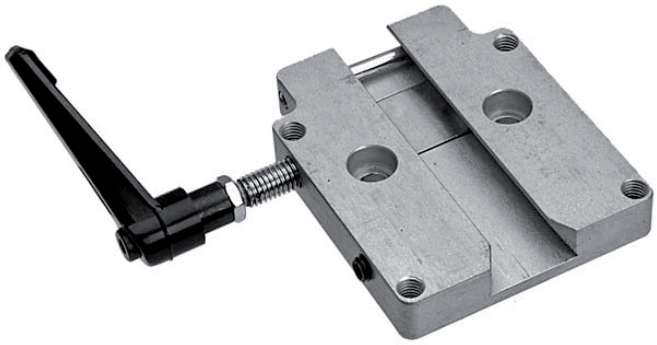
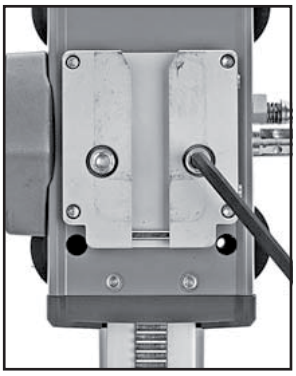
SB, Quick fit tool bracket, DS 250, 2013-04

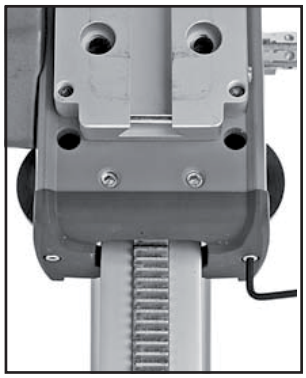
The older style tool bracket has been replaced by a quick attachment type art nr 577 95 06-01.

The older bracket requires that an Allen key is always available, and that the two screws are loosened or tightened. With the new tool bracket, the machine is locked to the carriage with a single knob, which means easier and faster handling. The Allen screw, on the same side of the knob, can be used as an extra safeguard for the machine.

The new tool bracket comes as an unassembled kit. The components must therefore be installed before fitting the tool bracket assembly to the carriage.





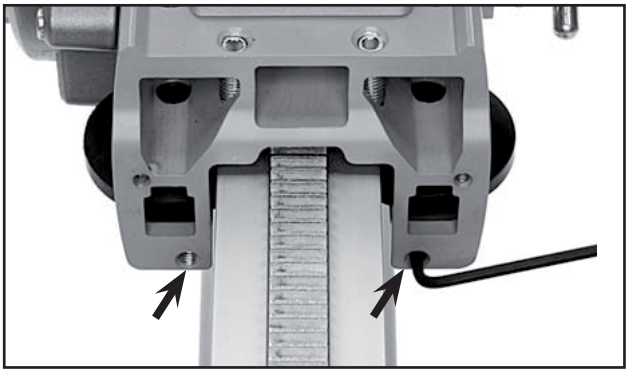


Remove the bracket

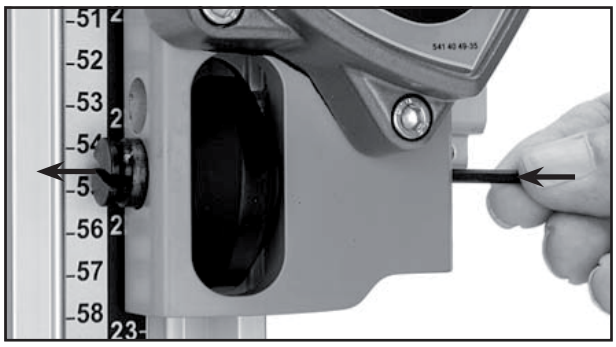
Remove the front screws
Start by removing the two screws, Allen key 6 mm, on the tool bracket. These are locked with Loctite and may sit very tightly.

For the next stage, remove the four screws that are visible in the corner of the tool bracket in the left image. To reach these screws you have to remove the lower roller pair.

Remove the cover
Remove the two screws, Allen key 3 mm, to the cover at the bottom of the carriage.

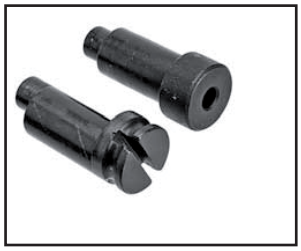


Remove the lower roller pair
Unscrew the locking screws, Allen key 3 mm, to the lower roller pair's shafts a few turns. Note that the upper roller pair does not need to be dismantled.



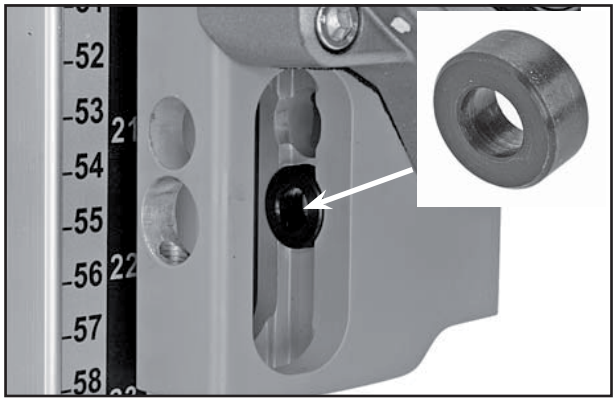
As the set screws are screwed out, as per the previous step, the two roller pairs' shafts can be easily pushed out.

Also remove the rollers.

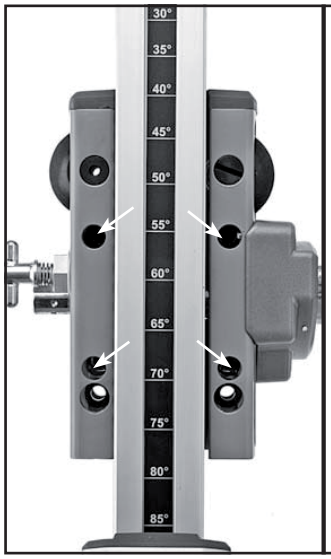


Shafts
Note the shafts have different designs. The shaft with the screwdriver groove is asymmetrical and is used for adjusting the application of the roller to the drilling column.

Rollers
The rollers are symmetrical and identical in design.



Bushings
Note the bushings for the shafts. These could fall out when removing the shafts.

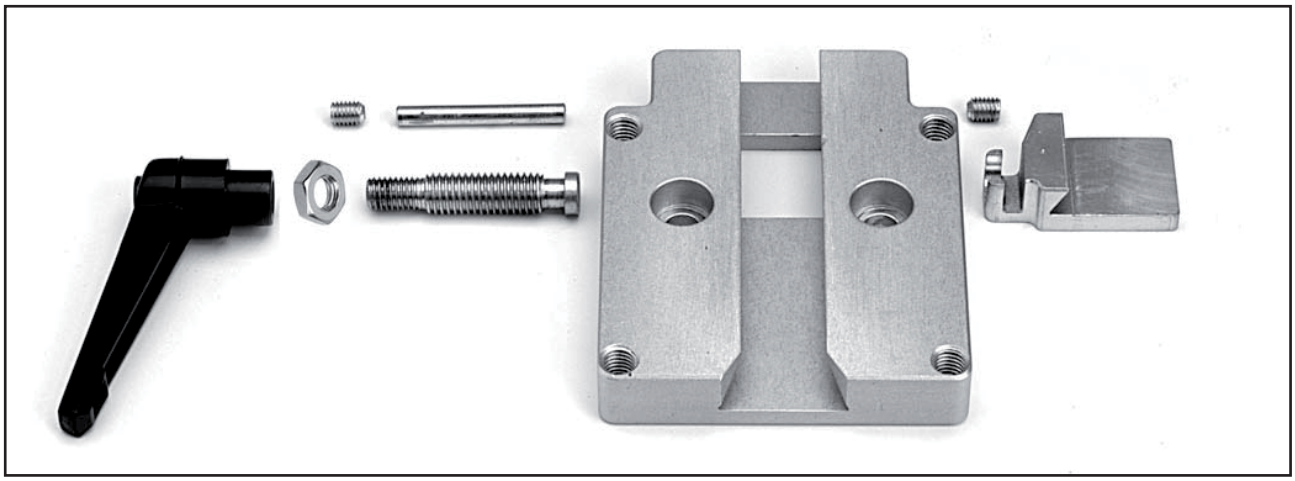


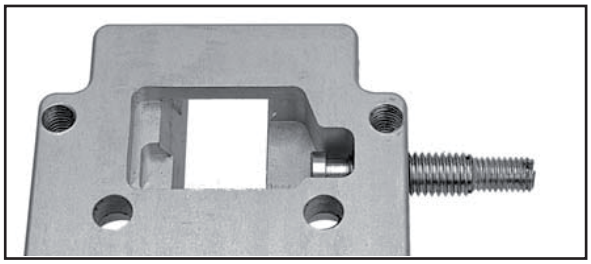
6 mm
Allen key

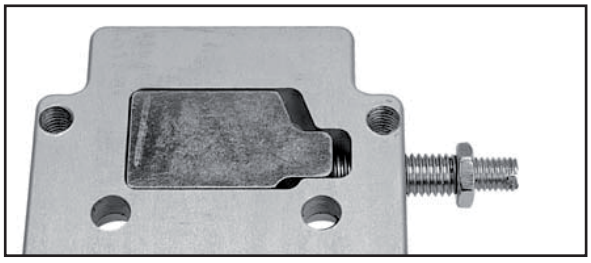
Loosen the four screws to the tool bracket
The screws are accessible from the rear. Use a long 6 mm Allen key and loosen the four screws.

Do not remove the screws
Unscrew the screws alternately and pull out the tool bracket on the opposite side so that the screws are retained in the carriage.

Be aware of the upper screws!
If the upper screws accidentally fall into the carriage, you need to remove the top cover and the upper rollers to access the fallen screws.







Fit the components

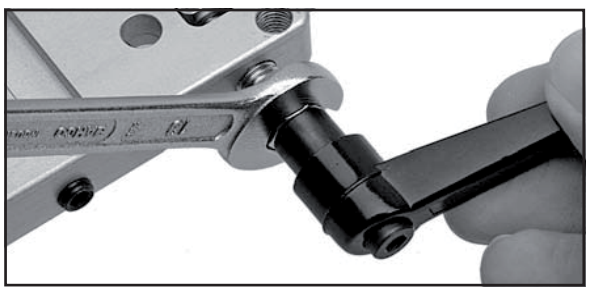
Fit the screw
Fit the screw from inside the bracket and screw out to the
side.

Fit the locking plate
Align the locking plate to the screw and tighten it with a
screwdriver to keep the locking plate in place.

Fit the check nut
Screw the nut farthest in on the screw by hand.

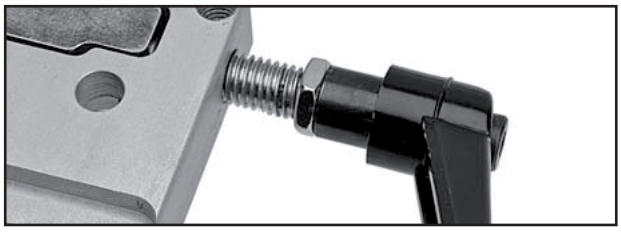
Loctite 638
It is important that the arm is locked to the screw with thread lock that is designed for firm and permanent locking. Loctite 243 is not strong enough for example.

Apply Loctite 638 to the screw where the arm and the nut are to be locked. Make sure that Loctite 638 does not reach the tool bracket!

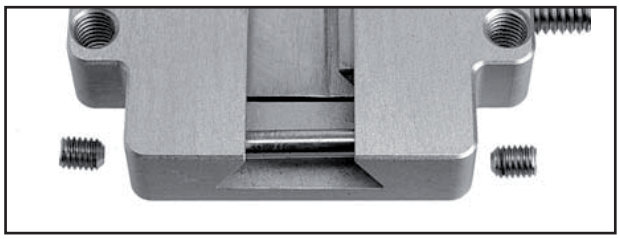


Fit the arm
Screw in the arm as far as it will go on to the screw.

Screw the check nut on the arm and tighten firmly.

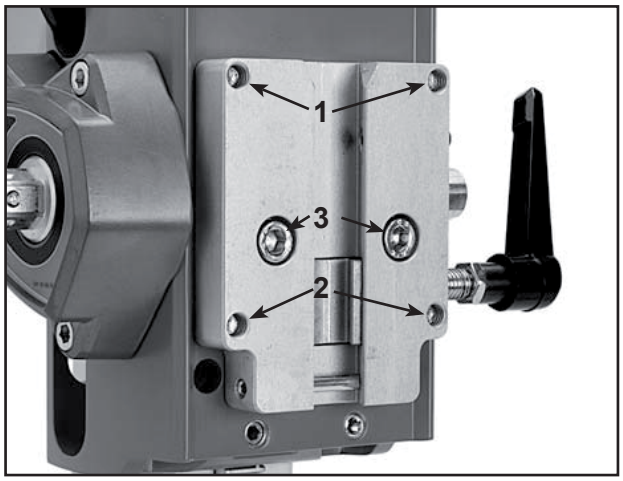


Allow to cure
Loctite 638 reaches full cure in about two hours. Do not touch the arm during this time.



Fit the stop pin
Fit the pin and attach the set screws, Allen key 3 mm, on each side symmetrically. Apply Loctite 243 to the screws.

Fit the tool bracket
Slide out the four screws and apply Loctite 243 to the threads.

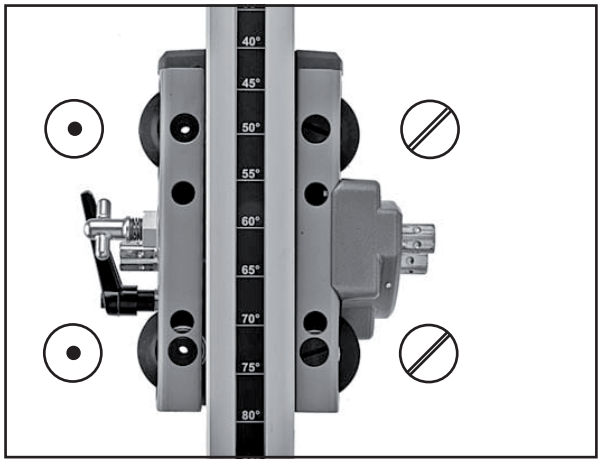


Hold the tool bracket a little out of the carriage so as not to push in the screws. Start by tightening the upper screws a few turns in the tool bracket, then the lower screws.

Now fit the two screws in the middle of the tool bracket. These must also be locked using Loctite 243.

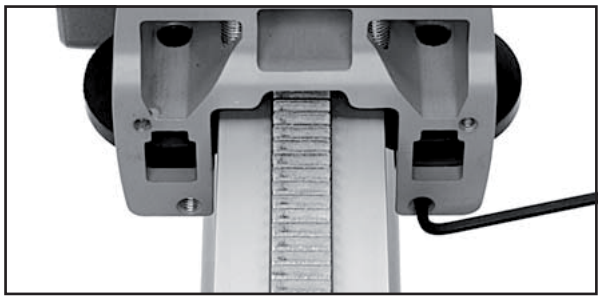
Tighten the screws alternately and finish by tightening them firmly.

Problem – lower left screw
If the screw starts to tighten at an angle, this is because the screw marked with a white arrow in the picture has encountered the left screw to the tool bracket. The solution is to unscrew the marked screw a few turns.



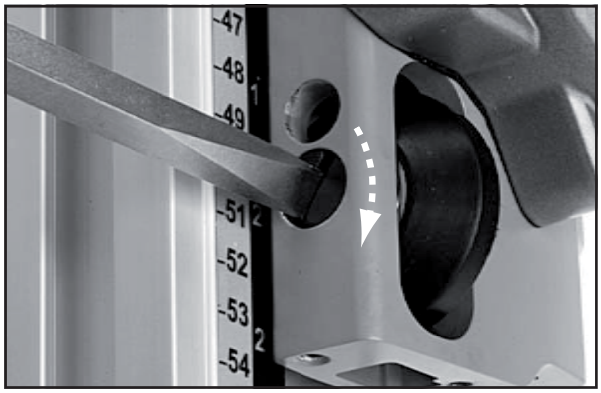
Fit the rollers
Note that the same type of roller is to be fitted on the same side of the drilling column.

Slide the rollers in place and fit each shaft.

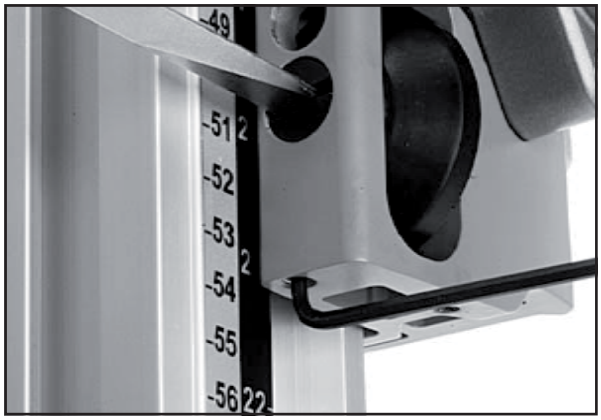


Fit the locking screws
Unscrew the locking screws completely and apply Loctite 243 on these.

Tighten the locking screw on the fixed roller firmly. The adjuster screw, with screwdriver groove, must be tightened slightly to keep the shaft in place while allowing movement for the next step, the adjustment of the roller application to the drilling column.



Adjust the roller's application to the drilling column
Use a screwdriver and turn this clockwise to apply the roller to the drilling column. Application is to be made at a level where the roller can be made to slide against the drilling column by hand.



Tighten the set screw
Tighten the locking screw to the adjuster roller firmly.

Fit the cover
Replace the cover at the bottom of the carriage. Apply Loctite 243 to both screws.