



VMC - 50-Taper - Gearbox - Vent Solenoid - Reconfiguration

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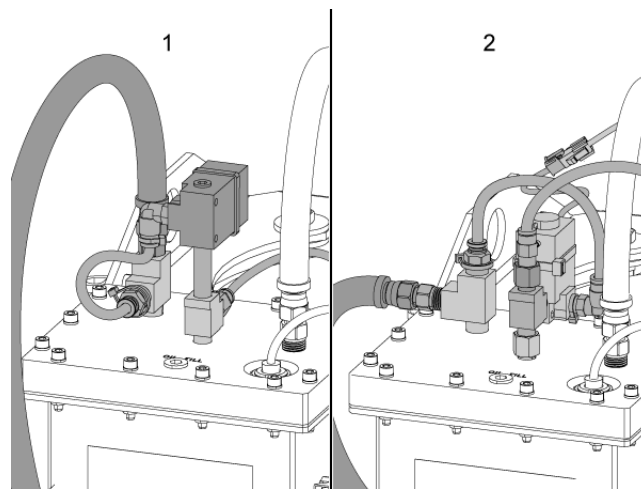


Translation Available



VMC - 50-Taper - Gearbox - Vent Solenoid - Reconfiguration - Introduction

This procedure tells you how to reconfigure the vent solenoid on the gearbox sump tank.






Reconfigure the vent solenoid [1] as shown [2]. This prevents oil leaks from the input hose into the coil of the vent solenoid .

Note: The solenoid on your machine may look different from the vent solenoid in these illustrations. The installation and operation of the vent solenoid is the same.

Prerequisites

Parts Required:

	FITG NPT 1/8NPT 1/8M ORIFICE .031 STR(P/N 58-0303) QTY:1		FITG NPT 1/8NPT 1/8M ORIFICE .010 STR(P/N 58-4081) QTY:1
	NIPPLE 1/8NPT X 1 HEX BRASS (P/N 58-16732) QTY:1		

Machine Compatibility

Do this procedure on vertical mills that have a gearbox and a 50-taper spindle.

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STEP 1

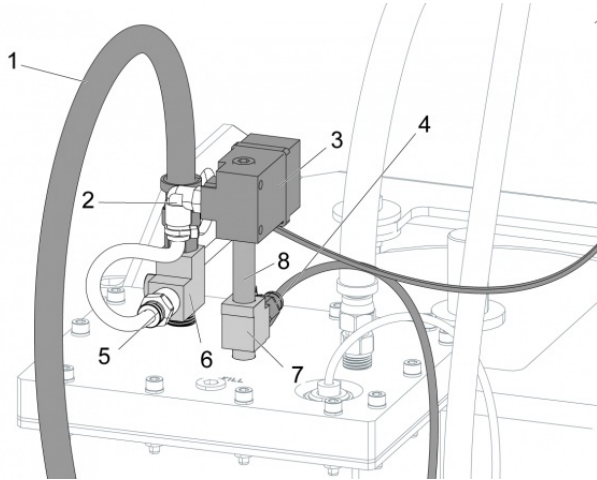


Push **[POWER OFF]**.

Set the main circuit breaker to the **OFF** position. Lock the main circuit breaker. Use an approved lock with an approved safety tag.

Turn the main air valve to the **OFF** position. This shuts off the air supply to the machine.

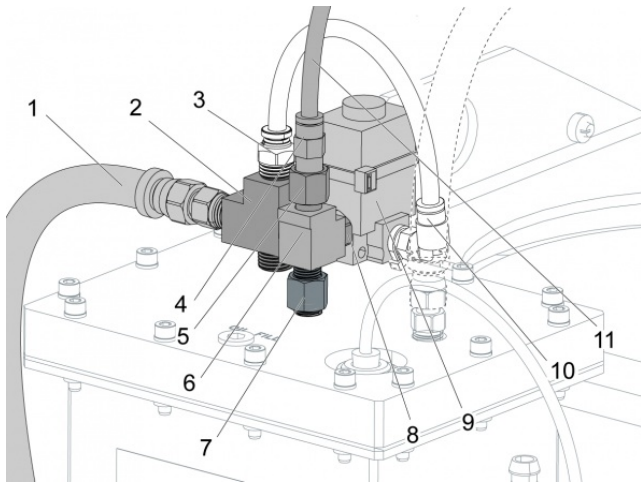
STEP 2



Disconnect these parts:

- return hose [1] and fitting
- 1/4" oil transfer tube and fitting [5] from the 1/8 NPT x 1/8 NPT brass tee fitting [6]. Do not remove the 90 degree 1/4" push-to-fit fitting [2] from the solenoid [3].
- 1/8 NPT x 1/8 NPT brass tee fitting [6] from the lid
- 1/4" oil supply tube and push-to-connect fitting [4]
- solenoid [3]
- extension nipple [8]. You may discard this part.
- 1/8 NPT x 1/8 NPT brass tee fitting [7]

STEP 3



Install these parts to the lid:

- 1/8 F NPT 0.31 orifice fitting [7]
- 1/8 NPT x 1/8 NPT brass tee fitting [2]. Align it so that the return hose [1] will drape over the side of the tank.

Turn the 90 degree 1/4" push-to-fit fitting [10] on the solenoid [9] until the fitting points up.

Install these parts onto the solenoid [9]:

- 1/8 NPT X 1 HEX nipple [8]
- 1/8 NPT x 1/8 NPT brass tee fitting [6]
- 1/8 F NPT 0.10 orifice fitting [5]
- 1/4" push-to-connect fitting [4]

Install the completed solenoid assembly onto the 1/8 F NPT 0.31 orifice fitting [7].

Connect the 1/4" oil transfer tube and fitting [3] to the 1/8 NPT x 1/8 NPT brass tee fitting [2].

Connect the return hose [1] and fitting to the 1/8 NPT x 1/8 NPT brass tee fitting [2].

Connect the 1/4" oil supply tube [11] to the 1/4" push-to-connect fitting [4].

Connect the solenoid wire to the spindle connection panel.

Turn the main air valve to the **ON** position.



Power on the machine.

Run a program to turn the spindle at a low speed. Check for leaking oil.

If there is an oil leak, it is a sign of a contaminated orifice. Check the fittings for contamination.