

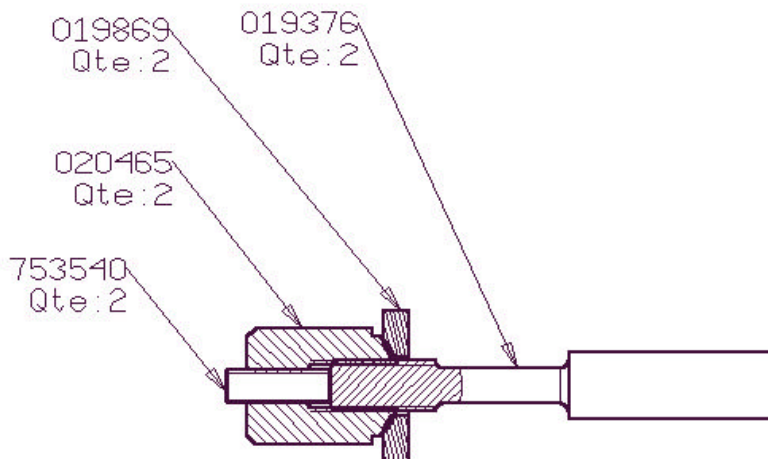
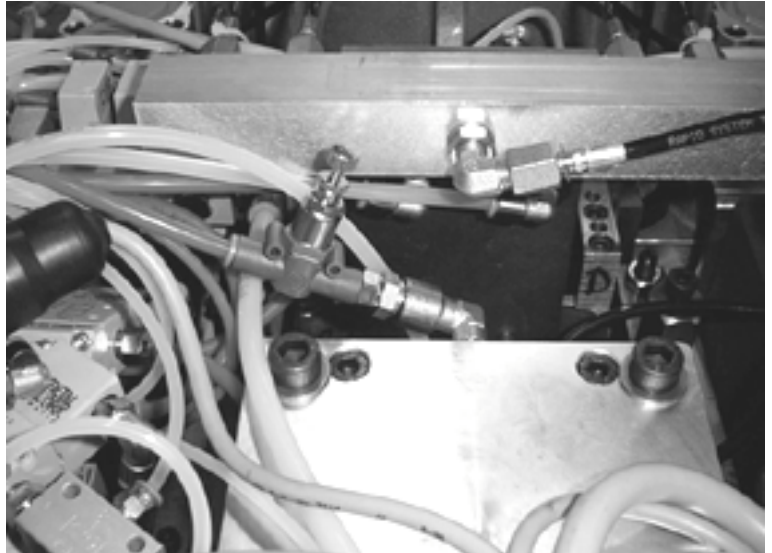
BREAKAGE OF CLAMPING BOLTS ON S 4.0

Due to recurrent breakage of clamping bolts **019376** and **018024** located into S 4.0 and upper models workheads, we have modified and improved the system in order to prevent this breakage.

1 – A pressure limiter set to 3 bars (**ref. 025599**) is added onto the air supply of the big aluminium clamping jack in order to reduce the strain applied on the bolts but with keeping at the same time a good clamping of the workhead (see opposite picture).

In case of clamping bolt breakage, this modification can be done on any S 4.0.
Part reference to order is : **025599**.

Note: On the latest S 4.0 Power models the 125 mm diameter clamping jack has been replaced by a 100 mm diameter jack. Therefore pressure limiter is not needed.



2 – The nuts (**ref. 020465**) which permits to set the position of the clamping bolts (**ref. 019376**) have been modified.

They have now on their bottom face a convex half-spherical shape which is in contact with a concave washer (**ref. 019869**; see picture). This permits to align the strains applied on the bolt with its axis. Therefore, the shearing strain which was causing the breakage is significantly reduced.

However to be perfectly efficient this modification needs a good setting of the clamping bolt position (See Technical Bulletin n°52).

All the S 4.0 Power machines with serial numbers over 352 included will be equipped with these upgrades.