



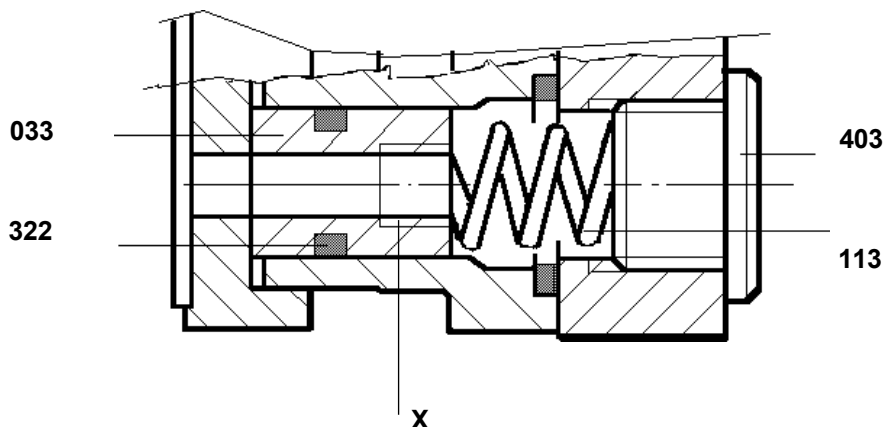
The mechanical moving parts of the turret are permanently lubricated.
The lubricant must be renewed only after eventual complete dismantling of the turret.
The lubricant, with viscosity 80 SW 90, must be compatible with rubber and teflon.
The following table indicates the quantities to be used.

Turret size	Quantity of oil Kg
TOE 120	0,5
TOE 160	0,7
TOE 200	1,5
TOE 250	2
TOE 320	4
TOE 400	4,5

SUBSTITUTION OF THE COOLANT BUSHING

Take off the airtight plug or the feeding pipe connector of the coolant, take off the spiral spring; then extract the bush 033 complete of O - ring by using a suitable thread X.
Clean the seating from any eventual incrustation, grease the outside part of the new bushes complete of O - ring, then insert them in their seating and check the sliding.

	TOE 120	TOE 160	TOE 200	TOE 250	TOE 320	TOE 400
X =	M8 x 5	M8 x 8	M10 x 8	M12 x 8	M16 x 8	M16 x 8





Remove the rear cover 011, disconnect the leads connecting terminal block to the motor, the brake and the thermal probes (heat sensor). Unscrew screws 311, extract the motor unit 150. Disassemble the gear 015 and remount it on the new motor unit. Mount the motor unit in the carcass and reconnect the electric wiring to the terminal block.

To check that the phases are properly connected, perform a tool change by calling up the nearest station... If the phases are properly connected, the change of station will take by the shortest route, if the disc goes the long way round then interchange two motor supply wires at the terminal block (phase rotation).

Replace the rear cover.

SUBSTITUTION OF THE PRE - INDEXING ELECTROMAGNET

Remove the top cover 044, remove the support 042, remove the washers 046a, extract the electromagnet 200.

Remove the rear cover 011 and disconnect the electromagnet supply leads.

Mount the new electromagnet in the carcass and fix it down with the two washers.

Replace the support complete with its proximity switch 301 and reset it (see page 22).

Connect the electromagnet lead wires to the terminal block (see electrical connection schemes page 8).

Replace top and rear cover.

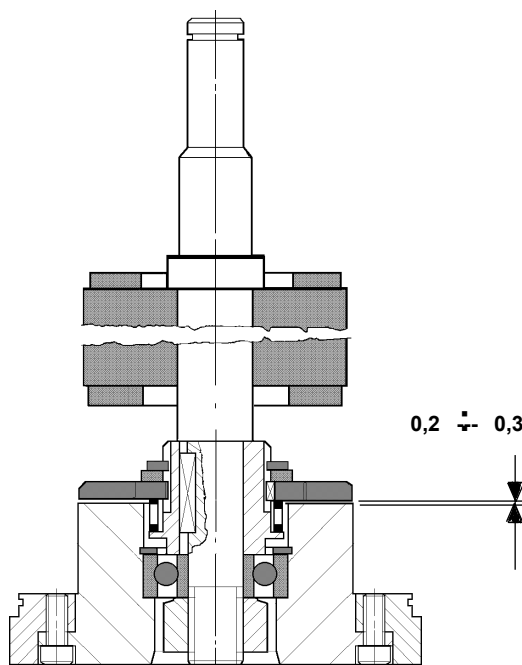
SUBSTITUTION OF THE BRAKE MAGNET AND ADJUSTMENT OF THE AIR GAP

Remove the rear cover 011, extract the motor unit 150 and the gear 015.

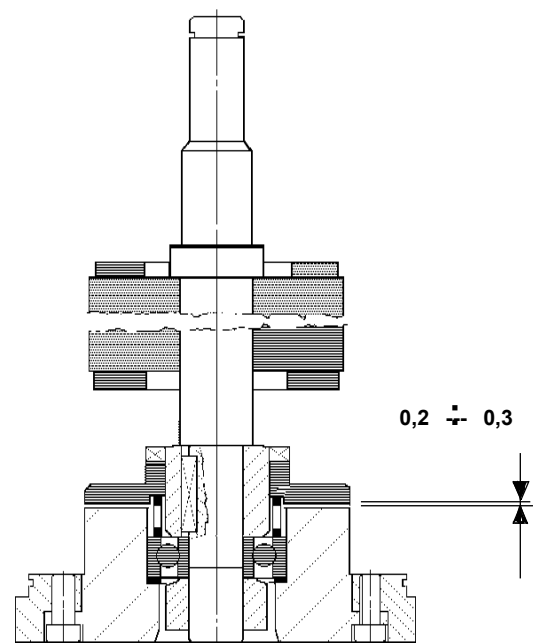
Disconnect the brake leads. Remove the defective brake magnet and substitute it with the new one.

Adjust the air gap (0,2 - 0,3 mm to be checked in a vertical position and acting on the distance pieces 090).

Reassemble the whole by following the above sequence in reverse.



TOE 120 - 160 - 200 - 250



TOE 320 - 400