RÖHM Standard 1485/1

Maintenance Manual

Clamping devices with central lubrication

Contents **page**

Date of issue**:** **20.05.2015**

General:

Clamping devices equipped with central lubrication connection are recommended to be operated as follows:

with 1 impulse per 20 clamping cycles for rotating chucks resp. 1 impulse per 50 clamping cycles for stationary devices,

+ with an impulse duration of at least 3 sec.,
+ with an impulse pressure between 10 and 45 bar (12 and 30 bar)*,
+ with an impulse interruption of at least 5 sec.,
+ with an impulse pause pressure of max. 3 bar (0,8 bar*) at the dosage valve intakes and
+ with a lubricant with ISO designation G CLP DIN 51517-3 of viscosity class VG 68 DIN ISO 3448:2010-02, max. permissible temperature approx. 70° C. (Alternatively, a lubricant of viscosity class VG 220 or low-viscosity grease NGL of classes 00 and 000 can be used. At high speeds, the lubricant VG 68 should be used).

These specifications apply to VOGEL metering units. (The values marked with * refer to MECA–FLUID metering units.)

Note:	Optimum lubrication can only be achieved if the lubricating impulse begins in the open phase of the clamping device.

Lubrication ratio:

Depending on the individual circumstances and wear the lubrication ratio (clamping cycles per lubrication pulse) must be adjusted/reduced in a way to ensure, all moving parts will get a sufficient amount of lubricant. This also applies if more lubricant will be consumed as stated earlier.

On the other hand the lubrication ratio may be extended if obviously too much of the lubricant leaves the clamping device unused.

Further maintenance, general inspection

The clamping device should be removed from the machine and subject to a general cleaning at intervals of a longer duration (these can only be determined under practical circumstances), but at the latest when running is noticeably sluggish, imprecise and/or there is a reduction in clamping force.

The clamping device should be dismantled into its individual parts for this purpose, checked for wear, cleaned and reassembled after repairing defective components. It is particularly recommended that sealing elements subject to dynamic stress to be replaced during this operation. A set of wear parts and sealing elements - marked in the piece list - should therefore be available at all times for such cases.

Ensure with the greatest of care that marked components are reinserted in the positions intended for them when reassembling the clamping device.

Rebalancing of the previously dismantled chucks running lower than 3000 rpm is usually unnecessary if this is observed. However, attention should be paid to the running smoothness of the clamping device during a test run after the general inspection. The clamping device can be re-balanced at the manufacturer's facility or with a mobile balancing unit by a **RÖHM** service technician at the customer's premises if chuck balance should prove unsatisfactory (an additional charge is involved here).

KOB Sontheim, Issued 12.08.2019