

PRODUIT: SERDI	OBJET: REGLAGE DU BLOCAGE DE LA TETE
PRODUCT: 60/100/200	SUBJECT: WORKHEAD CLAMPING ADJUSTMENT

TOOLS REQUIRED:

- 1 set of thickness gauges. The gauges required are 0.15 mm and 0.25 mm.
- 2 19 mm spanners.
- 1 6 mm ALLEN key.

OPERATING MODE:

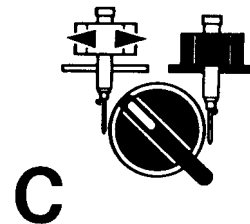
It is compulsory to follow the correct sequence:

- 1- checking the plane air flotation.
- 2- adjustment of the clamping bar parallelism with the height screw 18 and the clamping nut 15.
- 3- adjustment of the clamping backlash with the nut 14 and the lock-nut 15.

1. CHECKING THE PLANE AIR FLOTATION

Release the workhead , switch C.

Check that the head movements are strainfree and that air pressure is 5 bars min. If not, please report to the operator's manual, page 12.

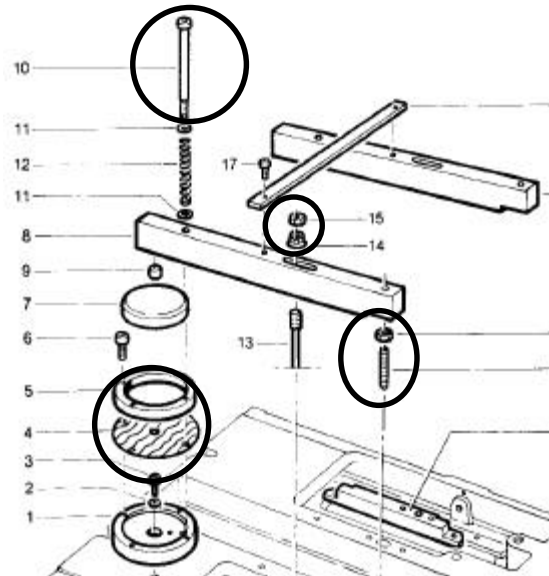
**2. CLAMPING BAR PARALLELISM**

The whole clamping device must be assembled, and particularly the screws 10, to avoid that the diaphragms 4 should be destroyed, before unclamping the head.

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Operate the pneumatic head unclamping. Adjust the nut 14 and the lock-nut 15 so that the nut 14 basis and the bar 8 upper surface should be flush. Move the head to the back and to the front and with the nut 15 and the screw 18 adjust the bar height until the nut 14 basis should be parallel to the bar 8. Adjust the parallelism with the thickness gauges in both extreme positions of the head.



The same operation must be done for the other bar 8. Check the first bar adjustment. Both bars are linked through the cross-bar 16, so the adjustments are not independant.

When the adjustments are good, lock the nuts 15 while keeping the screws 18 in position with the 6 mm Allen key.

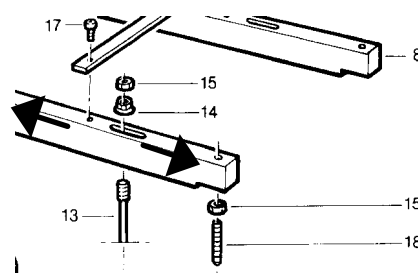
The backlash between the nut 14 basis and the bar 8 must be 0.2mm +/- 0.05mm.

3.CLAMPING BACKLASH ADJUSTMENT

The backlash value of 0.2 mm is obtained by modifying the nut 14 tightening.

Always verify the backlash value in both extreme positions. The 0.15 mm gauge must pass between the nut 14 basis and the bar, and the 0.25 mm gauge must not.

Lock the nut 14 and the lock-nut 15 with the two keys of 19.



IMPORTANT: Lock and unlock the head several times once the good backlash value is obtained. The adjustment must generally be done again after this operation.

Do the same with the other bar. The same controls must be done on both sides before considering that the adjustment is OK.