

**Tube Sheet Facing Kit
FXB630**
Technical documentation

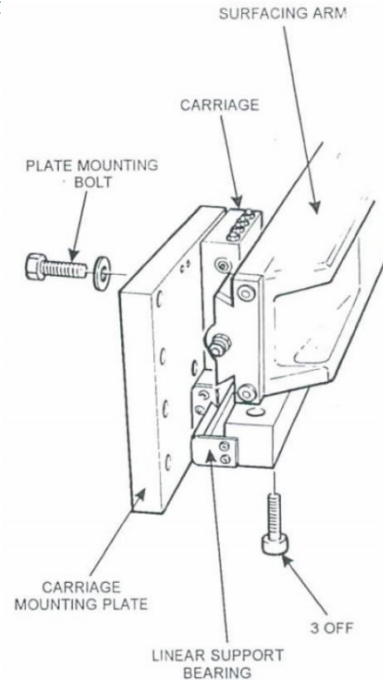


Instructions Machining the Flange Front Face

Note: These instructions presume a level of engineering experience and competence to operate this type of machinery. These instructions presume that the tube sheet mounting plate and the 630 machine have been mounted onto the tube sheet correctly as detailed in the 'Tube Sheet Mounting Kit' instructions.

Warning: Before continuing, inspect and check that all mountings are tight and the machine is secure on the tube sheet face

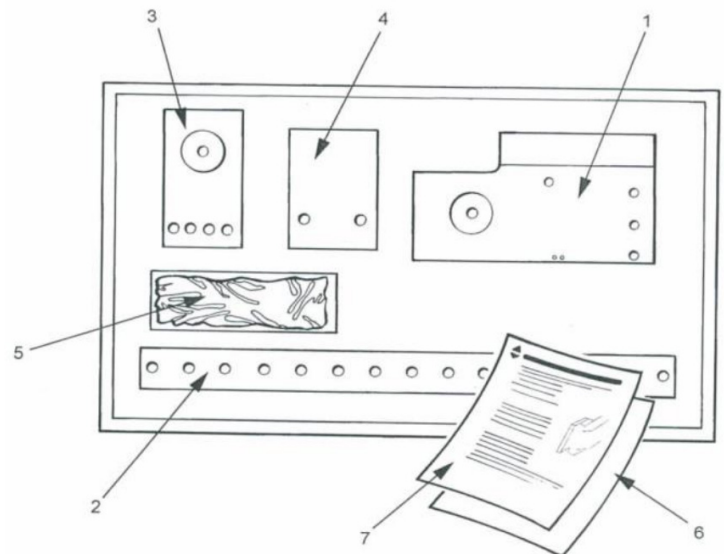
1. Slacken the two securing nuts on the surfacing arm clamping shoe and remove the surfacing arm.
2. Remove the centre caphead screw and lift off the too post. Lift off the aluminium spacer block – a soft drift may be necessary to free the two locating dowels from the carriage. Locate the carriage mounting plate onto the surfacing arm carriage and loosely fit the M12 hexagon headed bolt to lightly secure in position. Position the linear support bearing such that the linear bearing protrudes one screw hole past the end of the surfacing arm and the remaining three screw holes align with the three holes in the underside of the surfacing arm. Fit three M10 screws and lightly secure to align the plate and bearing assembly. Finally, tighten the mounting plate bolt and the three bearing support bolts to secure in position.



3. Locate the toolpost (without the aluminium spacer block) on the raised boss on the carriage mounting plate and secure in position with the centre caphead screw. Using a 5mm AF Allen Key in the end of the lead screw,

Packing List

1. Carriage mounting plate and linear bearing.
2. Rear face toolpost arm
3. Rear face toolpost mounting plate
4. Balance weight
5. Pack of screws/washers:
 - M12 x 100 caphead screws & washers (6 off)
 - M12 x 35 caphead screw (1 off)
 - M12 x 55 screws (2 off)
 - M12 x 120 screws (2 off)
 - M10 x 55 caphead screws & washers (3 off)
 - M12 plain washers (6 off)
6. Arm modification drawing
7. Instruction sheet



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