



Umbrella - Tool Changer - Pocket - Replacement

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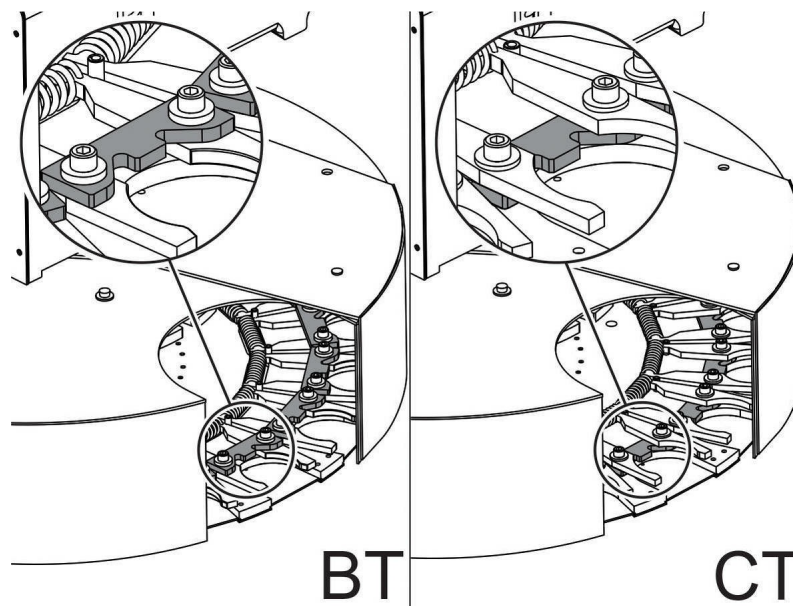


Translation Available



VMC - Umbrella Tool Changer - Pocket - Replacement

This procedure shows you how to replace the extractor fork and slider assemblies in an umbrella-style tool changer. Do this procedure for each pocket assembly that you must replace. The illustrations show a BT-style tool-changer. The instructions are the same for a CT-style tool-changer.



Prerequisites

This procedure is applicable to more than one kit. Only one of the kits is necessary.

- **93-2366** POCKET REPLACEMENT, BT UMBRELLA 32 STATION
- **93-2371** POCKET REPLACEMENT, CT UMBRELLA 10 STATION (SMM & GR ONLY)
- **93-2370** POCKET REPLACEMENT, BT UMBRELLA 10 STATION (SMM & GR ONLY)
- **93-2373** POCKET REPLACEMENT, CT UMBRELLA 20 STATION (NOT GR)
- **93-2372** POCKET REPLACEMENT, BT UMBRELLA 20 STATION (NOT GR)
- **93-2369** POCKET REPLACEMENT, CT UMBRELLA 20 STATION (GR ONLY)
- **93-2368** POCKET REPLACEMENT, BT UMBRELLA 20 STATION (GR ONLY)
- **93-2374** POCKET REPLACEMENT, BT UMBRELLA 10 STATION (NOT SMM)
- **93-2367** POCKET REPLACEMENT, CT UMBRELLA 32 STATION
- **93-2375** POCKET REPLACEMENT, CT UMBRELLA 10 STATION (NOT SMM OR GR)

Tools Required

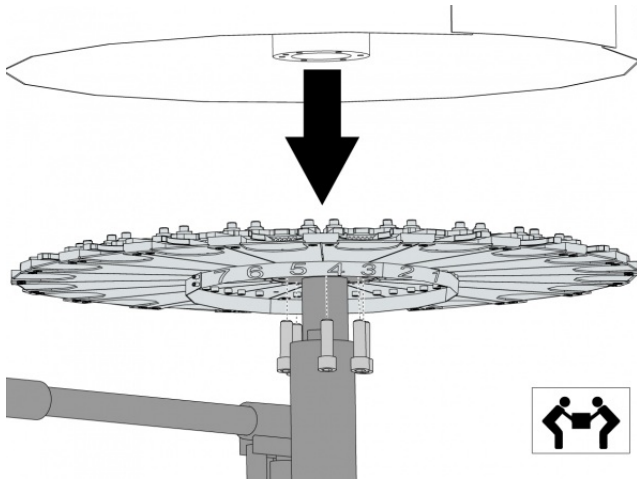


Mobil SHC 460 Grease



Medium-strength thread-lock compound

STEP 1



Remove all tools from the tool changer. Put wooden blocks on the table. Put a bottle jack on the wooden blocks.



Jog the table below the center of the carousel plate.

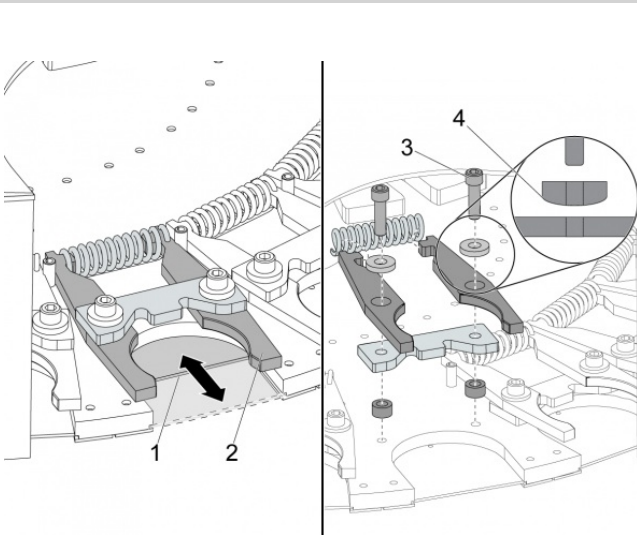
Support the carousel plate with the bottle jack.



Push **[POWER OFF]**.

Remove the (6) SHCS from the carousel plate. With a second person remove the carousel plate.

STEP 2



Use your hand to push the station door [1] fully in to make sure it moves freely. If it does not move freely, clean the chips from the door and the door track.

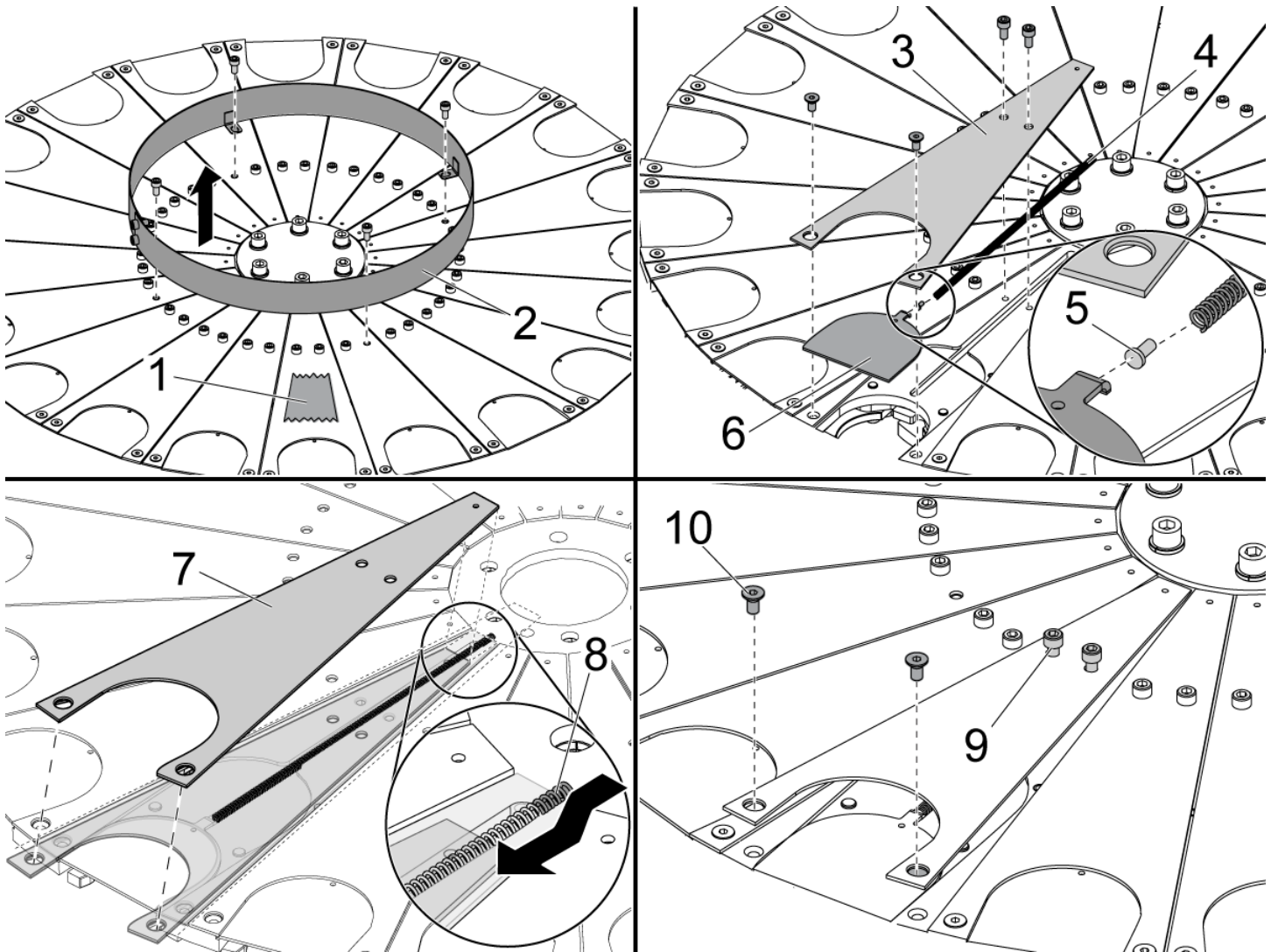
Use a straightedge on the extractor fork [2] to see if it is bent.

Remove the screws [3] that attach the damaged fork assembly to the carousel plate. Remove the assembly as shown. Replace all damaged parts.

Apply a medium-strength thread-lock compound (for example, blue Loctite®) to the threads on the fork assembly screws [3]. Apply Mobil SHC 460 grease to the thru-holes of the replacement assembly.

Install the replacement assembly. Make sure that the beveled side of the washer [4] is against the extractor key (BT, shown) or the fork bushing (CT). Torque the screws to 7 ft-lb (9.5 Nm).

STEP 3



Put a piece of tape [1] on the carousel at pocket 1. Remove the pocket number ring [2].

Remove the sliding panel cover [3], compression spring [4], rivet [5], and sliding panel [6]. Replace all damaged parts. Clean all debris from the pocket.

Apply Mobil SHC-460 grease to the new compression spring. Put the 3/32" rivet into the end of the compression spring. Install the new compression spring [4] and new sliding panel [6]. Install the new sliding panel cover [7] while you push the end of the spring [8] under the panel.

Torque the (2) 10-32 SHCS [9] to 20 in-lb (2.26 Nm).

Apply medium-strength thread-lock compound (for example, blue Loctite®) to the (2) 10-32 flat head cap screws (FHCS) [10]. Install the (2) FHCS [10] and torque to 20 in-lb (2.26 Nm). Make sure the sliding panel [6] moves freely.

Install the pocket number ring [2]. Make sure the number 1 on the number ring aligns with the tape [1] on pocket 1 of the umbrella tool changer.