RN 1485/5

driven by technology

Translation of the original maintenance manual

Chuck with manual lubrication and F80 grease

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Servicing

The service condition of the clamping device is decisive when it comes to its functionality, clamping force, precision and service life expectancy.

Every 8 operating hours / after 1000 clamping cycles:

Apply approx. 0.5 cm^3 of grease to each of grease nipples (see assembly drawing).

After every greasing, carry out 3-4 empty strokes so that the grease can distribute itself.

Note: Optimum lubrication can only be achieved if the grease lubrication is done in the open phase of the clamping device.
Afterwards, it is recommended to carry out several empty clamping cycles in order to distribute the lubricant.

Grease type:

To do this, a lithium-soapy, viscous grease must be used.
We recommend our **F80*** grease.

Note: **Lubrication should be adjusted with respect to the lubricant consumption.**

These specifications are only approximate guide values. The actually required lubrication intervals are also influenced by the occurring operating temperature of the chuck, the operating speed, the coolant pressure and flow, the clamping frequency, and last but not least, by the cut material as well as the way it is cut.
In order to be able to get an idea about the maintenance status, it is recommended to examine components which are subject to wear after about the first 8 weeks of operation. The lubrication and maintenance intervals / lubrication amounts should be adjusted based on the impression gotten from this.

Check the clamping forces 1x per week in the beginning (directly before the next lubrication procedure).

Blowing out:

Neither blow into jaws guidings nor vulcanization- or guide gaps.

* Recommended F80 grease:		
100 g tube	Id.-Nr.	630866
500 g cartridge	Id.-Nr.	308555
1000 g tin	Id.-Nr.	028975

Maintenance

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 noticeable sluggish 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 be replaced during this operation. A set of wear parts and sealing elements (marked in the piece list with an "X" in column "PTyp") 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 clamping device 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).

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