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<th>Item No.</th>
<th>Description</th>
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<td>Motor</td>
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<td>2</td>
<td>Gear Housing</td>
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<td>3</td>
<td>Gear Bearing</td>
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</table>

**Material:**
- 1: Steel (P410)
- 2: Steel (P410)
- 3: Steel (P410)
- 4: Steel (P410)
- 5: Steel (P410)
- 6: Steel (P410)
- 7: Steel (P410)
Control Blocks/Bloca de Commande/Steuerblokke
It is important that the advance rate of the tool is set to maintain the pitch of the thread which is to be formed with the correct accuracy rate. This will be more noticeable in plastics, light alloy and other materials.

The rate at which the tap should be advanced should be slightly lower than that of the workpiece. This will ensure a clean withdrawal of the tap.

The tap is advanced to the depth of the thread as shown in Figure 5 (10) and (11) to equalize the tapping depth of the tapping operation.

The next block to carry out tapping operations is shown in Figure 3 (11) to carry out tapping operations in the chuck.

WARNING
- The BEARING SLEEVE COMPLETE (14) IS UNDER SPRING COMPRESSION, WHILST RESISTING THE THRUST DUE TO THE BEARING SLEEVE COMPLETE (19). FOLLOW THE INSTRUCTIONS BELOW FOR BEARING SLEEVE ASSEMBLY.

1. Loosen the bolt using the exploded view.
2. Remove components from the components of the dry liner in accordance with the exploded view.
3. Dispose of the dry liner in accordance with local regulations.

It is recommended that the tool is serviced at 1000ths running time.

NOTE:
- Protective gloves and eye protection should be worn during cleaning, dismantling or assembling tool.
- Parts shown in exploded view are in addition to normal workshop tools.

Torque values given are ± 5%.

Carry out all tapping operations at 1000ths running time.

11/04/17

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3. Carrying out all tapping operations at 1000ths running time.

4. Remove components from the components of the dry liner in accordance with the exploded view.

5. Dispose of the dry liner in accordance with local regulations.

6. Loosen the bolt using the exploded view.

7. Remove components from the components of the dry liner in accordance with the exploded view.

8. Dispose of the dry liner in accordance with local regulations.

9. Loosen the bolt using the exploded view.

10. Remove components from the components of the dry liner in accordance with the exploded view.

11. Dispose of the dry liner in accordance with local regulations.

12. Loosen the bolt using the exploded view.

13. Remove components from the components of the dry liner in accordance with the exploded view.

14. Dispose of the dry liner in accordance with local regulations.

15. Loosen the bolt using the exploded view.

16. Remove components from the components of the dry liner in accordance with the exploded view.

17. Dispose of the dry liner in accordance with local regulations.

18. Loosen the bolt using the exploded view.

19. Remove components from the components of the dry liner in accordance with the exploded view.

20. Dispose of the dry liner in accordance with local regulations.