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## PROCEDURE TO ADJUST TOOL CLAMPING AND UNCLAMPING

1. Loosen four screws and take out cover. (See Fig 1) Move the Z down. (See Fig 2) Limit switch will be open. (See Fig 3) There is a gap between the air cylinder and the spindle. (See Fig 4)

Fig 1



Fig 2



Fig 3

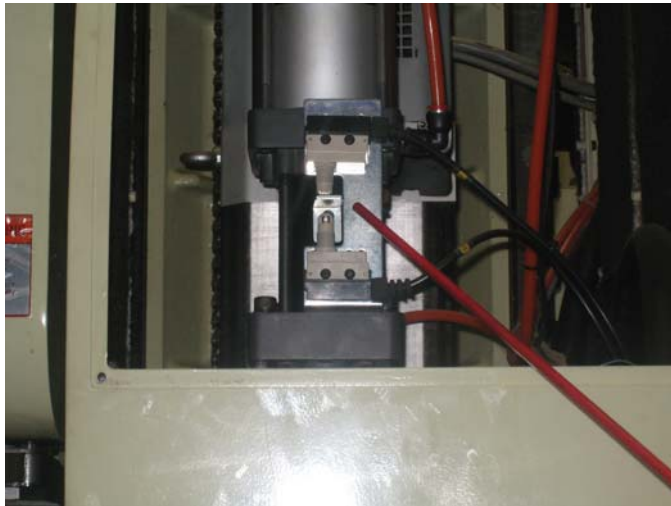
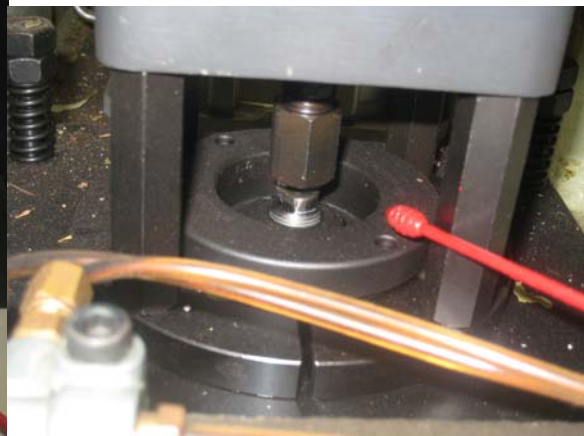


Fig 4



2. Push Clamp and Unclamp button. (See Fig. 5) Cylinder will be pushed down, limit switch closed. (See Fig. 6) Air cylinder push down to open spindle collet. (See Fig. 7).

Fig. 5



Fig. 6

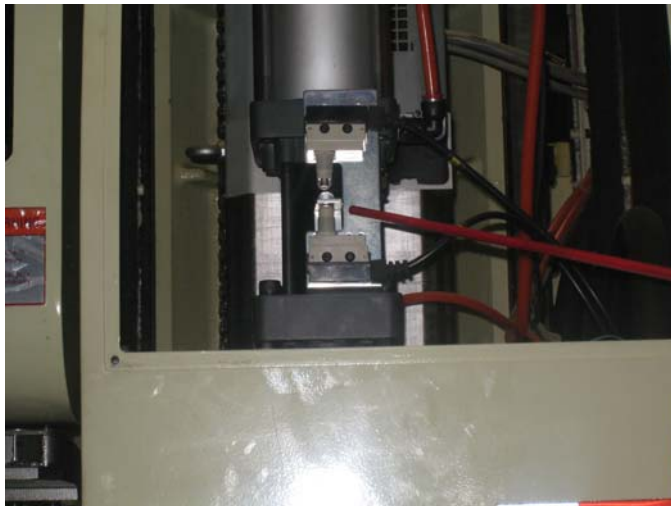
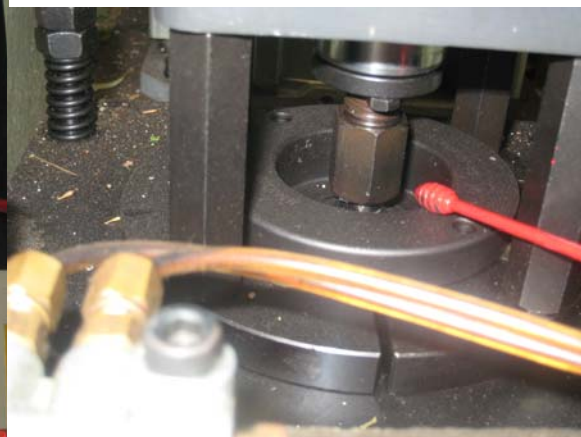


Fig. 7



3. Release Tool Clamping and Unclamping push button. Loosen **two** lock screws. (See Fig. 8) Adjust cylinder, clockwise or counterclockwise. The gap between the air cylinder and spindle is roughly 5mm. (See Fig. 9)

Fig. 8

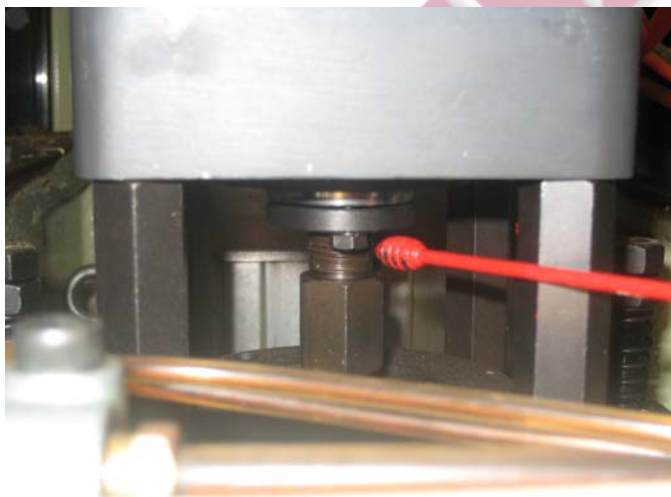
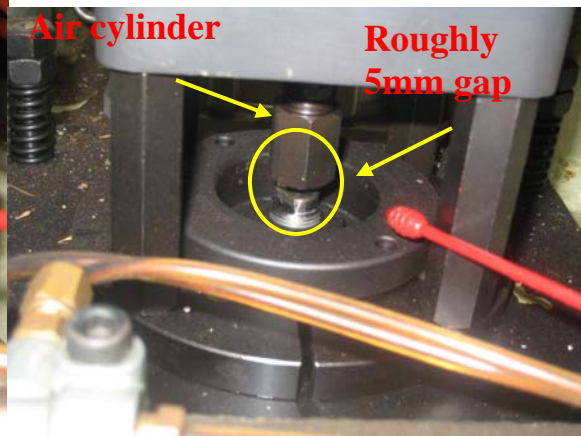


Fig. 9



4. Retighten **two** locking screws.

5. Testing.

Push Clamping and Unclamping button. Insert tool and push up tool against the nose of the spindle. (See Fig. 10) The tool will start to bump up and down. This bumping should be gentle. If too strong of a bumping, then it means that the gap is too close. If there is no bumping, then the gap is too far away. This means the collet jaw is open. Release tool and Clamping button. The spindle should catch tool automatically.

Fig. 10



6. Redo process 3-5 until spindle can catch tool smoothly.