

Service bulletin

2009-06-01

DS250

This bulletin only affect DS 250 with S/N between 1001 and 1199, and replace SB DS250 2009-03-27 !

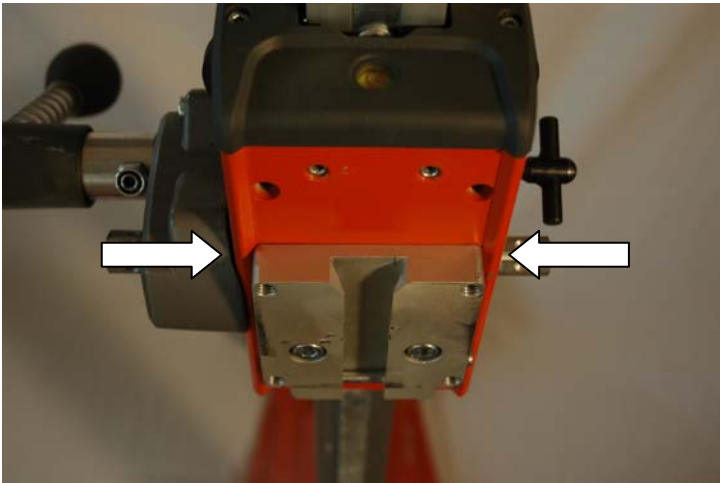
After assembly in production, the quick attachment plate (541 40 51-41), could sometimes be slightly deformed. The deformation was caused when the quick attachment plate ride on the side flanges of the carriage (Picture 1). The interference between the plate and carriage could be enough to prevent the DM 330 dove tail to fit. The solution is to grind down the sides of the quick attachment plate (Picture 2).

This problem only occur in the combination DS 250 and DM 330/340. And only on DS 250 with S/N 1001 to 1199.

Therefore, there is no need for action on all DS 250.

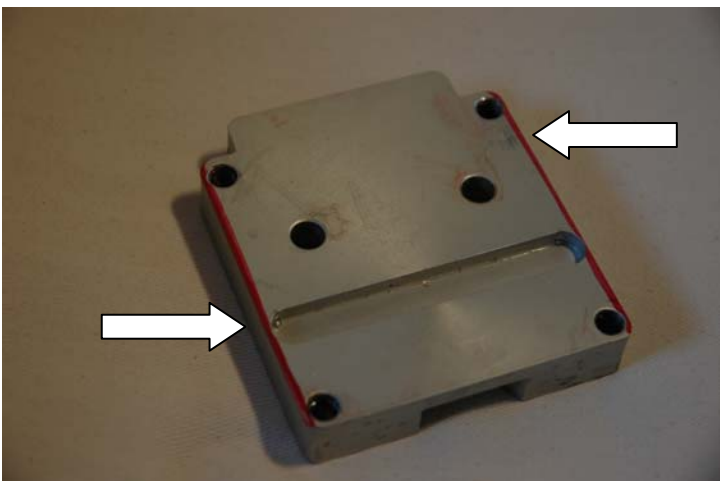
A very low number of plates might also have wrong geometric in the keyway. If so, the DM 330/340 dove tail will never fit, and the quick attachment plate needs to be replaced.

As from S/N 1200, all DS 250 that leave production are checked and approved.



Picture1.

The area where the quick attachment plate might ride on the side flanges of the carriage.



Picture 2.

Grind the red area, if needed.

If a faulty DS 250 is found, an instruction how to remove the quick attachment plate follows.

How to remove the quick attachment plate on DS 250

1.

Remove the carriage from the stand.

You can also do this with the carriage attached to the stand. But it is easier to work with them separately.

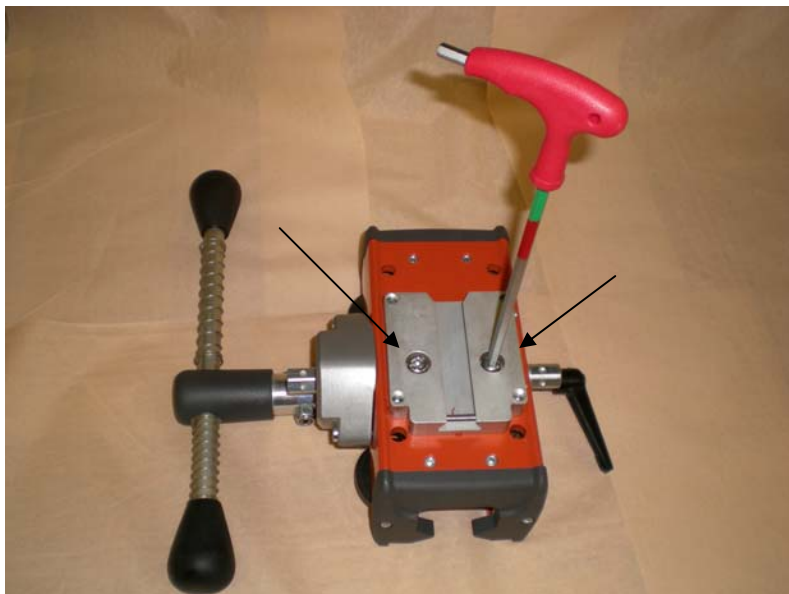
.



2.

Loosen the 2 lock screws from the quick attachment plate.

Then remove the motor plate.



3.

Remove these 2 screws.

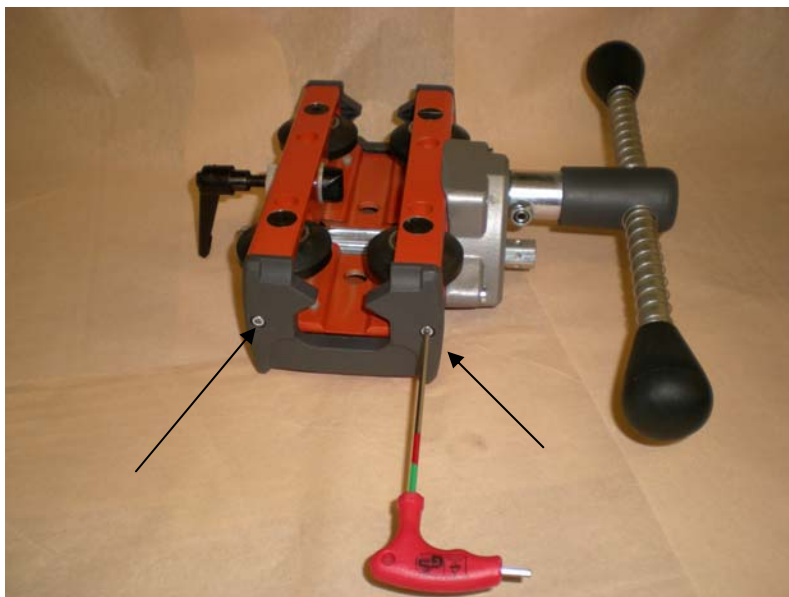
They are fixed with Loctite and can be hard to loosen.



4.
Turn the carriage and remove these 2 screws.
They are also fixed with Loctite, and can be hard to remove.



It is a help, to put the tool in a vice.



- 5.**
Before you can access the last 2 screws, the nylon rollers need to be removed.
To do that, dismount the plastic guard by removing these 2 screws.



- 6.**
Loosen these 2 lock screws.
After that, the axle can be pressed out, and the nylon rollers can be removed.



7.
Dismount the last 2 screws, and the quick attachment plate can be removed.

8.
Grind the quick attachment plate. Then remount everything again.