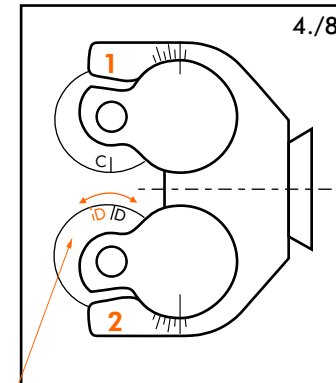




Quick guide of changing the rolls for similar thread

1. Take the tool out of the machine without the adaptor.
2. Open the cover of the tool's gear unit.
3. Remove the springs, the adjusting spindle and the medium gear-wheel.
4. Replace the thread rolls:
Side 1 = Roll C
Side 2 = Roll D
5. Check if thread rolls have axial clearance.
6. Reintegrate the gear-wheel, the adjusting spindle and the springs.
7. Synchronise the thread rolls.
8. Reintegrate the tool into the adaptor in Z- position.



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Quick guide of changing the rolls for different thread

1. Take the tool out of the machine without the adaptor.
2. Open the cover of the tool's gear unit.
3. Remove the springs, the adjusting spindle and the medium gear-wheel.
4. Replace the thread rolls:
Side 1 = Roll C
Side 2 = Roll D
5. Set new thread diameter in parallel position by means of the adjust gauge (gauge block).
6. Check if thread rolls have axial clearance.
7. Reintegrate the gear-wheel, the adjusting spindle and the springs.
8. Synchronise the thread rolls.
9. Reintegrate the tool into the machine's adaptor in Z-position.
10. Set new X-0 value by means of the micrometer adjust gauge.
11. Control the adaptor pendular adjustment.

