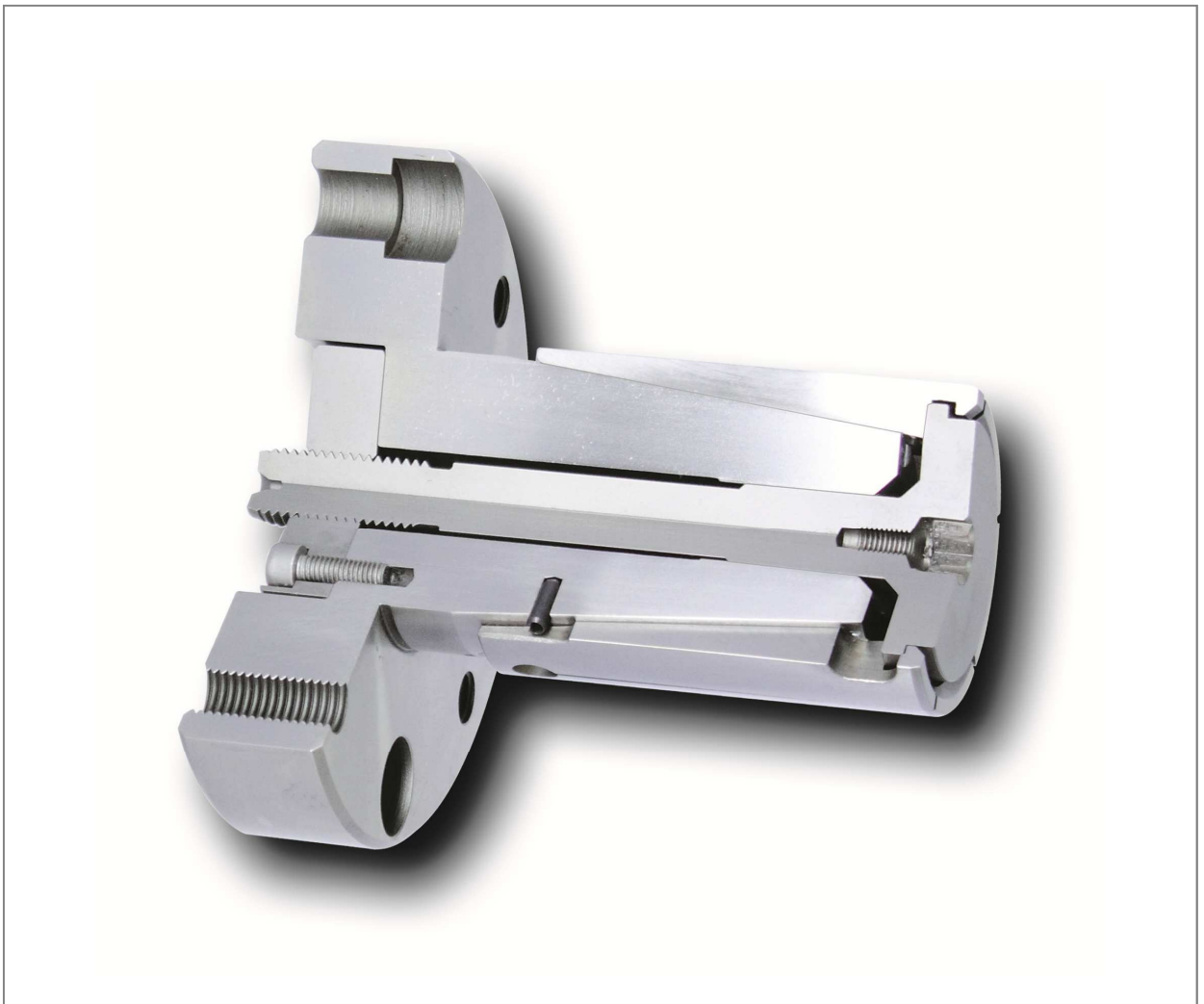


**Installation and Operating Instructions for
Taper Collet Flange Mandrels BKDF**

E 01.812e



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Important

Please read these instructions carefully before installing and operating the product. Your particular attention is drawn to the notes on safety.

These installation and operating instructions are valid on condition that the product meets the selection criteria for its proper use. Selection and design of the product is not the subject of these installation and operating instructions.

Disregarding or misinterpreting these installation and operating instructions invalidates any product liability or guarantee by RINGSPANN; the same applies if the product is taken apart or changed.

These installation and operating instructions should be kept in a safe place and should accompany the product if it is passed on to others – either on its own or as part of a machine – to make it accessible to the user.

Safety Notice

- Installation and operation of this product should only be carried out by skilled personnel.
- Repairs may only be carried out by the manufacturer or accredited RINGSPANN agents.
- If a malfunction is indicated, the product or the machine into which it is installed, should be stopped immediately and either RINGSPANN or an accredited RINGSPANN agent should be informed.
- Switch off the power supply before commencing work on electrical components.
- Rotating machine elements must be protected by the purchaser to prevent accidental contact.
- Supplies abroad are subject to the safety laws prevailing in those countries.

This is a translation of the German original version!

In case of inconsistencies between the German and English version of this installation and operating instruction, the German version shall prevail.

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1. General

1.1 General Safety Notices

The following hazard notices and warnings are used in these installation and operating instructions:



Warning!

This symbol indicates a situation where there is a risk of injury or danger for life or physical condition.



Caution!

This symbol indicates risks for the RINGSPANN product described and thus for equipment and machinery.



Note:

This symbol indicates notices, user tips and useful information.

- Only use RINGSPANN products in a technically impeccable condition.
- Consider all notices written on the product.
- Comply with the intended use.
- Before commissioning, ascertain and document that the machine the RINGSPANN product is to be built into is compliant with the country-specific regulations, rules of safety and standards.
- Perform a risk analysis for all parts and equipment of the machine with which safe operation of the RINGSPANN products is associated.

1.2 Product-related Safety Notices



Warning!

In the case of design modifications to the workpiece in the area of the clamping point, the clamping fixture must be checked to ensure it is suitable.

Such changes include:

- Changes to the workpiece diameter at the clamping point
- Changes to the workpiece tolerances at the clamping diameter
- Changes to the clamping length at the workpiece



Warning!

Do not let the fixture rotate without component or inspection ring!

Without clamped component or inspection ring there is a danger for life or physical condition.

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1.3 Further Applicable Documents

Catalogue 10 with further technical notices in the appendix

VDI 2230 Systematic calculation of highly stressed screw connections
Cylindrical screw connections
You can also find an excerpt of VDI 2230 in the appendix of catalogue 10

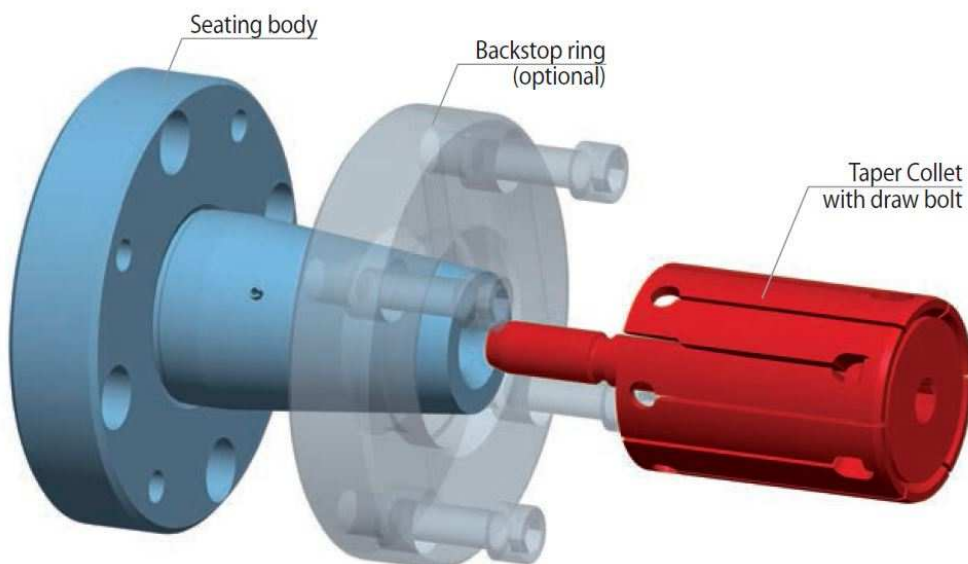


Note:

You will find the current versions of RINGSPANN data sheets and RINGSPANN catalogues at www.ringspann.com

2. Design And Function

2.1 Design

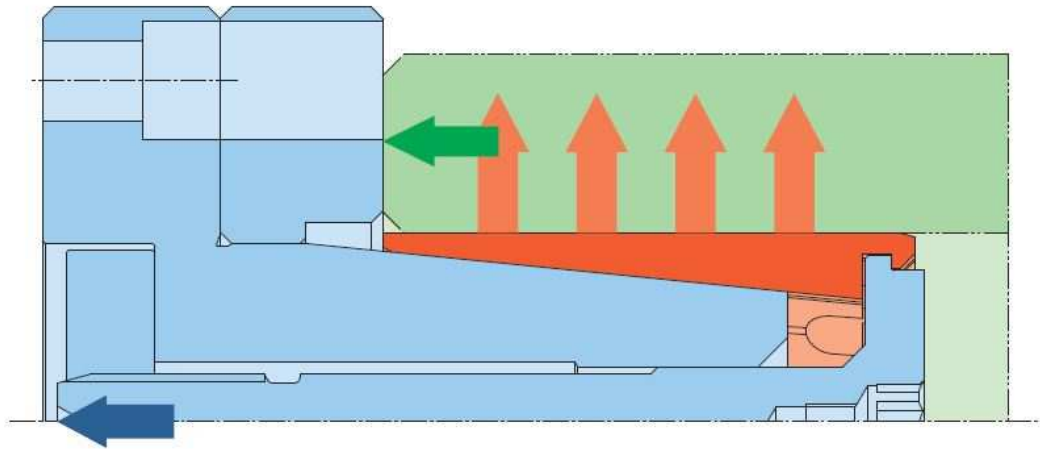


The Taper Collet Flange Mandrel consists of a seating body and a taper collet with draw bolt. Taper collets with hexagon head (series BAD) or pre-centring (series BVD), A sub assembly screwplate for hand actuation is optionally available. A backstop ring is individually design according to the component. The backstop ring is normally manufactured by the customer.

The Taper Collet Flange Mandrel is attached to the machine with the seating body. The clamping fixture is actuated by the draw bolt which is connected to the machine power actuating unit.

In addition intermediate flanges and spring force actuators can be provided.

2.2 Clamping Principle



Key:



For clamping the taper collet is pulled against the seating body. The component is centered, pressed against the backstop and aligned flush.

The cylindrical form of the component bore in the clamping area has to be smaller than the tolerance class IT7 independent of the component bore tolerance.

3. Intended Use

The Taper Sleeve Flange Mandrel HKDF is designed for the machining or inspection of components. The component will be clamped in a premachined cylindrical bore.

4. Improper Use / Warnings



Warning!

Applications that deviate from those given in Chapter 3. **Intended use**, are not permissible.



Warning!

In the case of design modifications to the workpiece in the area of the clamping point, the clamping fixture must be checked to ensure it is suitable.

Such changes include:

- Changes to the workpiece diameter at the clamping point
- Changes to the workpiece tolerances at the clamping diameter
- Changes to the clamping length at the workpiece

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5. Technical Prerequisites For Safe Operation



Clamping takes place in a pre-processed cylindrical bore hole. The bore diameter must be within an IT7 tolerance over its entire length.

Caution!

Clamping in bore holes with a cylindricity outside an IT7 tolerance is not permissible.



Clamping takes place in a pre-processed cylindrical bore hole. The face of the workpiece is ideally processed with the same clamping as the bore diameter.

Caution!

Clamping may only take place in bore holes with an actual dimension that is within the maximum permissible diameter change ΔD ".

If the diameter change is greater than ΔD , it may be that the workpiece is not clamped and/or the necessary transmissible torque is not reached.



Caution!

When using a pneumatic or hydraulic power clamping fixture, it must be ensured that, during workpiece processing, there is always the necessary actuating pressure for the processing forces/processing moments.



Caution!

During clamping / declamping it must be ensured by practical technical methods that peak forces do not exceed the maximum actuating force.

The maximum actuating force depends on the size of the fixture. You will see the maximum actuating force in the currently valid datasheet which can be found under

www.ringspann.com

6. Condition As Delivered

The Taper Collet Flange Mandrel BKDF is delivered fully assembled and in accordance with the ordered size, the specified bore diameter at the workpiece.

If an "Assembly Group For Hand Clamping" is ordered, it will be delivered as a separate order item.

A backstop ring and its fastening screws as well as an adapter for the power clamping device are usually provided by the customer.

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7. Installation And Commissioning

7.1 Mounting of Screw Plate For Hand Actuation

- Remove the taper collet with draw bolt from the seating body.
- Assemble the screw plate on the flange side of the seating body.
- Fix the screw plate with the shipped screws and tighten them with a pre-setted torque wrench.



Note:

Select screw torques according to VDI 2230 for minimum screw quality 8.8. An excerpt from VDI 2230 can be found in the appendix of catalogue 10.

7.2 Mounting of Backstop Ring

Put on the backstop ring (usually provided by the customer) and fasten it with screws (not included in delivery).



Note:

Select screw torques according to VDI 2230 for minimum screw quality 8.8. An excerpt from VDI 2230 can be found in the appendix of catalogue 10.

7.3 Installation In The Machine / Pallet etc.

Clean interfaces at machine spindle or adapter flange and the clamping fixture thoroughly. All centring diameters and all surfaces that are in contact with one another must be free of adhesions and be even.

Set the axial position of the power clamping unit in such a way that the taper collet can be relaxed completely. An adapter is usually required between the power clamping unit and clamping fixture. The draw bolt must be screwed in the adaptor until the bottom of the thread and tighten.

7.4 Commissioning



Caution!

The actuating force of the power actuating unit must be set before the clamping actuation with or without component. The actuating force must not exceed the maximum actuating force related to the size of the Taper Collet Flange Mandrel BKDF.

Maximum true running accuracy is reached by clamping the clamping fixture after assembly once without a workpiece with max. stroke (look to the data sheet in catalogue 10) and then three times with a component before being relaxed again. Machining of the workpieces and/or inspection can then be commenced.

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8 Maintenance And Repair

8.1 General Notices

The operating and ambient conditions for RINGSPANN clamping fixtures and clamping elements are different for each application. With its geometry, hardness, surface quality and kind of feed, the work-piece itself exerts influences on the clamping fixture. RINGSPANN can therefore not make any indications as to the wear properties of the clamping fixture and can only give general notices on maintenance.

The maintenance and cleaning of the clamping fixture should be carried out when the machine is maintained at the latest. More frequent maintenance intervals may be necessary depending on what is observed during operation and upon regular visual inspection (at the start of a shift for example).

In the case the clamping element is rubberised.

The rubber is elastic but takes the new shape with the duration of the deflection (stressrelaxation).

This might lead into a non full movement back to the original shape. The guide in clearance will be reduced and the removal or the load in of the component might be hindered.

The stressrelaxation of the rubberisation is no engineering defect.

8.2 Exchanging of The Clamping Element



Caution!

Put the power clamping device in the machine spindle into relaxed position. Ensure that the power clamping fixture cannot be moved during the disassembly/assembly of the clamping fixture.

Switch off machine tool.

- Untighten the draw bolt.
- Remove the draw bolt together with the taper collet.

Check all components for damage and wear. Exchange defective components.

Assembly is carried out in reverse order. Screw tightening torque in accordance with VDI2230.



Thoroughly clean and lightly oil all components before assembly.

Caution!

No lubricants with friction-reducing additives may be used on the clamping elements and the components in contact with these.

The angular position of the taper collet is determined by a pin (size BKDF 12 and bigger) or a sheet (sizes BKDF 6 and 7) in the seating body. This anti-rotational device is for positioning of the taper collet only. It is not meant for transmitting torques.

In the taper collet is one slot made wider. At the sizes BKDF6 and 7 the sheet fits into a free selectable slot.

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8.3 List of Wearing Parts And Spare Parts

The taper collet with the draw bolt is a wearing part.

The operating and ambient conditions for RINGSPANN clamping fixtures and clamping elements are different for each application. With its geometry, hardness, surface quality and kind of feed, the work-piece itself exerts influences on the clamping fixture or clamping element. RINGSPANN can therefore not make any indications as to the wear properties of the clamping fixture or clamping element and can only give general notices on maintenance. This means that no recommendation can be made as to the number of clamping cycles after which the taper collet with the draw bolt needs exchanging.

All spare parts (components) are specified in the catalogue 10. They are available individually or as part of a sub assembly.

9. Storage

If the clamping fixture is to remain on the machine, it is to be put into released position.

If put into storage, the clamping fixture is to be lightly oiled with an anti-corrosive oil (not wax) wrapped in anti-corrosive paper and kept in a sturdy box.

The corrosion protection is to be renewed every 6 months.

10. Technical Data

The technical data is dependent on the size. See the data sheet in catalogue 10 – Precision Clamping Fixtures for this.



Note:

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