

# Assembly Instructions M8107-EN

## Spare part cooling valve 2 (O/ID T25932-X, T25933-X)

### Purpose

Replacement of hydraulic parts cooling valve 2 (M 4)

### Precondition



**WARNING!**

**Danger for unauthorized persons!**

Conversion work may only be carried out by specialist staff who have been trained accordingly.

Therefore:

- Keep unauthorized persons away from the work area.



**NOTE!**

*Knowledge of the Instruction Manual is a precondition for carrying out conversion work on the unit.*

### Procedure



**DANGER!**

**Danger to life caused by electric current!**

Touching conductive parts causes a direct danger to life.

Therefore:

- For all work on the electrical system, for maintenance, cleaning or repair work, disconnect from the mains or disconnect all phases of the external power supply and secure them against being switched on again. Check unit is isolated from power supply.





**WARNING!**


**Danger of crushing due to rolling away or tipping**

With an uneven floor or when the castors are not locked, there is a danger that the unit tips over or rolls away causing crushing.

Therefore:

- Only install the unit on an even floor.
- Ensure that the castors are locked.

1. Proceed as follows in order to cool down the unit and empty the mould (mould evacuation):
  - Display menu page **Functions**.
  - Select the function **Cooling** and activate with the  key.
  - If the function **Mould evacuation** is available, select it and activate it with the  key.

→ The activated function is indicated with the  symbol.

  - Units HB-100X\_4 and HB-100/140/160Z\_4 without function **Mould evacuation**: Loosen the drain connection (G) slowly until the unit is depressurized.
2. Main switch off, remove the plug from the mains and empty the unit.
3. Remove the cover from the unit (see Instruction Manual Chapter Maintenance).
4. Proceed as follows in order to remove the cooling valve 2 (M 4):
  - Loosen the screw fixing the multiphase motor on the proportional module (2.1).
  - Turn the multiphase motor, slightly extract and move out of connection.
  - Remove the Torx locking screw for fixing the guide bush.
  - Disconnect the modules of the proportional module (2.1) from each other using 2x hexagon head screws.
  - Remove piston and guide sleeve.



### **ATTENTION!**

#### **Damage due to wrong mounting**

An incorrect assembly can lead to malfunctions.

Therefore:

- Observe correct mounting.
- Handle all parts with care.

5. Proceed as follows to insert the guide sleeve and piston:



**NOTICE!**

Do not remove the mounting rod to assemble the guide bush.

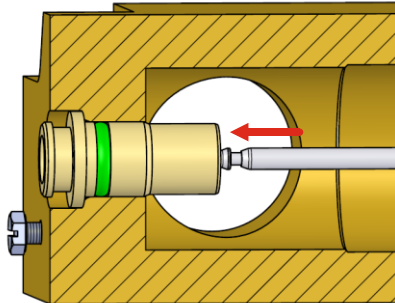


Fig. 1: Assembly of pistons

- Assemble new guide sleeve and fix it with Torx lock screw.
- **With T25933-X** Clean piston and rod.
- **With T25932-X** Use new piston.
- Carefully push the piston into the guide sleeve and press out the mounting rod (→ Fig. 1).
- Remove the mounting rod, it is no longer needed.

- Assemble and fix the proportional modules (2.1).



**ATTENTION!**

**Leakage when wrongly mounted!**

The wrong mounting of the O-ring can destroy it and result in leakage of the proportional module.

Therefore:

- Observe the correct assembly of the O-ring.

- Engage the multiphase motor (M 4), turn into final position and fix with the two hexagon head screws.

6. Reconnect mains plug and switch on main switch.

7. Proceed as follows in order to check the service function of cooling valve 2 (M 4):

- Readjust the parameter **Positioning KV 2** in menu **Service \ Support**.

(0 → valve closed; 295 → valve opened)





**NOTICE!**

The user profile must be set to support in order to access the parameter (→ Operating instructions: chapter Operation).

Service ▶ Support			
Actual value ▶			
Reset custom parameter			
Reset system parameter			
Reset logbook alarms			
Positioning KV 1			0
Positioning KV 2			0
<hr/>			
1	Main line	25.0 °C	Ready to operate
	Pressure	0.8 bar	

Fig. 2: Positioning cooling valve 2

8. Press the  key to switch on the unit, check unit functions and check it for leaks.
9. Switch the unit off by press the  key.
10. Main switch off.
11. Close the unit correctly again.

### Parts list

Pos	Description	O/ID	O/ID			
			T25932-1	T25932-2	T25933-1	T25933-2
			Pcs	Pcs	Pcs	Pcs
01	Piston complete	T25150	1	1	-	-
02	Guide sleeve 18x4x33	T25912	1	1	1	1
03	Ring 11x4x3,5 (mounted)	T25913	1	1	1	1
04	Lock ring 11x1 mm (mounted)	N10411	1	1	1	1
05	Grease Barrierta (mounted)	H1056	1	1	1	1
06	Seal FPM 4x10x4,2 mm (mounted)	T21756	1	-	1	-
07	Seal FFKM 4x10x4 mm (mounted)	T25590	-	1	-	1
08	O-Ring FPM 10x2,0 mm (mounted)	T23474	1	-	1	-
09	O-Ring FFKM 10x2,0 mm (mounted)	T25432	-	1	-	1
10	Rod (mounted)	B1255975	1	1	1	1
11	Torx screw M4x6	B3061615	1	1	1	1
12	Assembly instructions German	M8107-DE	1	1	1	1
13	Assembly instructions English	M8107-EN	1	1	1	1
14	Assembly instructions French	M8107-FR	1	1	1	1