

# Assembly Instructions M8116-EN

## Spare part cooling valve 2

- Guide sleeve with seal (O/ID T25929)
- Hydraulic part complete (O/ID T25928)

### Purpose

Replacement of 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.
  - Select the function **Mould evacuation** and activate with the  key.

→ The activated function is indicated with the  symbol.
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 locking ring 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 in order to assemble new parts:

- Assemble the new guide bush with the mounting rod and fix with the locking ring.



**NOTICE!**

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

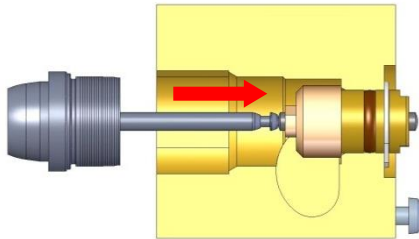


Fig. 1: Assembly of pistons

- With T25929 clean piston and rod.
- With T25928 use new piston.
- Carefully push out the piston with the mounting rod and install the piston (→ 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.

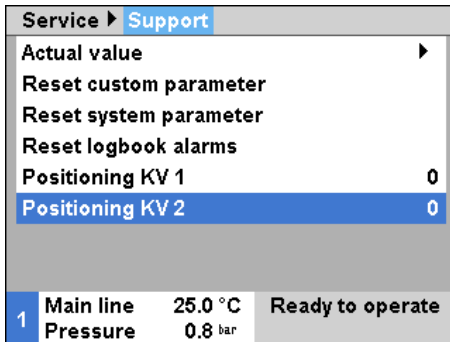


Fig. 2: Positioning cooling valve 2

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).

8. Press the key to switch on the unit 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	Spare part O/ID	
			T25928	T25929
			Pcs	Pcs
01	Piston complete	T24305	1	-
02	Bush 14x4x23	T25684	1	1
03	Bush 16x4x12,5 (mounted)	T25685	1	1
04	Seal FPM 4x10x4,2 mm (mounted)	T21756	1	1
05	Grease Barrierta L55/2 (mounted)	H1056	1	1
06	O-Ring FPM 10x2 mm (mounted)	T23474	1	1
07	Locking ring stainless steel 14x1 mm	B1254928	1	1
08	Rod (mounted)	B1255975	1	1
09	Assembly instructions German	M8116-DE	1	1
10	Assembly instructions English	M8116-EN	1	1
11	Assembly instructions French	M8116-FR	1	1