

# HWR

## Operating manual

INOFlex® VK-S 026 – VK-S 120

### Compensating 4-jaw Power Chuck



Translation of the Original Operating Manual (German)  
Keep for future use!

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DE

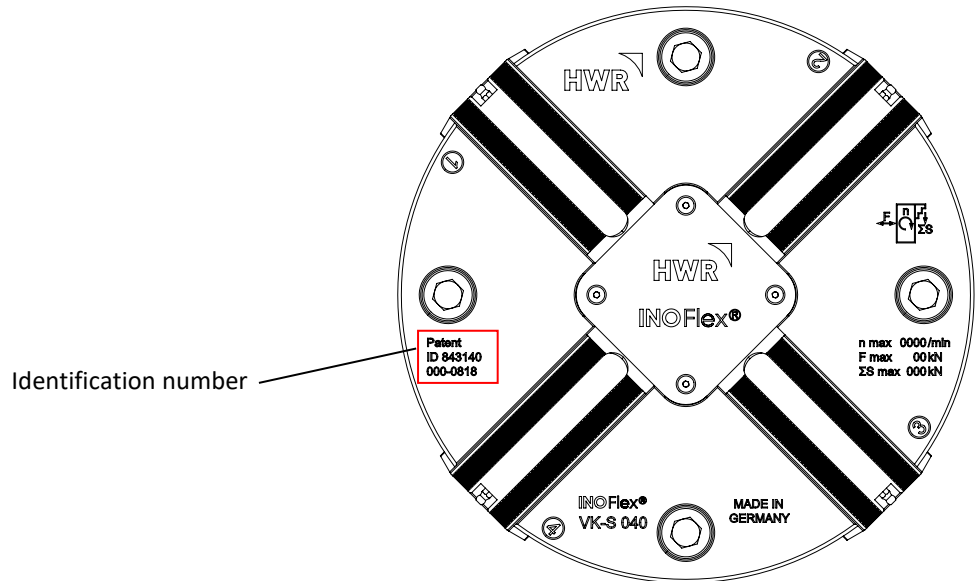
Betriebsanleitung INOFlex® VK-S 026 – VK-S 120 – Ausgleichendes 4-Backen-Kraftspannfutter

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The following figure shows the chuck with the embossed data.



## NOTICE

***If you have any questions for HWR Spanntechnik GmbH please hold ready the identification number. Errors and omissions in the documentation are excepted. Please inform HWR Spanntechnik GmbH of any errors in the documentation.***

### © Copyright

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This documentation is designated only for the operating company and its personnel. It contains instructions and information that may not be fully or partially reproduced, distributed nor be transmitted by technical data methods nor be utilized for the purpose of unauthorized competition.

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This operating manual gives you detailed information about the installation, operation and maintenance of the INOFlex® chuck. It includes safety instructions which ensure the safe use of the INOFlex® chuck. You will also find information in this documentation about the scope of delivery and troubleshooting.

With this manual we want to help you get the maximum benefit from your INOFlex® chuck.

The INOFlex® chuck will last long and can be used effectively provided that it is used in an appropriate way and serviced well. The documentation received with the chuck will assist you.

Always keep this operating manual and the other documentation (e.g. manufacturer's documentation) handy and in the immediate vicinity of the machine on which the chuck is used. Make sure to always follow all the information, notices and instructions contained therein. This will prevent accidents caused by incorrect operation, preserve the manufacturer's warranty and always provide you with a fully functioning chuck.

The manufacturer continuously strives to improve his products. He also reserves the right to make any changes and improvements he considers to be necessary. However, this does not include any obligation for retrofitting INOFlex® chucks previously delivered.



**DANGER**

***Before commissioning the INOFlex® chuck you must have read and understood the operating instructions and safety rules contained therein.***

**Employees must be instructed in the operation, installation and use of the INOFlex® chuck in accordance with this operating manual.**

If any questions remain after reading the operating manual, please contact the manufacturer.

We hope that you and your employees enjoy using the INOFlex® chuck and wish you a lot of success.

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The logo for HWR Spanntechnik GmbH, consisting of the letters 'HWR' in a bold, black, sans-serif font. To the right of the letters is a black square graphic element that is partially cut off by the edge of the page.

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## **Declaration of incorporation for the installation of an incomplete machine**

**in accordance with EU Machinery Directive 2006/42/EC; Annex II B**

Manufacturer: **HWR Spanntechnik GmbH**

Authorized representative for technical documentation: **Henrico Viets (Managing Director)**

Name of the machine: **Compensating 4-jaw power chuck**

Machine number: **INOFlex® VK-S 026 – VK-S 120**

### **We hereby declare**

that the above referenced incomplete machine is intended for installation in another machine. Commissioning is prohibited until the owner of the completed machine has determined that the complete machine complies with the provisions of EU Machinery Directive 2006/42/EC and has issued a declaration of conformity in accordance with Annex II, Part A of EC Machinery Directive 2006/42/EC.

that the basic safety and health requirements for the design and construction of machinery in accordance with Annex I of the EU Machinery Directive 2006/42/EC are met.

that the 'special technical documentation' has been prepared in accordance with Annex VII, Part B.

We undertake to provide national authorities, upon reasonable request, with the special technical documentation for the incomplete machine in paper format within a reasonable period of time.

A handwritten signature in black ink, appearing to be 'V. Henke', written over a horizontal line.

Oyten, 15. December 2020

Volker Henke, Managing Director

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## 1 SAFETY

### General information

The operating manual for your INOFlex® chuck contains important instructions for installation, operation, maintenance and troubleshooting. This information will help to ensure the safe operation of your INOFlex® chuck.

All of the required safety instructions and provisions on liability for working with the INOFlex® chuck are included in this chapter. In addition, you will also find instructions here on the intended use of the tool.



### **WARNING**

***Read this operating manual carefully and pay particular attention to this chapter before working with the INOFlex® chuck.***

### 1.1 SCOPE OF THE DOCUMENTATION

In addition to the safety instructions the operating manual includes:

- A general product description
- Information on installing the INOFlex® chuck
- Instructions on the use and operation of the INOFlex® chuck
- Maintenance and service instructions
- Troubleshooting instructions
- Technical data

The technical documentation also includes the following records:

- An integrated spare parts list
- A declaration of incorporation

### 1.2 MANUFACTURER'S INSTRUCTIONS

#### 1.2.1 CUSTOMER SERVICE

The manufacturer's contact details are printed on the back of the title page. Please contact the chuck manufacturer immediately in case any questions or problems arise.

### **NOTICE**

***Please have the identification number (ID No.) ready if you have any questions for HWR Spanntechnik GmbH.***

## 1.2.2 WARRANTY AND LIABILITY

As a basic principle, our »general sales terms and delivery conditions« do apply. These are made available to the operating company no later than at conclusion of the contract. Warranty and liability claims for personal injury and property damage are excluded if they can be attributed to one or more of the following causes.

- Inappropriate use of the INOFlex® chuck.
- Improper installation, commissioning, operation and maintenance of the INOFlex® chuck.
- Operating the INOFlex® chuck with defective machine safety devices or safety and protective devices that are incorrectly attached or not functioning properly.
- Failure to observe the instructions in the documentation regarding
  - storage
  - installation
  - operation (e.g. correct clamping of the workpiece, observe the max. speed)
  - maintenance and service
  - troubleshooting of the INOFlex® chuck
- Unauthorized modifications to the chuck or to the machine on which the chuck is mounted
- Inadequate monitoring of parts subject to wear
- Improper repairs
- Catastrophes caused by external influence or force majeure.

### **DANGER**

***No modifications, additions, or conversions to the INOFlex® chuck are allowed without permission of the manufacturer. All conversion measures require a written confirmation from the manufacturer.***

### **WARNING**

***Use only original spare and expendable parts. It cannot be guaranteed that externally procured parts are constructed to meet the required tolerance and safety standards.***

### **NOTICE**

***The manufacturer only provides a full guarantee for the spare parts ordered from him.***

### 1.2.3 NOTICE ON THE USE OF DOCUMENTATION

Always keep this operating manual and other documents for the INOFlex® chuck in the immediate vicinity of the control unit of the machine in which the chuck is used.

Read this operating manual and make sure to follow the safety instructions before initial use of the tool.

A symbol is used to mark points in the manual which are particularly important.




#### **NOTICE**

***The training of personnel by the manufacturer is only considered to be a provision of limited information. It does not exempt the user from reading the manual.***

#### 1.2.4 EXPLANATION OF THE PICTOGRAMS

The following symbols are used at all key points in this operating manual. Follow these instructions carefully and proceed with caution in these situations.

Identification of the safety instructions:

 <b>DANGER</b>	<i>indicates a hazardous situation which, if not avoided, will result in death or serious injury</i>
 <b>WARNING</b>	<i>indicates a hazardous situation which, if not avoided, could result in death or serious injury</i>
 <b>CAUTION</b>	<i>indicates a hazardous situation which, if not avoided, will result in minor or moderate injury</i>
<b>NOTICE</b>	<i>is used to address practices not related to physical injury</i>
<b>SAFETY INSTRUCTIONS</b>	<i>indicate specific safety-related instructions or procedures (title may be altered)</i>

## 1.3 INTENDED USE

### 1.3.1 THE SOLE INTENDED USE

The INOFlex® chuck VK-S 026 – VK-S 120 is solely intended for the clamping of components for mechanical machining in machine tools (see also Chapter "7" Technical Data).

Any other use is considered improper. The manufacturer is not liable for damages resulting from improper use.

### 1.3.2 OBSERVE THE INSTRUCTIONS AND RULES

Intended use also includes:

- Following all the instructions in the documentation as well as the manufacturer-supplied documentation (if applicable)
- Compliance with the manufacturer's prescribed service and maintenance conditions and intervals

### 1.3.3 OBSERVE THE ACCIDENT PREVENTION REGULATIONS

Observe the applicable accident prevention regulations and other generally recognized regulations related to safety.

## 1.4 WARNING ABOUT FAULTY OPERATION AND MISUSE

The functioning of your INOFlex® chuck has been tested at the factory. However, there are risks associated with faulty operation or misuse, e.g.:

- Risk to life and health of operators, third persons and animals in the vicinity of the machine tool in which the chuck is used
- Risk to the machine tool, the chuck and other property of the operating company
- Risk of losing efficient operation of the machine tool, in which the chuck is installed.

1.5 INSTRUCTIONS FOR SAFE OPERATION



**DANGER**

***Real safety means that you are familiar with all safety instructions. This applies to the type and location of the risk and in particular the protective measures that must be taken. Always remain vigilant and aware of the risk (s) involved.***

Malfunctions must be investigated immediately. The operating personnel should consult experts if necessary. Operation may only be resumed if the safety of the INOFlex® chuck and machine tool is absolutely certain.

Operation of the INOFlex® chuck may only be started after the operator has satisfied himself that all maintenance has been performed (as described in this manual).

Should it be determined during operation that pending maintenance was not performed then use must be stopped immediately.

Make sure to observe the permissible room temperature for operation of the INOFlex® chuck machine tool (if specified, see manual of the machine tool).

## 1.6 OBLIGATIONS

### 1.6.1 OBLIGATION OF THE OPERATING COMPANY

The operator agrees to only allow those persons to work with the INOFlex® collet chuck, who

- are familiar with the basic regulations on safety and accident prevention and who have been instructed in the operation of the INOFlex® chuck
- have read and understood the operating manual, the chapter on safety and the warning instructions and who have confirmed this with their signature

The operator is responsible for the selection of the operating personnel. He must pay particular attention to the suitability of the personnel selected for operating a machine tool with the INOFlex® chuck.

The operator always supplies his operating and maintenance personnel with the entire product documentation.

The operator periodically checks the operating and maintenance personnel with respect to safety conscientious work behavior.

The operating company of a machine tool with the INOFlex® chuck must abide by and observe the following rules and regulations:

- The functional limits and safety regulations listed in the technical operating manuals.



**DANGER**

***The operating company is ultimately responsible for safety. This responsibility cannot be delegated.***

## 1.6.2 REQUIREMENTS FOR OPERATING / MAINTENANCE PERSONNEL

The operator agrees:

- To only allow trained personnel (specialized in metal) and CNC lathe operators to work with the INOFlex® chuck
- To clearly define the responsibilities of personnel charged with installation, commissioning, operation, maintenance and repair
- To only allow personnel being trained to work with the INOFlex® chuck under the supervision of an experienced professional (specializing in metal) or a CNC lathe operator.

All persons who are assigned to operate the INOFlex® chuck agree:

- To always ensure the safety of third parties, the INOFlex® chuck and the machine tool
- To read the operating manual, the chapter on safety and the warning instructions and to confirm with their signature that they have understood them
- To observe the basic regulations concerning work safety and accident prevention
- To only use the INOFlex® chuck if they are familiar with the function of the chuck itself and the function of the machine tool and have full control over the corresponding safety and emergency equipment

The operating personnel must be completely focused when working with the machine tool and the INOFlex® chuck.

 **DANGER**

***These are matters which concern your own safety and the safety of colleagues and bystanders in the vicinity of the machine!***



## 1.7 ACCIDENT PREVENTION REGULATIONS

### 1.7.1 GENERAL INFORMATION

Check the operational safety of the INOFlex® chuck each day prior to startup! In addition to the instructions in the documentation, please observe the general, local safety and accident prevention regulations as well.

Faults which occur and impair safety must be eliminated immediately. Damaged parts must be replaced immediately. The machine with the INOFlex® chuck may not be operated until the fault is eliminated.

### 1.7.2 PROTECTION MEASURES TAKEN BY THE OPERATING COMPANY

#### Workplace ergonomics

The workstations for the operating personnel must be designed according to ergonomic guidelines. Clear access (prevention of tripping hazards), adequate lighting, etc. (accident prevention regulations, operator workstation safety) must be ensured by the operating company.

#### Personal protective measures

Personal protective equipment must be worn according to company guidelines and regulations of the employers' liability insurance association (work clothes, anti-slip safety shoes, hair net, etc.).

#### Machine access

Make sure that unauthorized persons cannot access the work area. This can be accomplished with automatic closing doors which can only be opened with a key or other similar safeguards.

### 1.7.3 INSTALLATION AND COMMISSIONING

Check to make sure that the chuck is properly inserted and attached in the machine tool.

Before starting the INOFlex® chuck the commissioning personnel must make sure that the INOFlex® chuck is in perfect working condition by conduction mandatory inspections and a trial run!

### 1.7.4 SAFETY WHEN NOT IN USE

Secure the machine tool with the INOFlex® chuck when it is not in use against operation by unauthorized persons (e.g. with a padlock on the main switch of the machine tool).

Make sure that children are unable to access the INOFlex® chuck and the machine tool.

**1.7.5 MAINTENANCE AND REPAIR**

**Maintenance periods**

Perform all required maintenance on time.

**Cleaning agents**

All surfaces that come into contact with the product must be cleaned with cleaning agents that comply with applicable hygienic or sanitary standards.

**Inspection work**

The clamping and the rotating parts must be inspected before each use to ensure that they are in perfect working condition. Damaged parts must be replaced immediately with fault-free parts.

Examine the function of all components after completion of maintenance and repair work.

**Disposal**

Make sure to properly handle and dispose of substances and materials that are used, especially greases and solvents.

## 2 TECHNICAL DESCRIPTION

### 2.1 GENERAL INFORMATION

The INOFlex® chuck VK-S 026 – VK-S 120 is intended solely for the clamping of components for mechanical machining in lathes (see also Chapter "7" Technical Data).

The chuck is to be used solely in accordance with VDI [Association of German Engineers] 3106, the user manual of the machine tool and this manual.

#### **NOTICE**

***The chuck is delivered pre-greased from the factory and must be regreased if necessary.***

### 2.2 OVERVIEW OF THE INOFLEX® CHUCK

#### 2.2.1 SET-UP

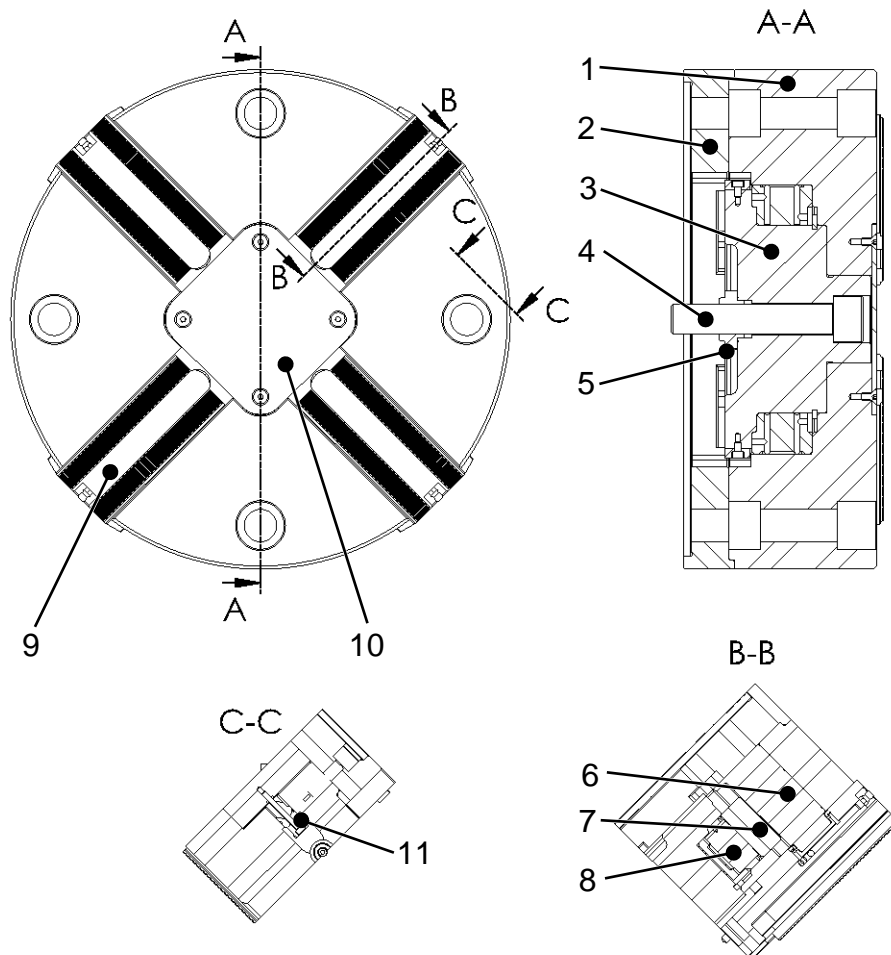


Fig. 2-1: Set-up of the INOFLEX® power chuck

- |                      |                          |
|----------------------|--------------------------|
| 1. Upper housing     | 7. Cam                   |
| 2. Lower housing     | 8. Compensation pin      |
| 3. Center part       | 9. Base jaw              |
| 4. Draw bolt         | 10. Cover plate          |
| 5. Bolt lock         | 11. Stroke monitoring ** |
| 6. Tangential slider |                          |

\*\* only to VK-S 040

### 2.2.2 DESCRIPTION OF FUNCTIONS

After the power chuck has been installed in the machine tool by a trained specialist (specializing in metal) or CNC lathe operator the same person clamps the workpiece to be machined in the chuck.

The concentric and compensating 4-jaw power chuck allows clamping of round, cubic and geometrically irregular parts and is also suitable for workpieces which are susceptible to deformation.

After installation of the clamping device on the machine spindle (by utilisation of an adapter installed by the customer) the clamping force of the hydraulic cylinder is transmitted by the draw bolt (3) and centre part (4) via the cams (5) and compensation pins (7), to the tangential sliders (6) and base jaws (1).

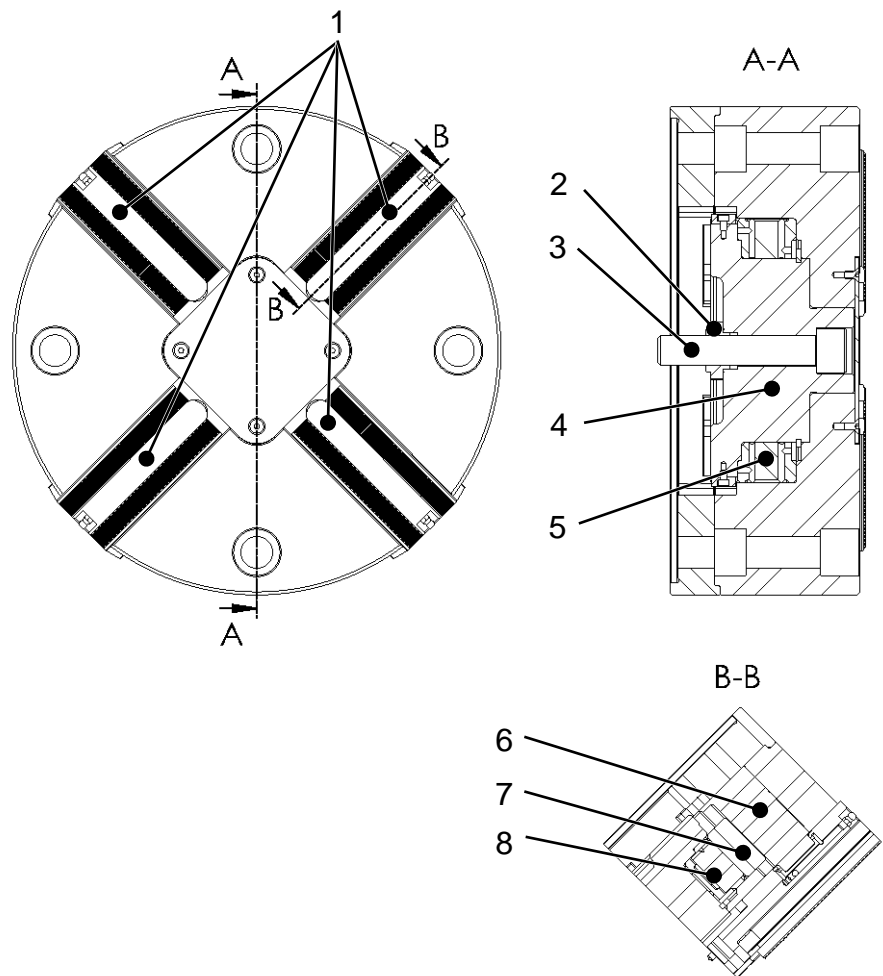


Fig. 2-2: How the INOFlex® power chuck works

## 3 TRANSPORT AND INSTALLATION

### 3.1 GENERAL INFORMATION

Work in a relaxed and careful manner when installing the chuck. Avoid stress and hectic, as this may lead to working mistakes or even accidents.

Keep all transport routes and the installation area free from interfering objects during the entire work period.

During the installation process observe the operating manual of the machine tool on which the power chuck is being mounted.



#### **WARNING**

***Also make sure to comply with the regulations and policies of the operating company regarding personal protective equipment (PPE).***

### 3.2 TRANSPORT

#### 3.2.1 TRANSPORT TOOLS

After delivery, the safely packaged chuck can be transported with the following tools depending on its weight:

- Crane
- Forklift truck or pallet truck

#### 3.2.2 INSTRUCTIONS ON THE PACKAGING

Observe the notes and instructions (if any) affixed to the packaging.

### 3.2.3 SAFETY PRECAUTIONS FOR TRANSPORT

Transport of heavy chucks may only be conducted by specially qualified personnel, if need be with auxiliary tools.



**DANGER**

***During transport, there is a risk that the component may tilt, swing or fall. This can result in equipment damage or serious bodily injury.***

The following measures must be taken to prevent equipment damage and life-threatening injuries:

- The chuck may only be lifted on the designated attachment point.
- Please observe the center of gravity and the attachment position of the chuck during pick-up, hanging and transport.
- Load-carrying and lifting equipment must comply with the accident prevention regulations.
- When selecting the load-carrying and lifting equipment make sure to consider the weight of the chuck and if necessary the length of the load arm (e.g. crane boom).
- Make sure to cordon off the transport routes used for the transport of floating loads and mark these routes to keep people off.



**DANGER**

***At no time are people allowed to stay under a floating load. Risk of accident!***

#### 3.2.4 CHUCK TRANSPORT WITH EYEBOLT

The eyebolt (DIN 580) supplied at delivery must be used for transportation.

**CAUTION** *The permissible load is marked on the eyebolt.*

**Step 1** Prior to transport, screw the eyebolt into the main body of the chuck (see the figure below). Attach the hoist.

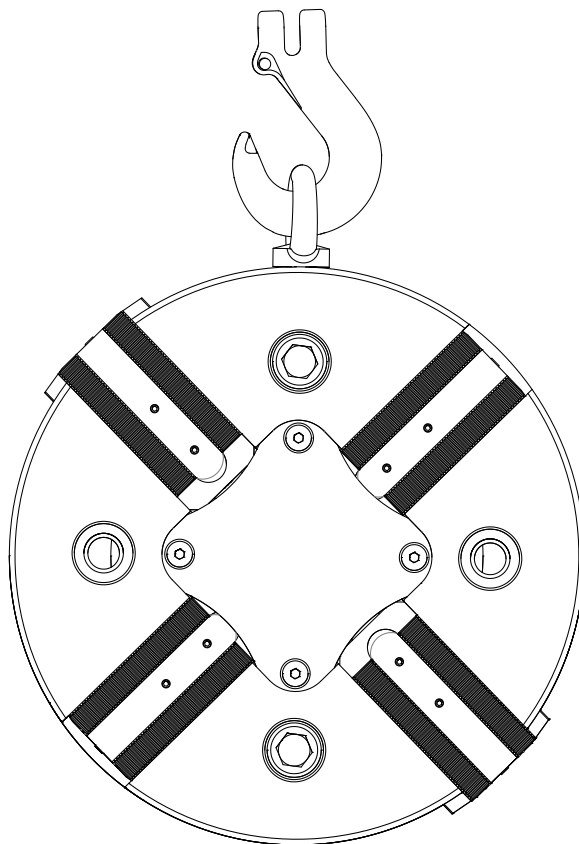


Fig. 3-1: Transport with eyebolt

**Step 2** Observe the safety precautions described in section 3.2.3 during transport.

**WARNING** *Do not remove the hoist and the eyebolt until the chuck is installed properly in the machine tool.*



### 3.2.5 INSPECTIONS AFTER TRANSPORT / RECEIVING THE CHUCK

Check the condition of the INOFlex® chuck immediately after receiving it (transport damage).

Inform the shipping company and the manufacturer of the chuck (HWR Spanntechnik GmbH) if any damage has been found. The address and telephone number you will find on the inside of the front cover.



#### **WARNING**

***Damage caused during transportation of the chuck must be repaired completely and properly before commissioning.***

### 3.3 INSTALLATION



#### **CAUTION**

***Installation of the INOFlex® chuck may only be carried out by personnel who are trained and instructed in the operation of the machine tool.***

#### 3.3.1 SPACE REQUIREMENT

The free space required to install the INOFlex® chuck corresponds with the space requirements of the operator of the machine tool (see corresponding manual of the machine tool).

3.3.2 MEASURES PRIOR TO INSTALLATION

**NOTICE**

*The chuck can be mounted on the machine spindle of the machine tool with an intermediate flange and adequate adaptor.*

- Step 1** Clean the mounting surfaces of the machine spindle, and if using an intermediate flange, also clean its center mount and bearing surface. No dirt or chips are allowed on any of these surfaces. If an intermediate flange is used it must rest completely against the machine spindle. Also make sure that all holes are deburred and clean.
- Step 2** Use a dial gauge to check the bearing surfaces (machine spindle and if applicable intermediate flange) of the chuck for true-running.

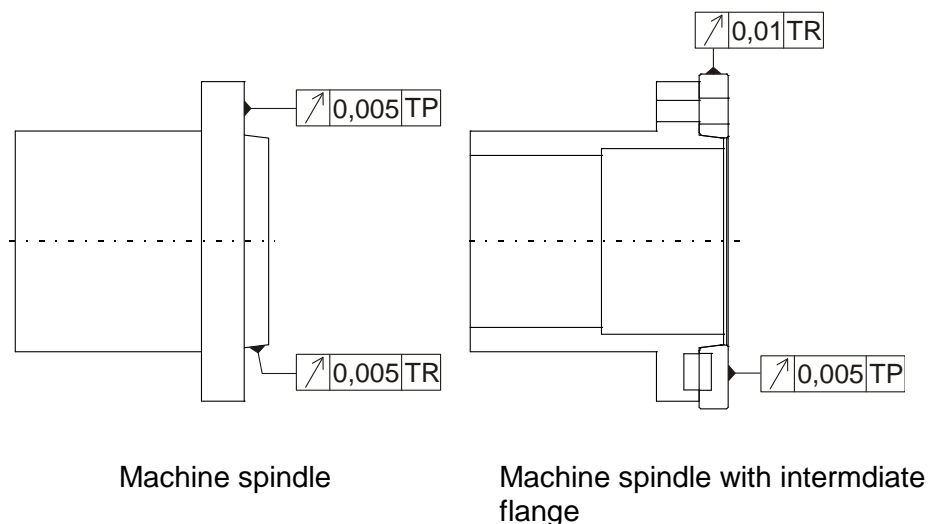


Fig. 3-2: Checking the true-running

- Step 3** Check the max. drag force of the clamping cylinder. It may not exceed the max. actuating force of the chuck. If need be limit the hydraulic pressure of the clamping cylinder!



**WARNING**

*The max. drag force of the clamping cylinder must under no circumstance exceed the actuating force of the chuck. Risk of accident.*

**Step 4** Check the endurance strength of all self-made joints.

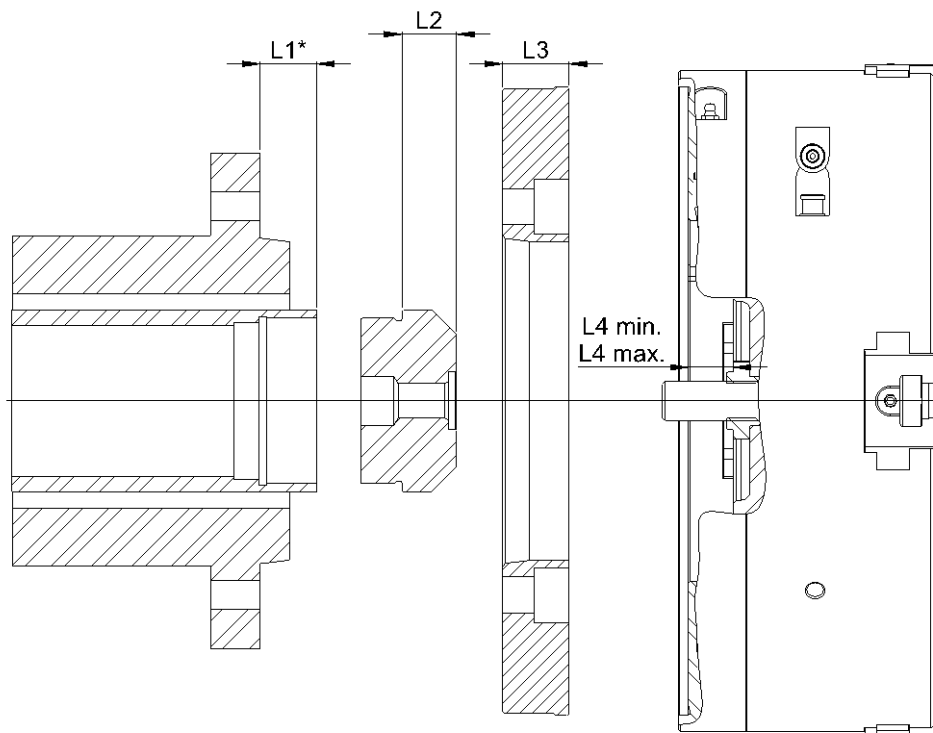
**Step 5** Calculations for the adaptor:  
 Determine the intermediate size:  $L3 + L4 \text{ max.} = X$   
 Check the adaptor size:  $L1 + L2 = X$

### NOTICE

*The following figure is an exemplified illustration (here with drawtube outside the spindle and with inside thread).*

$$L2 = L4 \text{ max.} + L3 - L1$$

*Please contact the manufacturer for any other constellation*



\*) Cylinder in front position

Fig. 3-3: Determination of the adaptor length

#### 3.3.3 INSTALLATION OF THE CHUCK

## NOTICE

*The chuck can be mounted on the machine spindle of the machine tool with an intermediate flange and adequate adaptor.*

- Step 1** Check to make sure that measures required prior to installation (see Section 3.3.2) are carried out.
- Step 2** Remove the cover (1) from the chuck and insert the associated draw bolt (5).
- Step 3** Screw the bolt lock (6) onto the draw bolt. A clearance of 0.1 mm must be set between the contact surfaces of the bolt lock (6) and the chuck!
- Step 4** Secure the bolt lock (6) by tightening the threaded pin on the side.
- Step 5** Bring the draw pipe (2) in the most forward position and screw the adaptor (3) into the draw pipe after the thread has preventively been cleaned with copper paste to avoid rusting or galling
- Step 6** Mount the intermediate flange (4) on the spindle (in case the chuck is not directly screwed onto the spindle) and check the true-running according to Fig. 3-2.
- Step 7** With the help of the hoist carefully and slowly move the clean chuck in front of the intermediate flange and/or the machine spindle.
- Step 8** Slide the chuck onto the intermediate flange or the machine spindle. Make sure that the through-holes for mounting the chuck are aligned with the threaded holes of the flange and the spindle.

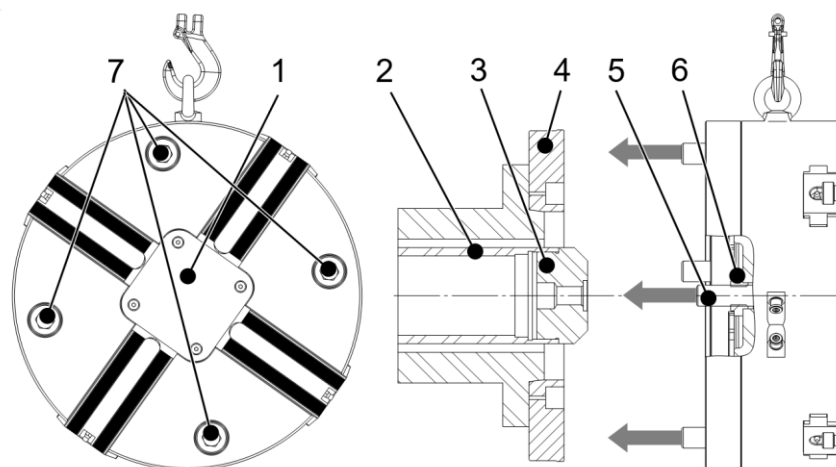


Fig. 3-4: Installation of the chuck

- Step 7** Screw in the mounting screws (7) - preferably strength class 12.9 - and the draw bolt (5) and tighten the screws gently (crosswise).
- Step 8** Remove the hoist and eyebolt.
- Step 9** Reduce the pressure of the clamping cylinder to the lowest possible pressure and actuate the cylinder to "chuck closed".
- Step 10** Check the true-running of the chuck.  
Depending on the chuck size the following tolerances have to be observed:

VK-S	026	040-120
Concentricity tolerance [mm]	0.03	0.05
Axial runout tolerance [mm]	0.03	0.05

Table 3-1: Concentricity/axial runout tolerance

- Step 11** If need be align the chuck with light plastic-hammer strokes on the external diameter.
- Step 12** Tighten the mounting screws (7) and the draw bolt (5) with a torque wrench (8) (crosswise).

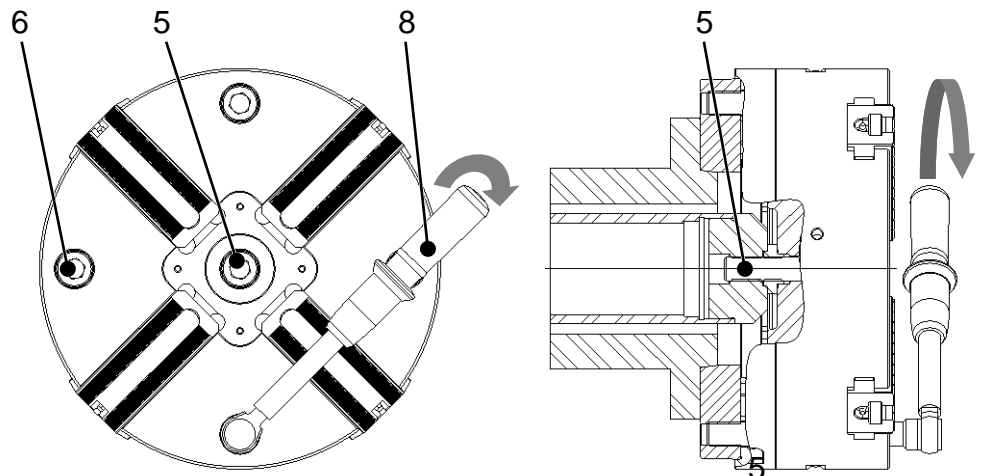


Fig. 3-5: Tightening the bolts with the correct torque

### NOTICE

***Please observe the maximum tightening torques for mounting screws (see Table 7-7).***

### ! WARNING

***The body of the chuck must not be distorted.***

**Step 13** Check again the true-running of the chuck according to table 3-1.

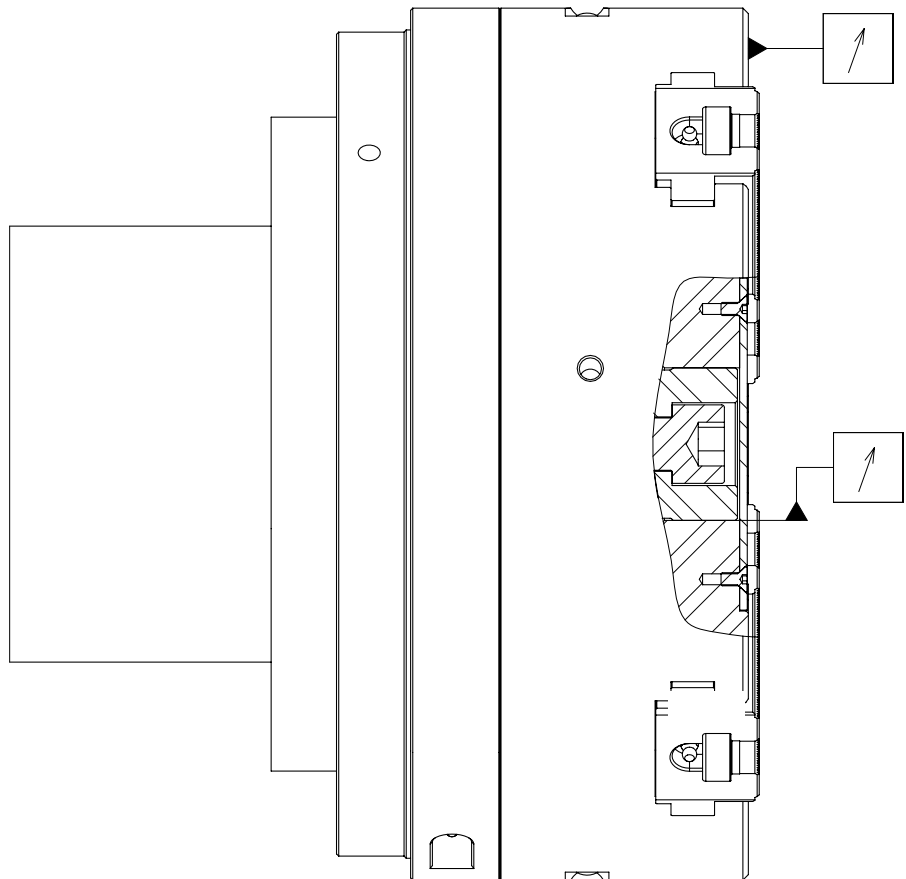


Fig. 3-6: Chuck mounted on intermediate flange

## 3.4 INSERTION OF THE CLAMPING JAWS

### 3.4.1 GENERAL INFORMATION

Depending on the workpiece to be processed soft or hard top jaws can be used.

#### **NOTICE**

*The manufacturer recommends the use of original clamping jaws from HWR Spanntechnik GmbH. The manufacturer does not guarantee performance of externally procured parts.*



#### **WARNING**

*Consult with the chuck manufacturer HWR Spanntechnik GmbH before you use clamping jaws from a different manufacturer. You also need to carry out a calculation in accordance with VDI 3106 to determine the maximum permissible speed and required clamping force.*

## 3.4.2 INSTALLATION OF THE TOP JAWS

**Step 1** Insert the sliding block (1) into the chuck with the bevelled end towards the center.

**Step 2** Put the clamping jaw onto the serration (2) and screw-in two cylinder screws (3) each of strength class 12.9.



### WARNING

**Make sure the serration is free from any dirt. Allocate the clamping jaw-number to the corresponding base jaw number.**

**Ensure sufficient screw-in depth (min. 1.25 x thread diameter)**

**Step 3** First tighten the screw (3) at the non-bevelled end of the sliding block with a torque wrench and afterwards the screw (3) at the bevelled end.

### NOTICE

**Please observe the maximum tightening torques for mounting screws (see Table 7-7).**



### WARNING

**Mounting the jaws requires at least two fixing screws, which are completely positioned inside the groove of the base jaw.**

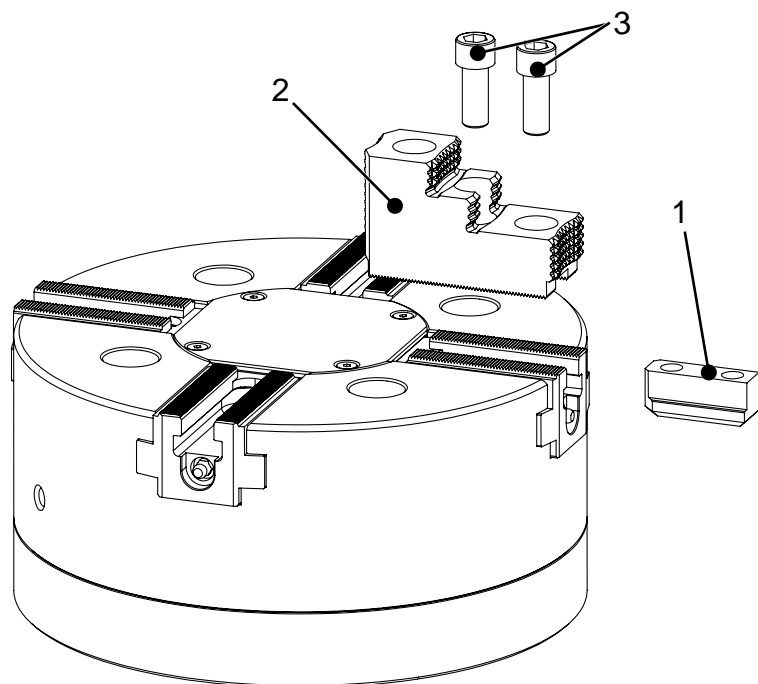


Fig. 3-7: Installing the clamping jaws



### 3.5 FUNCTION CHECK

The function of the chuck must be checked after installation and before commissioning. Pay particular attention to the clamping force at this time:

- The clamping function of the chuck is to be checked by actuating the clamping cylinder (opening and closing).
- In order to control the correct mounting to the machine spindle the jaw travel has to be checked.
- If need be carry out a calculation of the permissible speed according to the VDI 3106 guideline.
- Measure the clamping force with a suitable clamping force meter on 2 jaws (1/2 total clamping force).

## 4 OPERATION

### 4.1 GENERAL INFORMATION

In this chapter you will find information on how to operate the INOFlex® chuck.



#### **WARNING**

*Also make sure to comply with the regulations and policies of the operating company regarding personal protective equipment (PPE).*



#### **WARNING**

*In addition, observe the operating instructions of the machine tool in which the chuck is installed.*

### 4.2 PREPARATIONS

- Step 1** Check to make sure that the chuck is properly installed on the machine tool.
- Step 2** Make sure that a functional test was carried out (see chapt. 3.5).

## 4.3 CLAMPING THE WORKPIECE



### WARNING

*Make sure the machine tool is in proper working condition before turning on the machine and before operation of the chuck.*



### DANGER

*If the max. speed of the lathe is higher than the max. permissible speed of the chuck then a speed restrictor must be installed in the machine. Excessive operating speed of the chuck and therefore excessive centrifugal force must never be allowed. Otherwise there is a risk that the workpiece is not clamped sufficiently.*

**Step 1** Use both hands when putting the workpiece in the chuck and clamp it by pressing the foot switch.



### DANGER

*During the clamping process NOBODY else apart from the dedicated and trained person for this job is allowed near the machine.*



### DANGER

*An unsafely clamped workpiece increases the risk of accident by dropping out of the chuck.*



### WARNING

*When clamping the workpiece there is a risk of squeezing your hands.*



### DANGER

*Make sure that the workpiece is clamped by both pairs of jaws. You may never clamp or operate when the piece is clamped by 3 jaws only.*

**Step 2** Check the two stroke controls to make sure that the workpiece is clamped safely (see chapter 4.3.1 to VK-S 040 and 4.3.2 up from VK-S 050).

**Step 3** After correct clamping of the workpiece start operating the machine according to the operating manual of the machine tool. Do not exceed the permissible speed.



### DANGER

*maximum clamping diameter = chuck diameter*

**4.3.1 STROKE CONTROL VK-S 026 - VK-S 040**

When the workpiece is clamped the stroke control has to be in the green sector as shown in Fig. 4-3. This eliminates the possibility that the base jaw abuts before the workpiece is clamped safely.

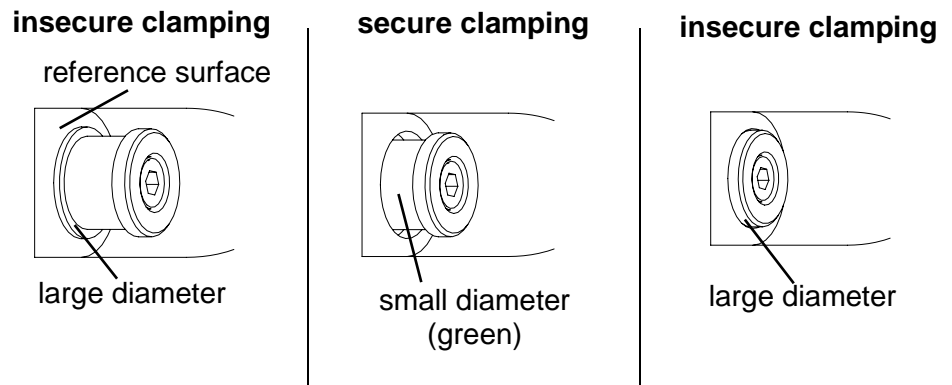


Fig. 4-3: Stroke control VK-S 026 - VK-S 040

**4.3.2 STROKE CONTROL VK-S 050 – VK-S 120**

When the workpiece is clamped the rear edge of the base jaw has to be between the inner and outer area as shown in Fig. 4.4 This eliminates the possibility that the base jaw abuts before the workpiece is securely clamped.

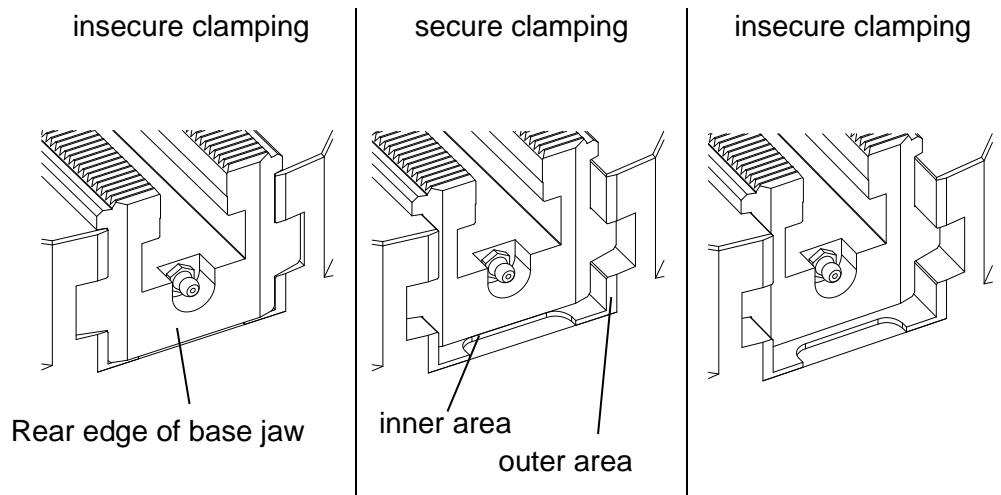


Fig. 4-4: Stroke control VK-S 050 – VK-S 120

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#### 4.4 REGULAR TASKS DURING OPERATION

- Carry out visual inspections for contamination on a regular basis. If necessary stop operation and clean the chuck / machine (see Chapter 5 "Maintenance").
- In addition, observe the operating manual of the machine tool.

## 5 MAINTENANCE

### 5.1 GENERAL INFORMATION

Regular maintenance and service intervals must be maintained in order to ensure trouble-free operation of the INOFlex® chuck and the machine tool. This includes a test of functions and a visual inspection for damage and wear.



#### **WARNING**

***In addition, observe the operating instructions of the machine tool in which the chuck is installed.***

Keep ready the required materials for cleaning the chuck.

### 5.2 MAINTENANCE

#### 5.2.1 MAINTENANCE PERIODS

Carry out all required maintenance work in due time.

#### 5.2.2 INSPECTION WORK

The load bearing and the moving parts must be checked before each use to ensure they are in perfect working condition. Damaged parts must be replaced immediately by fault-free parts.



#### **WARNING**

***Repair and replacement work on the INOFlex® chuck may only be carried out by personnel who are trained and instructed in the operation of the machine tool.***

Examine the function of all safety devices on the machine after completion of maintenance and repair work. Protective cladding and protective covers must be installed correctly.

#### 5.2.3 LUBRICANT

Use only the special lubricating grease OKS 265 from HWR Spanntechnik GmbH (or other grease accepted by HWR).

#### 5.2.4 SAFETY INSTRUCTIONS

Switch-off the machine tool and secure the machine against restarting (see operating manual of the machine tool) prior to conducting maintenance and service work.

## 5.2.5 MAINTENANCE SCHEDULE

<b>before each use of the chuck</b>
Visual inspection for condition and function
Table 5-1: Maintenance work before each use

<b>during operation</b>
frequent visual inspection for contamination
Table 5-2: Maintenance work during operation

<b>after each use of the machine</b>
manual cleaning
Table 5-3: Maintenance work after each use

	<b>VK-S 026 – VK-S 040</b>	<b>VK-S 050 – VK-S 120</b>
Clamping force monitoring with suitable clamping force measuring device: measured over 2 jaws (1/2 total clamping force) or over 4 jaws	after 1000 clamping strokes	after 500 clamping strokes
Monitoring of the base jaw stroke	after 1000 clamping strokes	after 500 clamping strokes
Table 5-4: Maintenance work after clamping strokes		



***The chuck must be greased sufficiently. Otherwise clamping force will be lost. Risk of accident!***

### 5.2.6 MONITORING OF THE CLAMPING FORCE

According to the maintenance schedule, the clamping force of the chuck must be checked regularly. Use a suitable measuring device with to measure the clamping force using 2 jaws (1/2 total clamping force) or 4 jaws.

#### **NOTICE**

*The total clamping force results from the sum of the clamping forces of each base jaw.*



#### **WARNING**

*The achieved clamping force can change after prolonged operation of the chuck.*

#### Procedure for excessive clamping force

Increasing the measured clamping force, in comparison to the value specified in chapter 7.8, does not constitute a malfunction of the chuck. If the clamping force is more than 10% above the value specified in chapter 7.8, the operator must record and use a new characteristic curve for the relationship between actuating force and clamping force (template in chapter 9.1).

The maximum actuating force of the chuck must be reduced in this case so that the maximum clamping force specified in chapter 7.8 is not exceeded.

#### Procedure for insufficient clamping force

If the clamping force is more than 15% below the value specified in chapter 7.8, the chuck must be re-lubricated (see chapter 5.3).

If the desired total clamping force is not achieved even after lubricating all grease nipples, then the chuck must be disassembled and completely cleaned (see chapter 5.4).

If the total clamping force cannot be achieved even after complete cleaning, including relubrication of the chuck, the chuck must be sent to the manufacturer for inspection.

### 5.2.7 MONITORING OF THE BASE JAW STROKE

According to the maintenance plan, the stroke of the base jaws must be checked regularly. The values from the technical specifications (chapter 7.8) serve as a reference.

If the measured stroke per base jaw does not align with the table value, the chuck must be disassembled and completely cleaned (see chapter 5.4).

If the required stroke per base jaw cannot be achieved even after complete cleaning, the chuck must be sent to the manufacturer for inspection.



## 5.3 LUBRICATING

### NOTICE

*The chuck is lubricated at the factory before it is shipped. To maintain the required clamping force the chuck **MUST** be re-greased with a dosed amount of grease. For lubrication intervals see Table 5-4.*

### NOTICE

*Use only the special lubricating grease OKS 265 from HWR Spanntechnik GmbH (or other grease accepted by HWR).*

Lubricate all grease nipples (1) with the grease gun. About 5 strokes with the grease gun per grease nipple are sufficient.

### ⚠ WARNING

*Too little/too much grease causes a loss of clamping force and increases the risk of accidents.*

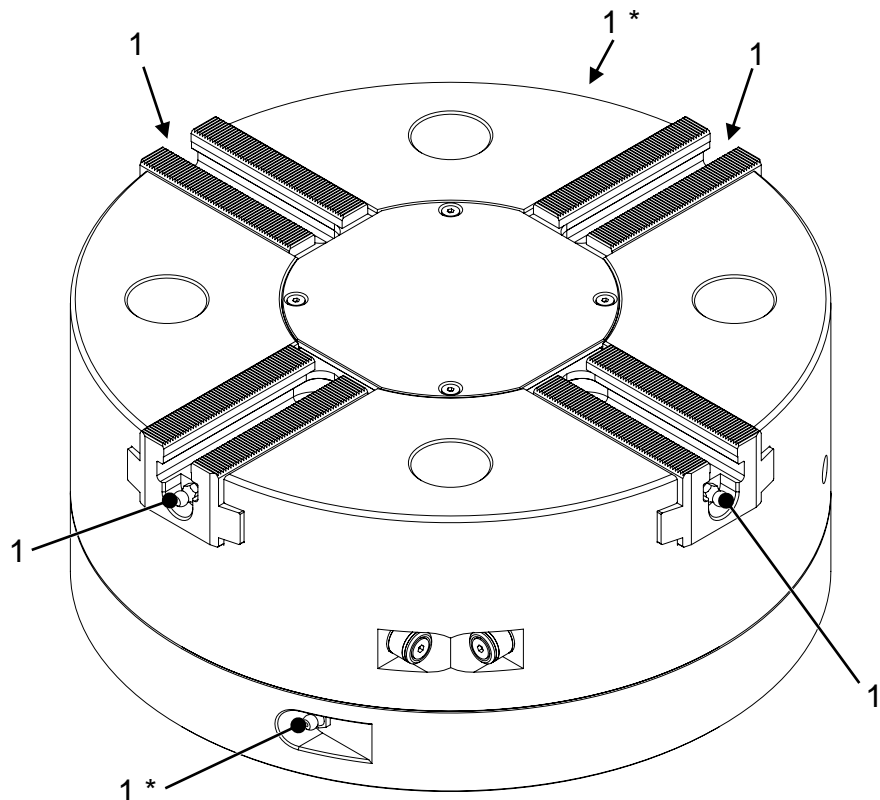


Fig. 5-1: Grease nipple

\*) starting from VK-S 050 on top surface

### 5.4 DISASSEMBLY / CLEANING / ASSEMBLY OF THE CHUCK

To ensure proper clamping force, the chuck must be disassembled at regular intervals, cleaned and greased again.

#### **NOTICE**

*Disassembly and cleaning intervals see Table 5-4.*

#### **Disassembly and cleaning**

- Step 1** Place the chuck with the jaw side on the workbench.
- Step 2** Remove the fastening bolts (1).
- Step 3** Remove the lower housing (3) by pushing it off with the fastening bolts (1) in the threaded holes (2).
- Step 4 (This step does not apply from VK-S 050)**  
Remove the stroke control (9) by loosening the respective fixing screw. The pins are detached from the parallel slide and can be removed.
- Step 5** Lift the inner parts out of the chuck body (7) by lifting them using the pull screw (4).
- Step 6** Now separate all parts from each other and put them down individually. Loosen the bolt lock (5) and remove the locking ring (6).



#### **WARNING**

*The circlip (6) must be replaced by a new one after each removal.*



#### **WARNING**

*Pay extra attention to the position and mounting orientation of the parts put aside. This will facilitate the assembly later on.*

- Step 7** Pull the base jaws (8) out of the chuck body (7).
- Step 8** Clean all parts thoroughly. If necessary, use cold cleaner/petroleum.
- Step 9** Check all components. Replace damaged parts prior to recommissioning the chuck.

#### **NOTICE**

*If you are uncertain or if you have questions please contact the producer HWR Spanntechnik GmbH.*

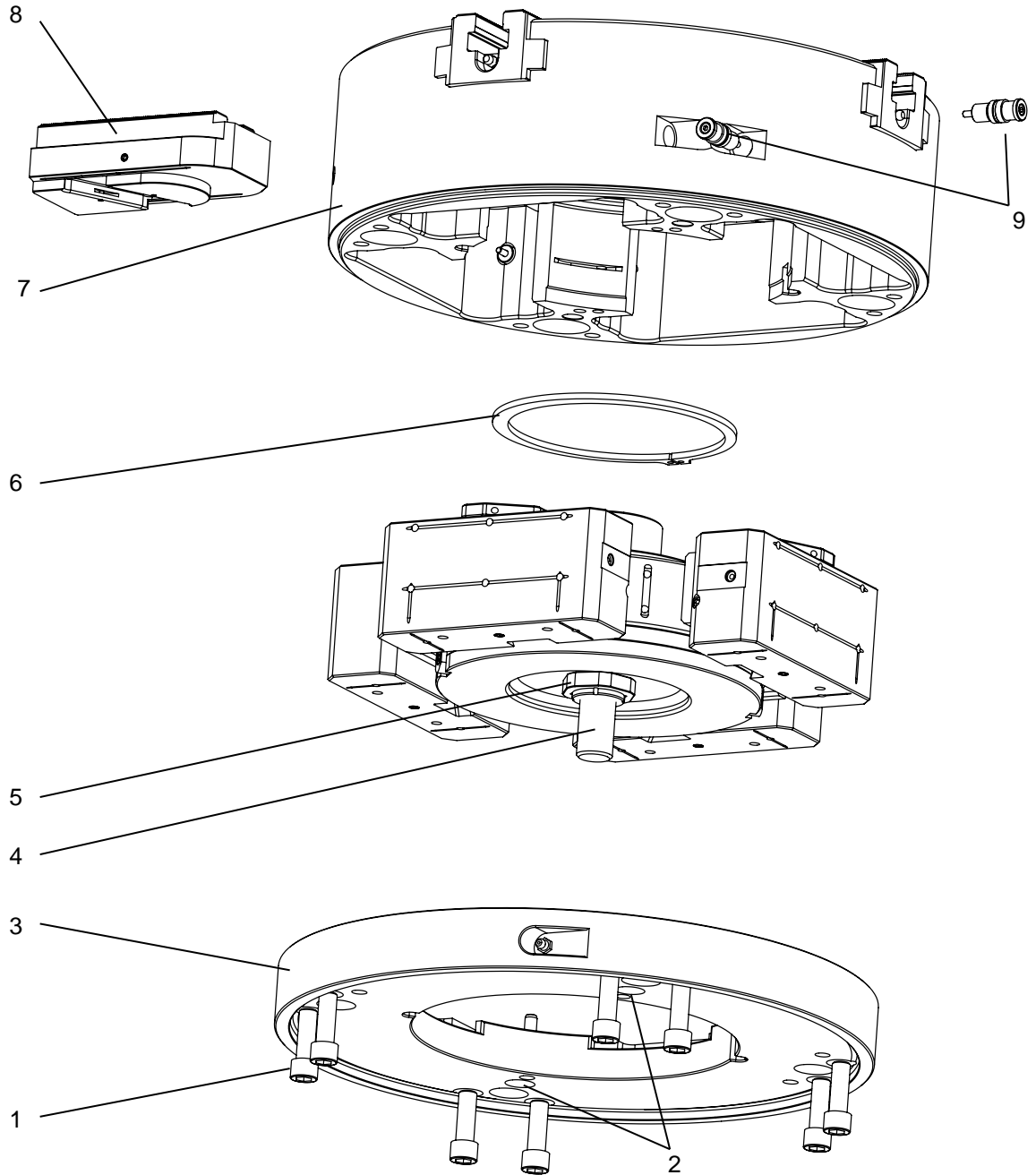


Fig. 5-2: Disassembly / assembly of the chuck (VK-S 026 – VK-S 120)

5.5 ASSEMBLY

**NOTICE**

*The internal components of the chuck can be inserted using an auxiliary tool. Please contact the manufacturer HWR Spanntechnik GmbH.*

**WARNING**

There are marking points on the base jaws, the tangential sliders and the upper part of the housing for the arrangement of the components in the chuck.

- Step 1** Mount the chuck in reverse order of the disassembly steps. During assembly, lubricate all sliding and guide surfaces with lubricant OKS 265 from HWR Spanntechnik GmbH (or other greases approved by HWR).
- Step 2** After assembly, lubricate the chuck with the lubricant by HWR Spanntechnik GmbH via the six grease nipples (s. chapter 5.3).
- Step 3** Check the clamping force with a suitable clamping force measuring device:  
measured over 2 jaws (1/2 total clamping force) or over 4 jaws

**WARNING**

*The initial clamping force measured after greasing may lie below the specified values.*

5.6 TASKS AFTER PROLONGED STANDSTILL

The technical maintenance personnel must carry out the following jobs prior to each start after an extended period of standstill:

After a long period of standstill
Visual inspection of the condition and function of the chuck
Cleaning of the chuck
Table 5-5: After a long period of standstill

5.7 DISPOSAL

Have a trained expert dismantle and break down the chuck into its individual components.

Properly handle and dispose of substances and materials used in accordance with the national laws, especially greases and solvents.

## 6 FAULTS

### 6.1 GENERAL INFORMATION

This chapter describes the course of action in the event of a fault.

### 6.2 IF FAULTS OCCUR

**Step 1** Switch-off the machine tool prior to troubleshooting and secure the machine against restarting (see manual of the machine tool).

**Step 2** Eliminate the fault.

#### **SAFETYINSTRUCTIONS**

***Repair and replacement work on the INOFlex® chuck may only be carried out by personnel who are also trained and instructed in the operation of the machine tool.***

***Before restarting the chuck or the machine the person responsible for the machine must ensure that:***

- ***Repair work is completed***
- ***The chuck is securely installed in the machine tool***
- ***The overall machine is in safe working condition***

***Also observe the safety instructions in Chapter 1 of this manual and the manual of the machine tool regarding repairs.***

**Step 3** Resume operation of the machine tool.

#### **⚠ WARNING**

***Please observe Chapter 4 of this manual and also the manual of the machine tool when restarting the chuck and the machine.***

6.3 POSSIBLE CAUSES OF ERRORS AND TROUBLESHOOTING

Error	Cause	Troubleshooting
Only three jaws abut on the workpiece	First gripping pair of jaws impede the compensation	When inserting the workpiece watch its contour so that it does not cant
Jaw (s) is jamming in the guide track	Base jaw deformed, contact surfaces and top jaw not plane, soiled or damaged	Check top jaw, clean and replace if necessary.
	Base jaw deformed, tightening torque of the mounting screws too high	Comply with the prescribed tightening torque.
	Base jaw deformed	Follow the sequence of tightening sliding block screws (s. 3.4.2)
	Original jaw (s) not used	Use original jaws.
Concentricity error	Jaws not properly turned or milled	Turn or mill top jaws again.
	Jaw inserted in the wrong guide track	Insert the jaw into the guide track with the appropriate identification.
	Base jaws soiled or damaged	Clean or replace the base jaws.
	Mounting screws for the top jaws are too short, too long or overstretched	Check screw depth, replace screws, and observe torque.
	Projection of the top jaws too large	Change the top jaws or clamping method.
	Chuck damaged or worn	Send the chuck for inspection to the manufacturer (HWR Spanntechnik GmbH).
Strong vibration of the machine spindle	Imbalance from the workpiece or top jaws	Change / rework top jaws or add weight to the body of the chuck.
	Imbalance on: <ul style="list-style-type: none"> <li>• machine spindle</li> <li>• drive</li> <li>• chuck flange</li> </ul>	Check the concentricity of various components in stages. Align, balance or replace components.
	Imbalance caused by collision	Send the chuck for inspection and repair to the manufacturer (HWR Spanntechnik GmbH).
Table 6-1: Troubleshooting		

6.3 POSSIBLE CAUSES OF ERRORS AND TROUBLESHOOTING - CONTINUED

Error	Cause	Troubleshooting
Chuck does not close	No hydraulic pressure	Check hydraulic system
	Hydraulic cylinder does not close	Check travel control on cylinder
Loss of clamping force	Short jaw stroke with large number of identical workpieces Inadequate lubrication film	Actuate the full stroke of the chuck repeatedly without workpiece for buildup of the lubrication film and to reach full clamping force.
	Insufficient lubrication Lubricant	Lubricate the chuck. Check lubricant and replace if necessary.
	Soiled chuck	Dismantle, clean and lubricate the chuck.
	Impaired function of the chuck	Check all components, replace damaged parts by original parts, if need be send the chuck for inspection and repair to the manufacturer (HWR Spanntechnik GmbH).
	Clamping cylinder leakage	Overhaul clamping cylinder
	Hydraulic system does not generate pressure	Overhaul hydraulic system
Table 6-1: Troubleshooting [continued]		

**7 TECHNICAL DATA**

**7.1 GENERAL INFORMATION**

All important technical data about the INOFlex® power chuck is contained in this chapter. The data is listed in tables and structured according to individual sizes.



**7.2 GENERAL PRODUCT DATA**

Service life	25,000 operating hrs
Clampable workpieces	Commercially available steels, cast metals, non-ferrous metals and plastics
Table 7-1: General product data	

**7.3 OPERATING MATERIALS**

Lubricating grease	OKS 265 (or other grease accepted by HWR)
Table 7-2: Operating materials	

**NOTICE**

***The special lubricating grease OKS 265 (or other grease accepted by HWR) is to be obtained from HWR Spanntechnik GmbH.***

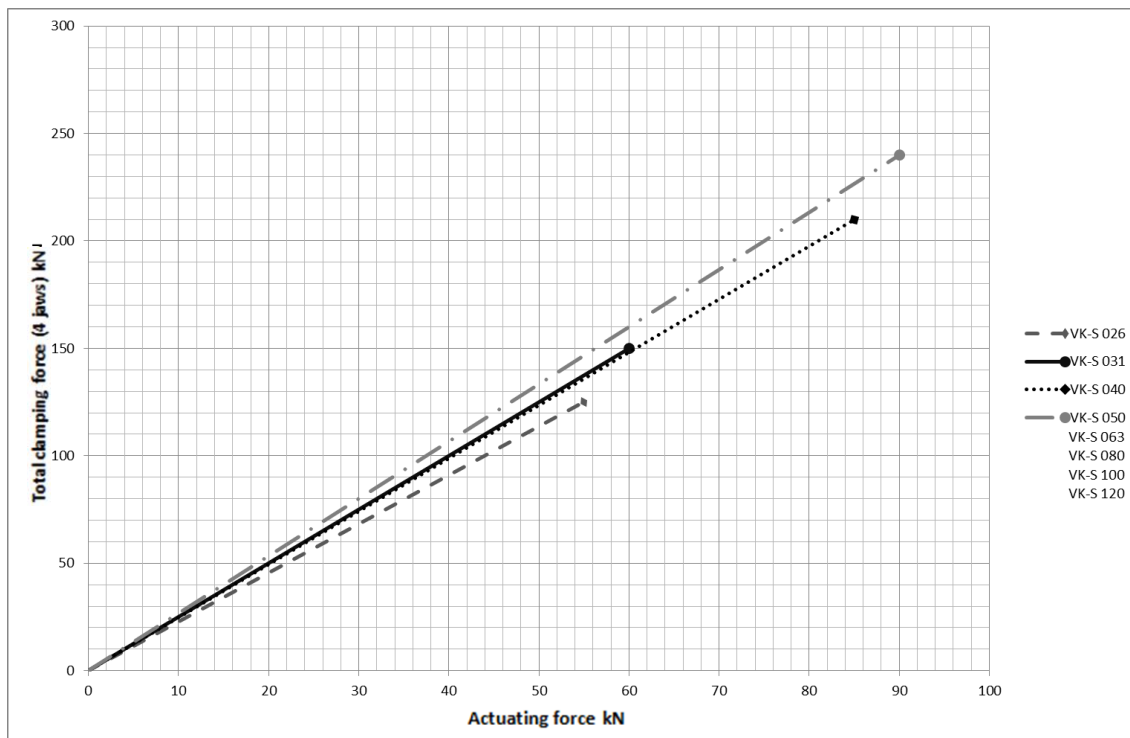
**7.4 AMBIENT CONDITIONS**

Factory	For temperature range see the operating manual of the tools
Storage	No temperature restrictions
Relative humidity	5-85 %
Installation location of the machine tool	Level, firm ground adequately ventilated
Table 7-3: Ambient conditions	

**7.5 OTHER DOCUMENTS**

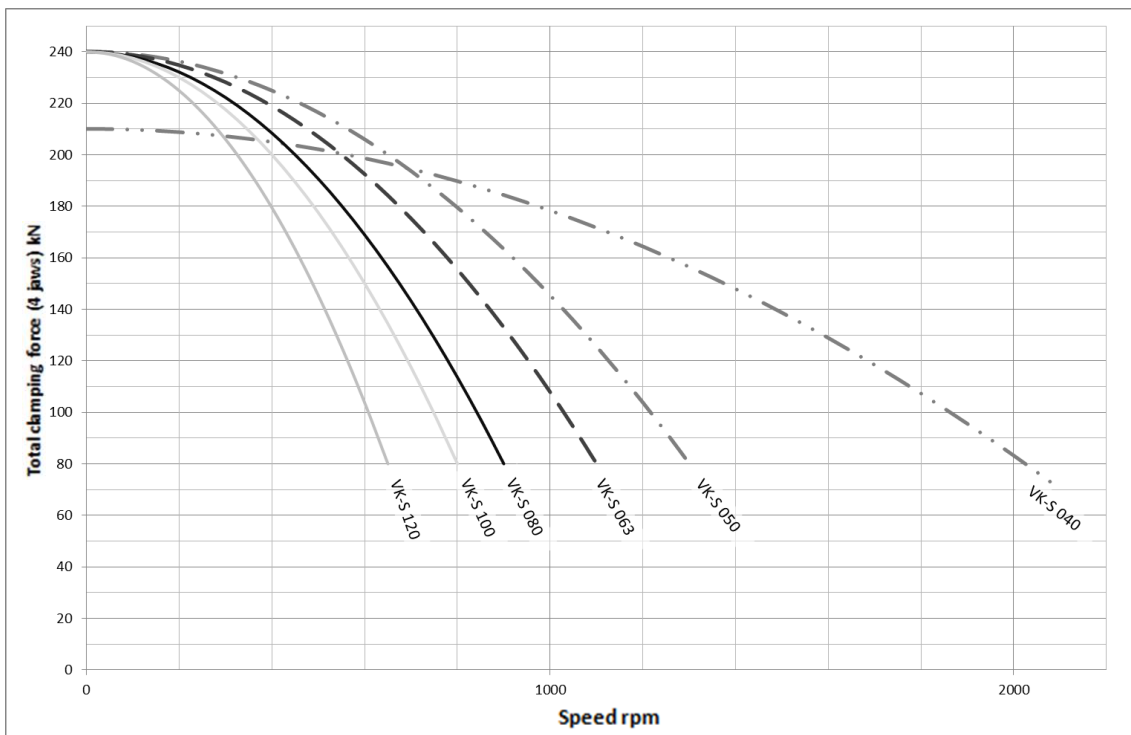
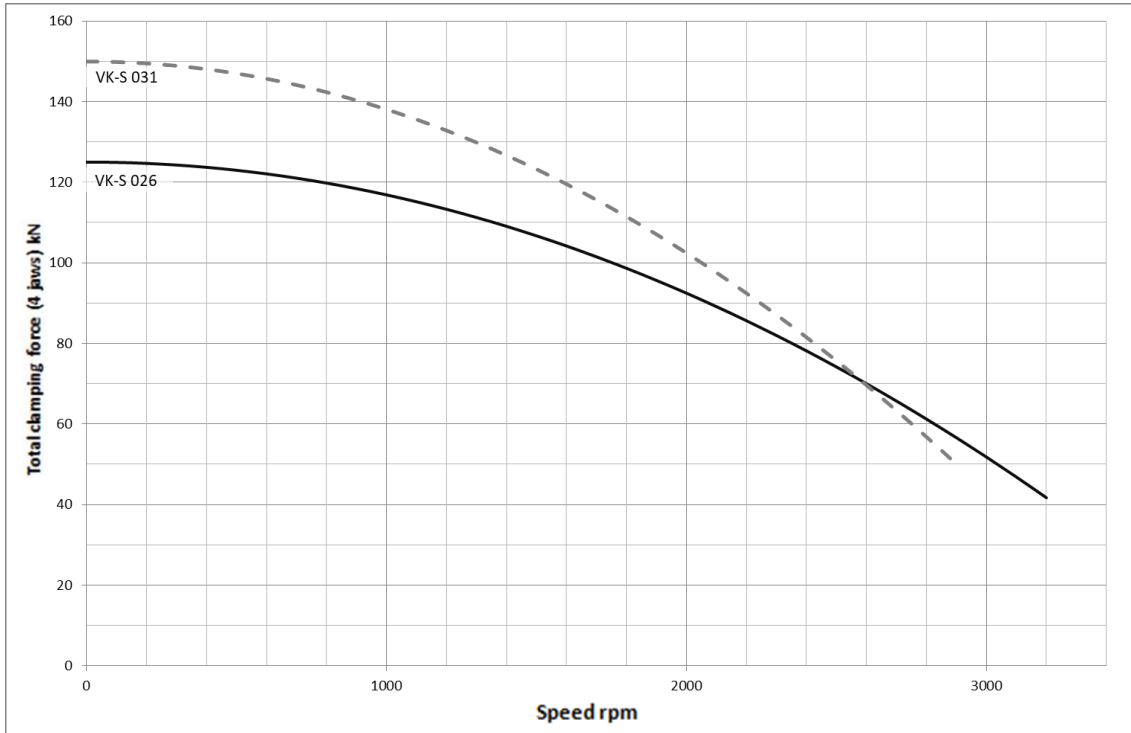
Spare parts list Declaration of incorporation Assertion of knowledge by the instructed personnel
Table 7-4: Other documents

7.6 CLAMPING FORCE / ACTUATING FORCE DIAGRAMS



*The diagrams apply to chucks in the delivery state. The clamping force curve must be resumed if necessary (see chapter 5.2.6).*

## 7.7 CLAMPING FORCE / SPEED DIAGRAMS



7.8 TECHNICAL DATA

Type		VK-S 026	VK-S 031	VK-S 040	VK-S 050	VK-S 063	VK-S 080	VK-S 100	VK-S 120
Ident-no.		843126	843131	843140	843150	843163	843180	843100	843120
Diameter	mm	264	315	400	500	630	800	990	1200
Radial jaw stroke per jaw	mm	5	5,5	6,1	6,8	8	8	8	8
Compensation per jaw	mm	4	4,4	5	5,3	6,7	6,7	6,7	6,7
Axial piston stroke	mm	22	24	27	30	35	35	35	35
max. actuating force	kN	55	60	85	90	90	90	90	90
max. clamping force	kN	125	150	210	240	240	240	240	240
max. speed*	r.p.m.	3200	2900	2100	1400	1100	900	800	650
Weight (without jaws)	kg	44,1	64	125	223	349	528	812	1165
Moment of inertia	kg·m <sup>2</sup>	0,41	0,84	2,6	7,4	17,7	33,7	82,5	203,8
T-nut	--	GP11	GP11	GP13	GP21	GP21	GP21	GP21	GP21
Standard jaws	Please see our chuck data sheets which you will find in our clamping jaws finder under <a href="https://www.hwr.de/en/">https://www.hwr.de/en/</a>								
Table 7-5: Technical Data									

\* Balance quality acc. to DIN ISO 1940-1: G 6,3 (ungreased)

**NOTICE**

*The specified data for the maximum clamping force apply to the chuck in delivery state. The clamping force may potentially change. Please refer to chapter 5.2.6.*

**! DANGER**

*maximum clamping diameter = chuck diameter*

## 7.9 CONNECTING DIMENSIONS

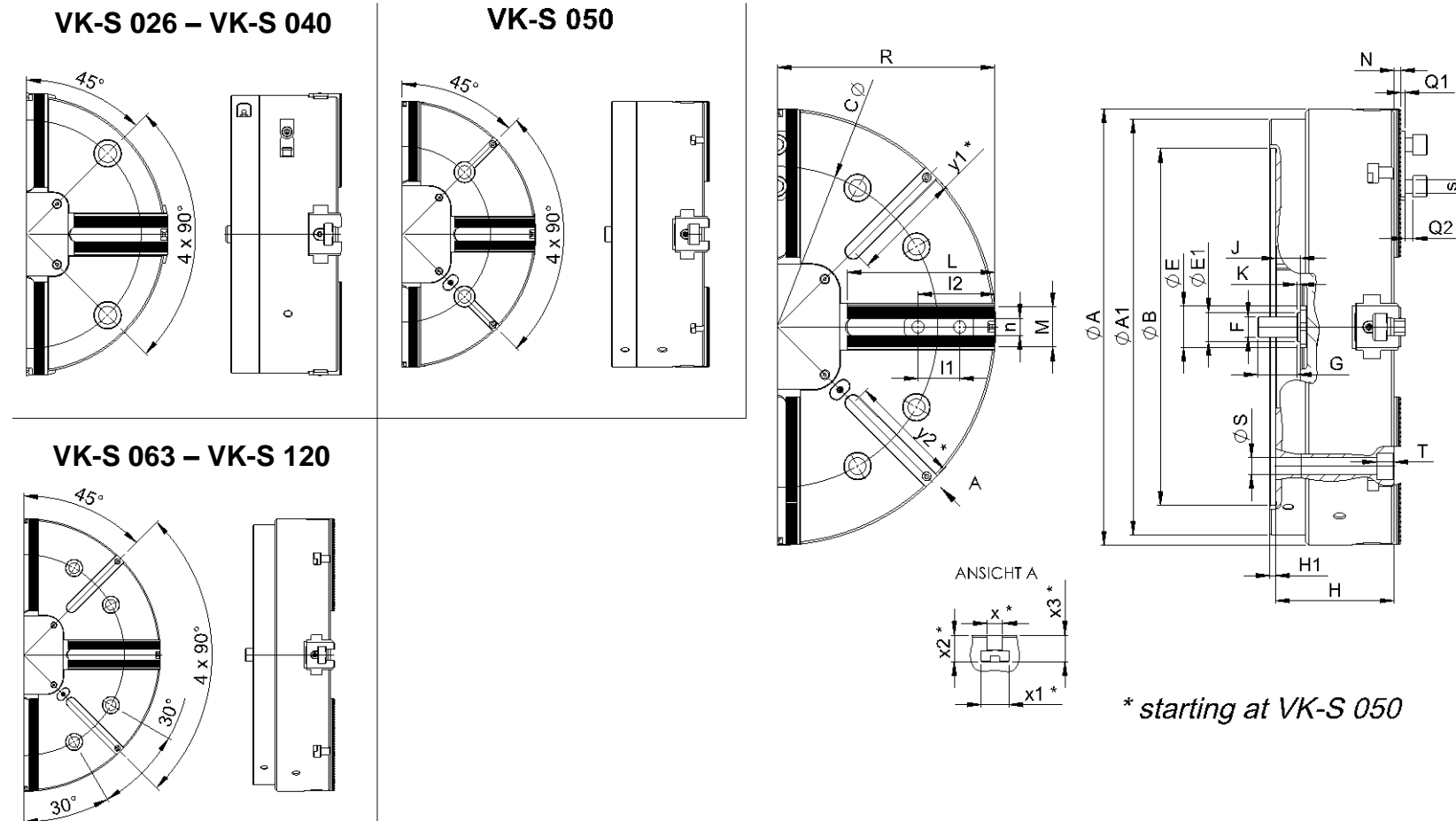


Fig. 7-1: Mounting dimensions (VK-S 026 – VK-S 120)

7.10 MOUNTING DIMENSIONS

Typ		VK-S 026	VK-S 031	VK-S 040	VK-S 050	VK-S 063	VK-S 080	VK-S 100	VK-S 120
<b>A</b>	mm	264	315	400	500	630	800	990	1200
<b>A1</b>	mm	264	315	400	500	600	600	800	800
<b>B H6</b>	mm	220	300	380	380	520	520	720	720
<b>C</b>	mm	171,4	235	330,2	330,2	463,6	463,6	647,6	647,6
<b>E</b>	mm	45	49	49	64	64	64	64	64
<b>E1 h7</b>	mm	26	35	35	42	42	42	42	42
<b>F</b>		M20	M24	M24	M30	M30	M30	M30	M30
<b>G</b>	mm	28	36	36	47	47	47	47	47
<b>H</b>	mm	122	128	149	165,5	170,5	170,5	170,5	170,5
<b>H1</b>	mm	5	5	6	8	8	8	8	8
<b>min. / max.</b>	<b>J</b>	mm	0 / 22	0 / 24	0 / 27	0 / 30	0 / 35	0 / 35	0 / 35
	<b>K</b>	mm	4	4	4	4	4	4	4
	<b>L</b>	mm	82,5	102	135	150	213	300	393
	<b>M</b>	mm	42	46	52	58	58	58	58
	<b>N</b>	mm	2	2	5	10	10	10	10
<b>serration</b>	<b>P</b>	mm	1,5 x 60°	1,5 x 60°	1,5 x 60°	3 x 60°	3 x 60°	3 x 60°	3 x 60°
	<b>Q1</b>	mm	3	3	3,5	6	6	6	6
	<b>Q2</b>	mm	8,5	8,5	11,5	16,5	16,5	16,5	16,5
<b>Chuck open</b>	<b>R</b>	mm	134,2	160	203,3	249,1	314,1	399,1	494,1

Tabelle 7-6: Anschlussmaße

### 7.10 MOUNTING DIMENSIONS

Typ		VK-S 026	VK-S 031	VK-S 040	VK-S 050	VK-S 063	VK-S 080	VK-S 100	VK-S 120	
<b>S</b>	mm	16,5	22	26	24,5	24,5	24,5	33	33	
<b>T</b>	mm	18	25	32	56,7	25	25	31	31	
<b>l1</b>	mm	30	30	30	60	60	60	60	60	
<b>min. / max.</b>	<b>l2</b>	mm	40 / 73	40 / 88	40 / 122	70 / 125	70 / 188	70 / 272	70 / 367	70 / 470
	<b>n H8</b>	mm	16	16	21	25	25	25	25	25
	<b>s</b>		M12x30	M12x30	M16x35	M20x55	M20x55	M20x55	M20x55	M20x55
	<b>x H12</b>	mm	--	--	--	14	22	22	22	22
	<b>x1</b>	mm	--	--	--	23	40	40	40	40
	<b>x2</b>	mm	--	--	--	25	38	38	38	38
	<b>x3</b>	mm	--	--	--	9	16	16	16	16
	<b>y1</b>	mm	--	--	--	65	160	160	340	445
	<b>y2</b>	mm	--	--	--	65	160	160	340	445

Tabelle 7-6: Anschlussmaße [Fortsetzung]

### 7.11 MAXIMUM TIGHTENING TORQUE FOR MOUNTING SCREWS

Strength class	Standard	Thread								
		M5	M6	M8	M10	M12	M14	M16	M20	M24
		max. tightening torque [Nm]								
12.9	ISO 4762 (DIN 912)	10	16	30	50	70	105	150	220	450
10.9	ISO 4762 (DIN 912)	8	12	25	42	58	88	125	180	350

Table 7-7: Maximum tightening torque for mounting screws

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## **8 SPARE PARTS**

### **8.1 GENERAL INFORMATION**

Spare parts may be required for the maintenance and repair of the INOFlex® chuck.

This chapter informs you about the information you should have available when ordering spare parts from the manufacturer HWR Spanntechnik GmbH.

### **8.2 BASIC INFORMATION REQUIRED FOR ORDERING SPARE PARTS**

- Size: e. g. INOFlex® VK-S 040
- Identification number (ID No.)
- Name of the spare part
- Order quantity



## 8.3 SPARE PARTS ORDER VIA E-MAIL

### NOTICE

*Please observe the minimum information requirements (see section 8.2 "Basic information about ordering spare parts").*

We recommend the following procedure when ordering spare parts:

- Step 1** Look for the desired part in figure 8-1.
- Step 2** Put down the minimum required order information in your e-mail (see Section 8.2).
- Step 3** Send the order to HWR Spanntechnik GmbH stating your company address.

### NOTICE

*The e-mail address can be found on the inside of the front cover of this operating manual.*

8.4 SPARE PARTS ORDER BY FAX

**NOTICE**

*Please observe the minimum information requirements (see section 8.2 "Basic information about ordering spare parts").*

We recommend the following procedure when ordering spare parts:

- Step 1** Look for the desired part in figure 8-1.
- Step 2** Copy the figure and if possible the corresponding Table 8-1.

**NOTICE**

*Make sure to place the original sheet back into the documentation to ensure the integrity of your data.*

- Step 3** Clearly indicate the desired spare part (s) in the figure and in the parts list.  
Also enter the desired quantity if it should deviate from the quantity already indicated.
- Step 4** Fax this page (s) to HWR Spanntechnik GmbH stating your company address.

**NOTICE**

*The fax number can be found on the inside of the front cover of this operating manual.*

### 8.5 SPARE PARTS

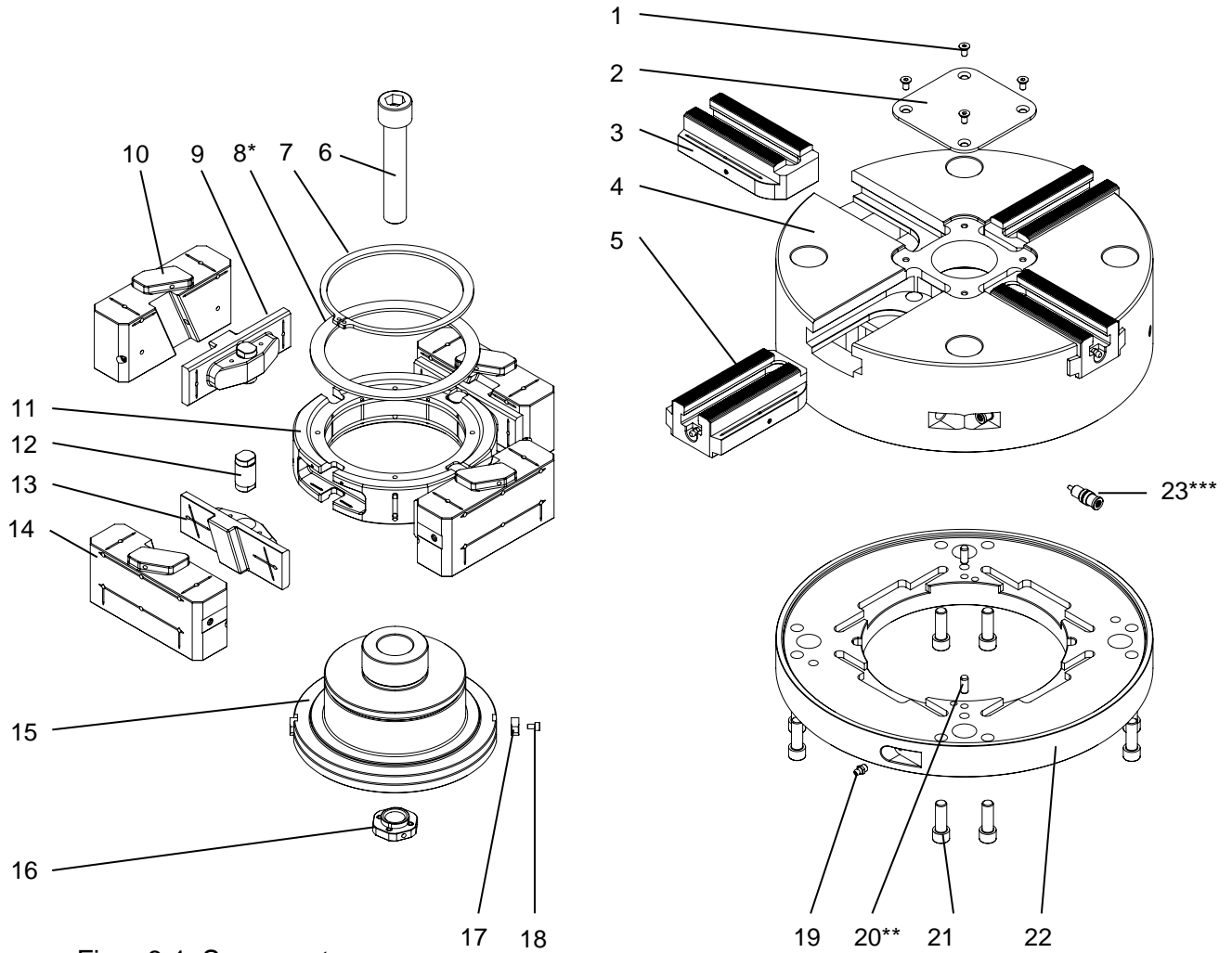


Fig. 8-1: Spare parts

Pos.	Benennung
1	countersunk bolt
2	Cover plate
3	Base jaw 1 / 3
4	Upper housing
5	Grundbacke 2 / 4
6	Draw bolt
7	circlip
8 *	support disc
9	cam 2
10	Tangential slider 2
11	Pull ring
12	Compensation pin
13	Cam 1
14	Tangential slide 1
15	Center part
16	Bolt lock
17	Feather key
18	Cylinder head bolt (for feather key)
19	Grease nipple
20 **	cylindrical pin *
21	Cylinder head bolt (for lower housing)
22	Lower housing
23 ***	Stroke control
Table 8-1: Spare parts list	

\* not applicable du to type and version

\*\* Starting at VK-S 050 replaced by keyway nut incl. cylinder head screw

\*\*\* Not applicable from VK-S 050

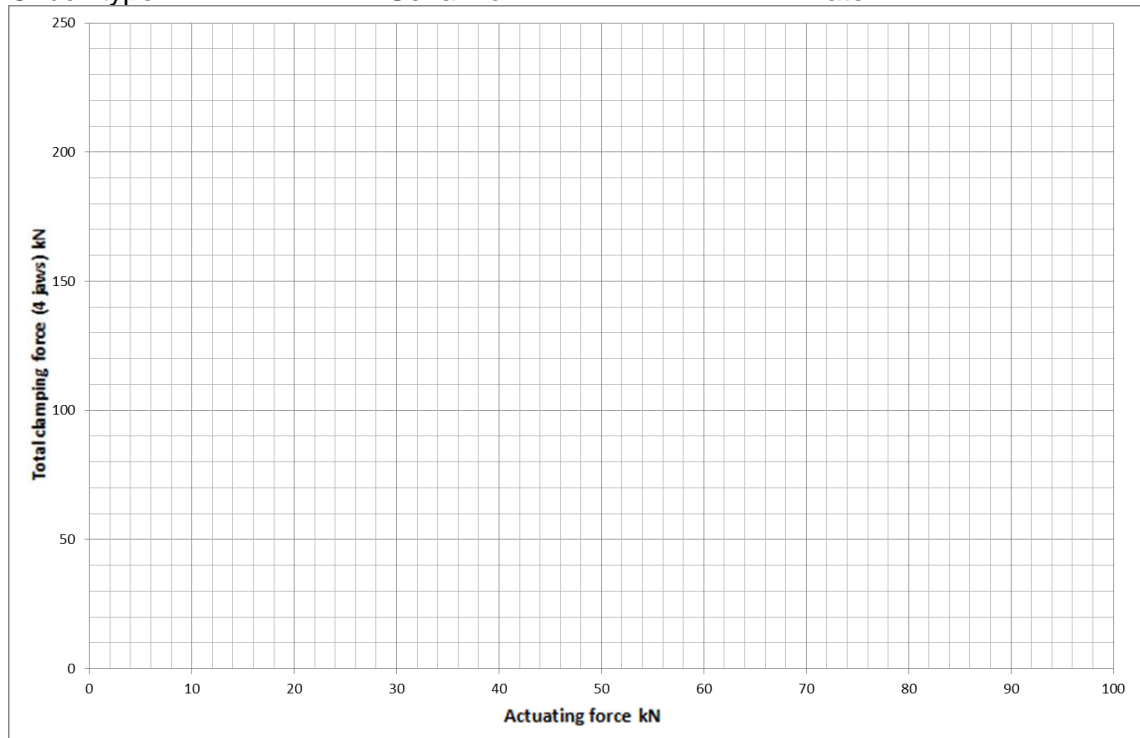
## 9 NOTES

### 9.1 CLAMPING/ACTUATING FORCE DIAGRAM (TEMPLATES)

Chuck type:

Serial no.:

Date:



Chuck type:

Serial no.:

Date:

