

BISON CHUCKS

Maintenance procedure

It is recommended, at least once a week, to remove the jaws from the chuck body; clean the working surfaces (guides, teeth, and threads in the case of independently set jaws) and lubricate them with grease according to Table 6. In the case of heavy operating conditions of scroll chucks it is recommended to lubricate them with machine oil type „16” through the lubricating nipple located on the chuck body face, every 8 hours.

Table 6

<i>Item</i>	<i>Grease Brand</i>	<i>Lubrication Area</i>
1	GLEITMO - 805	Jaw and body guides, jaw teeth, scroll, body hub, feed screws for the chucks with independent jaw setting.
2	Machine grease 2 ISO 6743-9	Toothing of scroll and toothed wheel.

An inspection should be performed at least every 6 months and any minor reduction of the jaw gripping force should be taken into consideration. At least once a year the chuck should be removed from the spindle and disassembled. Thoroughly clean and inspect all parts. Replace all worn out and damaged parts. Lubricate all working surfaces according to directions contained in Table 6 and reassemble the chuck.

In case of a shortage of grease (item 1, Table 6) or equivalent, it is permitted to lubricate all the working surfaces with the machine grease type 2.

⚠ NOTE: Jaws and guides in the scroll-chuck bodies are marked with sequential numbers. When assembling the chuck, jaws must be screwed into the guides marked with the same number. Example: Jaw no. 1 must be inserted in the guide no. 1.