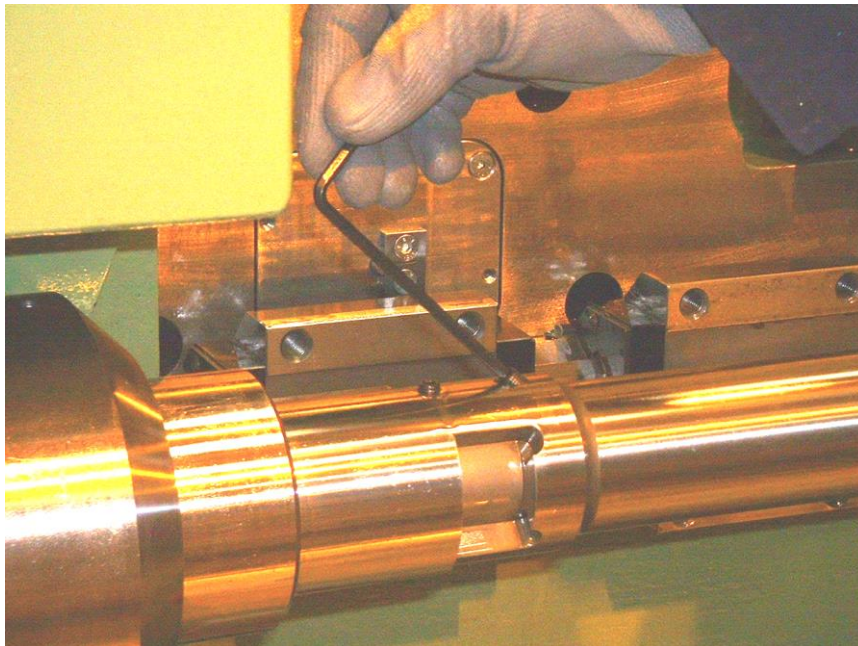➢ **<u>Remove</u>** the two grub screws from the driver.



➢ Unload the active spindle tool (I.T.S. bar tool) from the magazine.

1. Machine.
2. Menu Select.
3. Parameter.
4. Tool Management.(Skip if already at Tool List)
5. Tool List
6. Cursor to 9998.(Active spindle tool)
7. Press:- Unload
8. Press: - From Magazine.

➢ Release 'W' axis docking position.

1. Machine.
2. Menu Select.
3. T.B.T.
4. Machine Setup.
5. Auto.
6. Semi-functions.
7. I.T.S. tool base position.
8. Start.
9. +Action.
10. 'W' axis docking position
11. – Auto action. (Unlocks tool).
12. Re-tooling position.
13. + Auto action

➢ Remove the I.T.S. bar from the spindle. (6 – off  cap screws)
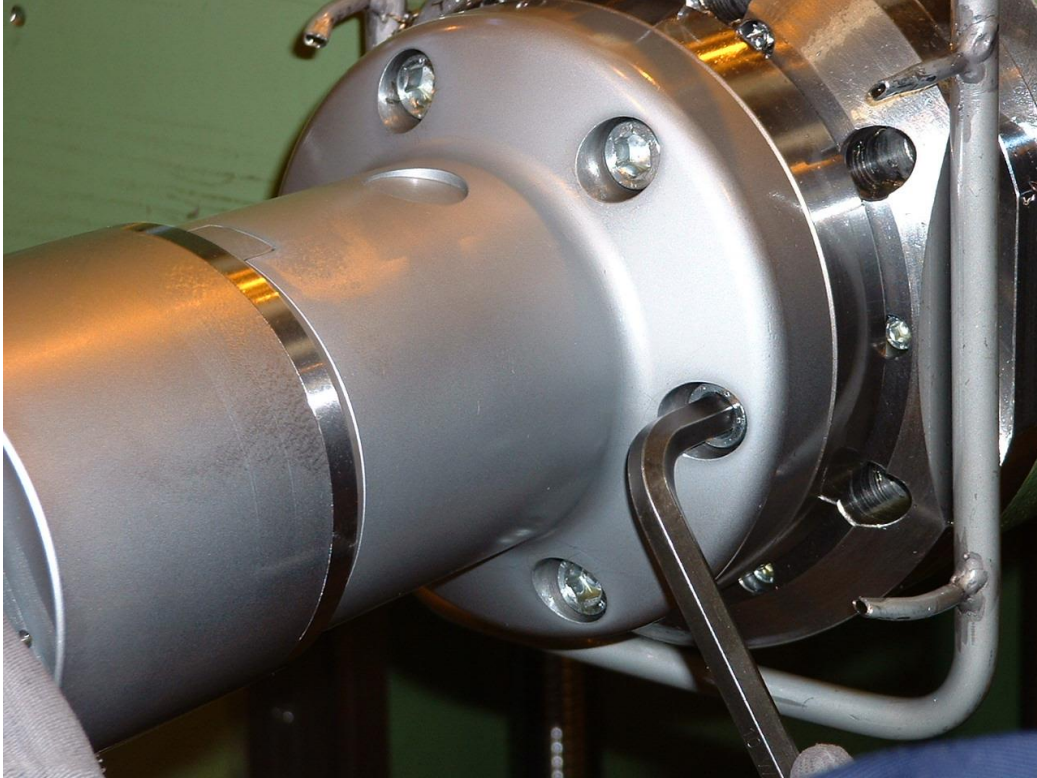
> Assemble the Capto drive shaft into the driver.

      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.

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



➢ 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. 'W' axis docking position.
2. − Action.
3. Tool conventional clamp.
4. + Action.