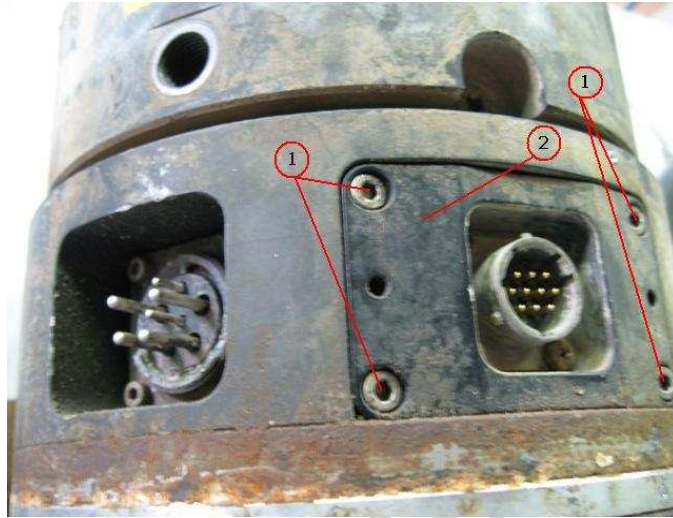
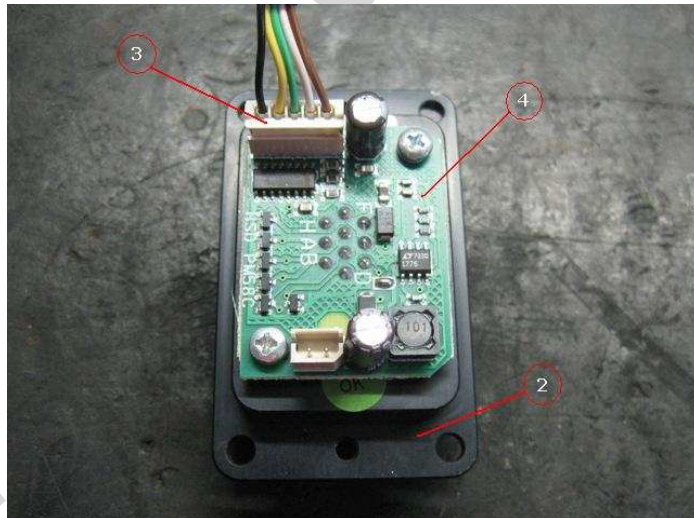


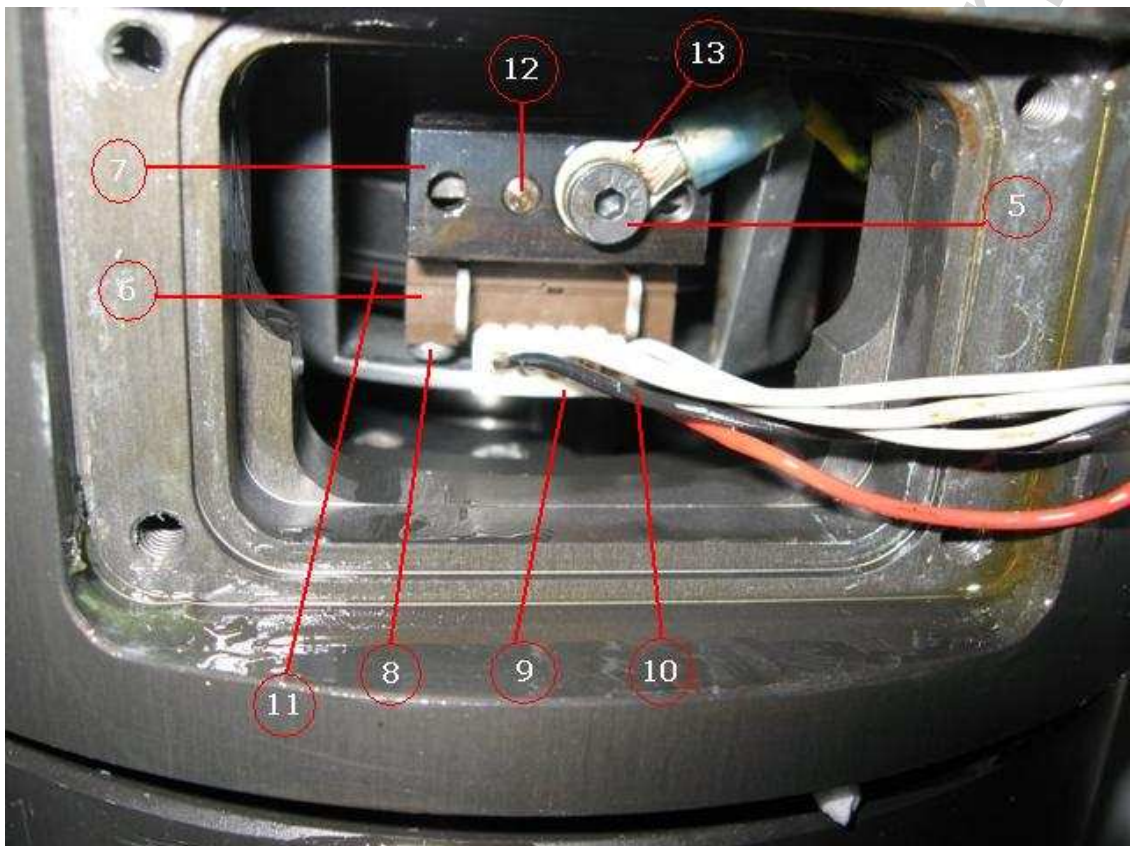
Procedure to replace the encoder on elm HSD ES710E-ES721 ISO40



- a) Disconnect the encoder plug cable of the machine from encoder circuit board (2).
- b) Remove four screws (1) of the black encoder circuit board support (2).



- c) Remove the support of the encoder circuit board (2) disconnecting the white plug (3) from the encoder circuit board (4).



- d) Remove the screw (5) where is located the earth wire (13).
- e) Remove the encoder reader (6) with the reader support (7).
- f) Remove the encoder reader (6) from the support (7) removing two small screws (8). Pay attention: do not loose the spacers (if they are present) behind the small screws (8).
- g) Disconnect the white plug with cable (9) from the encoder reader (6).
- h) Assemble the new encoder reader (6) on the black support (7) with spacers (if they are present) and in the same position of the old one by two small screws (8).
- i) Connect the new white plug with cable (9) on the encoder reader (6), pay attention: the black wire (10) must be connected where there is located that mark "Δ" on the encoder reader (6).
- j) Install the new reader (6) with new cable and plugs (9) and with support (7) inside the window, the correct location is given by the pin (12), pay attention to the optical disk (11) when you insert it. The encoder optical disk (11) must be in the centre of the encoder reader.
- k) Connect the earth wire (13) to the encoder reader support (7) by the screw (5) and lock it.
- l) Connect the white plug with cable (3) to the encoder circuit board plug (4), there is only one connection position.
- m) Assemble the new black encoder circuit board support (2) equipped with the encoder circuit board (4) on the electric spindle by four screws (1).
- n) Connect the encoder cable of the machine to the encoder circuit board support (2).