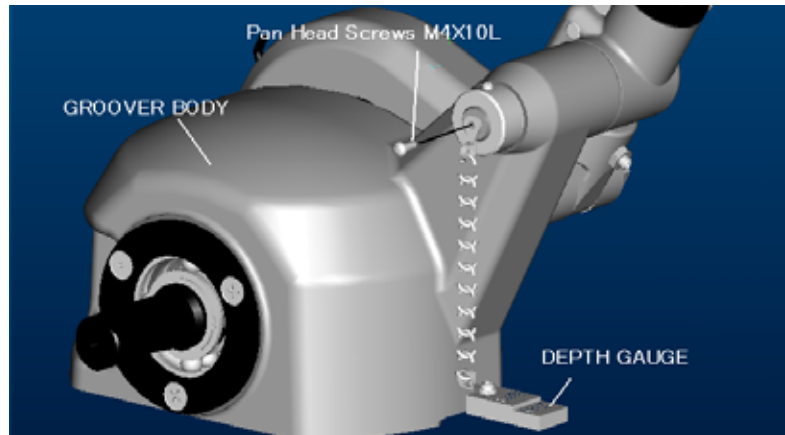


How to replace BEG6 GROOVER BODY EXCHANGE PARTS E

Please refer to the following instructions.

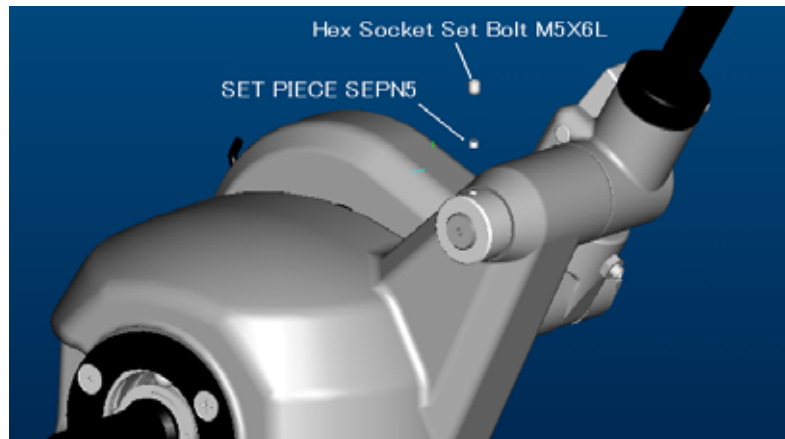
A. Disassembling

1. Remove Pan Head Screw M4x10L with DEPTH GAUGE.

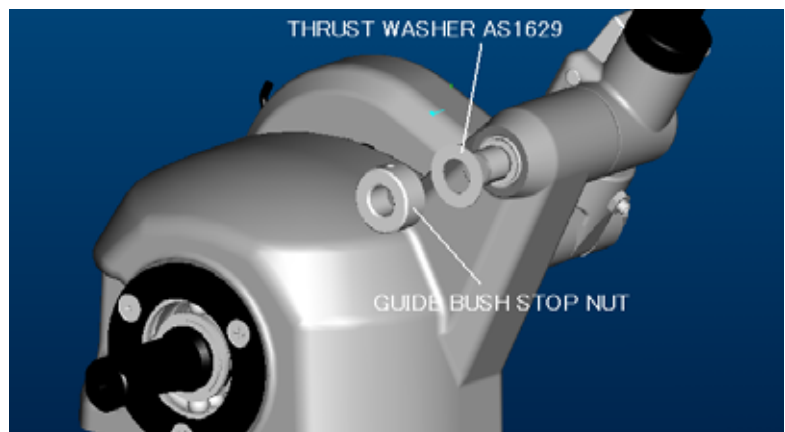


2. Remove Hex Socket Set Bolt M5x6L.
3. Remove SET PIECE SEPN5.

Caution :
SET PIECE SEPN5 is in the screw hole.
Do not lose it.

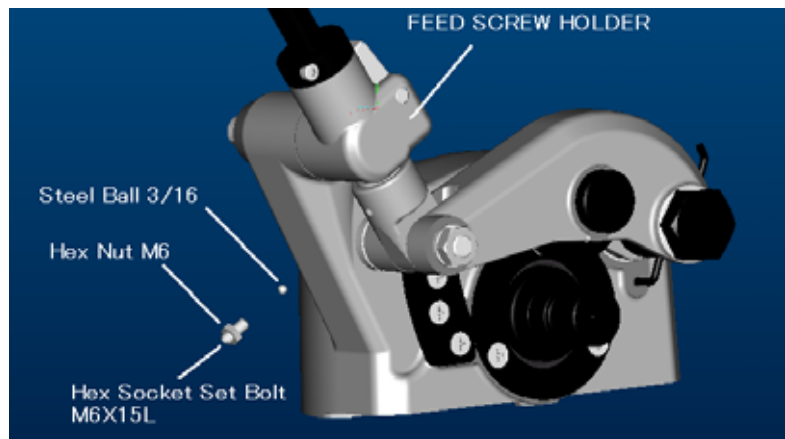


4. Remove GUIDE BUSH STOP NUT and THRUST WASHER AS1629.

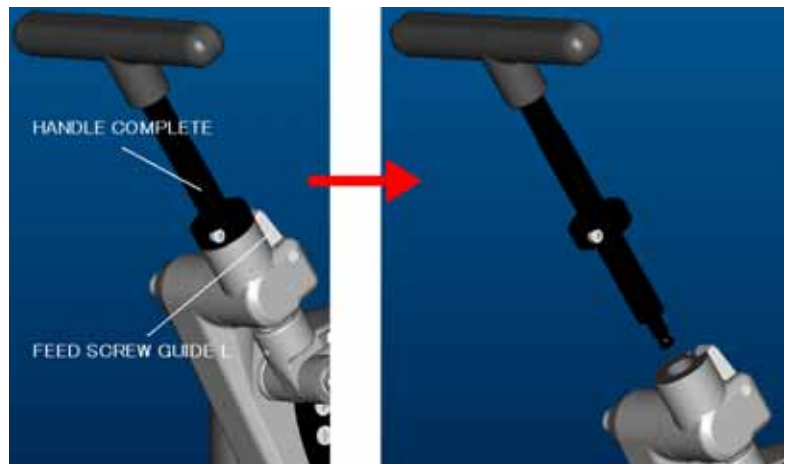


- Loosen Hex Nut M6 which fixes CUTTER HANDLE for FEED SCREW HOLDER and remove Hex Socket Set Bolt M6x15L to remove Steel Ball 3/16.

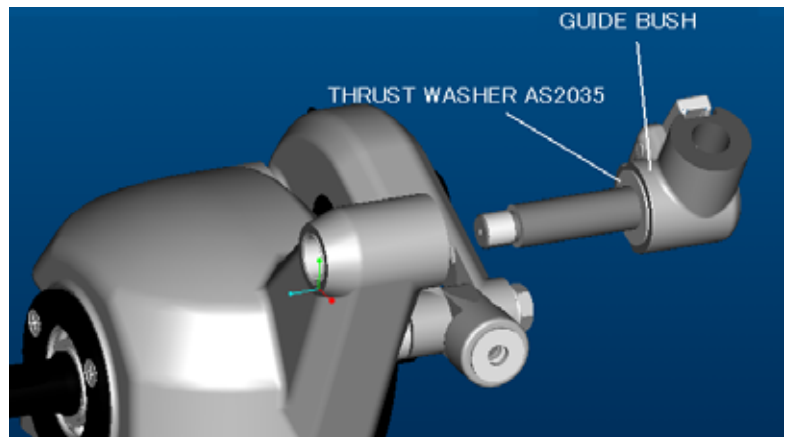
Caution :
Steel Ball 3/16 is in the screw hole.
Do not lose it.



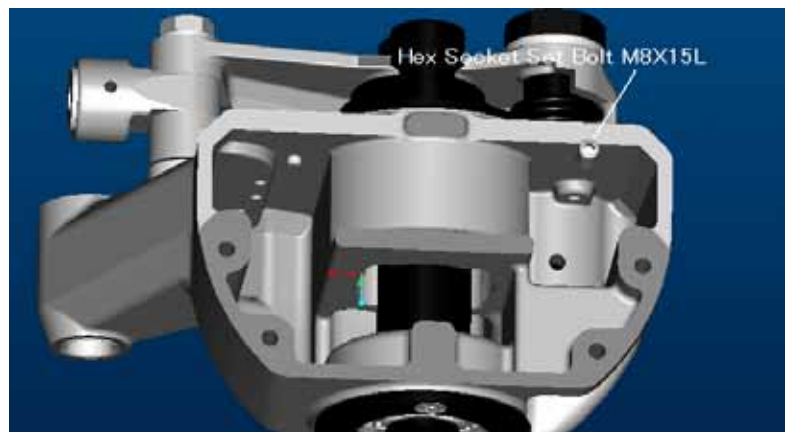
- Remove HANDLE COMPLETE pushing FEED SCREW GUIDE L.



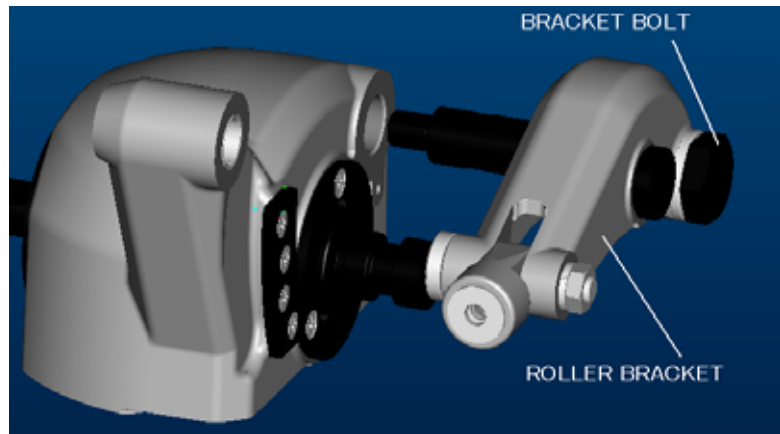
- Pull out GUIDE BUSH together with THRUST WASHER AS2035.



- Remove Hex Socket Set Bolt M8x15L behind GROOVER BODY.



9. Loosen BRACKET BOLT and pull out ROLLER BRACKET together with THRUST WASHER AS2542.



10. Remove Flat Head Screw M6x15L behind GROOVER BODY to remove BEARING PLATE.



11. Pull out GROOVE SHAFT 50-150A with BEARING 5206ZZ.



Now Disassembling is completed.

B. Assembling

1. Prepare GROOVER BODY EXCHANGE PARTS E.



2. Insert GROOVE SHAFT 50-150A with BEARING 5206ZZ into GROOVER BODY EXCHANGE PARTS E

Caution :

There is OIL SEAL AE2775E0 at the front side of GROOVER BODY EXCHANGE PARTS E.

Insert GROOVE SHAFT SLOWLY not to damage OIL SEAL AE2775E0.

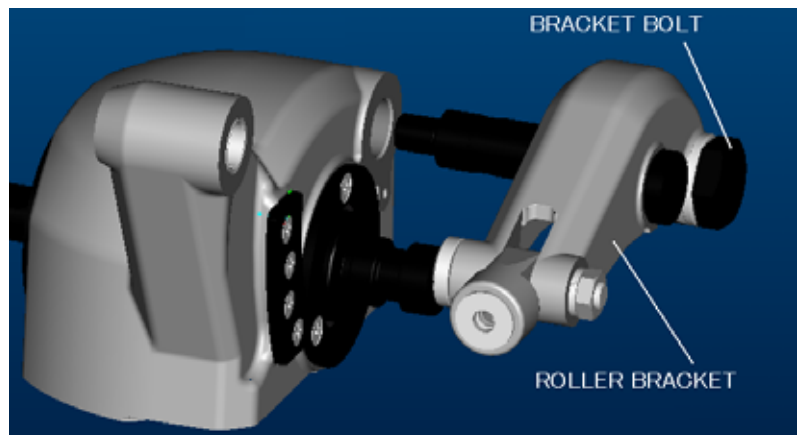


3. Put BEARING PLATE and then Flat Head Screw M6x15L at the rear side of GROOVER BODY EXCHANGE PARTS E.

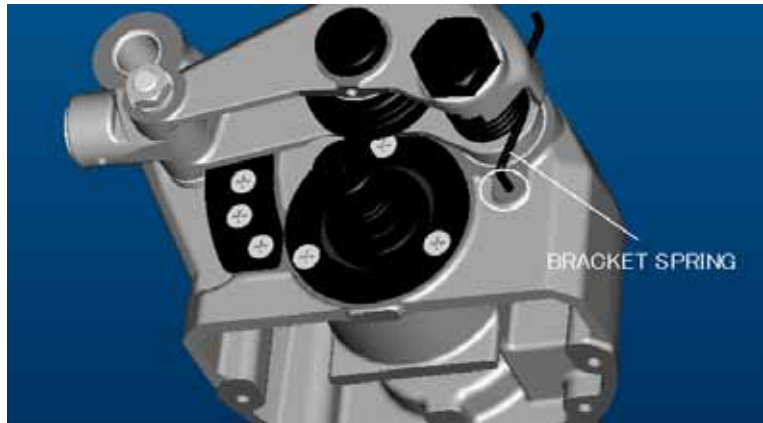


4. Insert BRACKET BOLT with ROLLER BRACKET into GROOVER BODY EXCHANGE PARTS E.

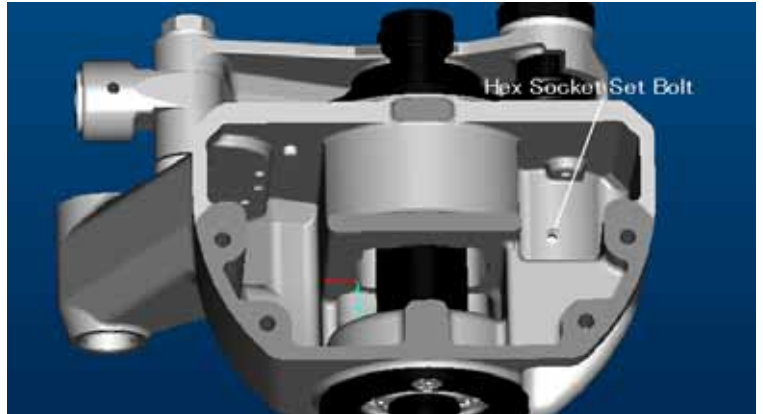
5. Tighten BRACKET BOLT.



Caution :
Make sure that the edge of BRACKET SPRING is inserted into the hole on GROOVER BODY EXCHANGE PARTS E.

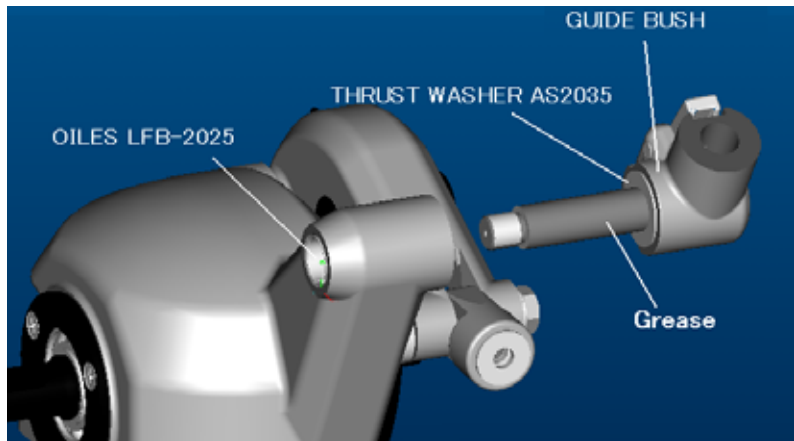


6 . Install Hex Socket Set Bolt M8x15L behind GROOVER BODY EXCHANGE PARTS E.

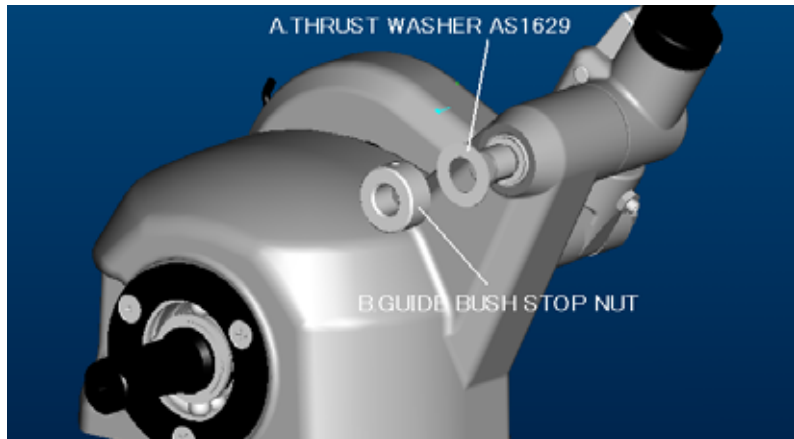


7 . Apply grease to the shaft of GUIDE BUSH and insert it to GROOVER BODY EXCHANGE PARTS E.

Caution :
Do not damage OILES LFB-2025 when you insert GUIDE BUSH.

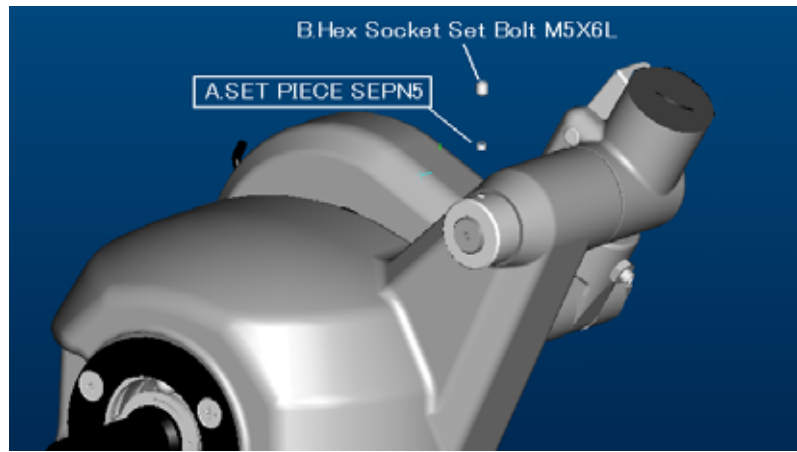


8. Install THRUST WASHER AS1629 and then GUIDE BUSH STOP NUT to GUIDE BUSH.

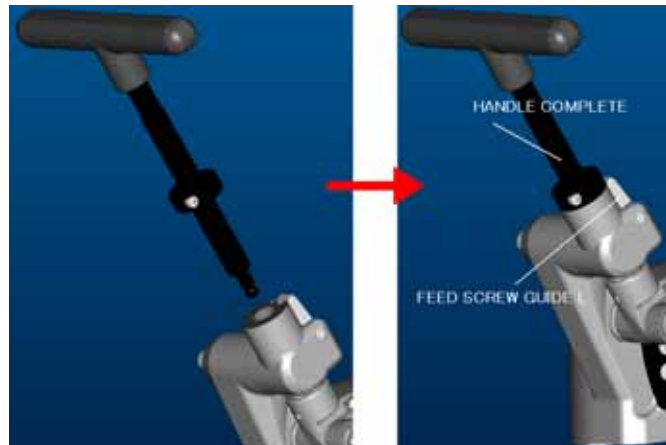


9. Install SET PIECE SEPN5 and then Hex Socket Set Bolt M5x6L to the hole at the side of GUIDE BUSH STOP NUT.

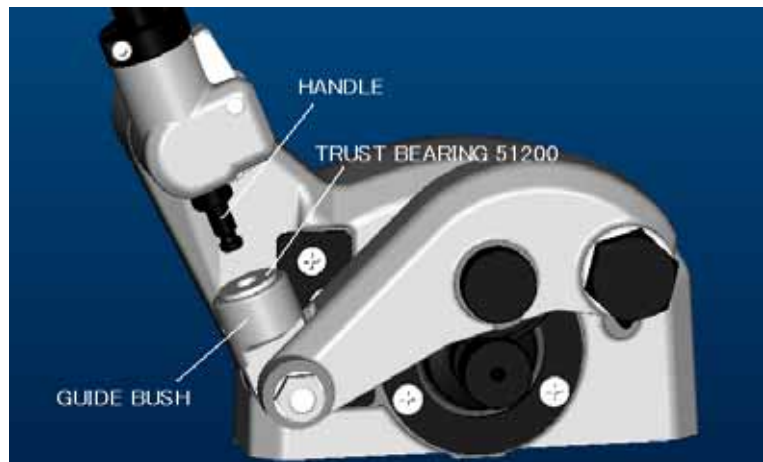
Caution :
Do not forget to put SET PIECE SEPN5.
GUIDE BUSH will be damaged if Hex Socket Set Bolt is tightened without SET PIECE SEPN5.



10. Insert HANDLE COMPLETE into GUIDE BUSH.

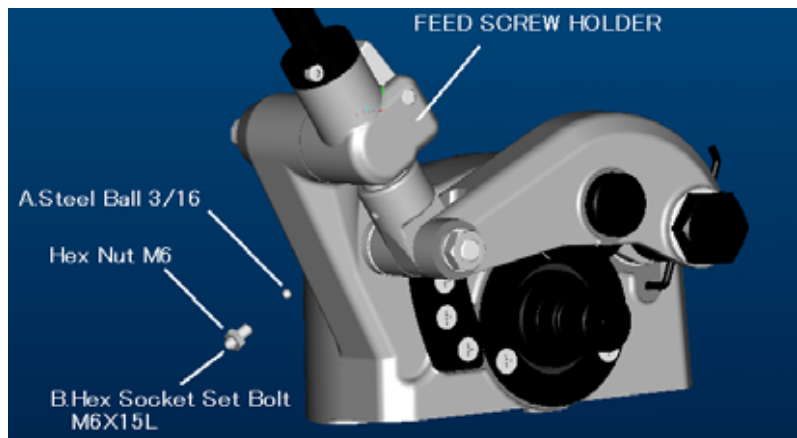


11. Insert the edge of Handle into FEED SCREW HOLDER with THRUST BEARING 51200.

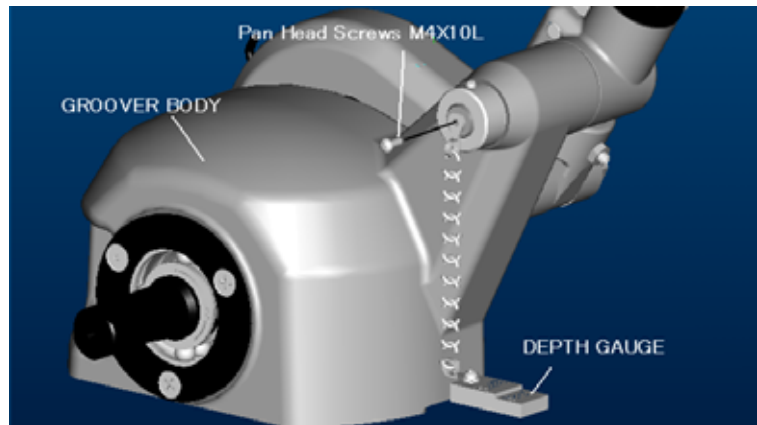


12. Install Steel Ball 3/16 and then Hex Socket Set Bolt M6x15L (with Hex Nut M6) to the screw hole.

After fully tightening Hex Socket Set Bolt M6x15L, turn it counterclockwise 60° (loosen).
Tighten Hex Nut M6 to fix it.



13 . Install Pan Head Screw M4x10L with DEPTH GAUGE to GROOVER BODY EXCHANGE PARTS E.



Now the assembly is completed.

Make sure that GROOVE SHAFT 50-150A and HANDLE rotates smoothly.