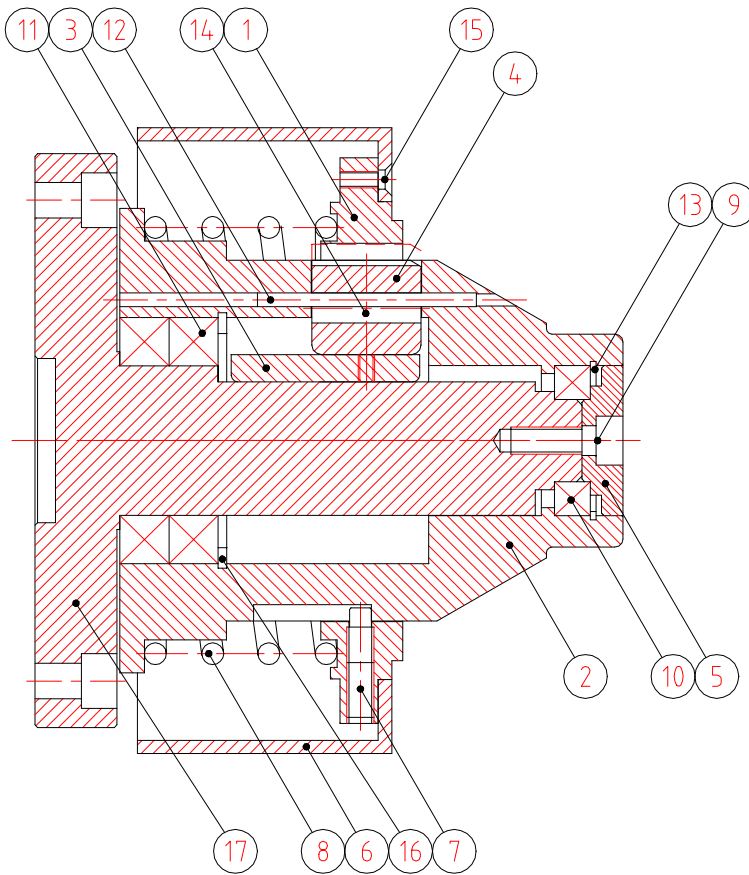


Construction

3659-3 Chuck Ø134,5



Pos.	Name	pc
1	Sensor inner flange	1
2	Outer body	1
3	Bed plate	3
4	Sector plate	3
5	Cover	1
6	Sensor ring	1
7	Stop screw	3
8	Spring	1
9	Hex socket screw	1
10	Bearing	1
11	Bearing	2
12	Cotter	6
13	Lock ring	1
14	Hex socket screw	6
15	Hex socket screw	6
16	Lock ring	1
17	Lifting body	1
18		
19		
20		

Fig. 1

Safety instructions:

Do not place your feet under the chuck when mounting or removing chucks.

When assembling the roll to the roll bracket, ensure that the chucks are intact and the roll will fit between the chucks.

Ensure that the chucks are inside the core.

However, do not press the chucks against the core using too much force.

Do not place your hands between the chuck and core when pushing the core or roll in place.

Do not place your hands between the chuck and sensor ring when pushing the core or roll in place.

General safety regulations of the plant must always be observed.

Principal and operational description Chuck Ø134

Before starting the reel-up operation, the chuck is pushed horizontally into the openings of the core ends.

Pushing/clamping force must not be so high that it would cause damage to the core ends.

By the action of rotational moment, the chuck clamps to the core end.

The clamping force depends on the tightness of the web and ends as the tension ceases.

After the unwinding is completed and the core is empty, the reeling arms are opened for core removal and for taking a new paper roll.

The sensor ring (pos. 1 and 6) indicates when the paper roll/core is in the reeling station.

The chuck is composed of parts described in Fig. 1. In this construction a guided pin and key assembly, by the action of rotational moment and web tension, pushes the sector plates (pos. 4) outwards against the wall the core opening, clamping the chuck to the core.

To ensure good operational reliability, the chucks must be cleaned regularly during use.

The chuck is made of tempered high quality alloy steel and protected by chemical nickel plating and black finishing.

Mounting and Putting into Use

The chuck is delivered from the manufacturer completely assembled and protected against corrosion.

Before using the chuck the first time, the protective agents should be removed by wiping the surfaces with a clean cloth or tissue. If necessary, some solvent can be used.

The chuck is pre-lubricated by the manufacturer for the first use.

Lifting body (pos. 17) is installed to the mounting flange fitted to the reeling station shaft.

The chuck is placed on the lifting body.

Put the cover (pos. 5) in place and tighten the screw (pos. 9).

Push the sensor ring (pos. 1 and 6) manually backwards in order to expose the outer body (pos. 2) and sector plates (pos. 4).

The outer ring and sector plates must turn without resistance when they are rotated back and forth by hand.

The chuck is now ready for use.

Maintenance

Open the setscrew (pos. 9).

Pull the chuck away from the lifting body.

Bring the chuck to the maintenance location.

Open the sensor ring screws (pos. 15) and remove the sensor ring (pos. 6).

Push the sensor inner flange in such a way that the spring (pos. 8) is compressed slightly.

Open the stop screws (pos. 7).

Release the inner flange with special care.

NOTE! Dismantling the chuck without loading the thrust ring may cause danger to the serviceman and persons near the service location.

Open the sector plate screws (pos. 14) and remove the bed plates.
Tap the cotters (pos. 12) out and remove the sector plates (pos. 4).

Remove the lock rings and bearings.

Clean and inspect the components.
Worn-out components must be renewed.

Inspect the lifting and bearing surfaces of the sector plates (item 4) and the lifting body (item 17).

If other parts are worn more than 0.2 mm, such parts may have to be changed. If any cracks are found in the parts, such parts must absolutely be changed.

The following points must be lubricated before assembly

- Gap between the lifting body (pos. 17) and bed plate (pos. 3), grease lubrication
- Gap between the outer body (pos. 2) and sector plate (pos. 4), dry lubrication

The dry lubricant must be dry grease containing graphite or MoS₂.

For grease lubrication, high-quality grease containing graphite or MoS₂ should be used.

The lubricants must have

- good corrosion protection, adhesion and lubrication characteristics, as well as good thermal stability.
- high pressure and shock resistance

The assembly is done primarily in reverse order.

Ensure that the parts are moving smoothly after the maintenance.

Tightening torques

Torque Nm			
Screw	Material		
Size	8.8	10.9	12.9
M5	5	8	9
M6	9	13	15
M8	22	32	38
M10	45	67	78

M12	80	115	134
M16	190	278	326
M20	380	537	629

Malfunctions

The chuck cannot be inserted into the core

- Check that the chuck fits the core. The diameter of the outer body (pos. 3) must be at least 0.3 mm smaller than the inner diameter of the core opening.
- Remove possible damaged material from the edges of the core end.
- Check the operation of the chuck. If the sector plates (item 4) do not move loosely and are not flush with the outer surface of the outer body, tap on the chuck with a soft hammer and blow it clean. Repeat this procedure, if necessary.

The chuck slips inside the core

- The core end is damaged. Change the core.
- The core is soft and gives in (one of the sector plates (pos. 4) is pressed into the core wall).
- Check the tightness of the web.
- Check that the chuck fits the core.
- The chuck is dirty or worn. Check the operation of the chuck and as necessary, carry out maintenance operations according to instructions.
- Poor grip. Replace the sector plates (item 4) with grooved plates.

The chuck does not come off the core

- Tap the core lightly in order to remove pulp from the grooves.
- Sector plates (pos. 4) has been pressed into the core wall (the core is soft). Check the condition of the cores and the tightness of the web before use.
- The chuck is dirty or worn. Carry out maintenance operations according to instructions.

Abnormal noise from the chuck

- Inspect the chuck and carry out maintenance.

If you are unable to remedy a malfunction, please call **Oy Klim-ko Ltd's** service.

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