

Assembly Instructions M8113-EN

Spare part cooling valve 1 (O/ID T25921, T25922, T25923)

Purpose

Replacement of cooling valve 1 (M 3)

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 **OK** key.
 - If the function **Mould evacuation** is available, select it and activate it with the **OK** key.

→ The activated function is indicated with the **✓** symbol.

 - Units HB-100X_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 cooling water supply (C).
4. Remove the cover from the unit (see Instruction Manual Chapter Maintenance).
5. Proceed as follows in order to remove the cooling valve 1 (M 3):
 - Unplug the cable on the cooling valve 1.
 - Loosen screws of cooling valve 1 on the cooling water module.
 - Turn and remove the cooling valve 1.
6. Proceed as follows in order to assemble the cooling valve 1 (M 3)

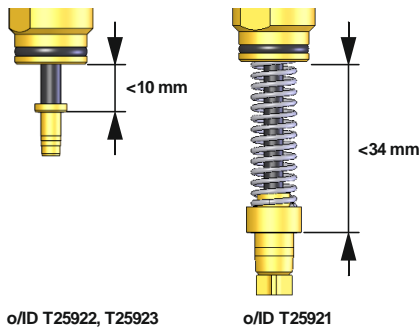


Fig. 1: Adjustment measure for cooling valves



ATTENTION!

Distortion when wrongly re-assembled!

Replacement valves are being delivered with pistons that are not completely extended. Valve piston can distort.

Therefore:

- Valves must never be installed with completely extended pistons (→ Fig. 1).

- Engage carefully the new cooling valve 1.
 - Turn the cooling valve 1 in its final position and fasten with the two Torx screws.
 - Plug the cable on the cooling valve 1.
7. Reconnect mains plug and switch on main switch.
 8. Connect cooling water supply (C).

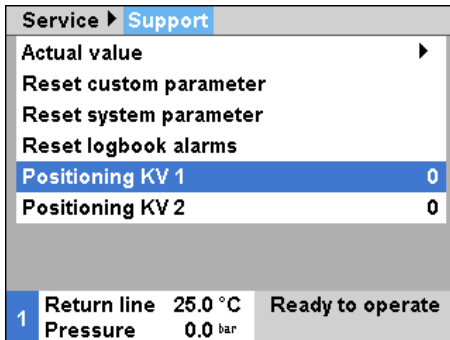


Fig. 2: Positioning cooling valve 1

9. Proceed as follows in order to check the service function of cooling valve 1 (M 3):
 - Readjust the parameter **Positioning KV 1** 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).

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

Parts list

Pos	Description	O/ID	O/ID		
			T25922	T25921	T25923
			Pcs	Pcs	Pcs
01	Cooling valve 1 complete	T25660	1	-	-
02	Cooling valve 1 complete	T25914	-	1	-
03	Cooling valve 1 complete	T25917	-	-	1
04	Assembly instructions German	M8113-DE	1	1	1
05	Assembly instructions English	M8113-EN	1	1	1
06	Assembly instructions French	M8113-FR	1	1	1