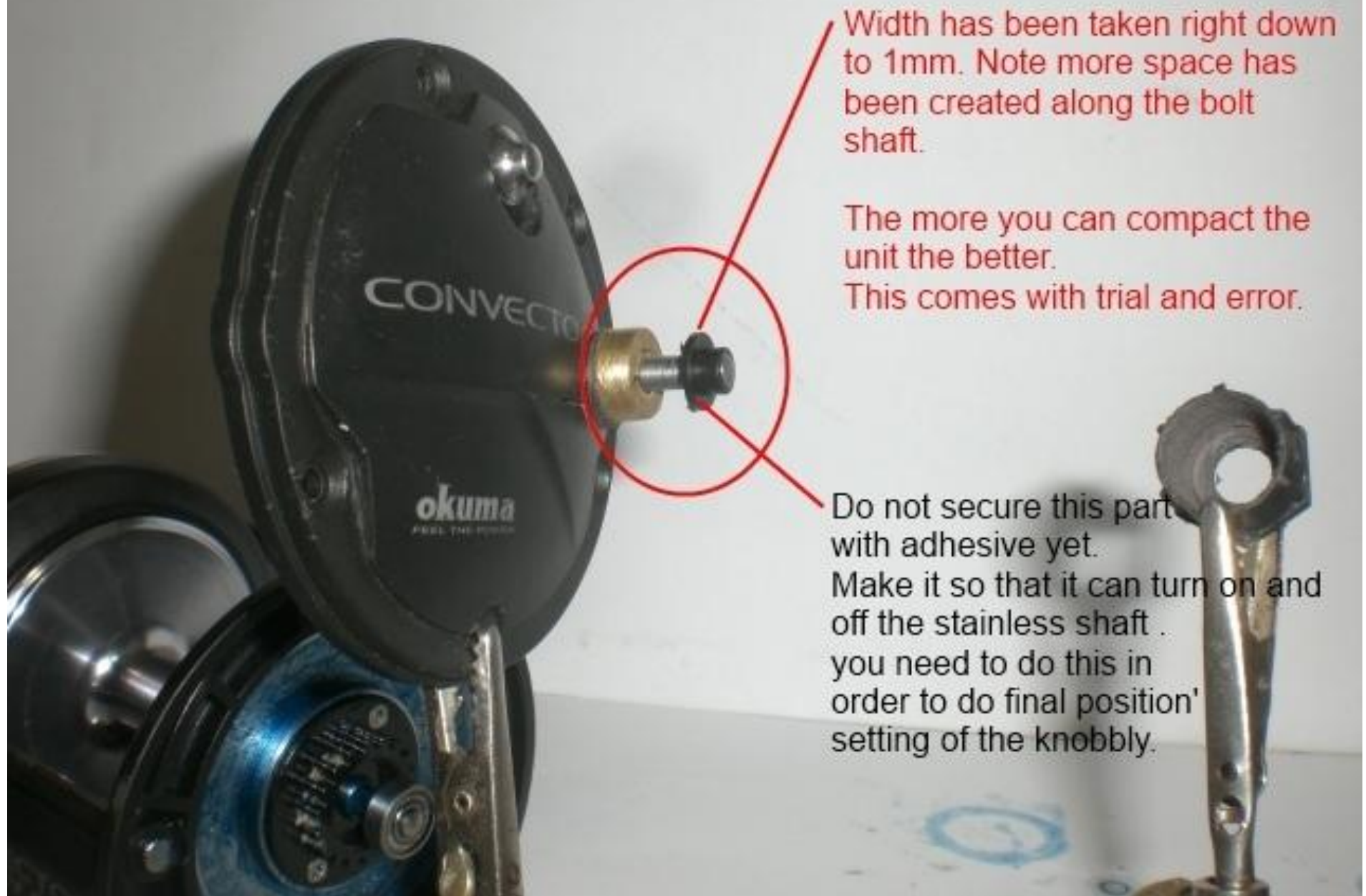
112.



113.



114.



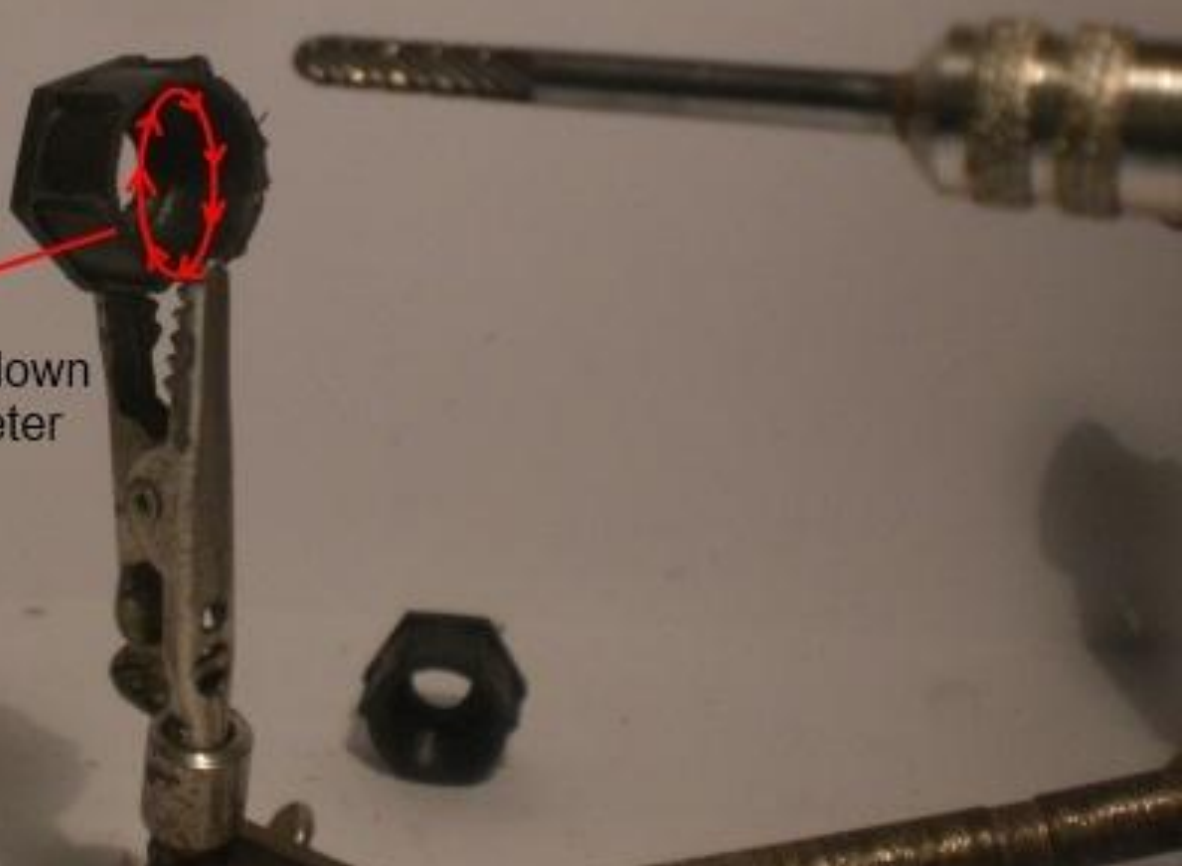
Width has been taken right down to 1mm. Note more space has been created along the bolt shaft.

The more you can compact the unit the better.
This comes with trial and error.

Do not secure this part with adhesive yet.
Make it so that it can turn on and off the stainless shaft .
you need to do this in order to do final position' setting of the knobby.

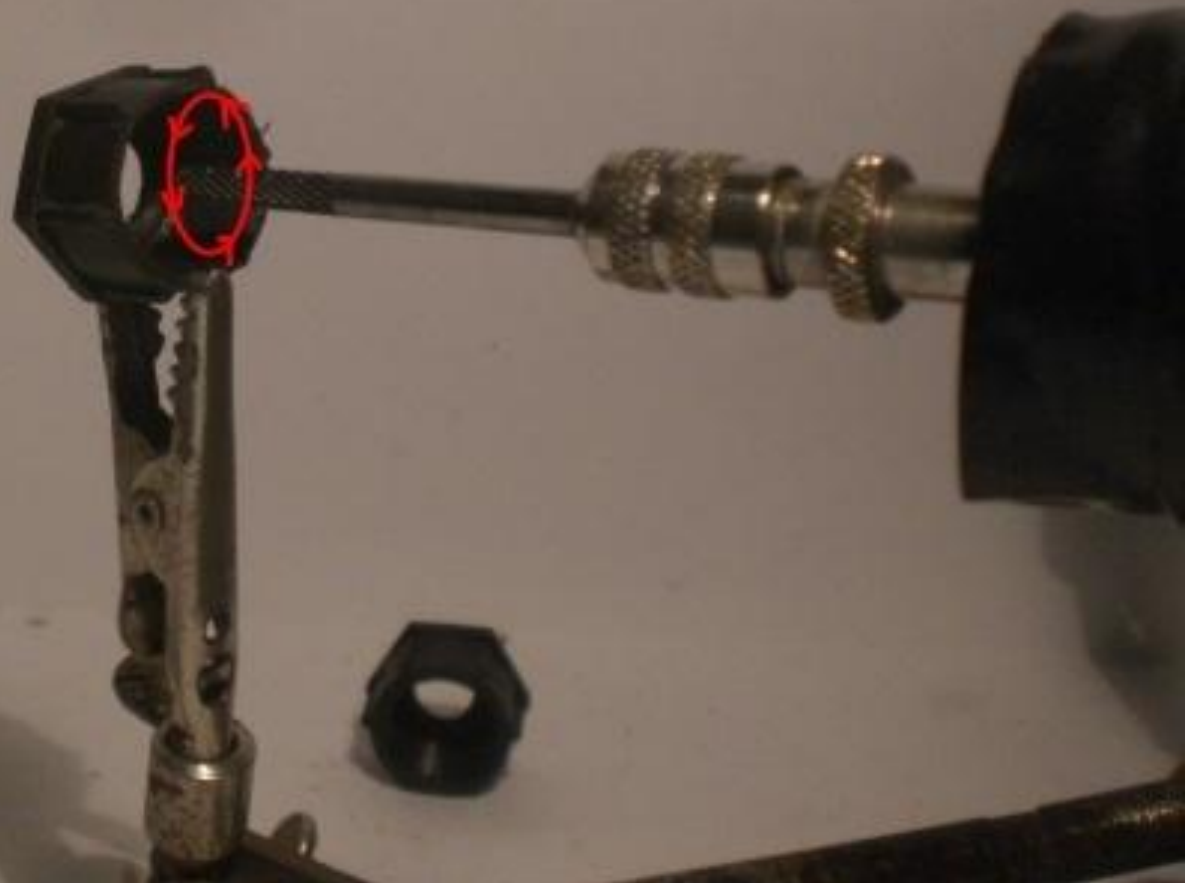
Open the internal diameter up with a dremal or a piece of rounded 40grit sand paper to 14mm. This will allow free movement over the brass collar when turning the magnets on to the full on position.

It also aids in making the unit very compact when magnets are on Hard.



Circular movements to take down the thread and open the diameter up to 14mm.

Opening the cap up to 14mm -



will
Sanding work just as well. turn the cap in both direction over the 40 grit
to remove the internal diameter to 14mm.



Twist and turn the cap over
the 40 grit sand paper.
Removing internal diameter
to 14mm.

118.

Cap can be placed over the spacer that is positioned on the stainless shaft. Lie the sideplate down horizontally so the cap is level when you apply the strong two part adhesive/epoxy. onto the inside of the cap.

SEE NEXT TWO PICS FOR ADHESIVE POSITION BEFORE APPLYING ADHESIVE..

This spacer must not be secured to the bolt with adhesive yet



119.



120.

Place cap over the spacer when you have applied the adhesive to the given positions. Adhesive can be seen bulging slightly out of this area.

Leave it to set in this position until it has cured.

The excess bolt and spacer with adhesive that is protruding can now be removed with the bastard file.

If you use a grinder to remove excess, use the grinder in brief intervals so the bolt and magnet do not get too hot.

Too much high heat damages the magnets power..

NB....



HOMESTRETCH - At this point the knobbly should be secure, but when turned out to its max off position it will lock at the spring point inside the reel allowing the unsecured spacer thread on the stainless bolt shaft to turn off.



122.

Take the sideplate off. Screw on the knobbly and find your desired position for the magnet setting. At this point you can secure the assembled knobbly onto the stainless shaft with adhesive.

Make sure it is not rubbing on the spool.

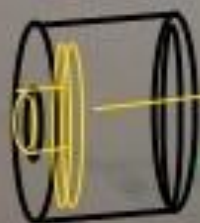


~~REMOVE~~ EXCESS SPACER AND BOLT.

Recheck your magnet position .
Make sure its not touching the
spool when turned into the
full ON position.

The yellow internal
spacer is secured into
the outer cap with
adhesive. The yellow
spacer threads onto
the stainless bolt.

Redraw your marker line if
it has become faint
before applying your adhesive



remove the tape
from the magnet

LBS/YDS 20/480
Ømm/M 0.45/440
KG/M 8/530

Mags set in the max ON position. Note that that cap runs over the brass bush.



Mags set in the Off position exposes the brass bush





GEAR RATIO 8.2:1
LBS/YDS 20/480 25/360 50/320
g/m/M 0.45/440 0.50/360 3.55/300
KG/M 8/530 10/440 12/360

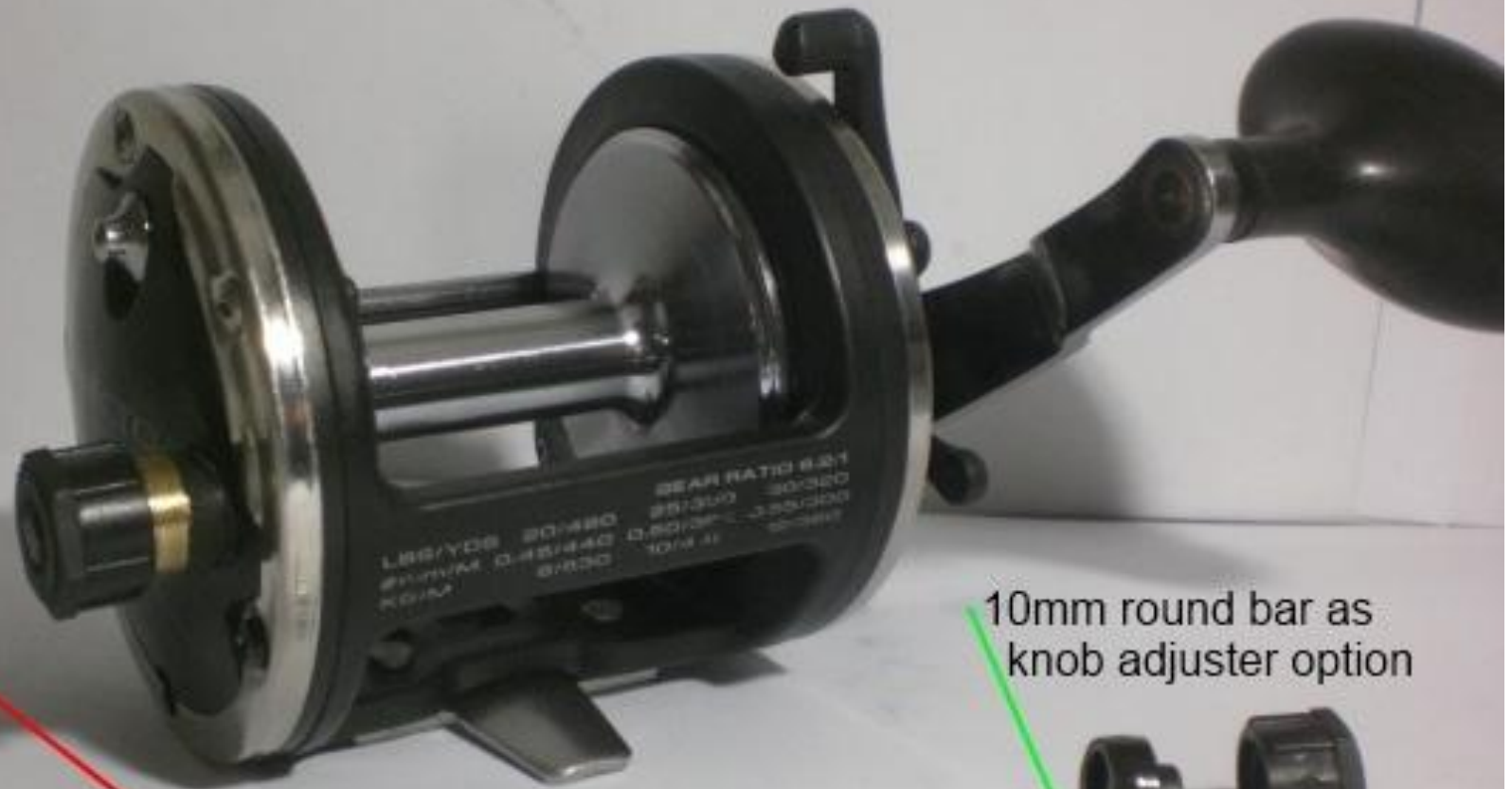
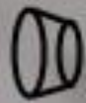
Magnetic Cast Control upgrade



127.

EXPLODED PARTS VIEW- Magnetic Cast Control COMPLETED

Heat over mag and platform then trim excess away. Leave magnet face exposed.



10mm round bar as knob adjuster option



128.

optional - shrink tubing over magnet once stuck to platform.