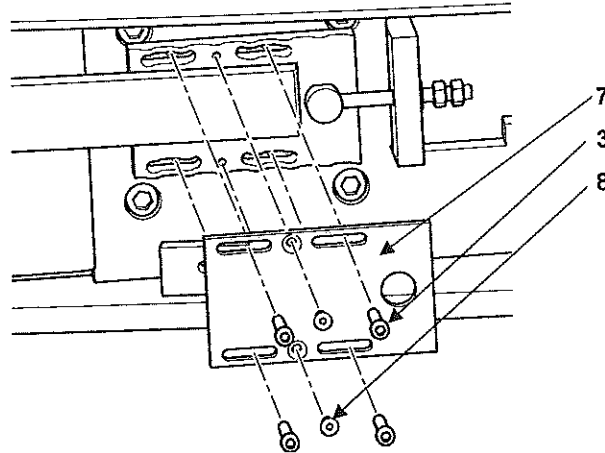
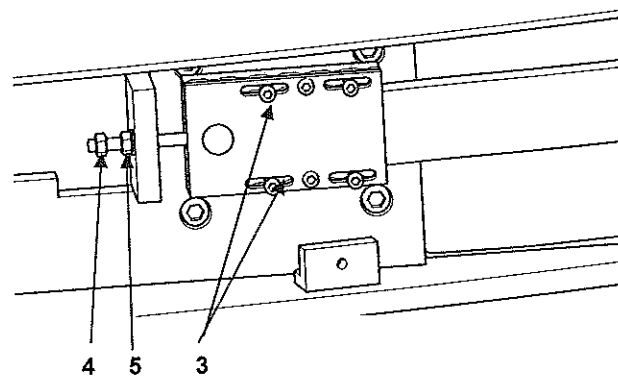


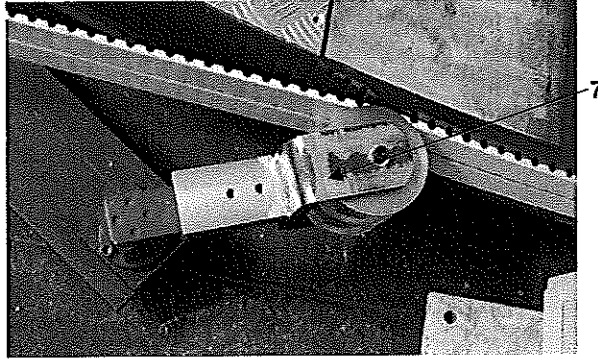
10. Stretch the belt and cut it at the correct length (it should be long enough to fit into both belt locks, but not stick out of the belt lock ends, see picture above).



11. Mount the belt lock (7) and tighten the two locking screws (5) properly. Mount, but **do not tighten** the four adjustment screws (3).



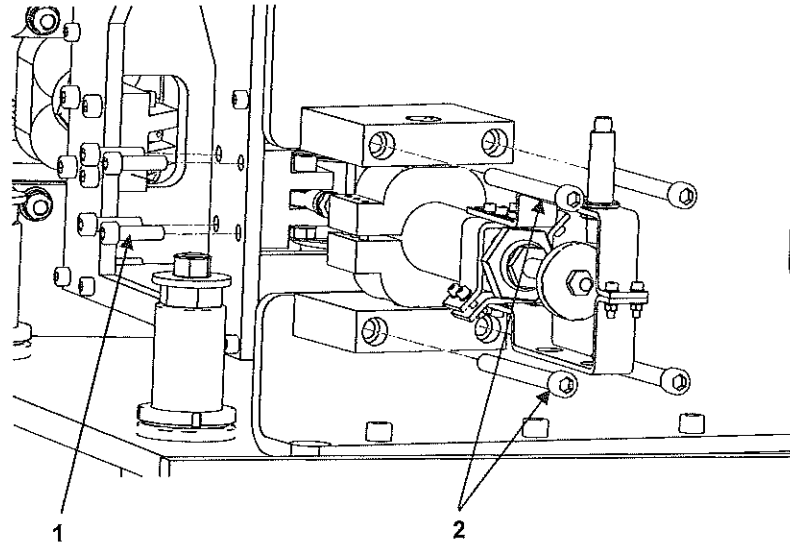
12. Stretch the belt using the adjustment nut (5).
13. Check the belt tension according to section 3.12 *Turntable Belt Tension*. When the belt is properly stretched, tighten the locking nut (4) and the locking screws (3) on both belt holders.



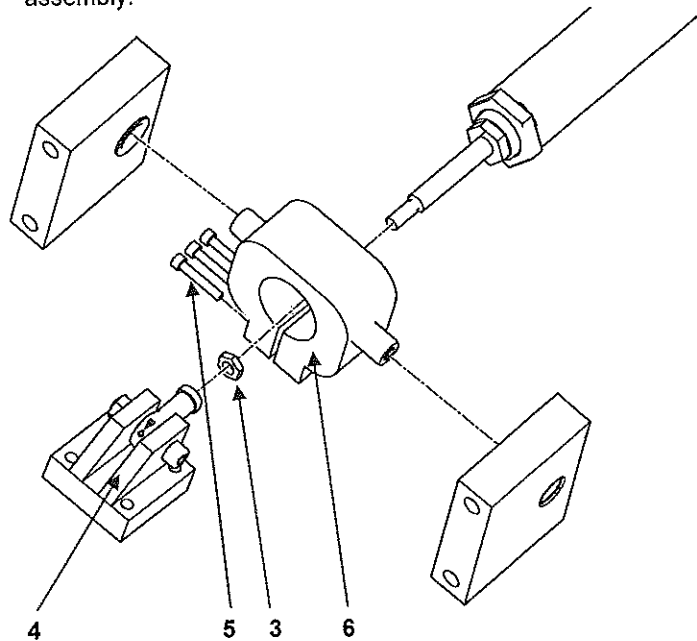
14. Mount the belt tension rollers (7).
NOTE! The roller can only be mounted in one fixed position.
15. After maintenance, see paragraph **3.1.2 After Maintenance**.

3.5 Change of Drive Unit Spring Assembly

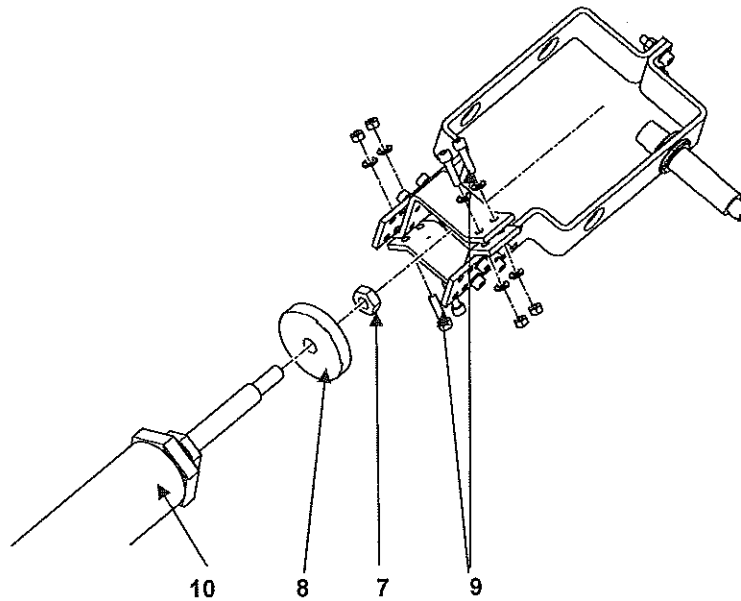
NOTE! Before maintenance – study the paragraph 3.1.1 *Before Maintenance*.



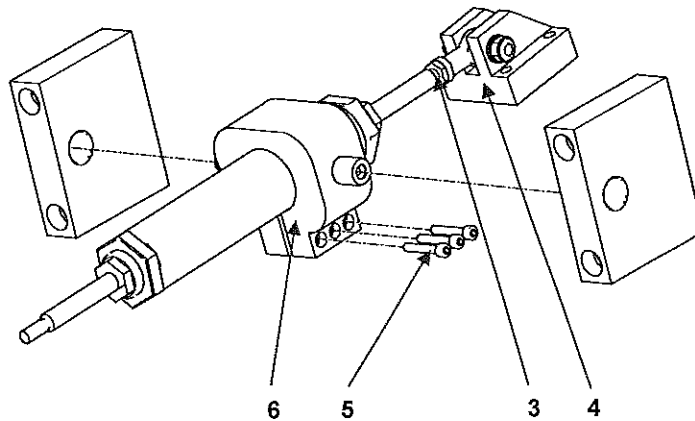
1. Remove the cylinder ball joint bracket, by removing the four screws (1).
2. Remove the cylinder brackets by removing the 2+2 screws (2) and remove the spring assembly.



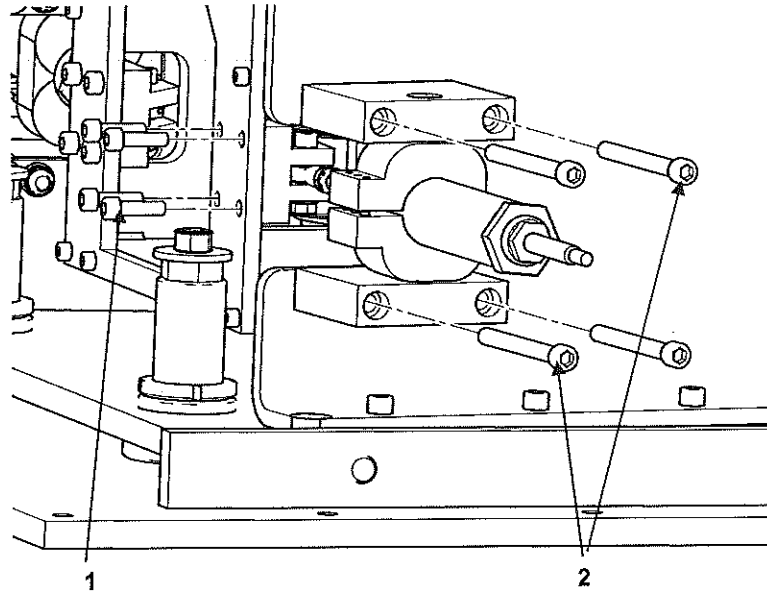
3. Loosen the locking nut (3) and unscrew the ball joint (4).
4. Remove the three screws (5) and remove the clamp hinge bracket (6)



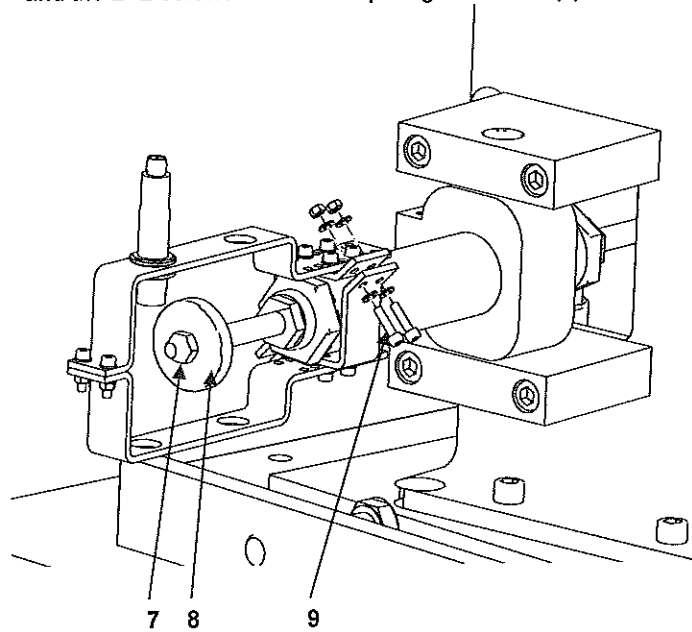
5. Remove the locking nut (7) and the sensor plate (8).
6. Remove the sensor bracket by removing the locking screws (9).
7. Exchange the spring assembly (10).



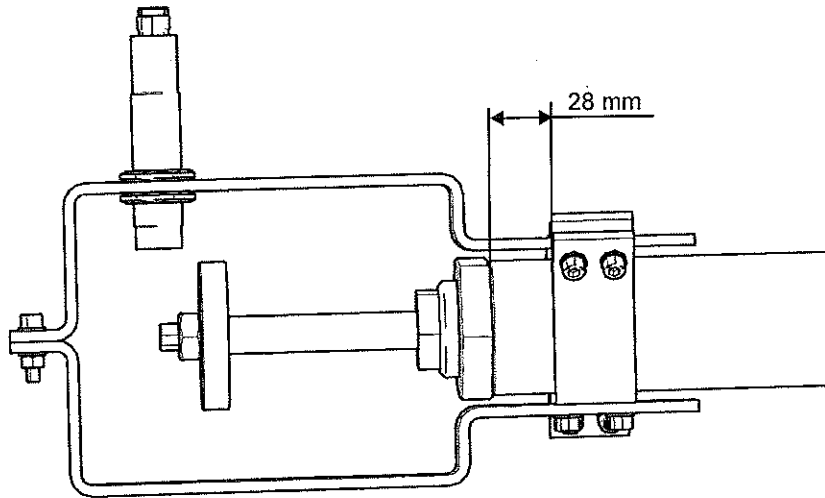
8. Mount the clamp hinge bracket (6) and locking screws (5), ball joint (4) and locking nut (3) onto the spring assembly.



9. Mount the spring assembly on the drive unit. Attach the four screws for the ball joint (1) and the 2+2 screws for the clamp hinge brackets (2).



10. Mount the sensor plate (8) and locking nut (7).
11. Mount the sensor bracket using the locking screws (9).



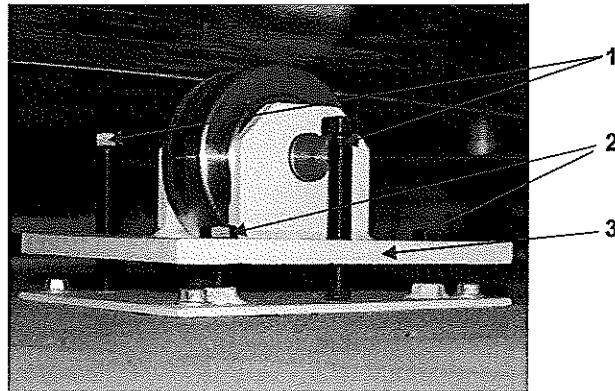
12. Adjust the position of the sensor plate and bracket according to above drawing.
13. After maintenance, see paragraph **3.1.2 After Maintenance**

3.6 Change of Turntable Wheel

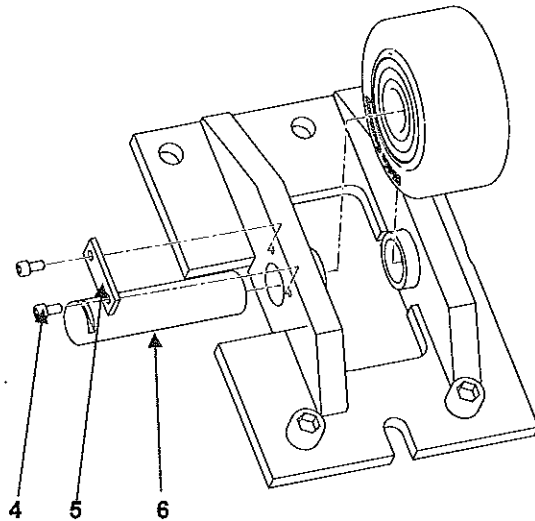
3.6.1 Outer Turntable Wheels

NOTE! Before maintenance – study the paragraph **3.1.1 Before Maintenance**.

The wheels on the outer turntable side can be removed from the outside.



1. Loosen the two adjustment screws (1).
2. Unscrew the wheels attachment screws (2) and pull out the wheel bracket (3).



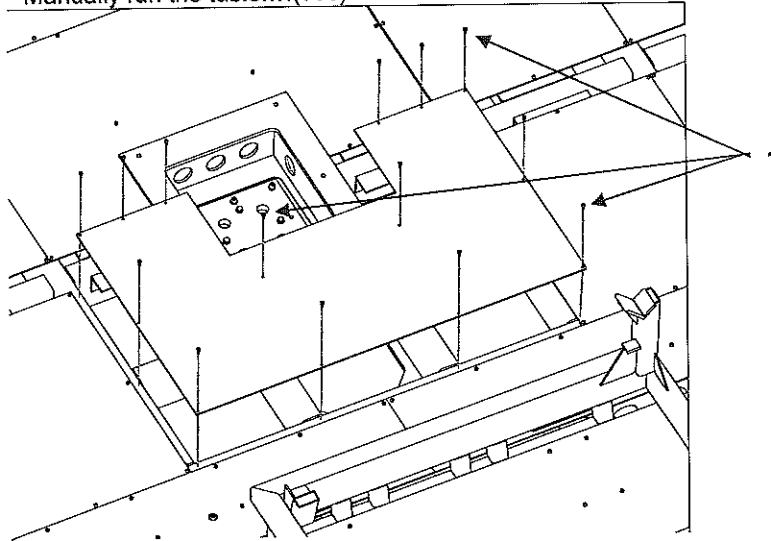
3. Remove the wheel by unscrewing the two locking screws (4) and lifting up the locking plate (5).
4. Pull out the shaft (6) and remove the wheel.
5. Mount the new wheel, push in the shaft (6) and lock it by attaching the locking bracket (5) and locking screws (4).
6. Mount the new bracket and attach the attachment screws (2), but do not tighten the screws.
7. Adjust the adjustment screws (1) until the wheel is pressed against the turntable.
NOTE! Make sure both adjustment screws are equally tightened.
8. Tighten the attachment screws (2).

9. After maintenance, see paragraph 3.1.2 *After Maintenance*.

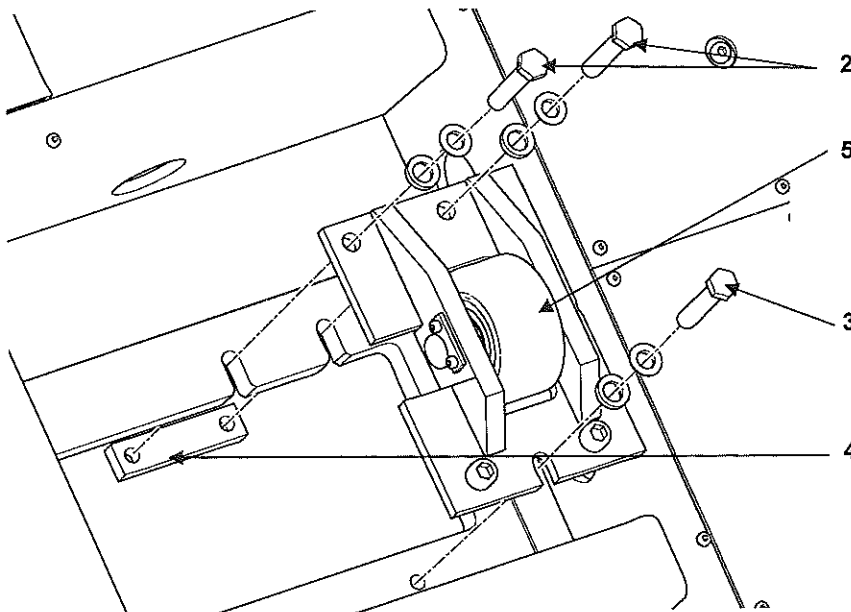
3.6.2 Inner Turntable Wheels

NOTE! Before maintenance – study the paragraph 3.1.1 *Before Maintenance*.

1. To access the inner turntable wheels the table must be in the 90 or 180 degree position.
Manually run the table....(???)

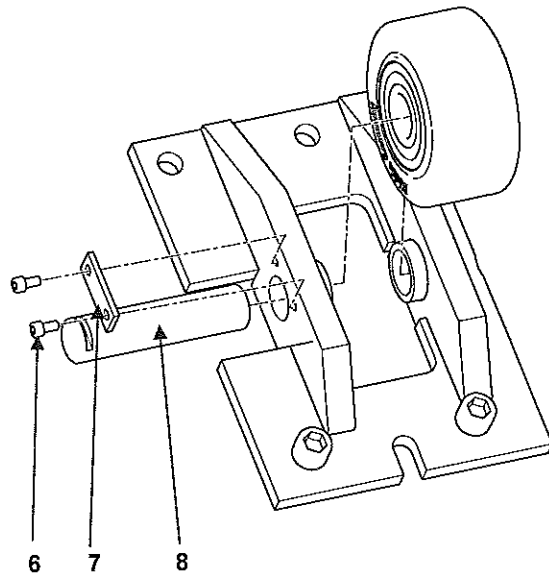


2. Remove the center floor plate above the wheel to be changed by removing the screws (1) and lifting up the floor board.

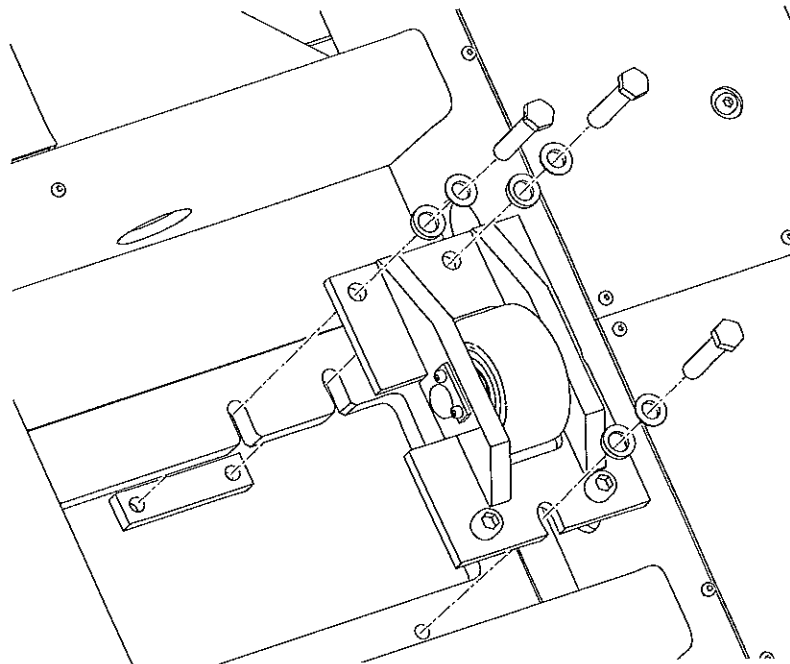


3. Remove the wheel by unscrewing the two front locking bolts (2) and the center rear bolt (3) (may only need to be loosened). Note that the front bolts are locked by a bracket (4).

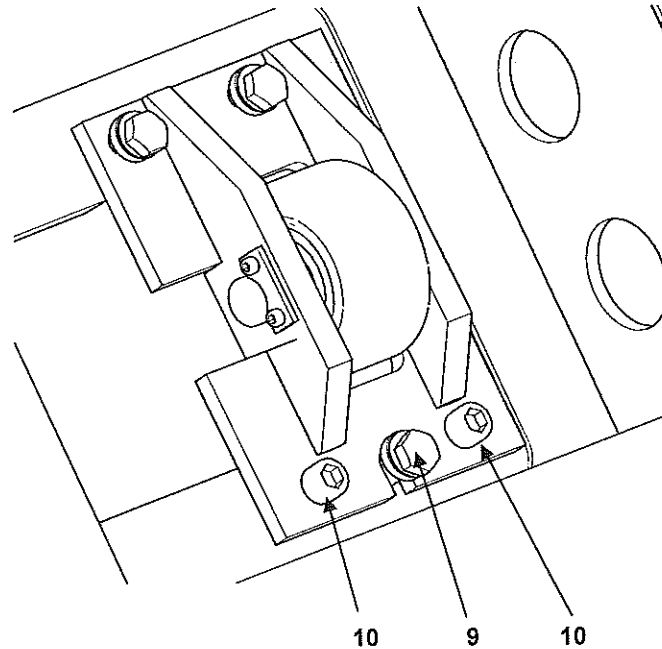
4. Remove the wheel assembly (5).



5. Remove the wheel by unscrewing the two locking screws (6) and lifting up the locking bracket (7).
6. Pull out the shaft (8) and remove the wheel.
7. Mount the new wheel, push in the shaft (8) and lock it by attaching the locking bracket (7) and locking screws (6).



8. Mount the wheel assembly using the same bolts and washers as in step 3 (see drawing above).



9. If necessary, adjust the distance between the wheel and turntable using the adjustment screws (10). Loosen the attachment screw (9) and adjust the adjustment screws until the wheel lies against the upper bar and is not possible to turn by hand.
10. When finished, make sure the adjustment screws are evenly adjusted, and then tighten the attachment screw (9) properly.
11. Re-mount the floor plate, according to step 1.
12. After maintenance, see paragraph **3.1.2 After Maintenance**.

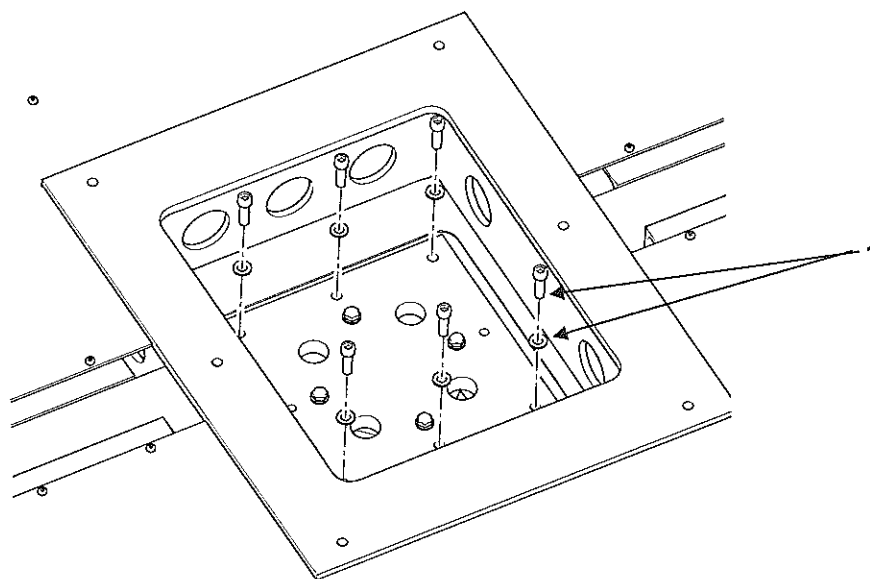
3.7 Change of Central Turntable Bearing

NOTE! Before maintenance – study the paragraph 3.1.1 *Before Maintenance*.

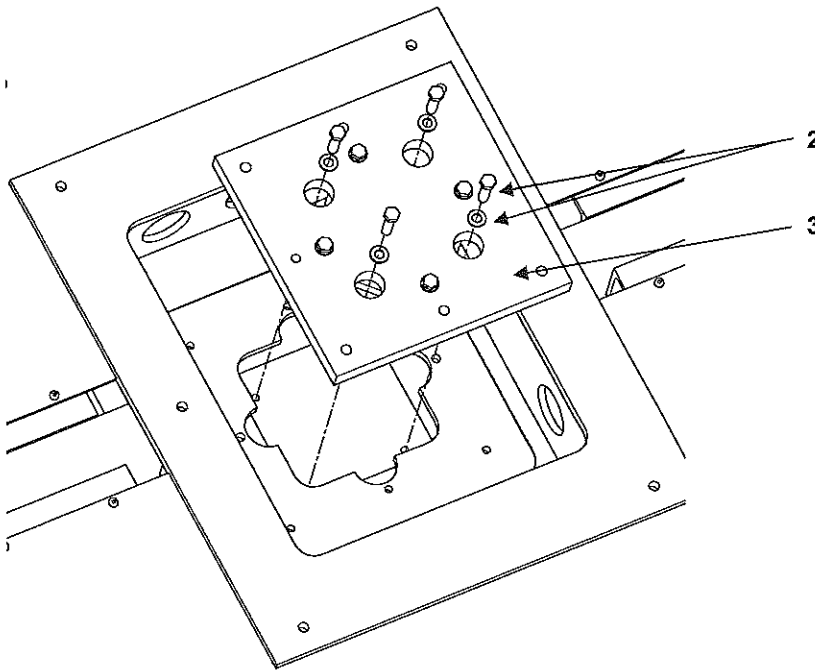
1. Manually run the table into a 45 degree position (how??).



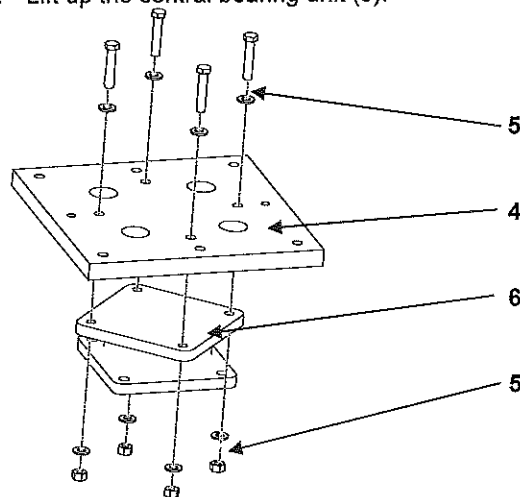
The bottom bolts (1) should now be visible and reachable through the clearance holes (see photo above).



2. Remove the six top bolts and washers (2).



3. Remove the four bottom bolts and washers (2).
NOTE! These can only be reached through the clearance holes when the turntable is in its 45 degree position.
4. Lift up the central bearing unit (3).



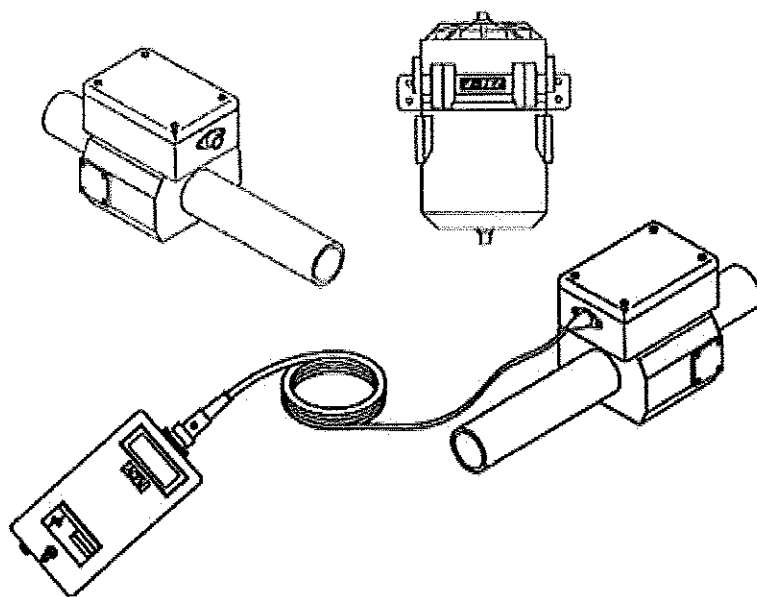
5. Remove the attachment plate (4) by removing the locking bolts, washers and locking nuts (5).
6. Exchange or repair the central bearing (6).
7. Mount the new or repaired bearing in the reversed order and tighten the bolts properly (Tightening torque: 80 Nm)
8. After maintenance, see paragraph 3.1.2 *After Maintenance*.

3.8 Cleaning the J-Tec Flow Meter

NOTE! Before maintenance – study the paragraph 3.1.1 *Before Maintenance*.

Note!

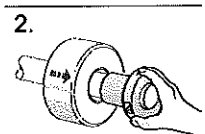
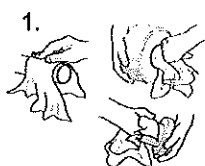
Do NOT use brush wires.
Do NOT use high-pressure liquids.
Do NOT use compressed air.
These may cause damage to the transducers.



To clean the flow tube and strut, gently brush the inside of the tube with a soft brush or cotton swab. An Isopropyl alcohol solution can be used to loosen deposits.

3.9 ETP-EXPRESS Fitting

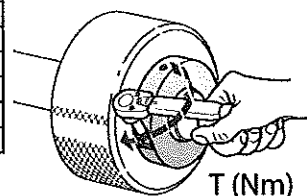
NOTE! Before maintenance – study the paragraph 3.1.1 *Before Maintenance*.



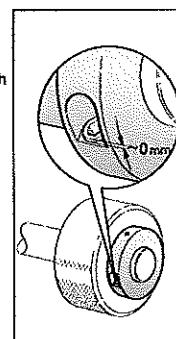
3.

ETP-EXPRESS	T (Nm)
15-35	5
38-60	21
70-80	39
90*-100*	39

* Two screws.

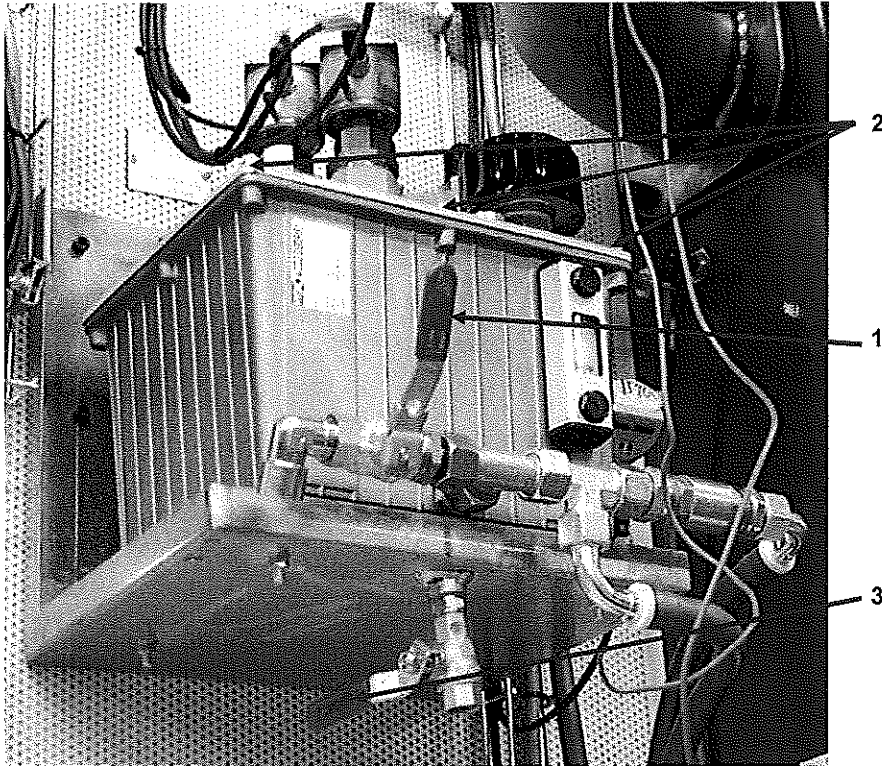


UK: At the recommended tightening torque the screw position is approx. level with the recess.



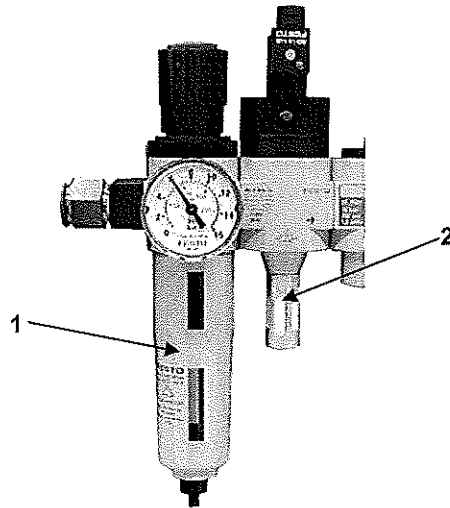
3.10 Cleaning Of Day Tank

NOTE! Before maintenance – study the paragraph 3.1.1 *Before Maintenance*.



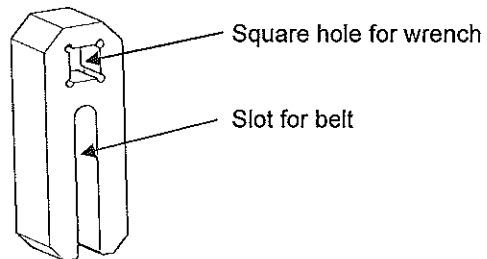
1. First empty the tank by opening the blue valve (1).
2. Dismount the lid by unscrewing the eight locking screws (2).
3. Wipe the inside of the tank clean with a cloth.
4. When finished, mount the lid and close the blue valve.
5. If required, empty the drip pan by opening the red valve (3) and placing a bucket underneath.

3.11 Change of Filters

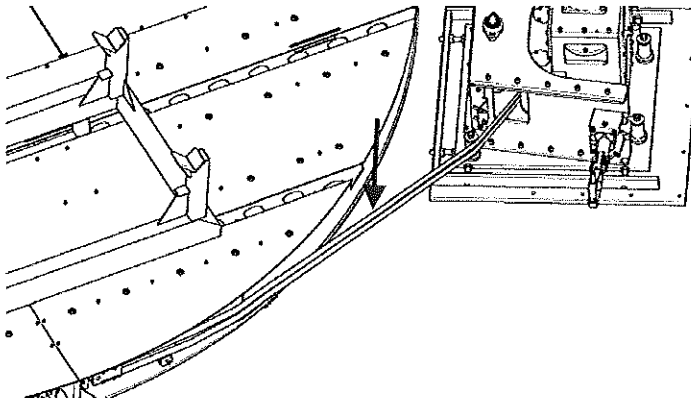


1. Remove the filter by unscrewing the filter cup (2) and replacing the filter inside
2. Remove and replace air filters (1) by simply unscrewing it.

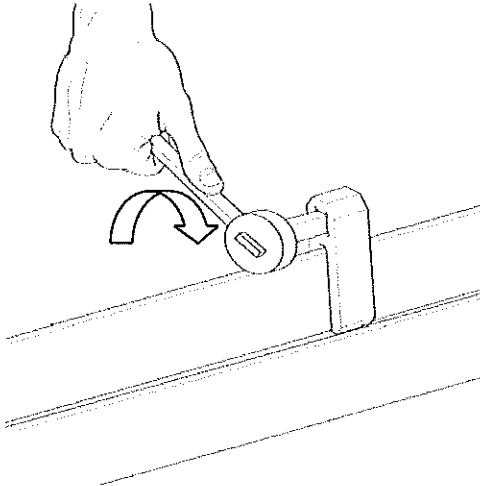
3.12 Turntable Belt Tension



Use the tool depicted above to test the belt tension according to the below instruction.



1. Place the tool on the belt on half the distance the turntable and the drive unit according to the above picture.



2. Put a dynamometric wrench in the square hole and turn 90 degrees down according to the above picture.
3. Stretch or slack the belt until the dynamometric wrench shows 5 Nm according to chapter **3.4 Change of Drive Belt.**