

Pos.	Item	pc
1	Spacer flange	1
2	Back plate	1
3	Cylinder liner	1
4	Piston	1
5	Body	1
6	Lifting cone	1
7	Jaw piece	6
8	Sensor plate 300	1
9	Sensor plate 300	1
10	Sensor plate 200	1
11	Sensor plate 151	1
12	Stopper pin	6
13	Spring pin	6
14	Gasket	2
15	Gasket	1
16	O-ring	2
17	O-ring	3
18	Cylindrical pin	2
19	Cylindrical pin	6
20	Spring	6
21	Allen screw	8
22	Washer	8
23	Allen screw	4
24	Washer	4
25	Allen screw	6
26	Washer	6
27	Allen screw	6
28	Washer	6
29	Allen screw	2
30	Washer	2
31	Allen screw	16
32	Washer	16
33	Allen screw	12
34	Washer	12
35	Retaining screw	2
36	Runner	3

Parts list

Safety instructions:

- Do not place your feet under the chuck when mounting or removing chucks.*
- When assembling the reel to the reel bracket, ensure that the chucks are intact and the reel will fit between the chucks.*
- Check that the chucks are inside the core.*
- Do not place your hands between the chuck and core when pushing the core or reel in place.*
- Do not place your feet under the chuck when mounting or removing the reel.*
- General safety regulations of the plant must always be observed.*

Functional Description

When starting the reel-up operation, the chuck is pushed horizontally into the openings of the core ends. Pressurised air pushes the lifting cone forward, and the jaw pieces clamp to the core end.

The clamping force depends on the air pressure.

When the reel-up has been completed, the chucks are pulled out of the core.

To ensure good operational reliability the chucks must be kept in good condition by regular inspections and maintenance.

Product Description

Double-acting PKILL 151/200/300 chucks are pneumatically expanding chucks. When the core or the reel is changed, pressurised air pushes the lifting cone to the rear position, when the jaw pieces are pushed in and the core is released.

The PKILL chuck is composed of parts described in the figures. In this construction pressurised air causes the lifting cone (item 6) to push the jaw pieces (item 7) outwards against the wall the core opening, clamping the chuck to the core.

When the pressurised air is connected to the other air channel, the lifting cone returns to the rear position, and the jaw pieces (item 7) are pushed back in.

The chuck is made of tempered high quality alloy steel and protected by coating.

Mounting and Putting into Use

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

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

The chuck is pre-lubricated for the first use.

Mounting the PKILL chuck to the reeling station

The chuck is mounted to the spacer flange (item 1) on the reeling station shaft, where the back plate (item 2) of the chuck fits.

The guide and mounting surfaces must be cleaned before mounting the chuck.

Align the air slots in the back plate (item 2) with the air holes of the spacer flange (item 1) and install the mounting screws (item 27).

Take care to not damage the sensor plate (item 8). Strong bumps will damage the mechanism.

Cleaning During Operation

In connection with each core change, the chuck should be cleaned by blowing air.

Maintenance

After approx. 3 months of use, cleaning and maintenance of the chuck should be carried out.

Remove the mounting screws of the chuck and spacer flange (item 27) and bring the chuck with its parts to the maintenance location.

Unscrew the sensor plate screws marked "A" (item 33) and remove the sensor plate.

Unscrew the rear plate (item 2) screws (item 25) and remove the rear plate and the O-ring.

Unscrew the piston (item 4) screws (item 23) and remove the piston.

Unscrew the cylinder tube (item 3) screws (item 29) and remove the cylinder tube.

Push the lifting cone (item 6) forward and remove the jaw pieces (item 7).

Remove the gasket.

Wash the parts and clean the air holes.

Check

- Gaskets (items 14,15,16 and 17) and sealing surfaces
- Mating surfaces between the lifting cone and the jaw pieces
- Mating surfaces between the body and the jaw piece

If other parts are worn more than 0.2mm, such parts may have to be changed.

If any cracks are found in the parts, such parts must absolutely be changed.

The assembly is done primarily in reverse order.

Lubricate the following items

- Gasket (item 14) and the cylinder surface, grease
- Gasket (item 15) and the surface of the body and the lifting cone, grease
- Mating surfaces between the lifting cone and the jaw piece, dry lubricant / anti-friction wax
- Mating surfaces between the body and the jaw piece, dry lubricant / anti-friction wax

It is recommended to use synthetic lubricants (grease) with the following properties:

- high corrosion resistance, adherence and lubricating capacity
- heat resistance exceeding 230°C
- high pressure and shock resistance

After service, check that the parts are moving without resistance.

Malfunction

The chuck cannot be inserted into the core

- Remove possible damaged material from the edges of the core end.
- Check the operation of the chuck. If the jaw pieces (item 7) do not move loosely, 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 (the jaw piece (item 7) 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.
- For soft, worn or slippery cores, so-called extended chucks are available.

The chuck will not detach from the core

- The jaw piece (item 7) has been pressed into the core wall (the core is soft). Check the condition of the cores before using them.
- The chuck is dirty or worn. Carry out maintenance operations according to instructions.

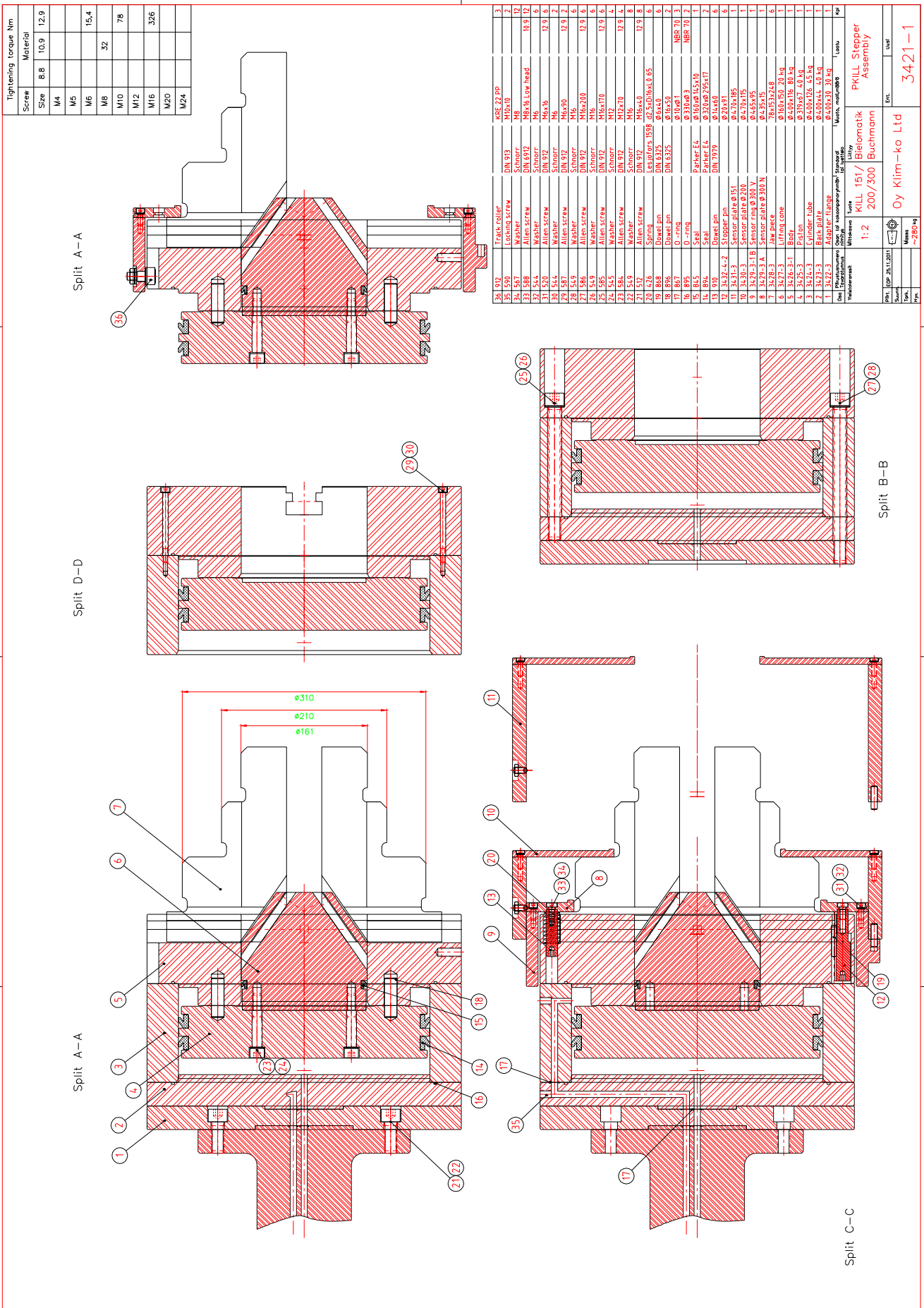
Abnormal noise from the chuck

- Inspect the chuck and carry out maintenance operations according to instructions.

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

Contact information:

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KILL Stepper Assembly

1:2 Biomatik 200/300

Oy Klim-ko Ltd

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~280 kg

Exp 25.11.2011

Metsä, moulton69

KILL 151 / Biomatik 200/300

Yksikkö

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