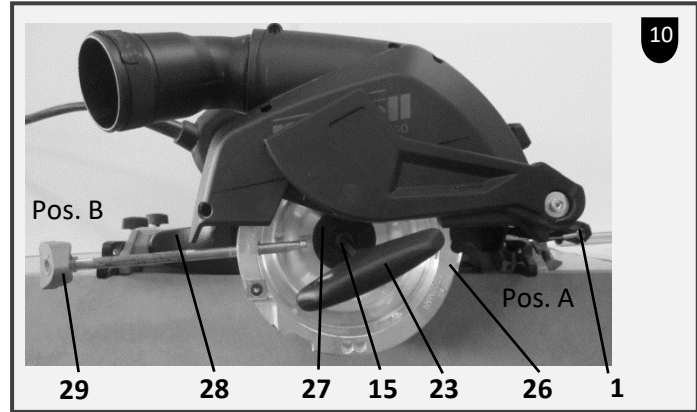
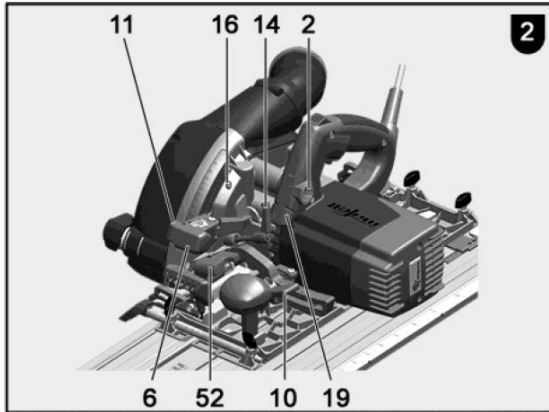


The procedure described below is part of the NFU50 operating manual and replaces section 4.3.

### 4.3 Tool change



#### Danger

The maximum permissible speed (indicated on the tool) must not be exceeded!

The operating speed must not be greater than the maximum speed indicated on the tool.

Ensure the correct direction of rotation!  
Clamp the tool in such a way that it cannot be released during operation. The tightening torque must be at least 20 Nm.

The cutting edges must not come into contact with each other or with the clamping elements.

Ensure cleanliness when changing tools. The clamping surfaces must be free of dirt.

Check the tool clamping at regular intervals.

#### Checking the tool clamping

- Disconnect the power plug before checking the tool voltage or changing the tool.
- Set the machine down as shown in Figure 10.
- Press pusher 2 (Fig. 2) and pull the locking lever 19 upwards.
- Open the movable protective cover 28 with the aid of the lever 1.
- Lock the tool with the position indicator 29. Put the position indicator 29 in the pos. B.
- To check the tool clamping: Tighten the cap screw 15 firmly (at least 20 Nm).

#### Tool change

- For tool change: Lock the tool with the position indicator 29. Position the position indicator 29 at pos. A.
- Using the hexagon screwdriver 23, unscrew the cap screw 15 counterclockwise, remove the flange 27 and the milling head 26.
- Clean the tool spindle and the clamping surfaces from adhering chips and dust. Put the tool on. Make sure that the two driving pins on the spindle engage in the two holes in the tool. If there is dirt between the components or if the components are not mounted correctly, there is still a risk that the milling head 26 may come loose during machining despite this procedure.
- Lock the tool with the position indicator 29. Position the position indicator 29 at pos. B.
- Insert the cap screw 15 and the flange 27 and tighten them clockwise with the hexagon screwdriver 23 (at least 20 Nm).
- Caution: After checking and changing the tool, remove the position indicator 29 and the hexagon screwdriver 23 from the tool.
- Close the movable protective hood 28 and press the locking lever 19 (Fig. 2) downwards.