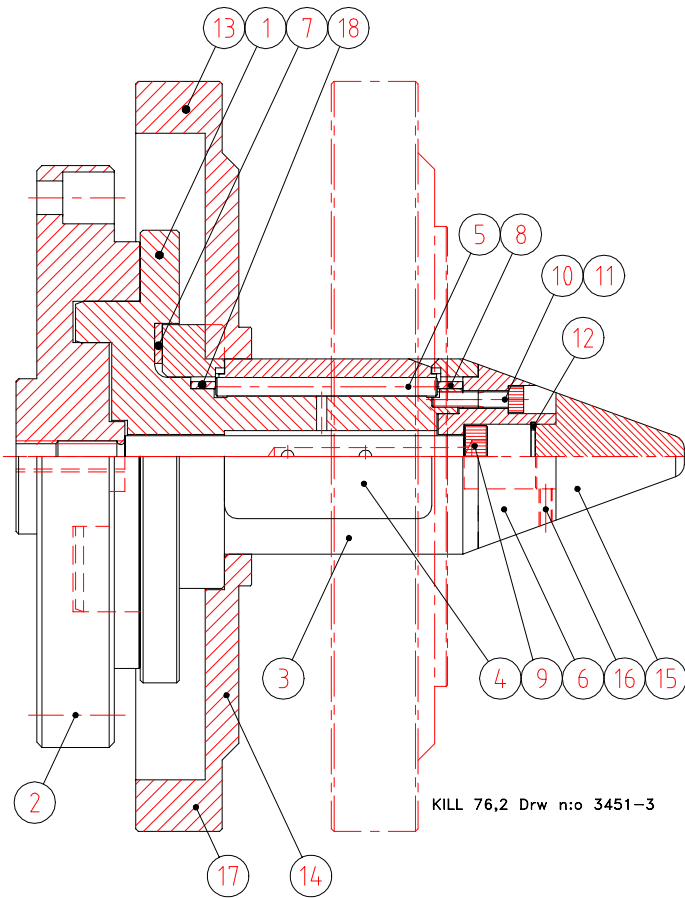


Construction



Pos.	Name	pc
1	Lifting body	1
2	Backplate	1
3	Outer body	1
4	Sector plate	3
5	Pin	6
6	Cover	1
7	Thrust bearing	1
8	Guide bushing	1
9	Central screw	1
10	Hex socket screw	3
11	Washer	3
12	Lock ring	1
13	Thrust ring	1
14	Thrust ring frontplate	1
15	Additional cover	1
16	Set screw	2
17	Hex socket screw	6
18	Cotter	1
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.

Check 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.

Functional Description

Before starting the reel-up operation, the chuck is pushed horizontally into the openings of 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 pull ceases. When the reel-up has been completed, the chucks are pulled out of the core.

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

Product Description

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

The KILL chuck removes the core by the thrust ring (pos. 13) when opening the reeling arms.

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

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.

Backplate (pos. 2) is installed to the mounting flange fitted to the reeling station shaft.

The chuck is lifted on the backplate guides and rotated in order to align the drive triangle parts (locks in place!).

When rotating the central screw (pos. 9), the chuck slides into its final fastening position against the backplate. The central screw (pos. 20) is tightened reasonably with an Allen key. *Put the additional cover (pos. 15) in place and tighten the screws (pos. 16). No 6 ".*

Push the thrust ring (pos. 13) manually backwards in order to expose the outer body (pos. 3) 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 reeling head is now ready for use.

Maintenance

Open the setscrew (pos. 16) and remove the additional cover (pos. 15). No 6".

Open the central screw (pos. 9) and remove the chuck.

Bring the chuck to the maintenance location.

Remove the lock ring (pos. 12) and the central screw (pos. 9)

Open the thrust ring screws (pos. 17).

Detach and remove the thrust ring (pos. 13) and the frontplate (pos. 14).

Unscrew the cover screws (pos. 10) and remove the cover (pos. 6).

Pull the outer body (pos. 3) out of the lifting body (pos. 1).

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

Inspect the lifting and bearing surfaces of the sector plates (pos. 4) and the lifting body (pos. 1). Check the condition of the pins (pos. 5). Inspect the bearing and guide surfaces of the guide bushing (pos. 8) and the outer body (pos. 3). The minimum thickness of the thrust bearing (pos. 7) is 2.5 mm.

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

- Thrust bearing (pos. 7) and its counter surfaces
- Guide bushing (pos. 8) sliding surfaces
- Pin (pos. 5) rolling surfaces
- Sector plate (pos. 4) rolling surfaces
- Lifting body (pos. 1) rolling surfaces
- Outer body (pos. 3) sliding surfaces

The lubricant must be dry grease containing graphite or MoS₂. The lubricant 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 sector plates (pos. 4) are aligned with the openings in the guide bushing (pos. 8).

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 (pos. 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 (pos. 4) with grooved plates.

The chuck does not come off the core

- Tap the core lightly in order to remove chuck material from the grooves and the thrust ring (pos. 13) pushes the core out of the chuck.
- 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 operations according to instructions.

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

Contact information:

Oy Klim-ko Ltd, Lohja, Tel. +358 19 315 575 Fax. 019 315 577