

Product Handling & Maintenance Guide
Air Power Chuck

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Chuck No.: _____

Used On: _____

Resource Drawing No.: _____

Manufacturing Date: _____

Notes:

Air Power Chuck Operating Instructions:

1. Air Power chucks should be used on the machine for which it is designed. The chuck design is based on the data sheet and design parameter provided by you. They are Reel Weight, Core ID, Minimum Reel Width, Tension and speed. The chuck will get damaged in case of using it for unplanned parameters.
2. Air Power Chuck needs 5 to 6 Bar (70 to 80 psi) air pressure. Make sure the line pressure is above the required pressure. It is also advisable to use FRL (Filter, Regulator and Lubricator) unit near Air Shaft.
3. To Grip the Core inflate the Chuck: Press the Air Valve (NRV) by Air gun nozzle, shown in figure 1. The press the Air Gun lever to the extent that the 5 – 6 Bar Air Pressure is developed. For good gripping, apply the air pressure for 45 seconds (ask operator to count 1 – 50).

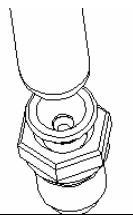


Figure 1: Air Gun Nozzle for Filling Air in the Air Valve. Keep it pressed for Air inflation.

4. To Release the Core Deflate the Shaft: Press the top head of the Air Valve. Sometimes, core does not get released even after releasing the air, in that case apply some air into the hole near air valve and keep the Air Valve pressed. This way, you will be forcing the plunger in the cylinder to go back.

Trouble Shooting for Air Power Chuck:

1. During production, if you find the reel slipping over chuck. Do the following check up:
 - A. Check the incoming line pressure. It has to be between 5 to 6 Bar. This can happen if enough Air is not filled in the shaft.
 - B. Check the Air Pressure inside the chuck. This can be done by applying Pressure gauge with nipple, similar to Vehicle tire check up. For good gripping, apply the air pressure for 45 seconds (ask operator to count 1 – 50).
 - C. After trying both A & B Solutions, if you still face the problem then check for the Non Return Valve (NRV). NRV might be leaking. For testing, fill the full air in the core holder and then put some water near air valve. The air bubbles will start coming near and around the NRV. Then, immediate replacement is needed. (Figure 2.)

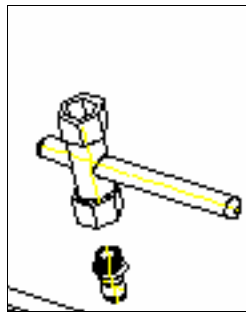


Figure 2: Checking Non Return Valve (NRV) With 12 X 13 Box Spanner

2. If leakage not found from NRV, then most probably the Rubber O - Ring must be damaged which does not allow the cylinder to operate. In that case, Air Power Chuck has to be opened to replace the U-cup seal.
3. The Air Power chuck is made of two parts front part with Metal Lugs and Back part with Pneumatic Cylinder. We advice you to first open the back side of it to check the O-ring. If the O-ring is not damaged then, something might have happened to the lug portion.

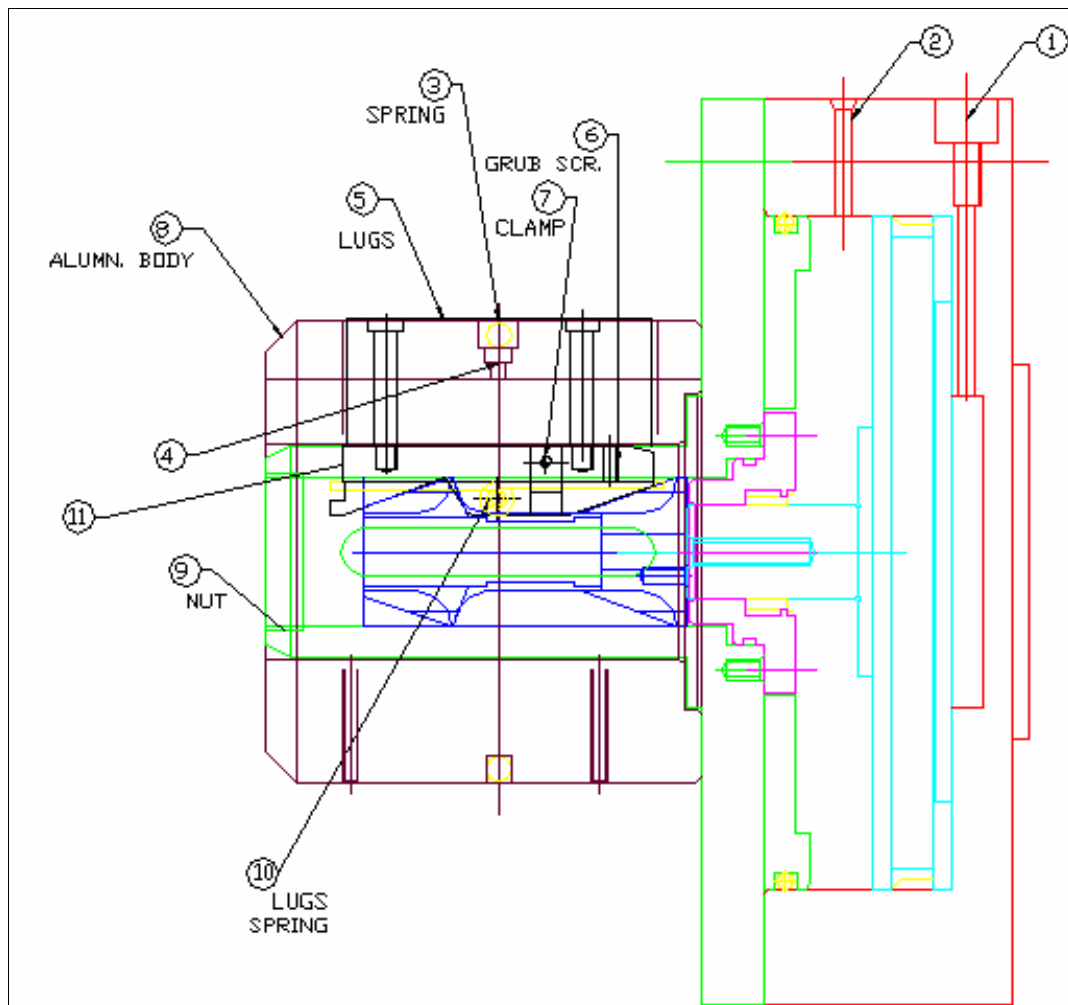
Opening of Air Power Chuck – Back Assembly O-Ring: (Open this part of Chuck only if the Air is not staying the Cylinder.)

1. For opening of the chuck, simply loosen remove the chuck from Machine.
2. Then, loosen the M12 or M16 Bolts from the top of the chuck.

3. Simply, fill up little air and the upper body will come up. Just pull it out and see the condition of U-cup seal and Hard Chrome plating on the side. If everything is fine, then just put thing to gather.
4. If at all u-cup seal is damaged then just order it.

**Opening of Air Power Chuck – Front Assembly Lugs:
(Open this part of Chuck only if the Lugs are not expanding.)**

1. If you have Adaptor for 6" chuck, then remove or release that from the chuck. This could done by loosening grub screws on top of the adaptor. (Shown in Figure 3).



a. Figure 3: X-section of the Air Power Chuck

2. Tighten Grub screw No.6. on all the lugs. By tightening of each screw, lug will come out and the Screw No. 7 will be visible.
3. Then, remove the small screw No. 7 with help of 2.5 mm Allen key.

4. Finally, Leave the L shaped strip in the pocket and pull out the lug care-fully. However, do not let L shaped strip to fall into Body.
5. Do the same for all the lugs.
6. Then, Remove the cap from the top, to see the condition of Piston.
7. If at all the components are damaged, then do inform the factory for the feed back. We shall help you out with the same.

Accessories Needed of Air Shaft Repairing :

| Components | Size | Quantity Needed |
|--------------------|----------------------|-----------------|
| Air Valve (NRV) | 1/8" or 3/8" BSP | 1 |
| Box Spanner | 12x13 mm or 18x19 mm | 1 |
| O Ring – Air Valve | Based on NRV Size | 2 |
| Allen Key | 2.5 mm | 1 |
| | 4 mm | 1 |
| | 5 mm | 1 |
| | 6 mm | 1 |
| Fix Spanner | 30 x 32 mm | 1 |
| Air Gun | | 1 |

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