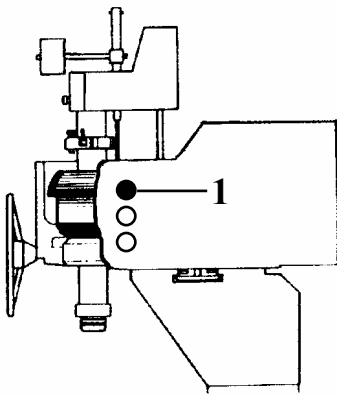
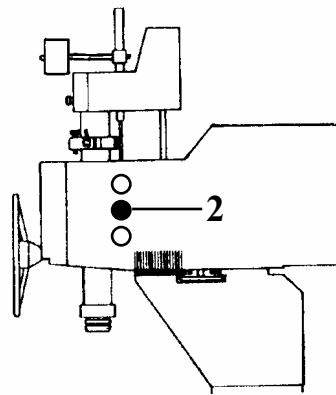


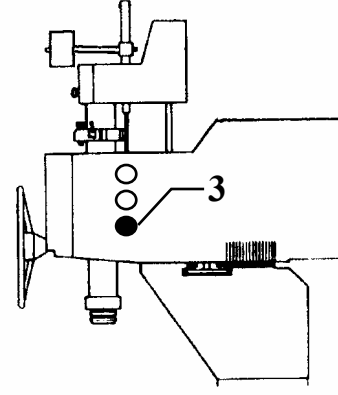
WORKHEAD AND SPHERE AIR REGULATORS (S60/S80/S100/M3.1)



1. Regulator for balancing of the sphere air flotation



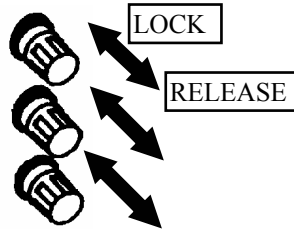
2. Regulator for head front air flotation



3. Regulator for head rear air flotation

(If the air regulators are located on top of the workhead, the No 1 will be the first you can reach).

These regulators can be locked. Before any adjustment, pull the regulator towards right and push it back once the adjustment is achieved. On the older models S100 and S60, there is a locking allen screw on the top of the cap.



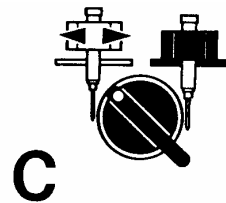
The regulators are preset at the factory. However, in case further adjustment is required, proceed as follows:

ADJUSTMENT OF THE WORKHEAD AIR FLOTATION

IMPORTANT: The spindle counterweight must be fitted.

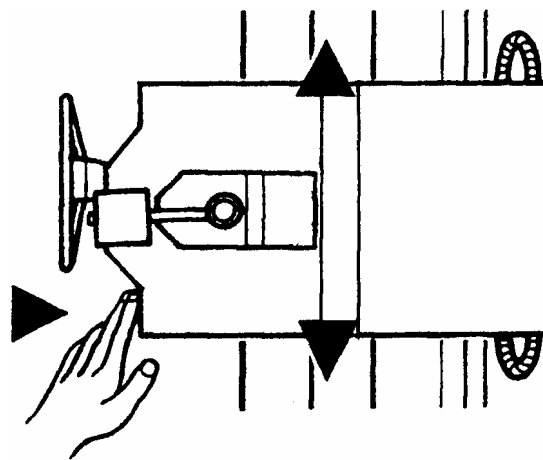
1st step :

- Shut down regulators 2 and 3 (turn counter clockwise).
- Release the workhead, switch C.
- Put full pressure on regulator 2 turning clockwise.



2nd step :

With the finger, push the head backwards and, simultaneously, **slowly increase pressure** on regulator 3. As the air cushion appears, the head moves.



3rd step :

Cut pressure on regulator 2 (Turn anticlockwise).



4th step :

Put pressure on regulator 2 until the head starts moving when pushed.



ADJUSTMENT THE SPHERE AIR REGULATOR

Leave the spindle at dead bottom point with the tool-holder and pilot fitted.

Shut down completely the air pressure on regulator **1** (anticlockwise) and increase slowly pressure until a smooth pendulum movement of the spindle is obtained.

Because of variations in the compressors setup, it should be checked that excess pressure at the bottom of the sphere will not lift it too much.

