

Assembly Instructions M8152-EN

Spare part cooling valve 2 (O/ID T27770, T27771)

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 **OK** key.
 - Select the function **Mould evacuation** and activate with the **OK** key.
- The activated function is indicated with the **✓** symbol.
1. Main switch off, remove the plug from the mains and empty the unit.
 2. Remove the cover from the unit (see Instruction Manual Chapter Maintenance).
 3. 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.



WARNING!

Bolted assemblies, combinations of stainless steel / stainless steel or steel / stainless steel can seize up. This results in difficulties in dismantling.

Therefore:

- Use a suitable lubricant.

for O/ID T27770

4. Proceed as follows in order to replace the piston and guide bush:
 - Undo connections (Label 1 → Fig. 1) on proportional module.
 - Mount proportional module on a T-piece in the vice.
 - Undo terminal nut with 65 mm wrench size (Label 2 → Fig. 1) and remove lower section of proportional module.
 - Remove safety screws (Label 3 → Fig. 1) for attaching the guide bush at the bottom of the proportional module.
 - Remove piston and guide bush.



NOTICE!

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

- Mount a new guide bush and secure with the safety screws (Label 3 → Fig. 1).
- Push the piston into the guide bush carefully; this pushes out the mounting rod.

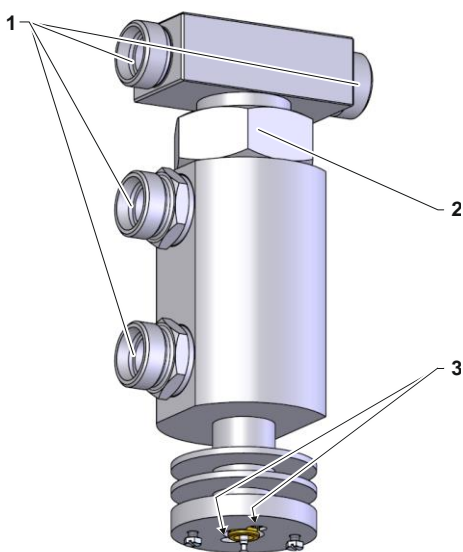


Fig. 1: Proportional module

- Remove the mounting rod, it is no longer needed.
- Attach the lower section of proportional module to the T-piece.
- Tighten terminal nut (Label 2 → Fig. 1) with torque 500 Nm.
- Mount proportional module in the unit and tighten connections (Label 1 → Fig. 1) with torque 150 Nm.

for O/ID T27771

5. Proceed as follows in order to replace the guide bush:
 - Remove the fixing screw (label 3 → Fig. 1) holding the guide bush at the bottom of the proportional module.
 - Remove the guide bush



NOTICE!

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

- Assemble the new guide bush. The mounting rod is being pressed out by the piston.
 - Remove the mounting rod, it is no longer needed.
 - Fix the guide bush with the fixing screw. (label 3 → Fig. 1).
6. Engage the multiphase motor, turn into final position and fix with the two screws.
 7. Reconnect mains plug and switch on main switch.
 8. Proceed as follows in order to test the functioning of the cooling valve 2:
 - Readjust the parameter **Positioning KV 2** in menu **Service / Support**.
(0 → valve completely closed; 295 → valve completely opened)



NOTICE!

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

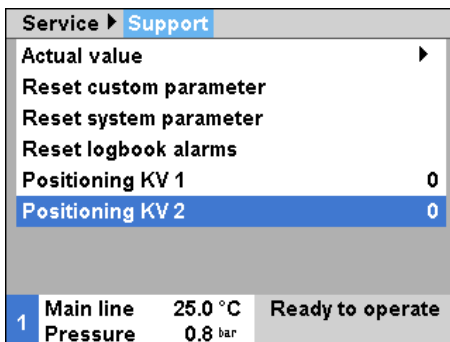




Fig. 2: Positioning KV 2

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

Parts list

Pos	Description	O/ID	O/ID	
			T27770	T27771
			Pcs	Pcs
01	Socket 18x4x33	T25912	1	1
02	Ring 11x4x2,4 (mounted)	T27139	1	1
03	Scraper ring 3,85x11,3x3 (mounted)	T27138	1	1
04	Locking ring 11x1 (mounted)	N10411	1	1
05	Grease Barrierta (mounted)	H1056	1	1
06	Rod (mounted)	B1306553	1	1
07	O-Ring 10x2 FFKM (mounted)	T25432	1	1
08	Seal 4x10x4 FFKM (mounted)	T25590	1	1
09	Torx screw M4x6	B3061615	2	1
10	Pistion 28x65 complete	T27754	1	-
11	Assembly instructions German	M8152-DE	1	1
12	Assembly instructions English	M8152-EN	1	1
13	Assembly instructions French	M8152-FR	1	1