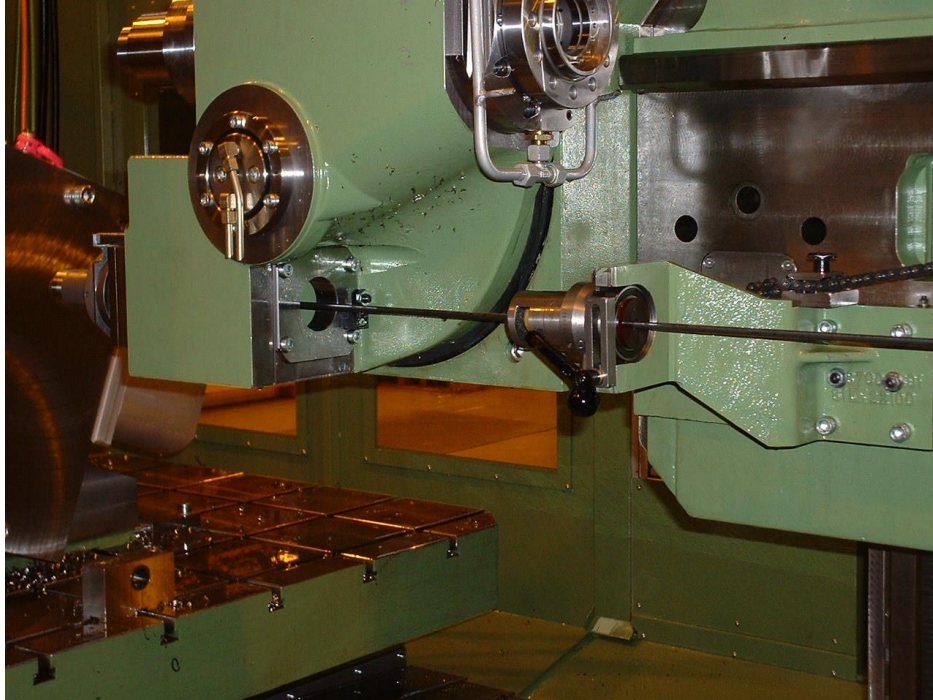


- **Unlock and remove the sealing unit.**



1. Manually jog drive shaft so that the grub screws are to the top.
2. Release the screws.
3. Release chain.



- **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.



➤ **Assemble the Capto drive shaft into the driver.**

1. Make sure the 'O' ring is in place to the rear of the drive shaft.



➤ **Lock in place the Capto drive shaft using the 2-off grub screws.(Longer one to r/hand side)**

1. Nip up the left hand grub screw to align.
2. Fully tighten the right hand one, then the left.



- Remove the 3-off bearing support guides.

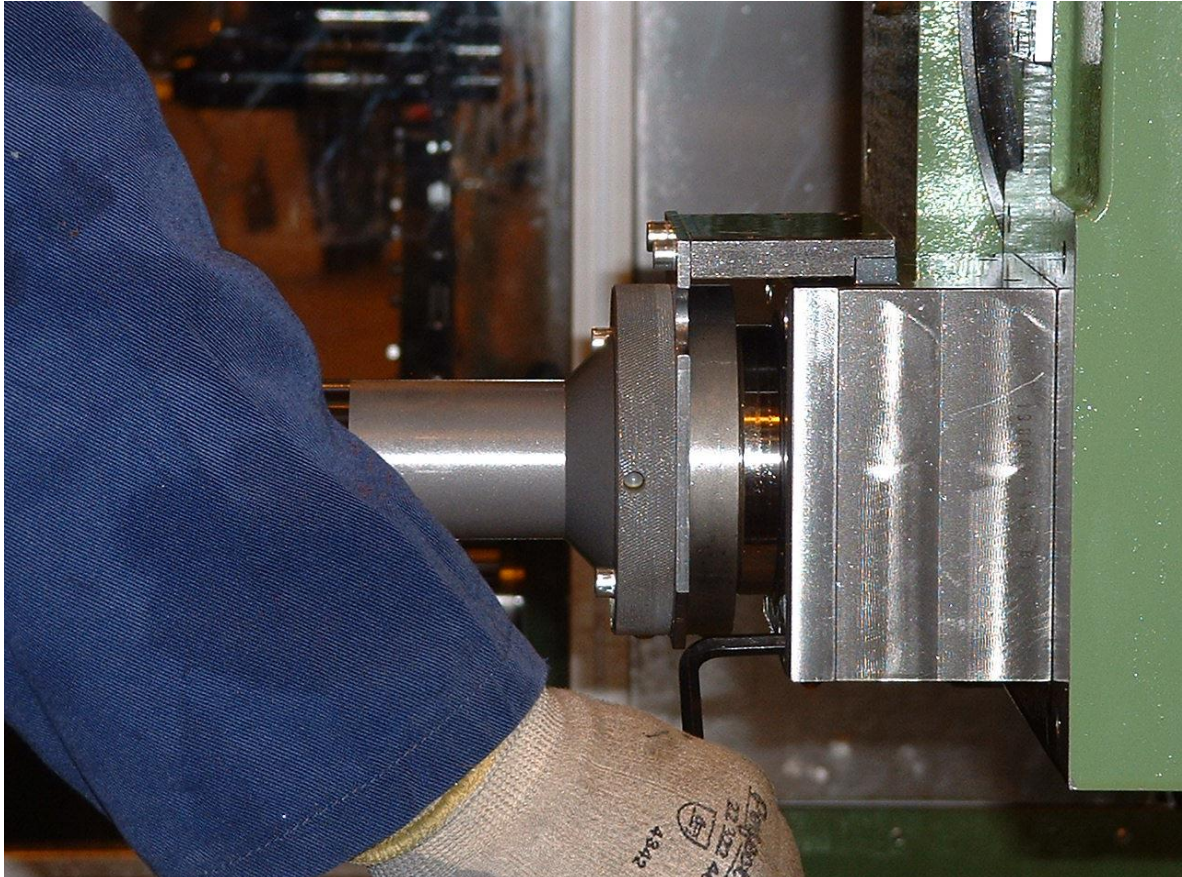


- Remove the housing for the sealing unit. (Can be left assembled.)



➤ **Remove the drill bush carrier and drill bush. (Can be left assembled.)**

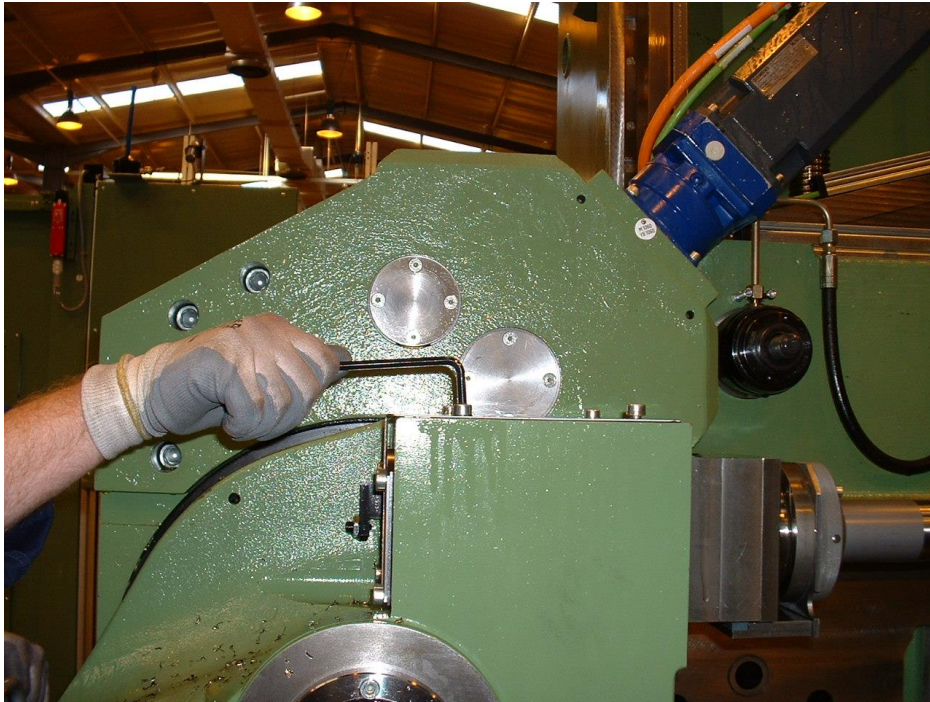
1. Otherwise remove the drill bush carrier and drill bush intact.



➤ **Index Revolver.**

1. Check revolver has clearance.
2. Collision is possible if gun drill steadies have been left on.
3. Machine.
4. Menu Select.
5. T.B.T.
6. Machine setup.
7. Semi function.
8. Auto.
9. Revolver.
10. Drilling.
11. Conventional.
12. + Action and rapid together to initiate movement.

- Replace the cover on the spindle housing.



- Assemble the Capto spindle.

1. Line up the key ways and chap in with a mallet if necessary.



- Assemble the Capto end plate.



- Tighten in place 14-off cap screws stamped 12.9.



1. Auto.
2. T.B.T.
3. Semi functions
4. 'W' axis docking position.
5. – Action.
6. Tool conventional clamp.
7. + Action.