leitech

Leitech Digi Speed

Replacement of thread insert.

1. Screw of the wear bushing.
2. Push the measuring sleeve into the handle.
3. Turn the gauge until the milling in the edge of the plug adj. rod point against display, and the screw can be seen through the key hole.
4. The key is entered in the key hole and thread the screw of the plug adj. rod.
5. The screw is loosened by turning the key against clock direction.
6. Take out the key and pull out the thread insert and plug adj. rod.
7. The plug adjusting rod is placed in a vice with soft jaws, the insert is beaten with a gauge in proper size.
8. The new thread insert is mounted and is pushed or knocked into the plug adjusting rod.
9. The plug adjusting rod is lead over the motor axle and pushed into position. By correct assembly the edge of the coupling should lay 4 mm under the edge of the wearbushing.
10. The key is entered in the key hole, and the screw is tightened hard.
11. Screw on the wearbushing

A calibration tool can be delivered for a fast and convenient calibration.

The procedure for using the calibration tool is the following.

1. Choose a tool with the correct pitch and gauge size
2. Turn on the display by using the on/ off bottom.
3. Move the measuring sleeve so the edge of the gauge plug is flush with the edge of the wear bush.
4. Mount the measuring tool on the wear bush, and press the measuring tool against the gauge plug.
5. Zero the display by pressing the on/off button shortly.
6. Now the handle is calibrated for the actual pitch, and will show the distance from the middle of the deepest full thread profile to the edge of the wear bushing.
7. The display will hold its setting until the “SET” button is pressed.
8. It can be an advantage to lock the calibration of the thread gauge by pressing the “REF” button until “REF 1” is displayed