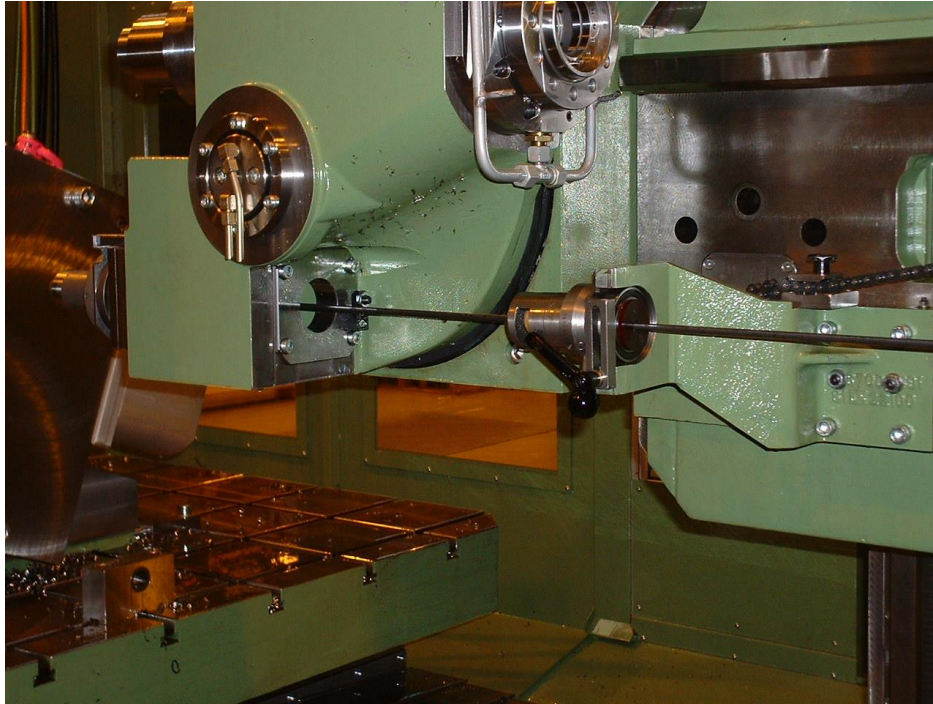
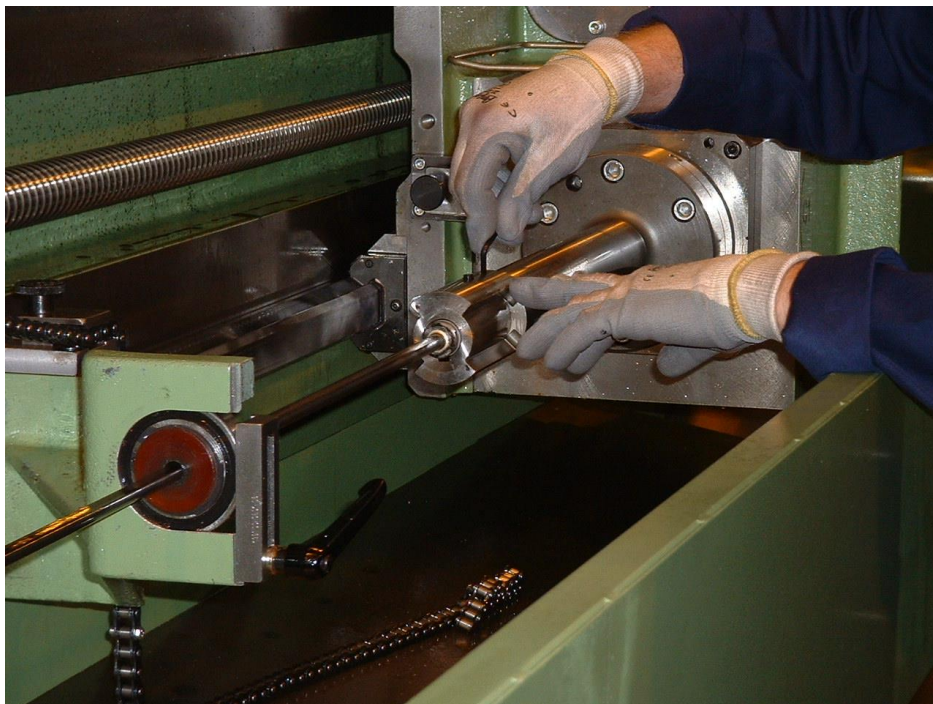


**Note:- Before starting ensure the M41 gear range is selected.
(in MDI input M41 and press cycle start.)**

- Unlock and remove the sealing unit.



1. Manually jog drive shaft (C1) so that the grub screws are to the top.
2. Release the screws.



- Manually jog the drive unit back to 'W+' soft limit.



1. Remove the chain from the 3-off locking positions.
2. Release the 3-off bearing support guides.

- Lift the gun drill with fittings clear and stand to drain.

1. Make sure the 'O' ring is in the back of the pull stud.



- Remove the driver. (6-off cap screws)



- Allow to drain.



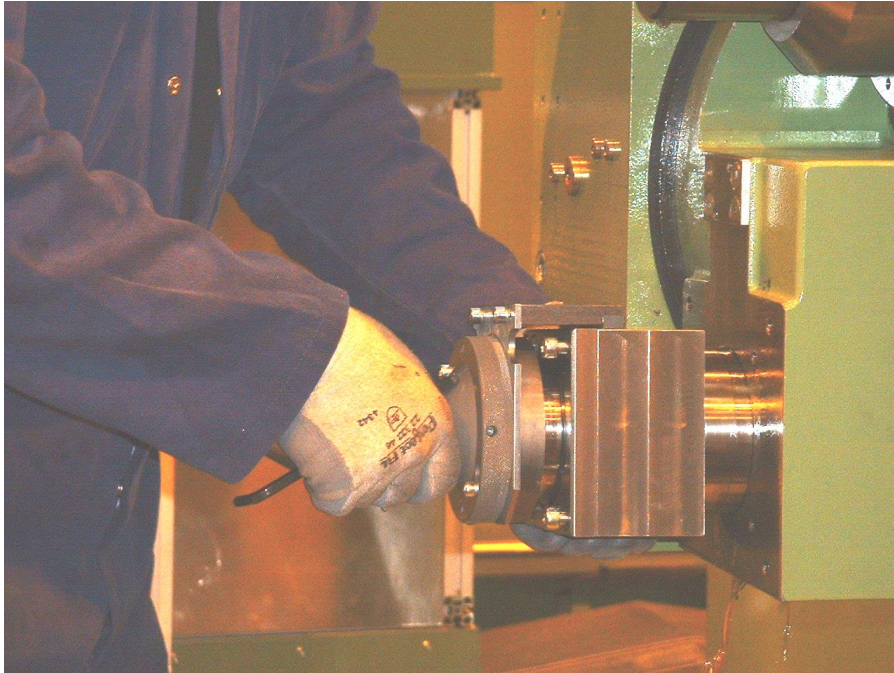
- Remove the 3-off bearing support guides.



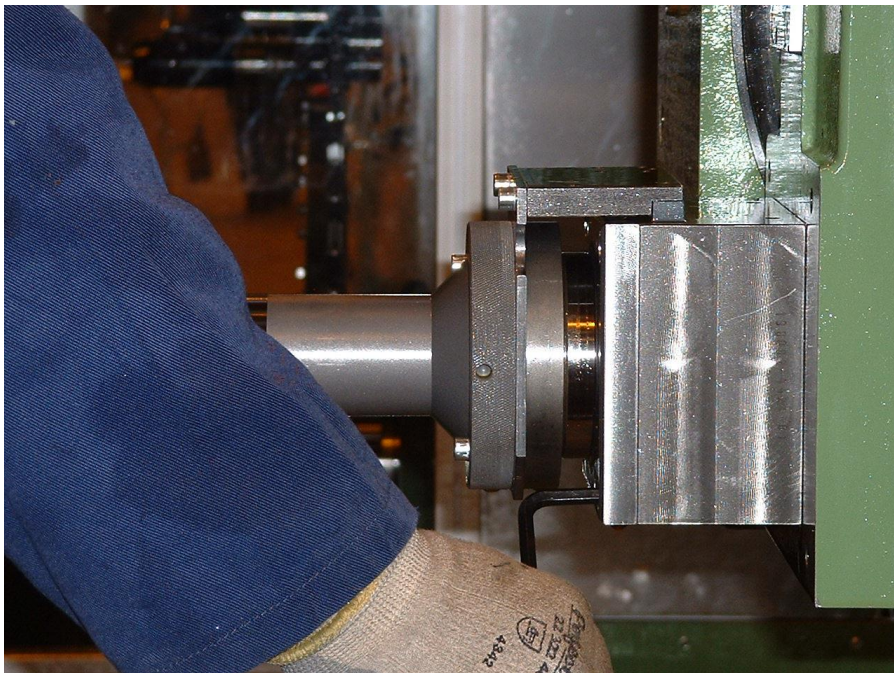
- Remove the housing for the sealing unit.



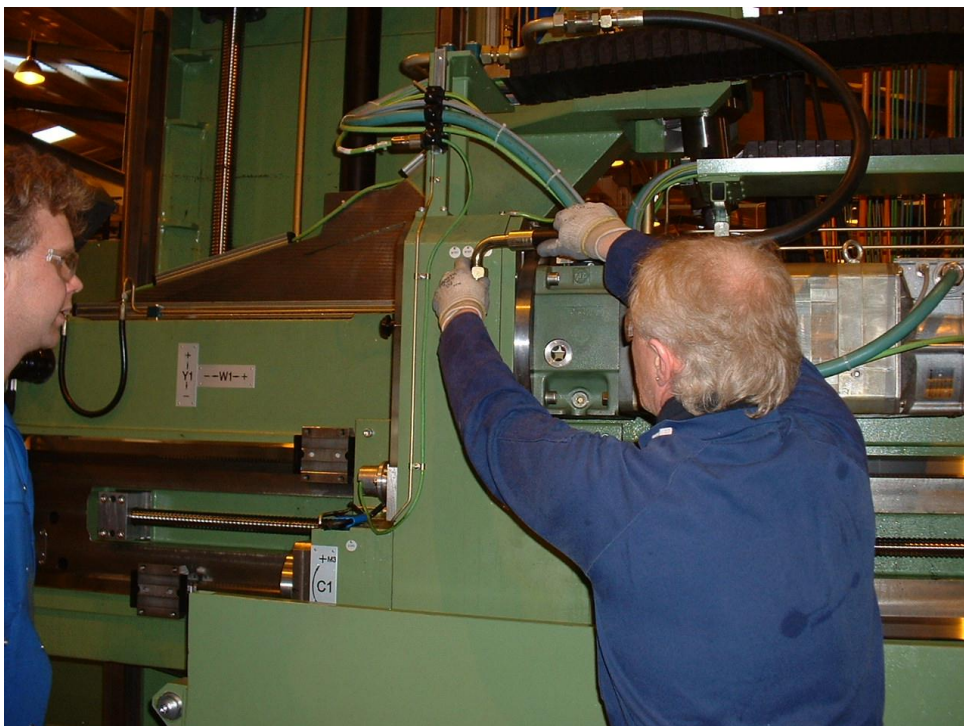
- Remove the drill bush if required.
 1. Loosen 2-off cap screws.
 2. Twist and turn to remove.



- Otherwise remove the drill bush carrier and drill bush intact.



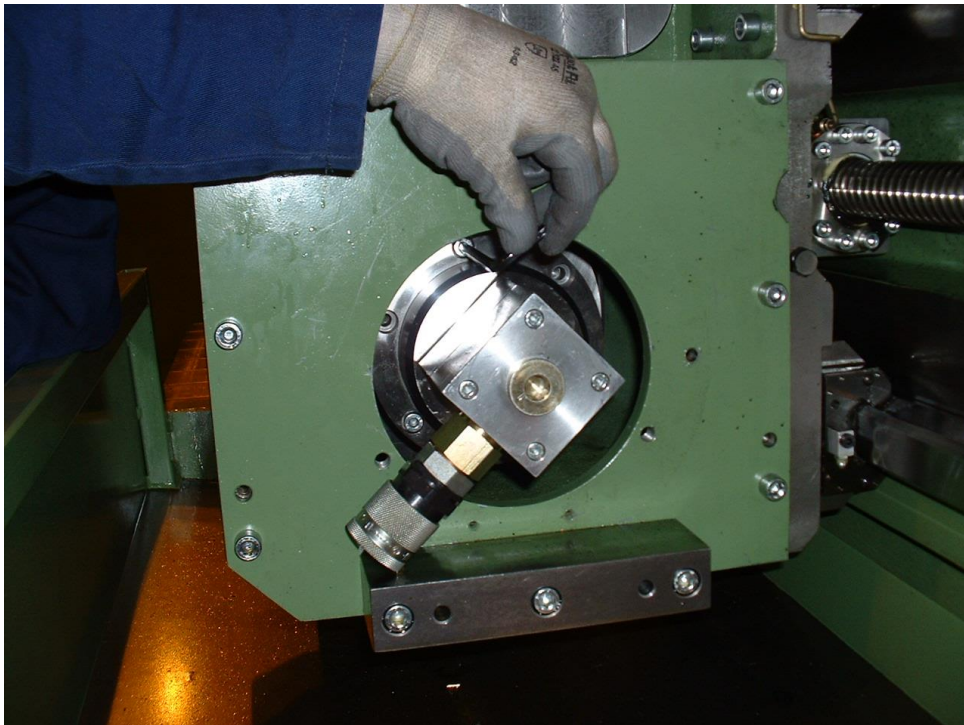
- Change the position of the coolant hose.



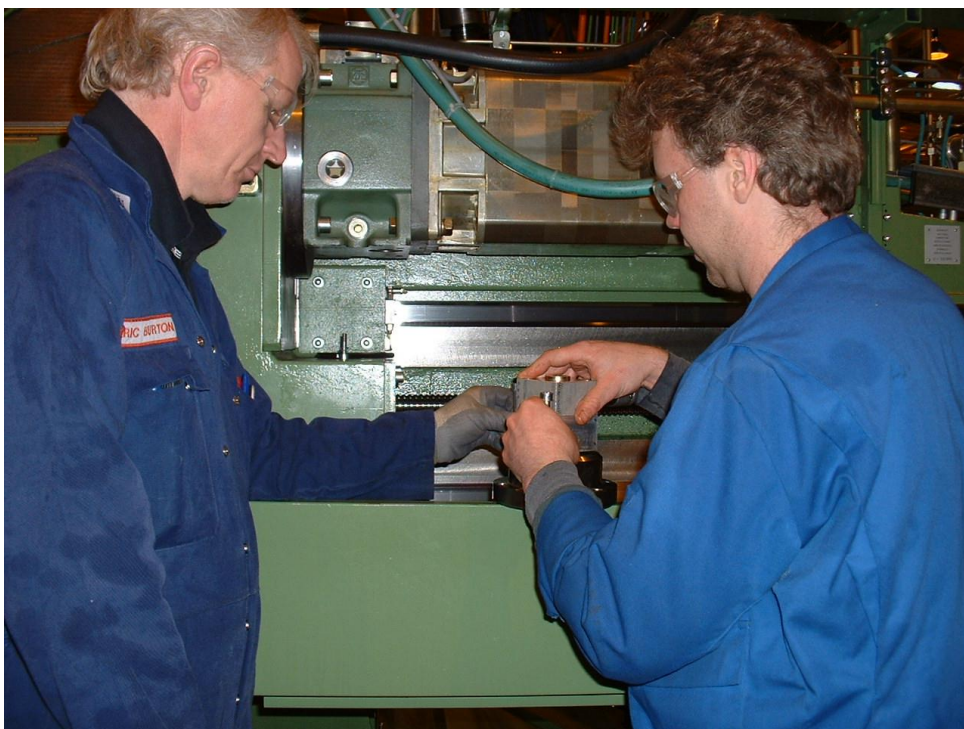
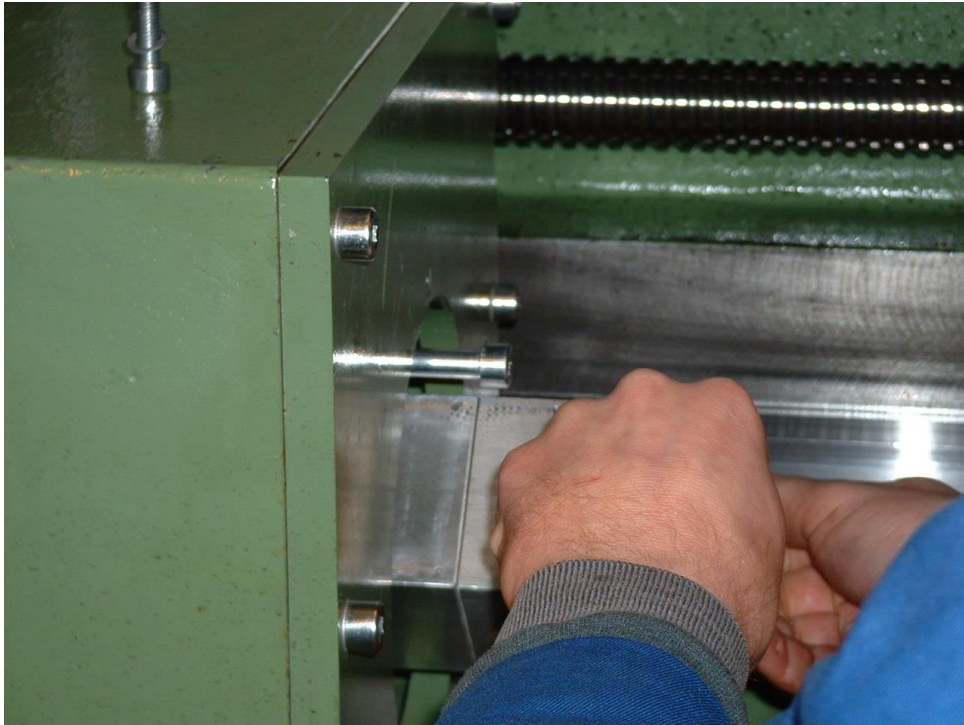
- Remove the coolant hose adaptor support plate.



- Remove the coolant hose adaptor.(only using 3-off cap screws)



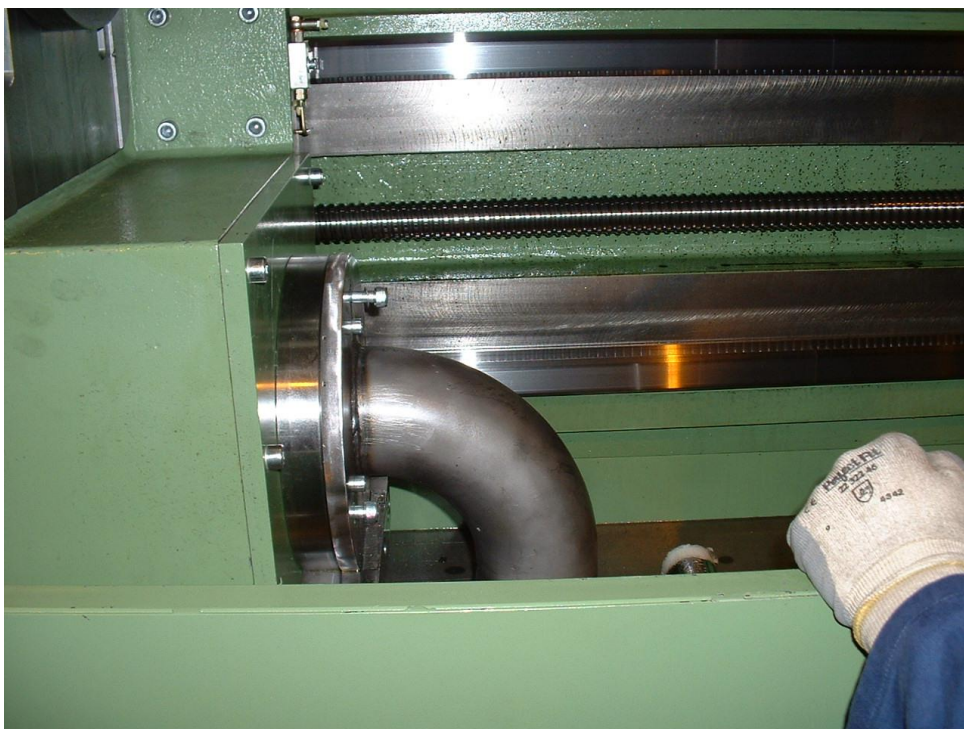
- If there is a problem removing the coolant hose adaptor?
 1. Use the modified broom handle and chap through from the drive shaft end.



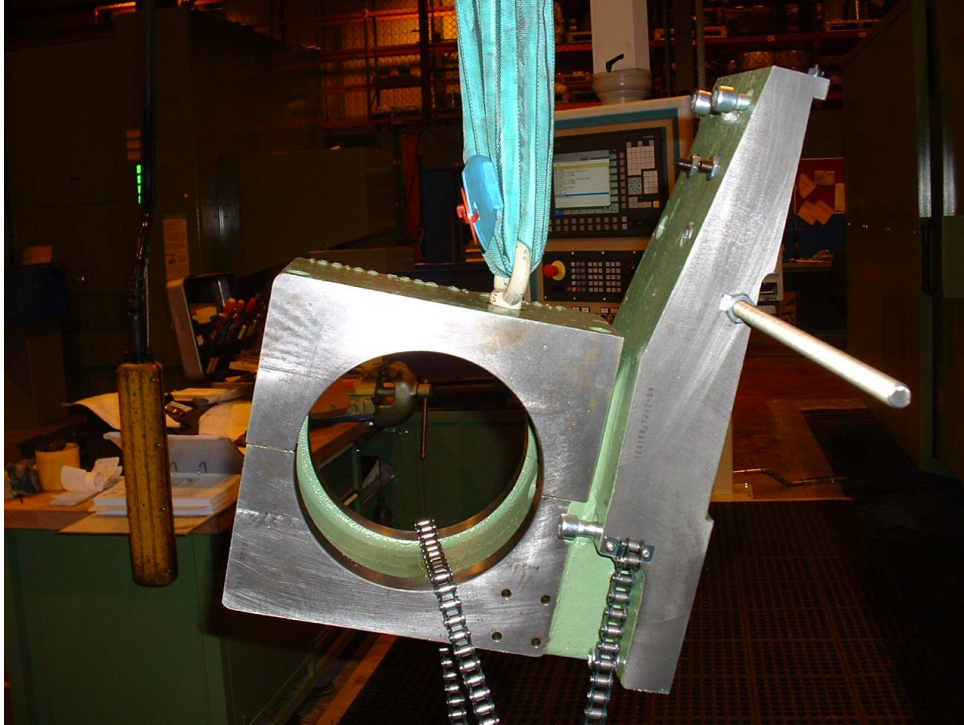
- Assemble the oil outlet using 3-off cap screws.



- Bolt in place the oil outlet chimney.



- Load the ejector drill dampener unit.



- Use slide blocks 2 and 3.





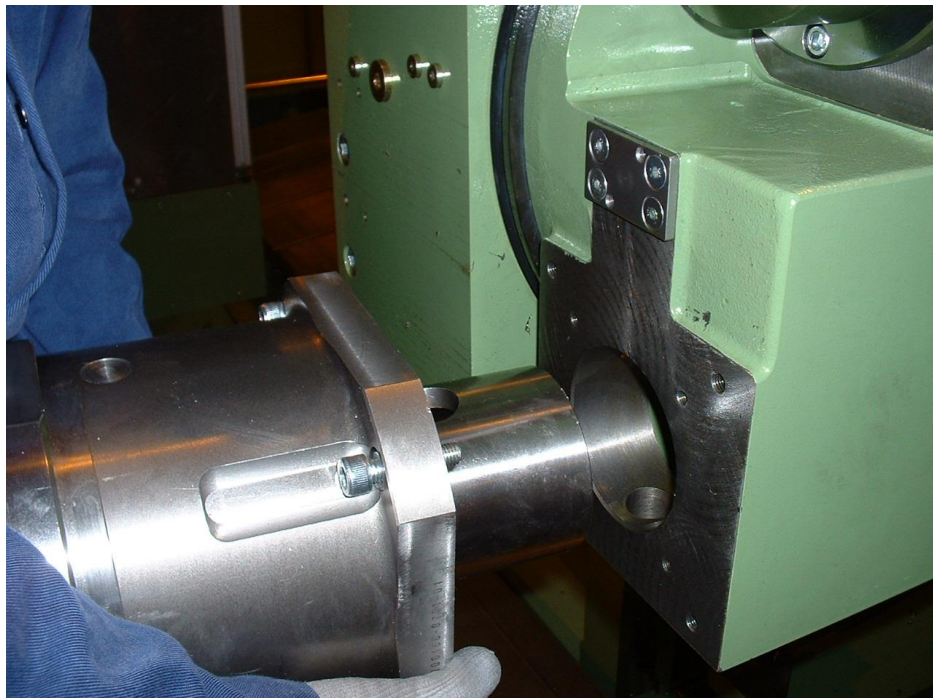
- Remove the top half of the dampener housing.



- Load the ejector drill boza to the spindle housing. (hole to the top)

1. Refer to page 28 to 31 if drill bush requires to be changed.

NOTE: - In the interest of safety use a sling and crane into place always.

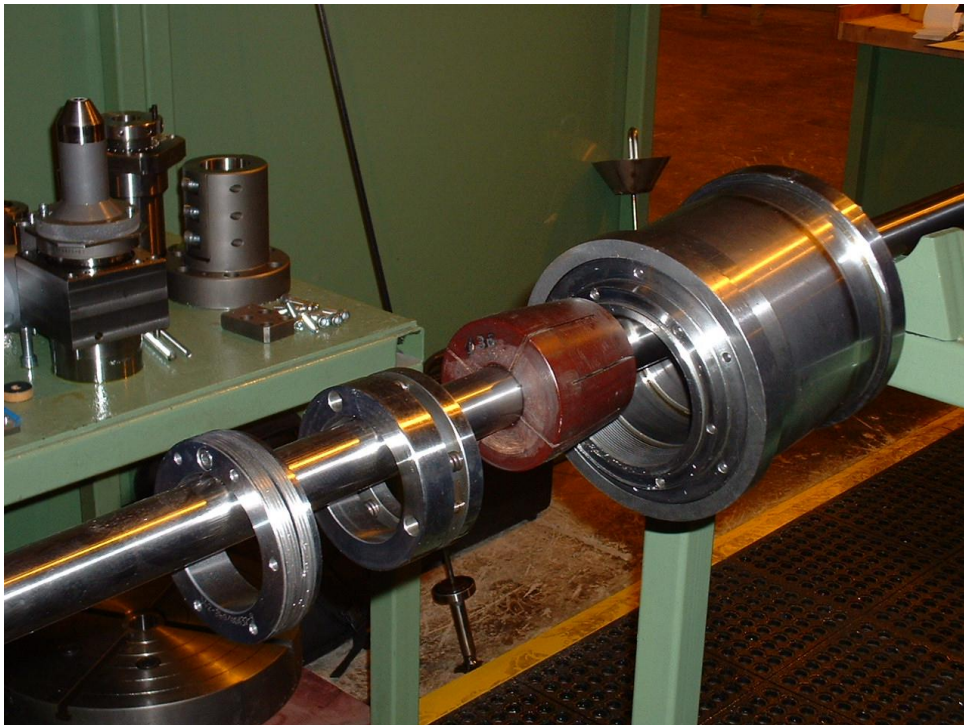




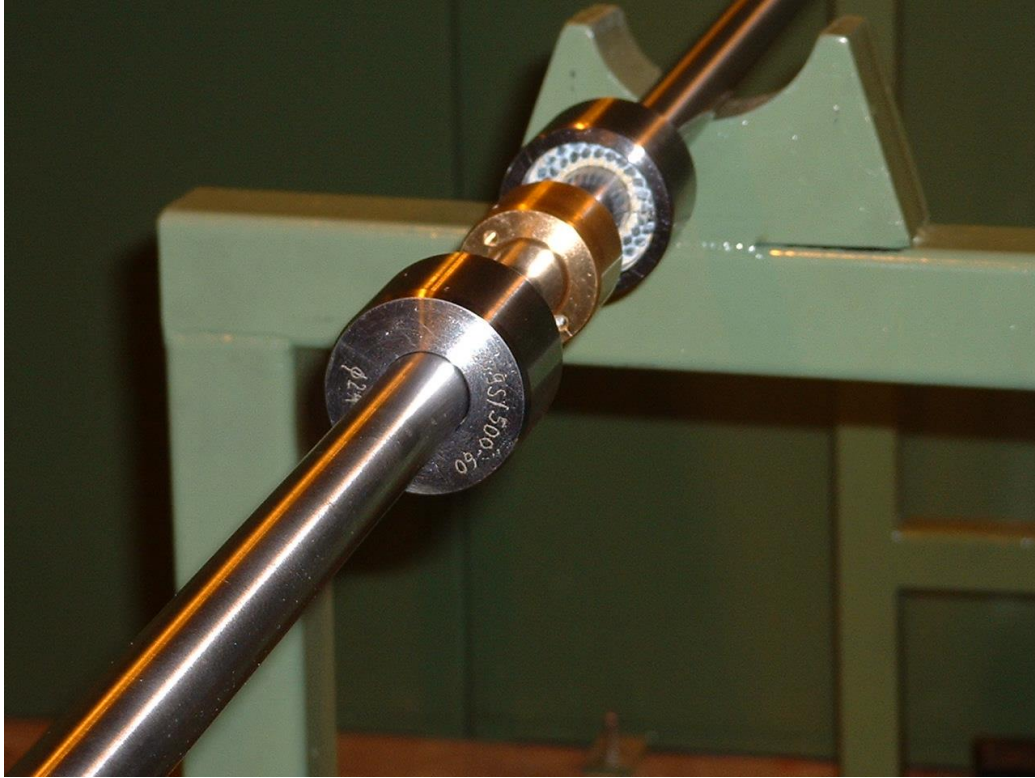
- **Load the Damper Housing with fittings to the ejector tube as shown.**

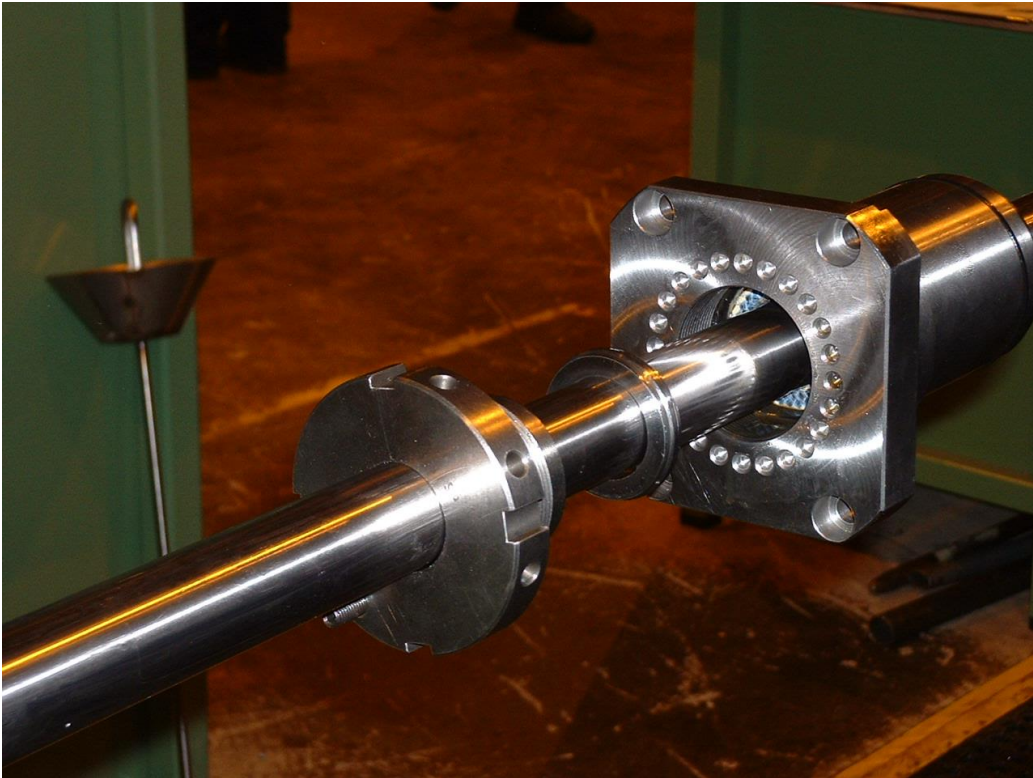
Note: - Refer to page 32 for assembly for Rosa Lira Hangers.

1. Assemble together on the tube.

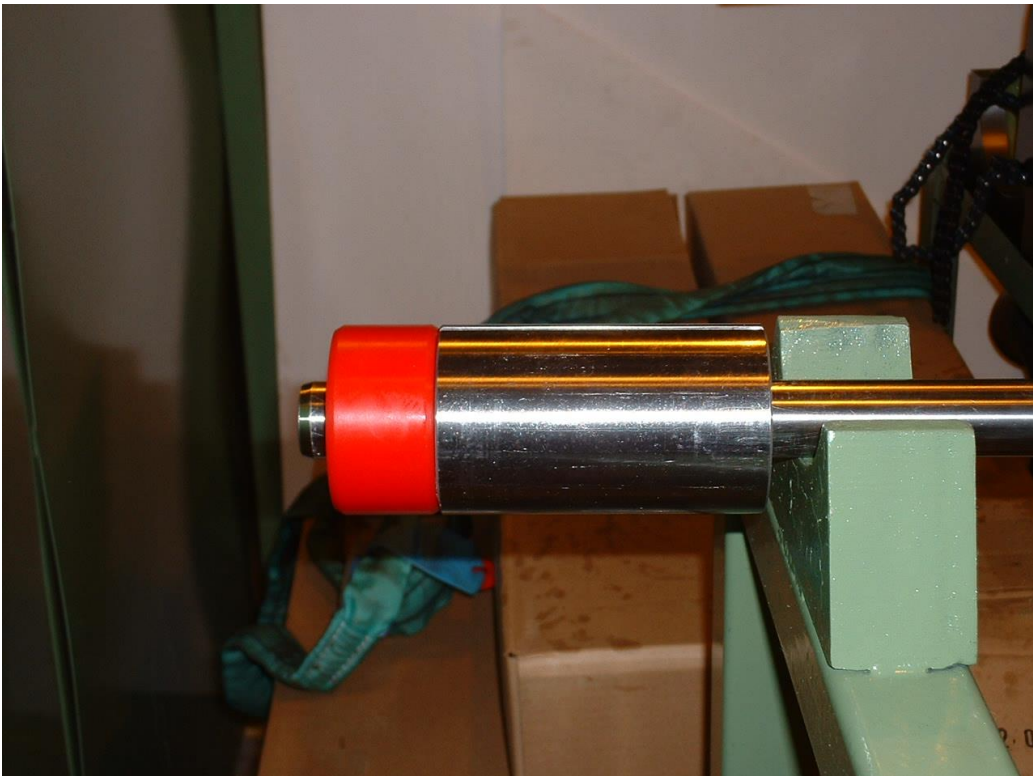


- Load the front sealing housing with fittings to the ejector tube as shown.





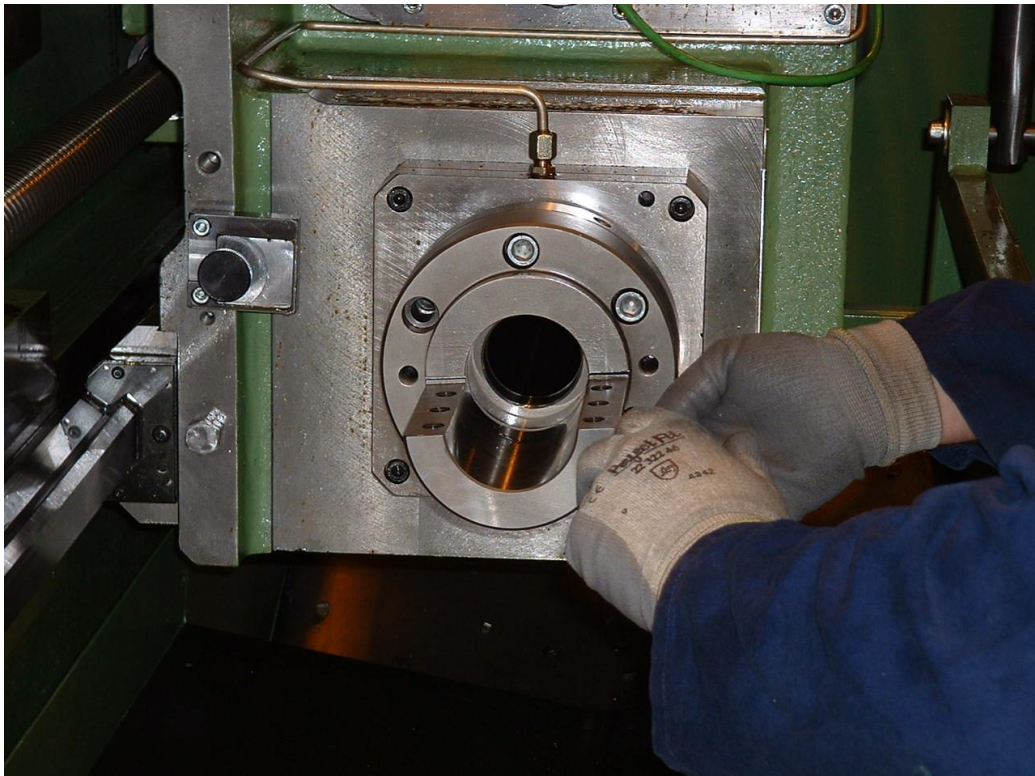
- **Assemble the bush driver to the end of the ejector tube.**



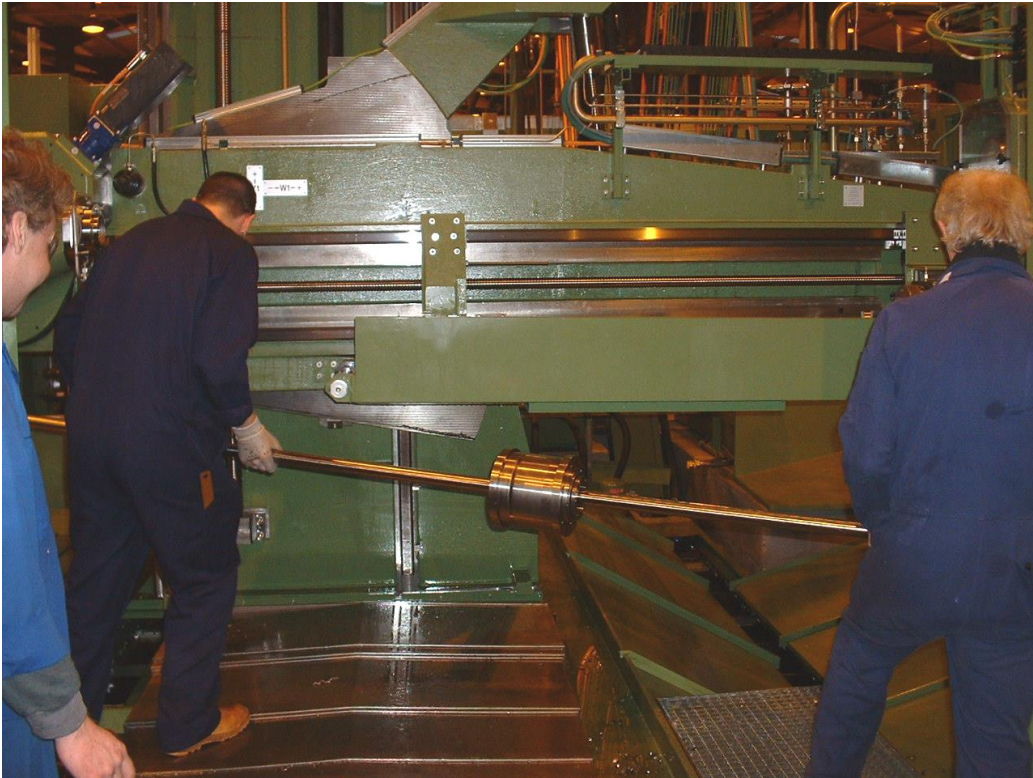
- Load the split bush holder to the driver unit.



- Make sure the top half has been removed.



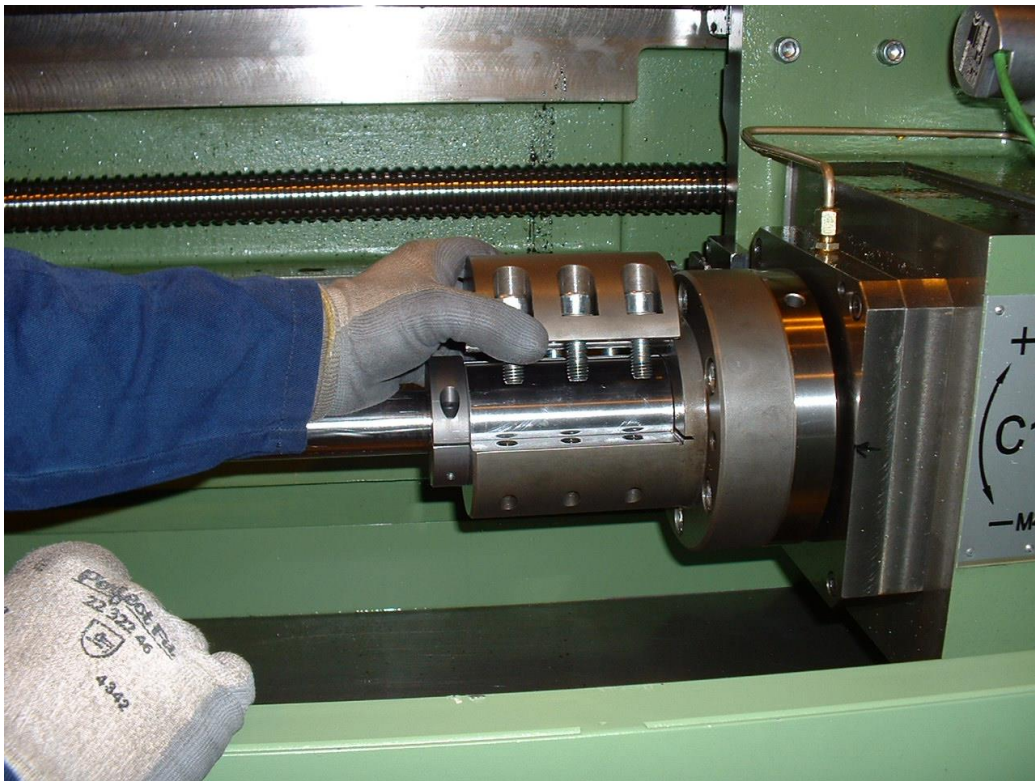
- Load the ejector tube with fittings to the machine.



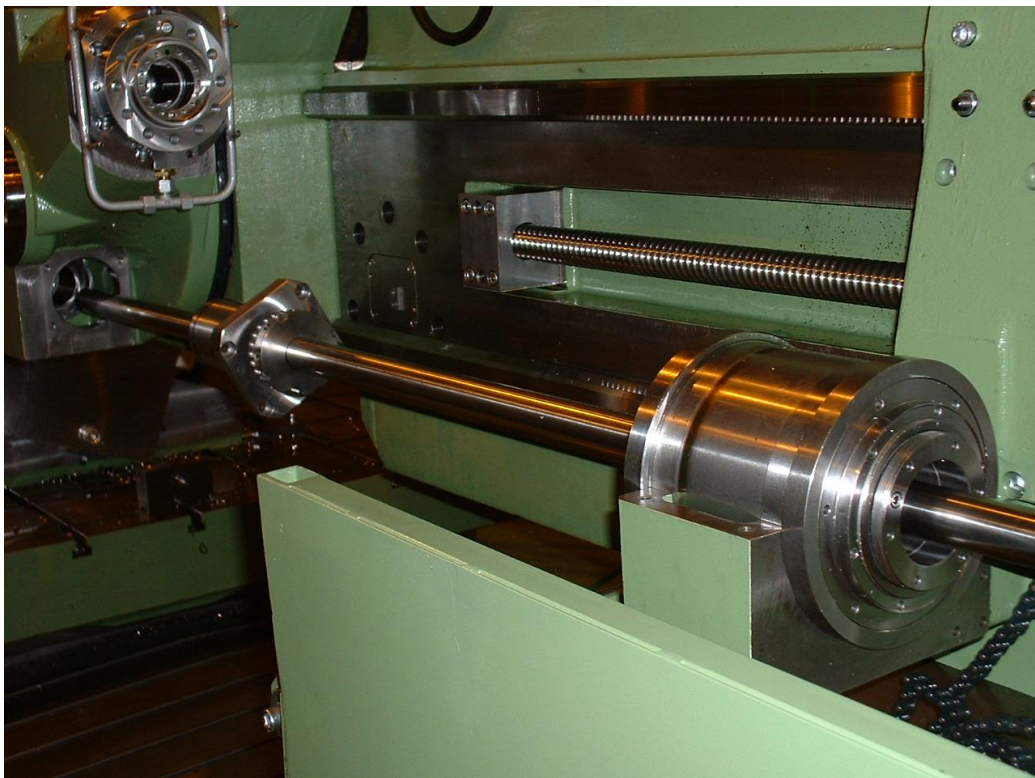
- Ensure the ejector drill is located fully back in the split bush holder.

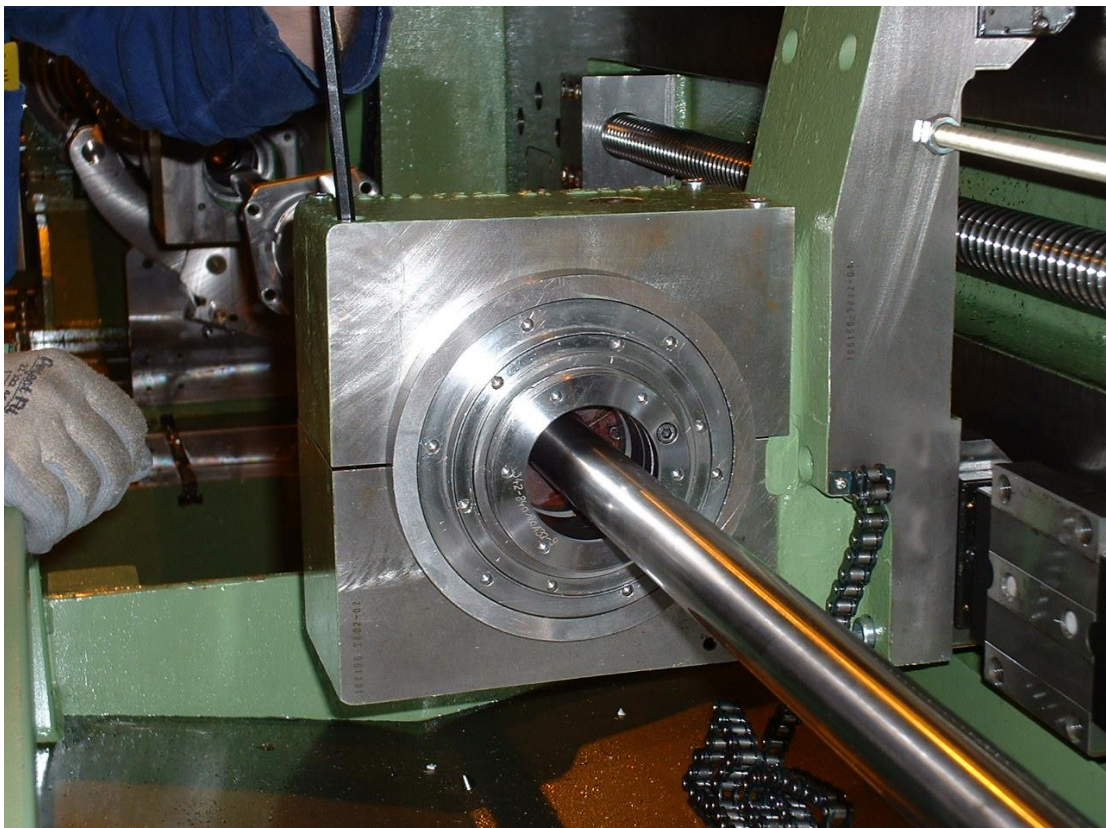


- **Assemble the split bush.**



- **Replace the top half of the dampener housing.**





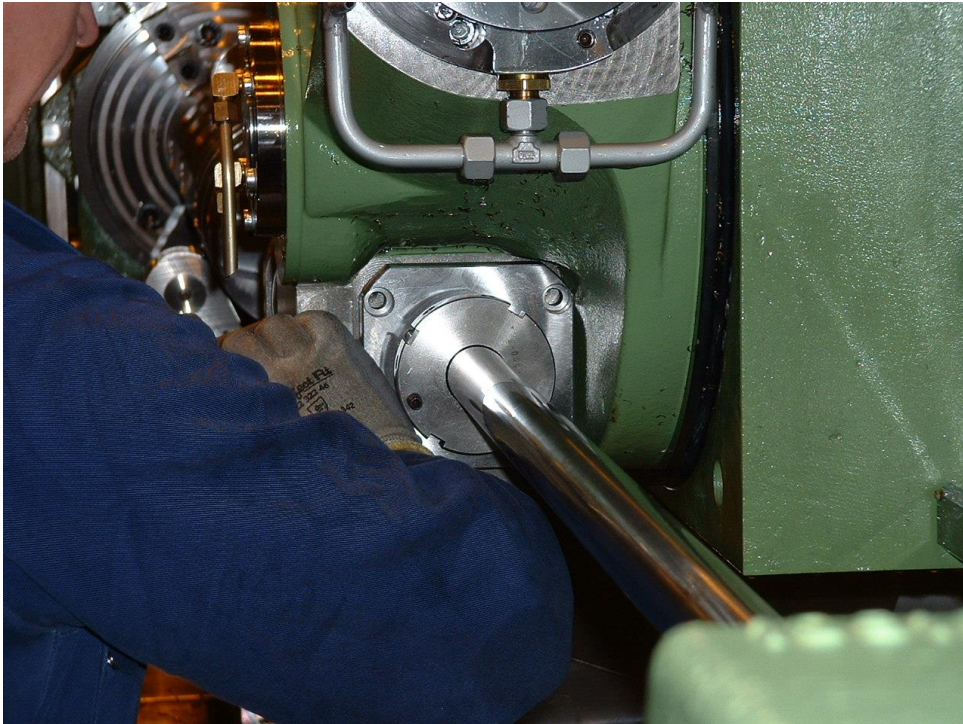
- Use the remote control to guide the ejector drill into the spindle housing and Boza.



- Fit the sealing assembly. (Watch the orientation of the bolt holes to ensure correct alignment.)

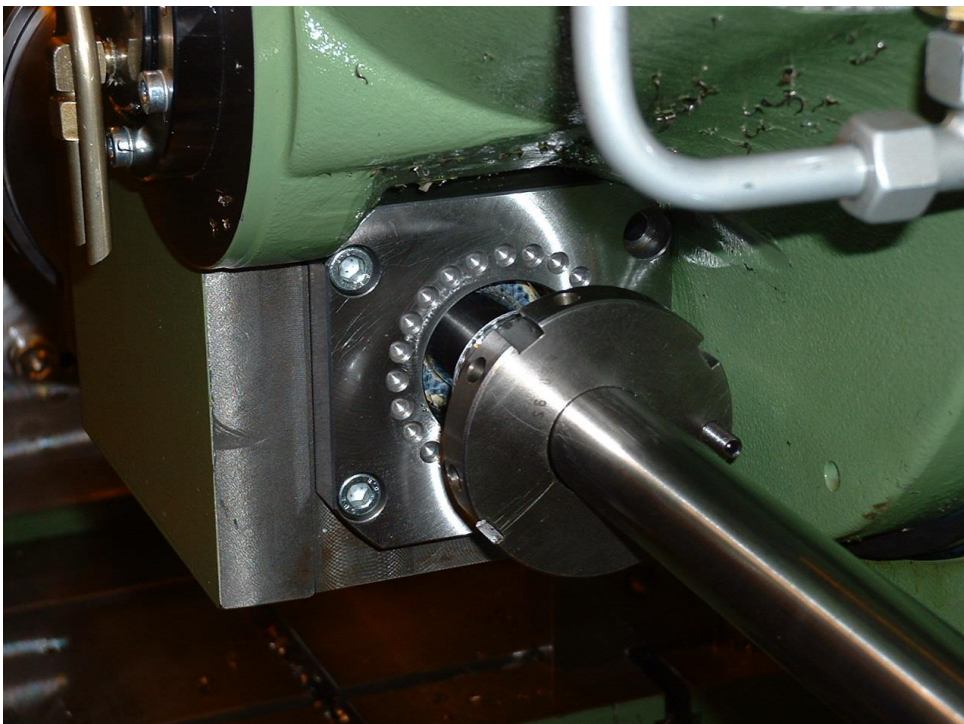


- Use a mallet if necessary to chap into position.



- Secure with 3-off cap screws.

1. Screw in lock nut firmly but hand tighten only.
2. Lock with the grub screws.



- **Ensure tube is clear of Boza. Load the cutting head to the tube :-**
 1. Measure the point of the lead insert to the full cutting diameter.
 2. Input this value into R114 in the program.

- **Using the remote control move the cutting head flush with the nose of the drill bush.**
 1. Record the W1 position and input into parameter R111 in the program.



➤ **Finish assembling the dampener housing.**

1. Screw in lock nut firmly but hand tighten only.
2. Tube must be able to run freely during the drilling operation.



➤ **Load the chain to the chain holder, taking up the slack.**



➤ **Load program.**

1. Machine.
2. Menu Select.
3. Program
4. Cursor to program required.
5. Select.
6. Input. (to edit)

➤ **Set coolant volume / spindle load monitors.**

1. Small diameter drills – high pressure / low volume.
2. Large diameter drills – low pressure / high volume.

➤ **Start Program (auto / cycle start.)**

Note: - the following instructions are only necessary if the drill bush requires to be changed.

- Remove front plate and bush assembly.



- Strip down and re-assemble with new bush.





- Measure the length of the drill bush if being used for the first time for use in programme.





- Refit front plate and bush assembly.



- To reduce the likelihood of the drill wandering during machining, assemble with the bush taper pointing inwards. Refer page 16.

