

Extra page

SAD segmented clamping bushing
for MANDO T211/G211

EN

1 General

1.1 Information about this extra page

This extra page enables you to work safely and efficiently with the product.

This extra page is part of the product and must be kept in a location directly beside the product that is accessible to the personnel at all times. The personnel must have read this extra page carefully and understood its contents before starting any work. The basic requirement for safe work is compliance with all stipulated safety notices and work-related instructions on this extra page.

If the product is passed onto a third party, this extra page must accompany it.

Illustrations on this extra page are there to facilitate a basic understanding, and may differ from the actual design configuration of the product.



WARNING

Serious injuries caused by individual products or by inappropriate combinations of them!

- In addition to this extra product page, all documents apply to products in this combination.
- Read and pay attention to all documents for individual products and this combination.

1.2 Scope of delivery

The scope of delivery of this product includes:

- SAD segmented clamping bushing
- Dressing ring
- Attachment

Additionally needed and included as optional items in the scope of delivery:

- Clamping device

2 Use

2.1 Use-related safety



WARNING

Serious injuries caused by unskilled staff during dressing of the product!

- Dressing of the product must be performed by skilled staff from the relevant specialist field.



WARNING

Serious injuries caused by tools and items of test equipment being ejected centrifugally!

- Before dressing the product, ensure that all tools and items of test equipment are removed from the working area of the machine.



WARNING

Serious injuries can be caused if the machine tool starts up accidentally!

- Before the dressing operation, close all safety doors or hoods on the machine tool.



WARNING

Serious injuries can be caused by using a wrong dressing ring!

- Only use the dressing ring with the right clamping diameter.

2.2 Axial actuating force during dressing

The table shows the specified values needed to clamp the dressing ring when dressing the product.

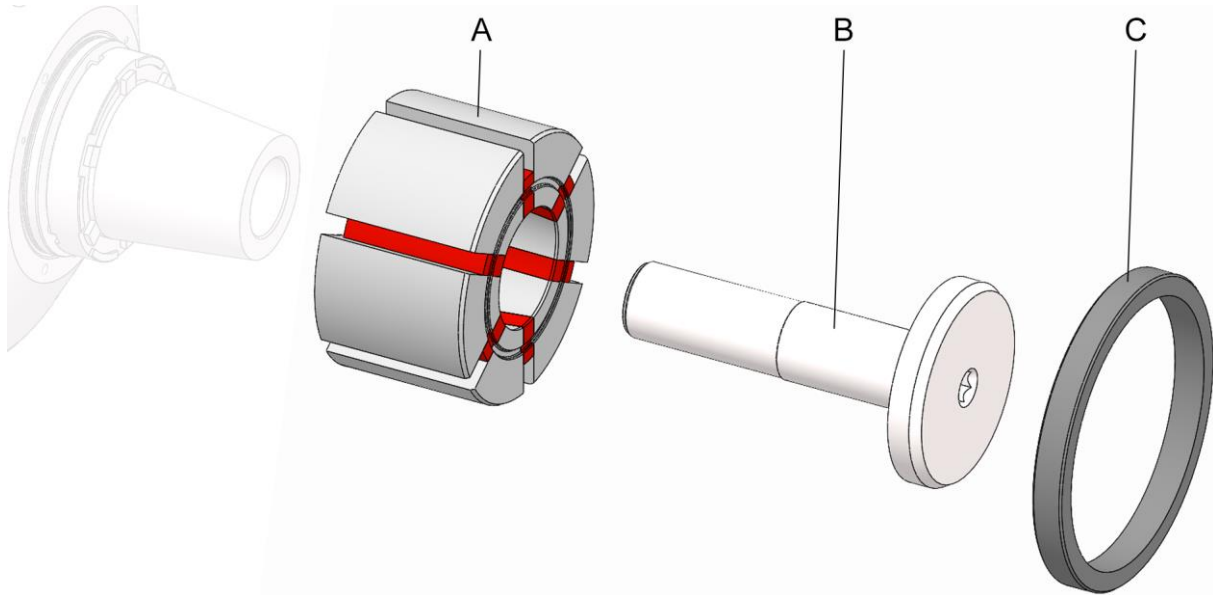
The following table lists the axial actuating forces of the clamping device in relation to the size of the product.

Size of the product	Axial actuating force of the clamping device [kN]
0	10
1	10
2	20
3	20
4	20
5	20

Size of the product	Axial actuating force of the clamping device [kN]
6	20
7	20

Table 1: Axial actuating force of the clamping device in relation to the size of the product

2.3 Dressing of the product



- A SAD segmented clamping bushing
- B Tension bolt
- C Dressing ring

The product can be machined within the specified limits.
The hardness of the face end and clamping surface of the product measures 50 HRC.

The steel segments have a tensile strength of $\sim 1500 \frac{N}{mm^2}$.



INFORMATION

Installation / removal of the product is described in the operating instructions for the clamping device.

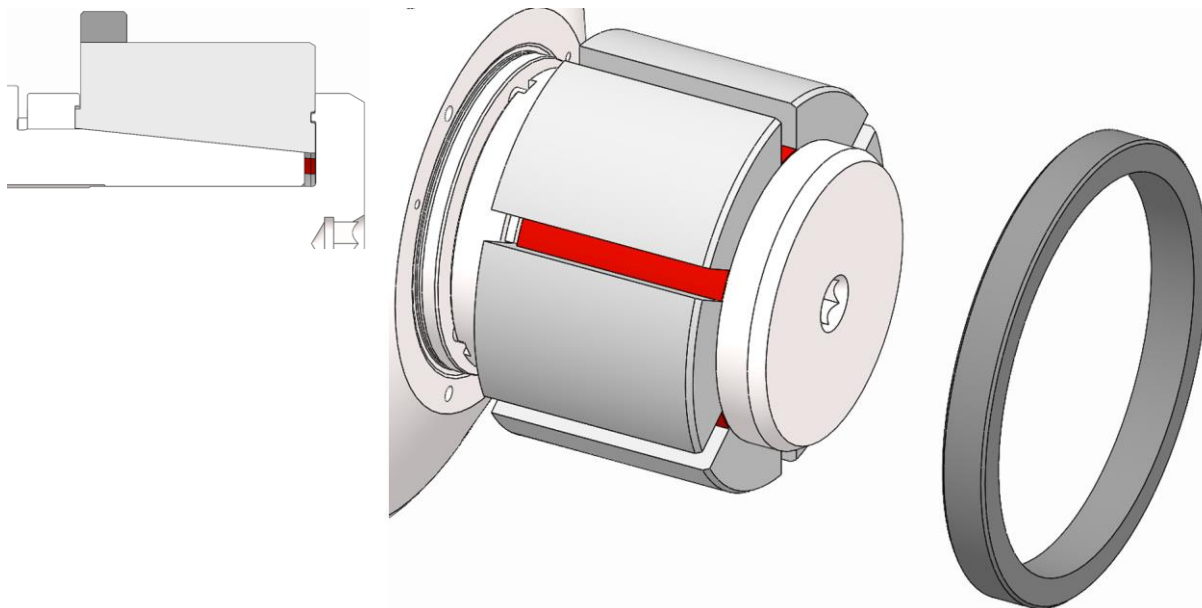


In addition to these operating instructions, also read and follow the operating instructions for the relevant clamping device.

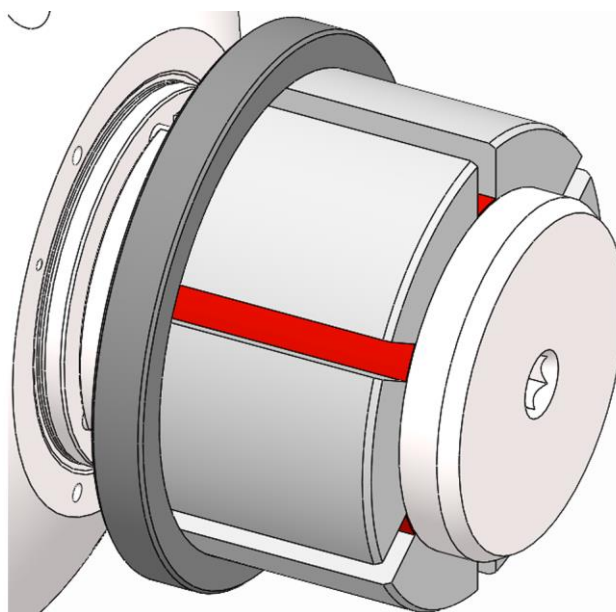
1. Install the SAD segmented clamping bushing [see »Installation of the clamping element« chapter in the operating instructions for the clamping device].

SAD segmented clamping bushing

Use



2. Fit the dressing ring to the clamping device with the rear edge of the dressing ring aligned with the rear edge of the SAD segmented clamping bushing.

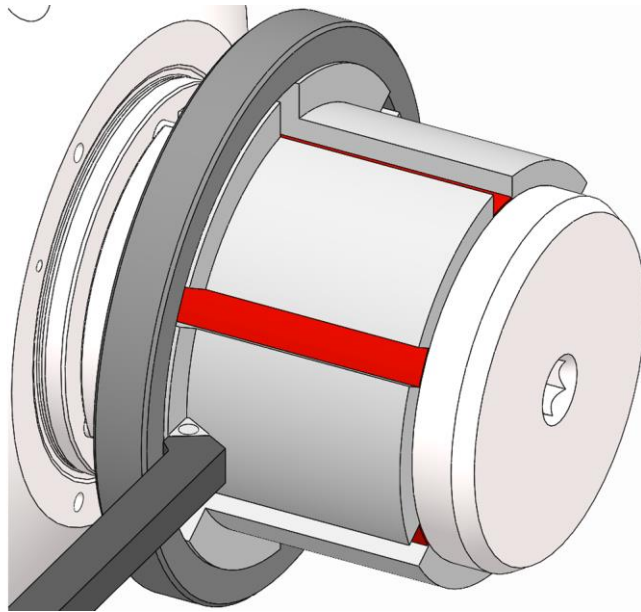


WARNING

Crushing injuries to hands / fingers if the dressing ring is installed incorrectly!

- Do not place hands / fingers between dressing ring and clamping device.
- Never reach into the clamping area.

3. Clamp the dressing ring with the specified axial actuating force [see »Axial actuating force when dressing« chapter].



WARNING

Serious injuries caused by exceeding the specified limits!

- The minimum diameter to which the SAD segmented clamping bushing can be dressed is limited by the rubber segments on the segmented clamping bushing.
- The rubber segments on the SAD segmented clamping bushing must not be machined, and must not be damaged by the dressing operation.
- The dressing operation must not cause damage to the dressing ring.



WARNING

Serious injuries caused by not clamping the dressing ring while dressing the product!

- The dressing ring must be installed straight.
- Only dress the SAD segmented clamping bushing while it is clamped.



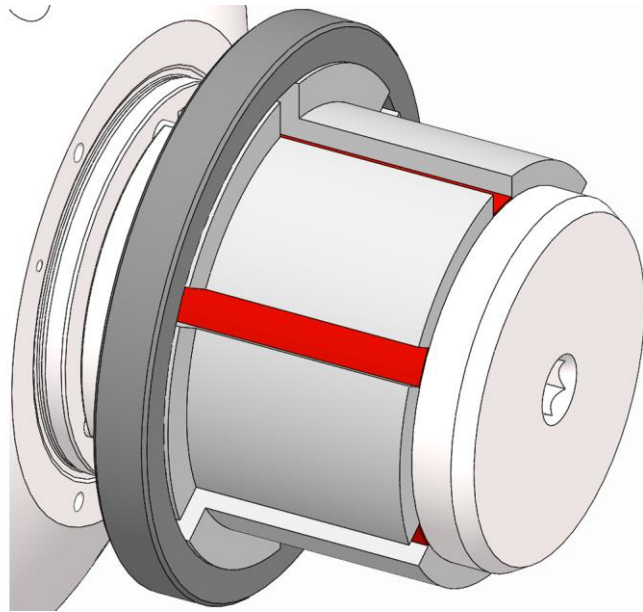
NOTE

Damage to materials caused by dressing the product without lubricant!

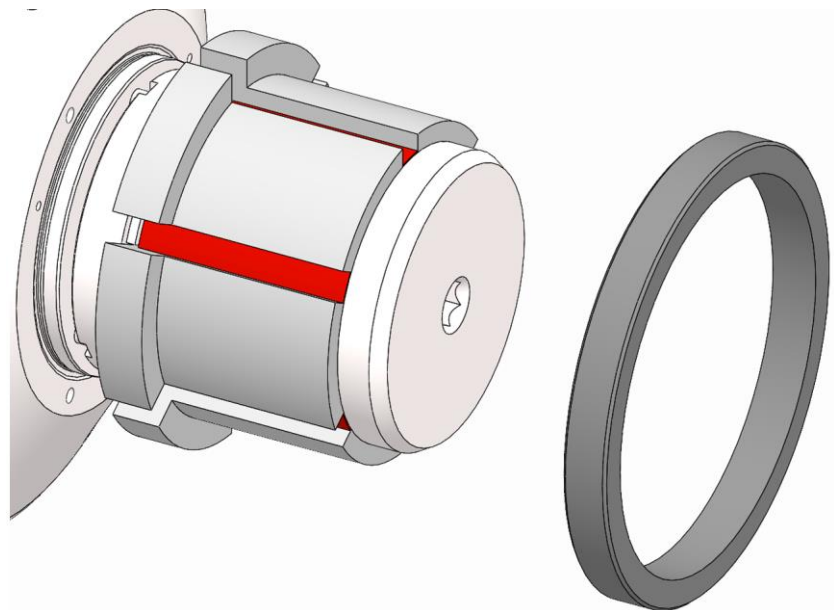
- Always use cooling lubricant when dressing the product.

4. Dress the SAD segmented clamping bushing to the desired dimension. Do not exceed the specified limits.

SAD segmented clamping bushing Use



5. Release tension on the dressing ring. If necessary, secure the dressing ring to prevent it from falling.



6. Remove the dressing ring from the clamping device.

3 Annex

3.1 Contact

The following hotlines are available to you for orders, schedule tracking and emergencies.

Order hotline

Ordered quickly, supplied swiftly. Just phone:

+49 7144. 907-333

Tracking hotline

Current status of your order? Just call:

+49 7144. 907-222

24 hour emergency phone line

Has a system crash occurred, or some other technical emergency?

Our experts are there for you around the clock:

+49 7144. 907-444

For advice or help, you can contact the sales partners and service staff listed in www.hainbuch.com.



HAINBUCH GMBH · SPANNENDE TECHNIK

Postfach 1262 · 71667 Marbach / Erdmannhäuser Strasse 57 · 71672 Marbach · Germany

Tel. +49 7144.907-0 · Fax +49 7144.18826 · verkauf@hainbuch.de · www.hainbuch.com

24 hour emergency phone line + 49 7144.907-444

08.2020 · 073.11/0101 EN · Technical modifications reserved