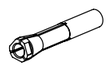
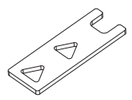
1000016445

MDX-50 ZC-50-6 ZC-50-1/4 Collet Replacement Method

Roland

Items Used in This Procedure

Included Items		Items Included with Main Unit	
			
Collet (1)	Grease (1)*	Wrenches (2)	Detection pin (1)

* Refer to the appropriate safety data sheet (SDS) for the chemical substances used in the grease and the safety related to those substances.

Replacement

⚠WARNING: **Be sure to securely fasten the collet. After securing in place, make sure no wrenches or other articles have inadvertently been left behind.**
If you do not check for these articles, they may be thrown from the machine with force, posing a risk of injury.

⚠CAUTION: **Do not touch the spindle unit or the surrounding areas immediately after cutting has ended.**
Doing so may result in burns.

⚠CAUTION: **Be sure to remove the cutting tool before performing replacement work.**
Contact with the blade may result in injury.

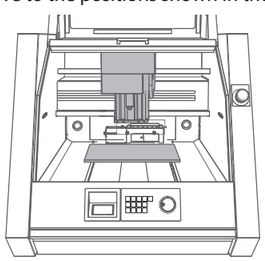
1. Remove the collet.

For details on the operation of the machine, see the user's manual included with the machine.

1 **If a tool bur or detection pin is mounted on the spindle, return the tool bur or detection pin to the ATC magazine.**

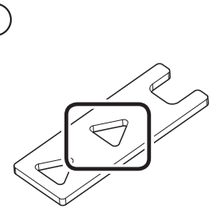
2 **If the inside of the cutting machine is dirty, clean it.**
Remove the workpiece.

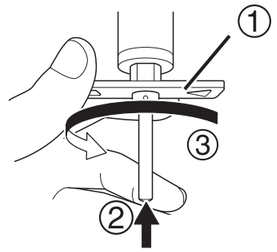
3 **Move the spindle and the table.**
① **Start VPanel.**
② **Click ⚙, the [Maintenance] tab, [Spindle maintenance], and then click [Move].**
The spindle and table move to the positions shown in the following figure.



4 **Open the collet.**
① **On the [Maintenance] tab, click [Open collet].**
② **When a confirmation dialog box appears, click [OK].**
The collet will open.

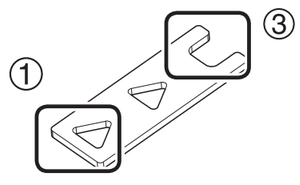
5 **Loosen the collet.**
① **Fit the wrench onto the collet.**
Fit the triangular hole in the center of the wrench onto the collet.
② **Insert the detection pin into the collet.**
③ **Loosen the collet with the wrench while supporting the detection pin with your hand.**

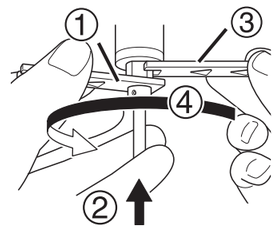




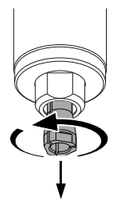
When the collet cannot be removed with the above method

① **Fit the wrench onto the collet.**
Fit the triangular hole at the end of the wrench onto the collet.
② **Insert the detection pin into the collet.**
③ **Fit the width-across-flats hole of the second wrench onto the spindle.**
④ **Turn the collet in the direction of the arrow to loosen it.**



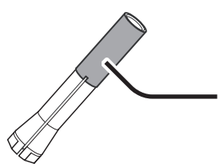


6 **Remove the collet.**
① **Remove the detection pin and the wrench.**
② **Turn the collet in the direction of the arrow to remove it.**

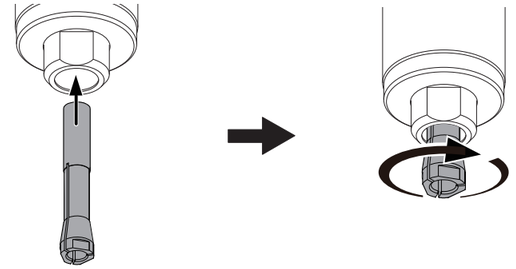


2. Attach the new collet.

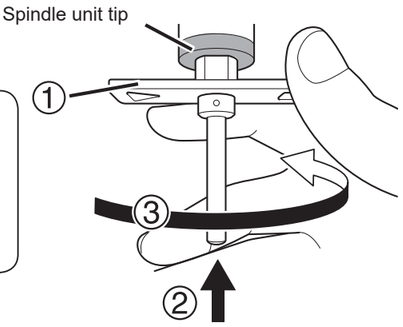
1 **Apply grease to the replacement collet.**
Lightly apply grease in the location shown in the following figure.



2 **Attach the collet.**
Insert the collet, and then turn it in the direction of the arrow to attach it.



3 **Tighten the collet.**
① **Fit the wrench onto the collet.**
Fit the triangular hole in the center of the wrench onto the collet.
② **Insert the detection pin into the collet.**
③ **Tighten the collet with the wrench while holding the detection pin.**



Point
Tightening is sufficient once the wrench and the tip of the spindle unit begin to rotate together.

4 **Remove the detection pin and the wrench.**

5 **Close the front cover and press [ENTER].**

3. Perform automatic correction.

1 **Close the collet.**
① **Start VPanel.**
② **Click ⚙, the [Maintenance] tab, and then click [Close collet].**
③ **When a confirmation dialog box appears, click [OK].**

2 **Perform automatic correction of the milling machine.**
For details on the operation of the machine, see the manual included with the machine.
Replacement of the collet is finished once automatic correction is complete.

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