

**PRODUIT: SERDI**  
**PRODUCT: 60/100/200****OBJET: REGLAGE DU DEGAUCHISSAGE DE LA TETE**  
**SUBJECT: WORKHEAD STRAIGHTENING ADJUSTMENT****TOOLS REQUIRED:**

- 1 set of thickness gauges. The gauges required are 0.15 mm and 0.25 mm.
- 2 19 mm spanners.
- 1 5- or 6-mm ALLEN key (according to the machine).

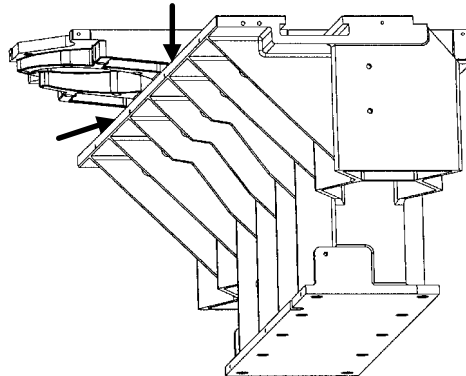
**CAUTION:**

Use the machine with care! Too many shocks are resulting in increasing the play in the different parts of the machine. Particularly, avoid shocks on the side head stops, that would save you reading this technical bulletin!

**OPERATING MODE:**

**1** Remove both head covers.

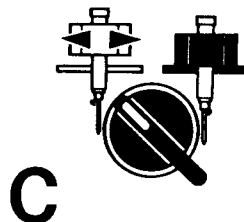
**2** Unlock the plane air flotation, set the head straight to the guides. The front edge of the workhead guides should flush the front edge of the upper bed guide ( See arrows).



Leave the head in this position by shutting regulators 2 and 3 (turn anticlockwise).



During the following steps, be sure that the head is always in this position.



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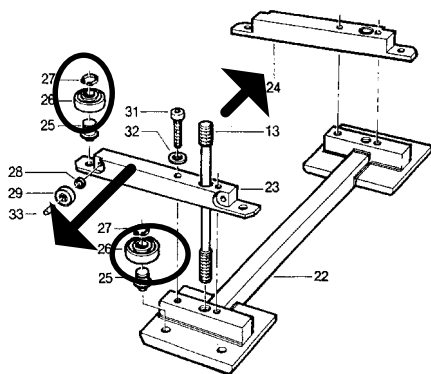
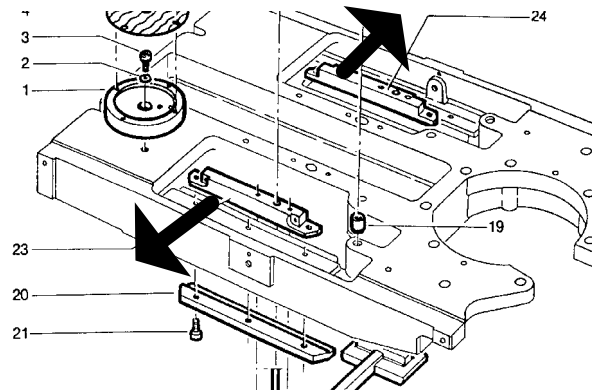
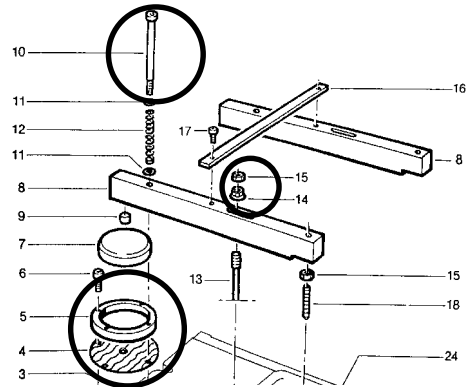
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 SUBJECT: **WORKHEAD STRAIGHTENING ADJUSTMENT**

**3** Remove the cross-bar rep. 16 by unscrewing screws rep.17.

Remove both clamping bars rep. 8 and 16. For this, unscrew only both nuts rep.14 and 15 from the workhead bolt rep.13, and unscrew both screws rep 10.

**DO NOT LOCK THE HEAD :**  
 That would destroy diaphragms rep.4 !

**4** Unscrew the screws rep. 31. Firmly maintain the guiding bar rep. 23 against the rolling surface of the head body, while pushing the workhead bolt rep.13 towards the head center. Lock the screws rep.31. Do the same with the guiding bar rep.24.



**5** With both hands, raise the mobile clamping bar rep. 22. Check that it falls down without wedging when free. Re-operate the plane air cushion by screwing the head regulators. Give a rotating movement to the head , and check that the four bearings rep.26 are in contact with the rolling surfaces.

If any of those points are not OK, please begin the adjustment again from point 4.

**6** Mount the clamping bars rep.8. Lock the screws rep.10, and fit the M12 nuts rep. 14 and 15 on the head bolts rep.13. Fit the cross-bar rep.16 and the screws rep.17. Tighten the M12 nuts to obtain a play of about 0.2 mm between the shouldered nut basis rep.14 and the bar 8. The 0.15 mm gauge must pass, and the 0.25 mm

gauge must not. Operate the head lock and unlock several times. Check that the clamping assembly movements are strainfree. If not, the tightening of the clamping bars must be decreased, the adjustment must be remade from point 2.

**7** Fit both head covers.