

Fig. 1

Parts list

Pos.	Item	pcs
1	Back plate	1
2	Outer body	1
3	Lifting cone	1
4	Lifting block	3
5	Sector block	3
6	Cover	1
7	Block spring	3
8	Spacer flange	1
9	Slide bearing	1
10	Slide bearing	1
11	Gasket	1
12	Gasket	1
13	O-ring	1
14	O-ring	3
15	Allen screw	8
16	Washer	8
17	Allen screw	6
18	Washer	6
19	Allen screw	4
20	Washer	4
21	Allen screw	8
22	Washer	8
23	Allen screw	8
24	Washer	8
25	Cylindrical pin	6
26	Retaining screw	2
27	Sensor plate	1
28	Spring pin	8
29	Stopper pin	8
30	Spring	8
31	Allen screw 10.9	16
32	Washer	16
33	Cylindrical pin	8

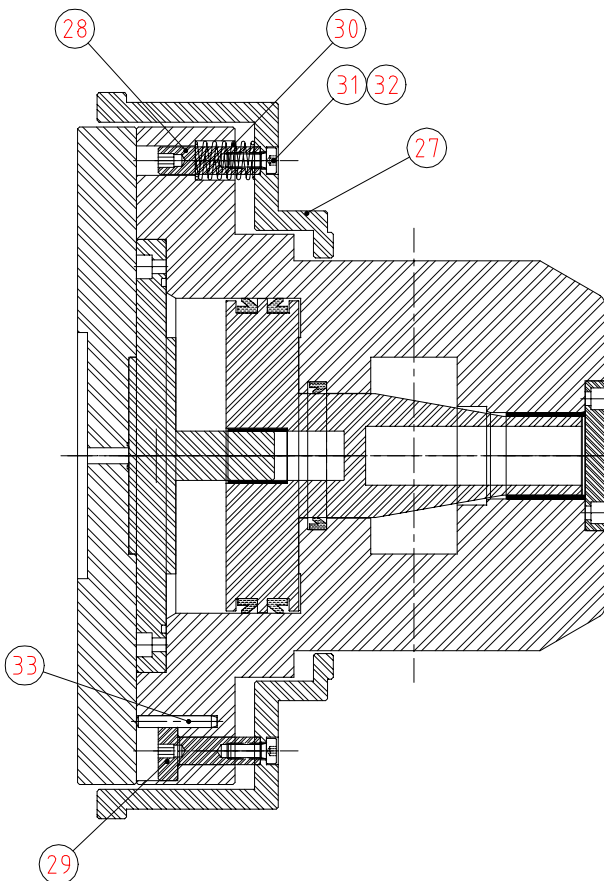


Fig. 2

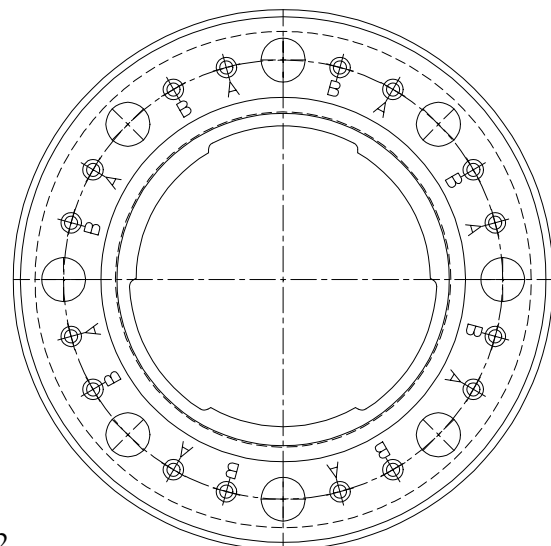


Fig. 3

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 **sector blocks** 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 200 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 sector blocks are pushed in and the core is released.

The PKILL chuck is composed of parts described in Fig. 1. In this construction pressurised air causes the lifting cone (item 3) to push the sector blocks (item 5) outwards against the wall the core opening, clamping the reeling head to the core.

When the pressurised air is connected to the other air channel, the lifting cone return to the rear position, and the sector blocks (item 5) are pushed back inside the outer body (item 2).

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. 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 8) on the reeling station shaft, where the outer body (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 1) with the air holes of the spacer flange (item 8) and attach the mounting screws in such a way that the screw ends are flush with the rear surface of the back plate.

Take care to not damage the sensor plate (item 27). 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, the following cleaning and maintenance operations shall be carried out.

Remove the mounting screws of the outer frame (item 2) and spacer flange (item 8) and bring the chuck with its parts to the maintenance location.

Unscrew the sensor plate screws marked "A" (Fig. 3) (item 31) and remove the sensor plate.

Unscrew the cover (item 6) screws (item 19) and remove the cover.

Unscrew the rear plate (item 1) screws (item 16) and remove the rear plate and the O-ring.

Push the lifting cone (item 3) out.

Loosen the sector block (item 5) screws (item 17) slightly and knock the lifting blocks (item 4) loose.

Remove the sector and lifting blocks and the springs.

Remove the gaskets.

Wash the parts and clean the air holes.

Check

The gaskets (items 11 and 12) as well as sealing surfaces

Slide bearings (items 9 and 10) and bearing surfaces

The surface between the lifting cone and the lifting block

The surface between the outer body and the lifting block

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 11) and the cylindrical surface of the outer body
- Gasket (item 12) and the surface of the lifting cone
- Slide bearings (items 9 and 10)
- The surface between the lifting cone and the lifting block
- The surface between the outer body and the lifting block

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

- Check that the chuck fits the core. The diameter of the outer body (item 3) must be at least 0.3mm 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 blocks (item 5) 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 blocks (item 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.
- For soft, worn or slippery cores, so-called extended chucks are available.

The chuck will not detach from the core

- A sector block (item 5) 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:

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

The tightening torques of the mounting screws are:

- M6 / 12.9 15.4 Nm
- M8 / 12.9 38 Nm M8 / 10.9 32 Nm
- M10 / 12.9 78 Nm
- M12 / 12.9 135 Nm
- M14 / 12.9 220 Nm
- M16 / 12.9 330 Nm