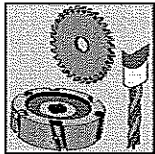


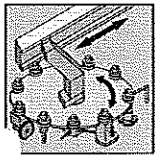
Preventive maintenance schedule



5.1.6

Main spindle
WBZ

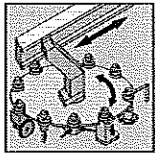
8-483-51-6020



5.5.4

12-part tool holder

8-483-55-4020



5.5.4

12-Part tool holder

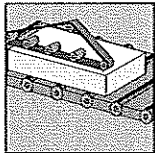
9-083-55-4130



5.5.5

Cooling Unit
For Tool Changing Spindle

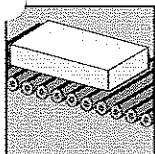
8-483-55-5010



6.1.3

Conveyor belt

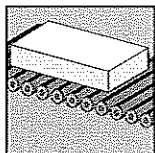
8-483-61-3010



6.1.7

Infeed roller table

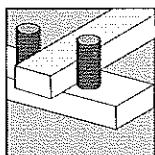
8-483-61-7060



6.1.7

Outfeed roller table

8-483-61-7070

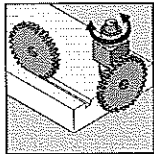
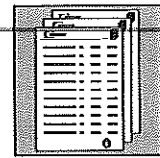


6.2.3

Clamp
WBZ

8-483-62-3090

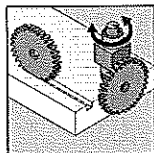




6.3.4

Heavy duty sawing unit

8-483-64-1050



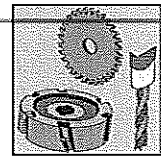
6.4.2

Fixed sawing unit
with automatically adjustable A-axis

8-483-64-2070







Main spindle

WBZ

5.1.6

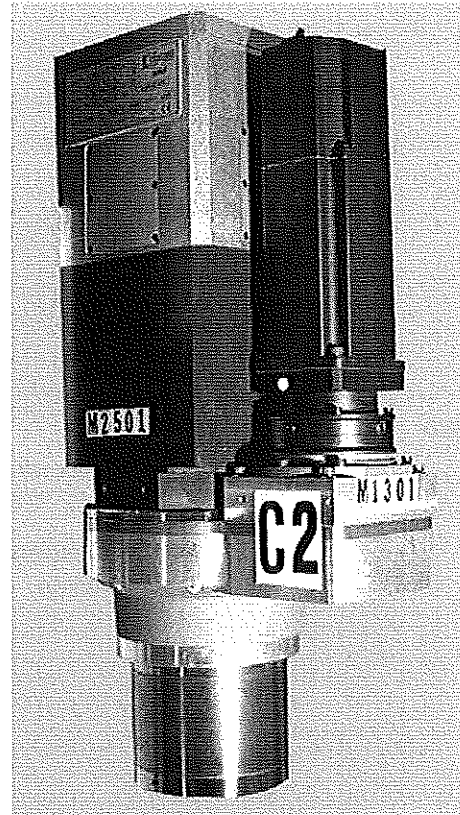
LANARK HOMES LT

PROFI WBZ150/12

0-390-01-0049

The main spindle serves as tool holding fixture. In combination with the C axis slewing-motion actuator it is used as a driving unit for machining units that rotate around the Z axis.

Features	Values			
Power max. (according to main spindle rating plate)	7,5	14,5	12	21 kW
	[S6]			
Infinitely variable speed	0 - 18000	750 - 18000	0 - 30000	rpm
Tool clamber	11000 N			
Voltage max.	380 520 V			
Direction of rotation	Right and left			
Cooling of motor and bearings	Water cooling system			
Front sealing	Labyrinth sealing			
Filter grade	8 µm			
Coolant temperature	15...45 °C			

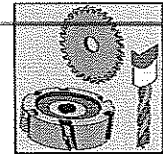


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Contents:

1	Service	2
1.1	Inspection	3
1.2	Cleaning clamping set	4
1.3	Visual control clamping set and HSK contact surface	10





1 Service



Inspection	A	1.1
Clean clamping set	B	1.2
Visual control	C	1.3
	D	
	E	
	F	
	G	
	H	
	I	
	J	

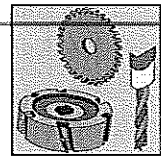


Note:

- The indications regarding service refer to 1-shift operation (8 hours)!
- Service work must be carried out only by trained personnel and/or skilled electricians!

20__		Responsible:	20__		Responsible:
		Name Date			Name Date
1	C		27	C	
2	C		28	C	
3	C		29	C	
4	C		30	C	
5	C		31	C	
6	C		32	C	
7	C		33	C	
8	C		34	C	
9	C		35	C	
10	C		36	C	
11	C		37	C	
12	C		38	C	
13	BC		39	BC	
14	C		40	C	
15	C		41	C	
16	C		42	C	
17	C		43	C	
18	C		44	C	
19	C		45	C	
20	C		46	C	
21	C		47	C	
22	C		48	C	
23	C		49	C	
24	C		50	C	
25	C		51	C	
26	ABC		52	ABC	





1.1 Inspection

The machine must be inspected by a WEINMANN technician. This implies, for example, checking the clamping force of the plate spring assembly.

If it is lower than 10 kN, the plate spring assembly must be replaced by the manufacturer.

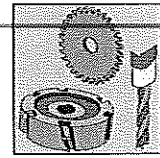
For this reason the complete spindle in the machine must be replaced.



Danger:

The replacement of the complete spindle must only be executed by a WEINMANN service team or by authorized and trained personell





1.2 Cleaning clamping set

Each time a tool/unit is changed, wood dust gets into the clamping set, which may result in gumming and influence the clamping force.



Danger:

Have the following work only carried out by WEINMANN service or persons who have been accordingly instructed by WEINMANN service personnel.

- Open the protective door
- Set key-operated switch on the control panel or on the tool changer to tool changer
- Release the spindle tension (button on the tool changer)



Note:

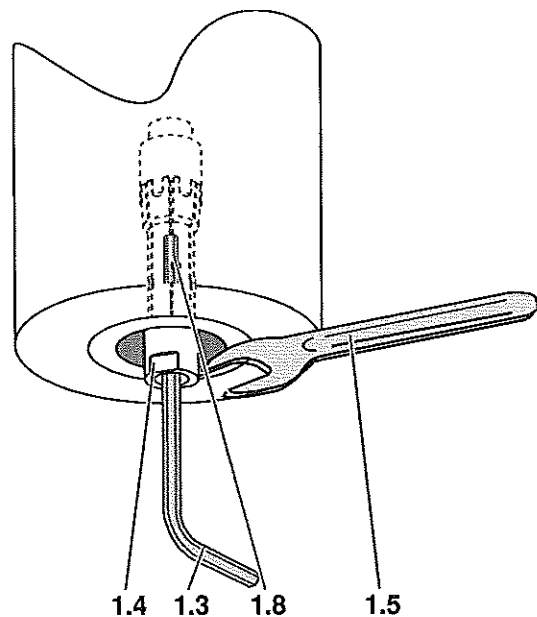
The spindle tension must always be released during this procedure.

- Secure clamping cone 1.4 to prevent twisting by means of fork wrench 1.5 (SW18).
- Loosen locking screw 1.8 by means of Allen key 1.3 (SW4)
- Loosen clamping cone 1.4 at the flat by means of fork wrench 1.5 (SW18)



Note:

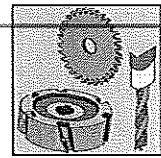
The clamping cone is secured with Loctite: Warm up with hot air fan, if necessary.



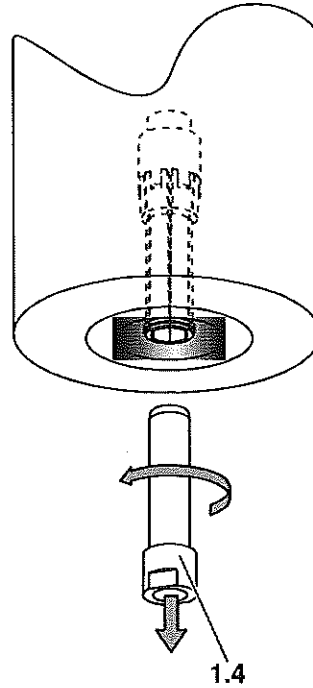
T:\B483\516010\lx00106d.WMF

1.3	Allen key (SW4)
1.4	Clamping cone
1.5	Fork wrench (SW18)
1.8	Locking screw





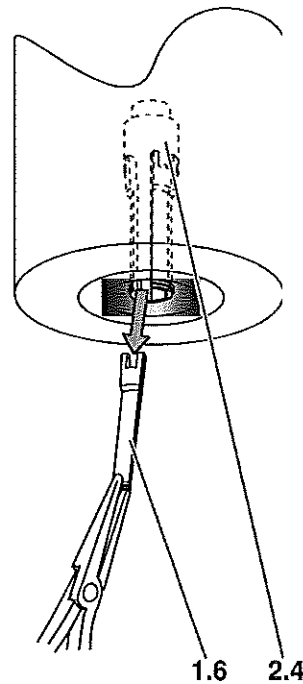
- Unscrew clamping cone 1.4



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1.4 Clamping cone

- Remove all 6 clamping elements 1.6 successively using pointed pliers of the clamp. Remove holding-down device 2.4
- Clean the clamping elements with a clean and soft cloth.

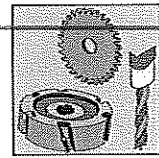


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1.6 Clamping elements

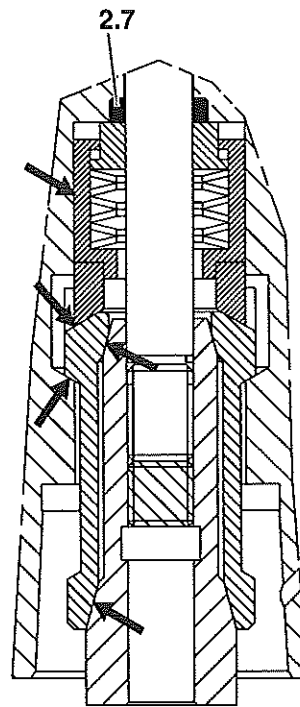
2.4 Holding-down device





- Check O-ring 2.7. (The O-ring must be installed, otherwise the lubricant is blown out)

- Grease the clamping elements and the holding-down device slightly with HOMAG special lubricant no. 4-017-02-0043 at the points marked with an arrow

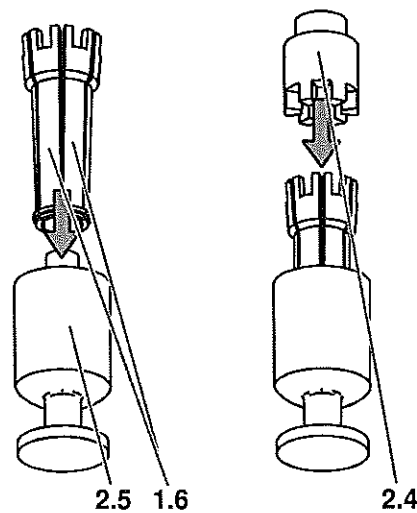


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2.7 O-ring

Assembly

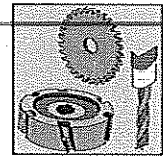
- Insert the 6 clamping elements 1.6 into the mounting holder 2.5
- Place the holding-down device 2.4 on top



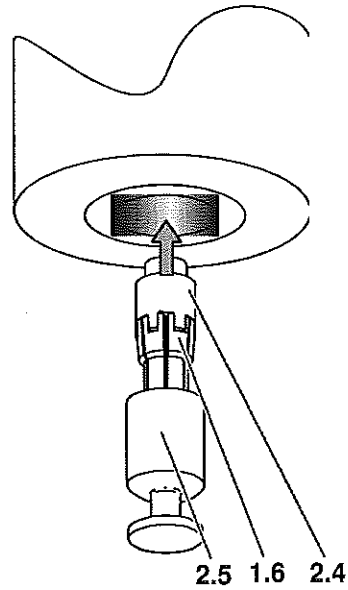
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1.6 Clamping elements
2.4 Holding-down device
2.5 Mounting holder



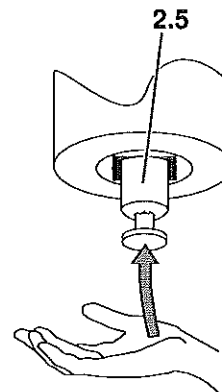


- Press the clamping elements 1.6 located in the mounting holder 2.5 together and insert them together with the holding-down device 2.4 into the spindle

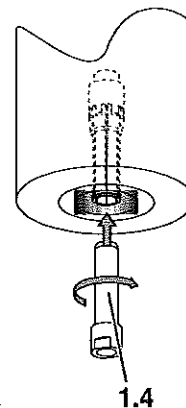


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- Lock the clamping elements into place by knocking slightly on the mounting holder 2.5



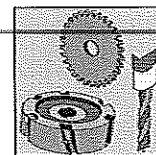
- Remove mounting holder 2.5
- Screw in clamping cone 1.4



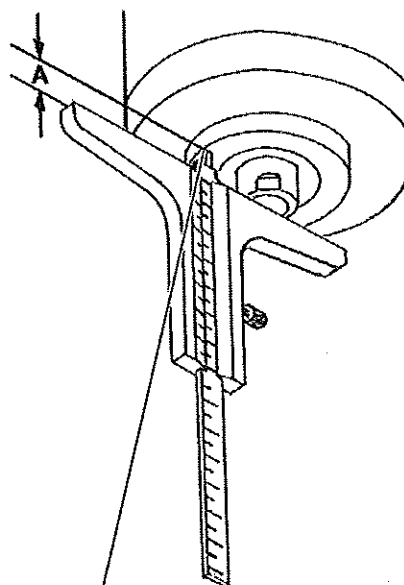
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1.4	Clamping cone
1.6	Clamping elements
2.4	Holding-down device
2.5	Mounting holder





- Check ejection dimension **A** with depth value **1.10** - it must be $10,5^{+0,1}$ mm
- Unscrew and clean locking screw **1.8** and moisten it with Loctite 221. Integrate locking screw **1.8** in the clamping cone **1.4**
- Adjust ejection dimension **A** by screwing the clamping cone **1.4** in or out
- Tighten the locking screw **1.8** with Allen key **1.3** (SW4) against the draw bar **1.7** (secure the clamping cone **1.4** to prevent twisting by means of fork wrench **1.5**)

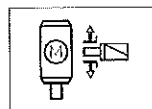


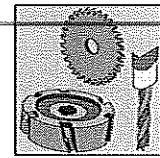
1.10

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1.10 Depth value

- Clamp the spindle again (button on the tool changer)





Main spindle

WBZ

LANARK HOMES LT

PROFI WBZ150/12

0-390-01-0049

5.1.6

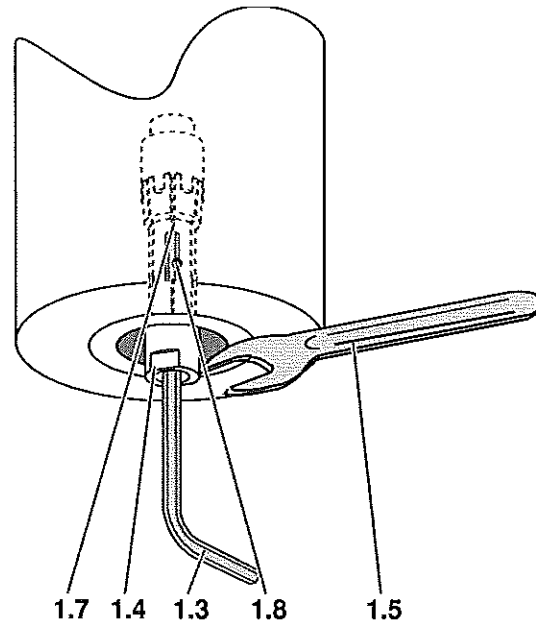
Functional check

- Clamp and release the spindle tension about 100x (button on the tool changer)
- Check if the clamping cone 1.4 is tightened firmly
- Check ejection dimension A again and readjust it, if necessary



Caution:

- Check if the clamping cone 1.4 is tightened firmly by means of fork wrench 1.5 (SW18) and Allen key 1.3 (SW4).
- Observe the setting time of Loctite before commissioning the spindle!

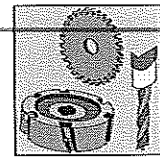


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1.3	Allen key (SW4)
1.4	Clamping cone
1.5	Fork wrench (SW18)
1.7	Draw bar
1.8	Locking screw

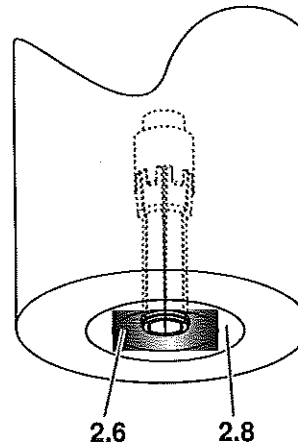
- Set key-operated switch on the control panel or on the tool changer to zero position again





1.3 Visual control clamping set and HSK contact surface

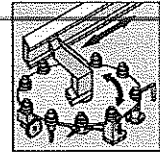
- Check the clamping set **2.6** visually for soiling and damage
- Clean the clamping set in case of soiling (see chapter Clean clamping set).
- Renew the clamping set in case of damage. (See chapter Clean clamping set for information on removal and installation).
- Check HSK contact surface **2.8** as regards damage



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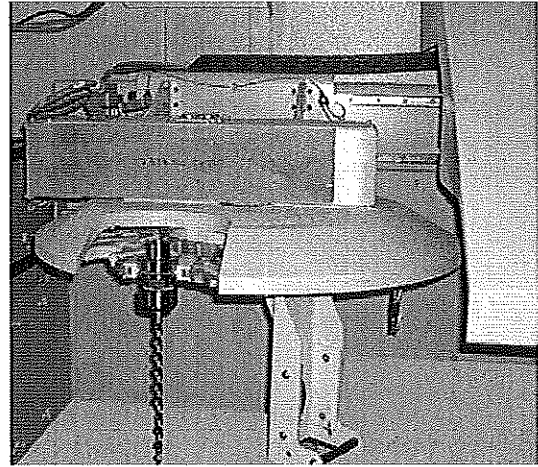
2.6	Clamping set
2.8	HSK contact surface





In the 12-part tool holder, tools and units are made available for automatic changing in the main spindle.

Features	Values
Tool chuck	HSK-F63
Unit chuck	HOMAG interface 9-002-04-3360
Number of slots	12
Pitch circle Ø	540 mm
Total weight of tool load max.	60 kg
Weight per tool / Unit max.	10 kg
Tool / unit Ø max.	300 mm
Tool/unit height (from HSK) max.	320 mm

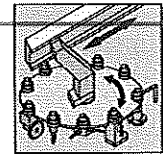


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Contents:

1	Maintenance work	2
1.1	Cleaning tool chuck	3
1.2	Checking the tool chuck.....	3
1.3	Replacing the tool chuck.....	3





1 Maintenance work





Check tool chuck	A	1.2
	B	
	C	
	D	
	E	
	F	
	G	
	H	
	I	
	J	



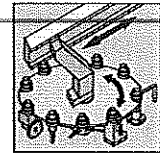
Note:

- All maintenance information is based on a 1-shift operation (8 hours).
- Routine maintenance may only be performed by professionally trained personnel and/or professional electricians.

20__		Completed by:
		Name Date
1		
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6		
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9		
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11		
12		
13	A	
14		
15		
16		
17		
18		
19		
20		
21		
22		
23		
24		
25		
26	A	

20__		Completed by:
		Name Date
27		
28		
29		
30		
31		
32		
33		
34		
35		
36		
37		
38		
39	A	
40		
41		
42		
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44		
45		
46		
47		
48		
49		
50		
51		
52	A	





1.1 Cleaning tool chuck

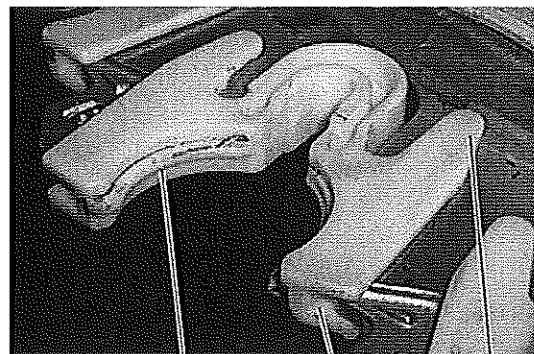
When replacing a unit/tool by hand ensure that the recessed grip on the tool chuck and the groove in the HSK chuck on the tool are both free of oil and grease.

⇒ Oil and grease contamination in the recessed grip impairs the gripping force of the tool chuck!

1.2 Checking the tool chuck

- Check chuck jaws **1.1** for wear
- Replace worn tool chucks

Otherwise there is a risk that the tool cannot be properly inserted into or removed from the tool holder.



1.1

1.2

1.3

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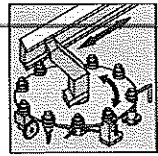
1.1	Chuck jaws
1.2	Tool chuck
1.3	Strap

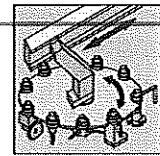
1.3 Replacing the tool chuck

Tool chucks **1.2** must be completely replaced if they become worn early or if their gripping force is significantly reduced, and in any case at least every 2 years.

- Removal force on the HSK chuck:
At least 50 N
- Measuring equipment: Spring balance
- Lift clip **1.3** with a screwdriver and pull the tool chuck out towards the front
- Slide in a new tool chuck until the clip engages

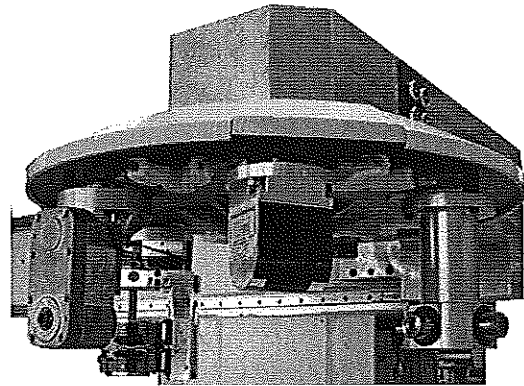






In the 12-part tool holder, tools and units are made available for automatic changing in the main spindle.

Features	Values
Tool chuck	HSK-F63
Unit chuck	HOMAG interface 9-002-04-3360
Number of slots	12
Pitch circle Ø	540 mm
Total weight of tool load	
max.	60 kg
Weight per tool / unit	
max.	10 kg
Tool / unit Ø	
max.	300 mm
Tool/unit height (from HSK)	
max.	320 mm

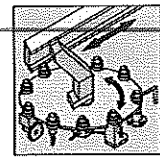


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Contents:

1	Routine maintenance	2
1.1	Lubricating the guide rails.....	3
1.2	Cleaning the tool chuck	3
1.3	Check the tool chuck	4
1.4	Replacing the tool chuck.....	4





1 Routine maintenance

Lubricating the guide rails	A	1.1
Check the tool chuck	B	1.2
	C	
	D	
	E	
	F	
	G	
	H	
	I	
	J	



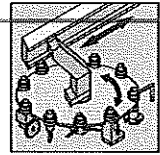
Note:

- All maintenance information is based on 1-shift operation (8 hours)!
- Routine maintenance may only be performed by professionally trained personnel and/or professional electricians!

20__		Completed by:
		Name Date
1		
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16		
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22		
23		
24		
25		
26	AB	

20__		Completed by:
		Name Date
27		
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38		
39	B	
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52	AB	





1.1 Lubricating the guide rails

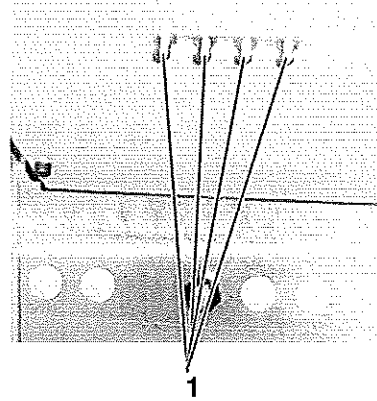


Note:

Only necessary for drive up tool holders!

Lubricate guide rails on the lubrication nipples 1.

Lubricant	Grease DIN 51825 HOMAG-No. 4-017-02-0035
Lubrication quantity	5 g per lubrication nipple
Hand-lever grease gun	4-014-07-0042 + 4-014-07-0043



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1 Lubrication nipple



Note:

Clean lubrication nipple 1 thoroughly before lubricating.

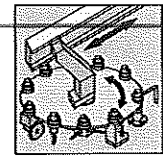
No dirt is allowed to enter the nipple opening!

1.2 Cleaning the tool chuck

When changing a unit / tool manually, make sure that the recessed grip of the tool chuck as well as the groove in the tool's HSK chuck are free of oil and grease.

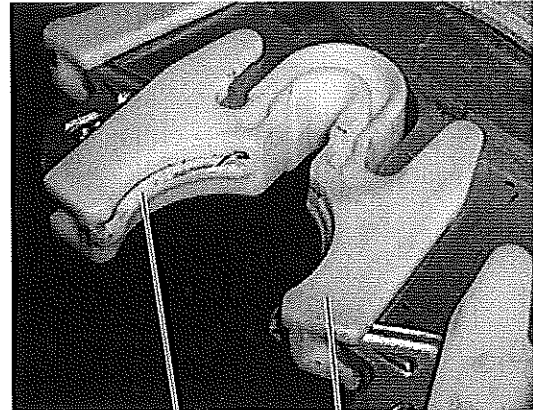
⇒ Oil and grease on the recessed grip lowers the retaining force of the tool chuck.





1.3 Check the tool chuck

- Check the mounting crosspieces **2** for wear
 - Replace the worn tool chucks
- Otherwise, there is the danger that the tool cannot be properly stored in or removed from the tool holder.



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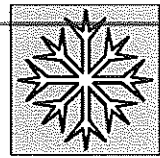
2	Mounting crosspiece
3	Tool chuck

1.4 Replacing the tool chuck

The tool chucks **3** must be completely replaced if they are prematurely worn, or if their tension force has been significantly reduced, but at the latest, they must be completely replaced every 2 years.

- Extraction force on the HSK chuck : at least 50 N
- Measuring equipment: Spring scale





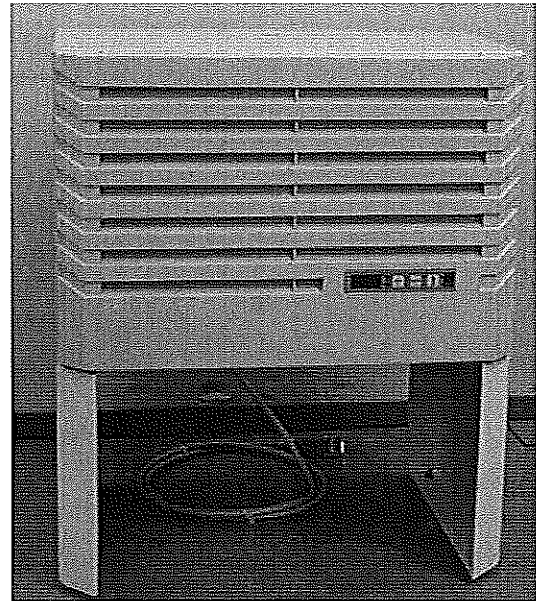
Cooling Unit
For Tool Changing Spindle

5.5.5

LANARK HOMES LT PROFI WBZ150/12 0-390-01-0049

The cooling unit is an air-cooled water cooler.

Features	Values
Nominal voltage	230 Volt
Line frequency	50 / 60 Hz
Coolant volume	2 l
Pump capacity	3 litres/min
Cooling liquid	75 % Water 25% Ethylene glycol
Ambient temperature	min. 10 °C max. 40 °C
Weight	46 kg

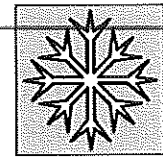


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Contents:

1	Maintenance work	2
1.1	Clean the cooling fins	3
1.2	Change the coolant.....	3
1.3	Check coolant level	4





1 Maintenance work

Clean the cooling fins	A	1.1
Change the coolant	B	1.2
Check coolant level	C	1.3
	D	
	E	
	F	
	G	
	H	
	I	
	J	

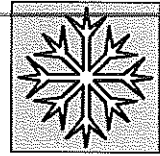


Note:

- All maintenance data refers to 1 shift operation (8 h)
- Maintenance work must only be carried out by suitably qualified personnel and/or electricians!

20__		Completed by:	20__		Completed by:
		Name Date			Name Date
1			27	AC	
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13			39	AC	
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15	AC		41		
16			42	AC	
17			43		
18	AC		44		
19			45	AC	
20			46		
21	AC		47		
22			48	AC	
23			49		
24	AC		50		
25			51	AC	
26			52	B	





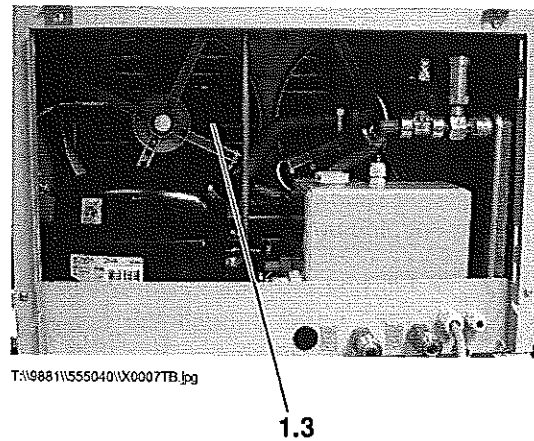
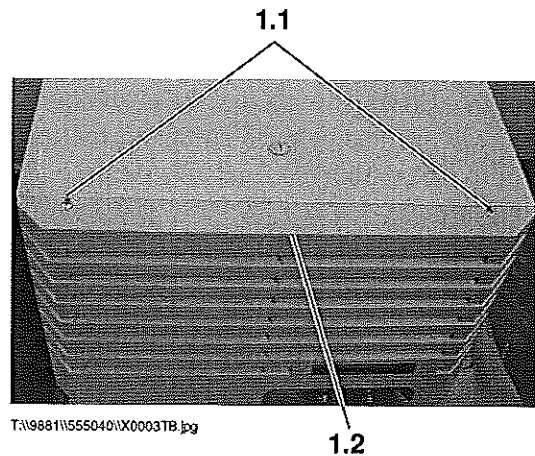
1.1 Clean the cooling fins

Clean the cooling fins every 100 hours. For this purpose switch off the unit and unplug from the electricity supply.

- By unscrewing the bolts **1.1** open the trim **1.2** on the unit
- Remove the trim **1.2**
- Using a compressed air gun, clean the entire fin area **1.3** from the inside out by moving the gun back and forward
- After cleaning securely refit the protective cap **1.3**
- Then refit the trim **1.2**

**Note:**

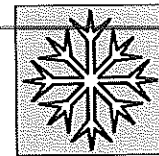
The cleaning intervals are to be adapted to the environment (dust production).



1.2 Change the coolant

The refrigerant is to be replaced every year.




Cooling Unit

For Tool Changing Spindle

LANARK HOMES LT

PROF1 WBZ150/12

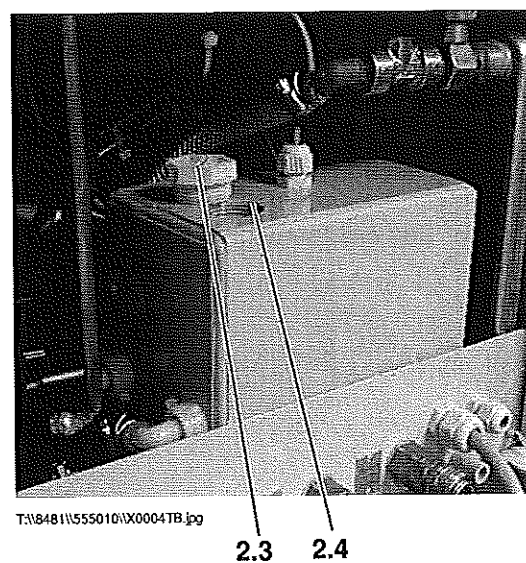
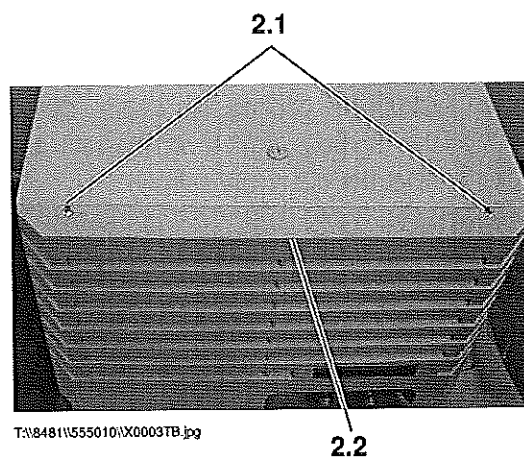
0-390-01-0049

5.5.5

1.3 Check coolant level

Check the coolant level every 100 hours. For this purpose switch off the unit and unplug from the electricity supply.

- By unscrewing the bolts **2.1** open the trim **2.2** on the unit
- Remove the trim **2.2**
- Open protective cap **2.3**
- Visually check the level through the opening **2.4**
- If necessary top up with coolant
- Securely refit the protective cap **2.3**
- Then refit the trim **2.2**



Topping up coolant

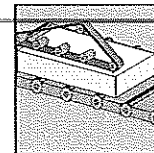
- Fill one 0.5 l can of ethylene glycol and 1.5 l water through the opening **2.4** (in total 2 l coolant)
- After filling, re-fit housing

Coolant:	Weinmann
	part number:
Ethylene glycol, 0.5 l	2-001-95-1140

Caution:

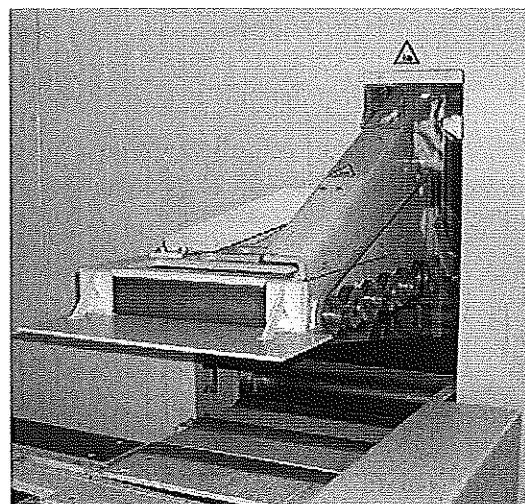
- Do not run the unit dry or without anti-freeze!
- Do not overfill the tank!
- If a pumping action is not produced, switch off unit immediately and check for faults!





The conveyor belt transports the workpiece out of the unit

Features	Values
Power	0,37 kW
Stroke	230 mm
Pressing force max.	1800 N
Transport speed	30 m/min
Pressure set at factory	2 bar

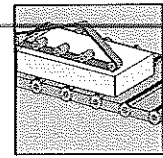


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Contents:

1	Maintenance work	2
1.1	Checking the belt.....	3

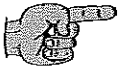




1 Maintenance work



Checking the belt	A	1.1
	B	
	C	
	D	
	E	
	F	
	G	
	H	
	I	
	J	



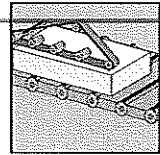
Note:

- All maintenance information is based on a 1-shift operation (8 hours).
- Maintenance work may only be performed by professionally trained personnel and/or professional electricians.

20__		Completed by:
		Name Date
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12	A	
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16	A	
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19		
20	A	
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22		
23		
24	A	
25		
26		

20__		Completed by:
		Name Date
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28	A	
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32	A	
33		
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35		
36	A	
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44	A	
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48	A	
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52	A	



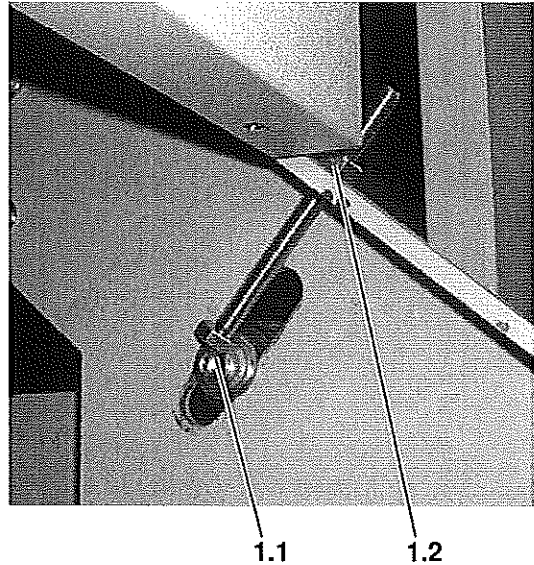


1.1 Checking the belt

- Visual inspection of the belt
- ⇒ If damage is noted, replace the belt

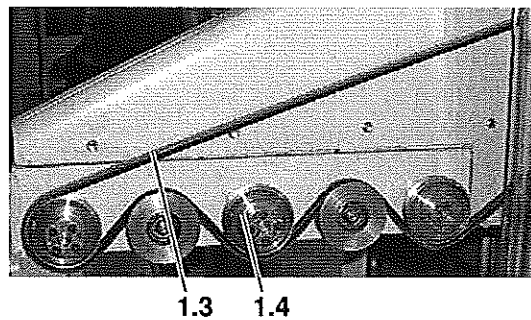
Replacing the belt

- Turn back clamping screw **1.2**
- Loosen screw **1.1**



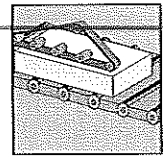
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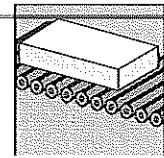
- Remove belt **1.3**
- Examine belt wheels **1.4** for damage and ensure free running
- Mount new belt
- Secure belt with clamping screw **1.2**
- Tighten screw **1.1**



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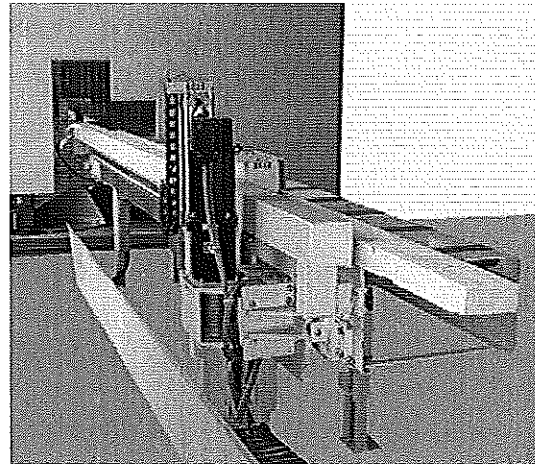






The infeed roller table feeds the workpiece into the processing center automatically.

Features	Values
Feed speed	120 m/min
Clamping force approx.	3000 N

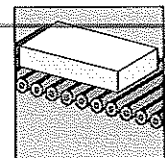


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Contents:

1	Maintenance work	2
1.1	Lubricating the wheel nozzle guide	3
1.2	Inspect toothed belt	5





1 Maintenance work



Lubricating the wheel nozzle guide	A	1.1
Inspect toothed belt	B	1.2
	C	
	D	
	E	
	F	
	G	
	H	
	I	
	J	

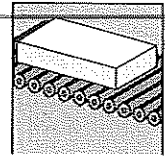


Note:

- All maintenance information is based on a 1-shift operation (8 hours).
- Routine maintenance may only be performed by professionally trained personnel and/or professional electricians.

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		Name	Date			Name	Date
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2				28	B		
3				29			
4	B			30			
5				31			
6				32	B		
7				33			
8	B			34			
9				35			
10				36	AB		
11				37			
12	AB			38			
13				39			
14				40	B		
15				41			
16	B			42			
17				43			
18				44	B		
19				45			
20	B			46			
21				47			
22				48	AB		
23				49			
24	AB			50			
25				51			
26				52	B		





1.1 Lubricating the wheel nozzle guide

**Note:**

All lubrication points are indicated with a **RED DOT**

- Place hand lever grease gun on lubricating nipple
- Squeeze in the required amount

**Note:**

Pack with grease only while the wheel nozzle guide is moving!

- ⇒ This will distribute the grease between the ball bearings more evenly
- Add more lubricant until grease escapes from the end and side seals
- Wipe away any escaping grease with a soft, clean cloth.

**Note:**

Do not use solvent of any kind!

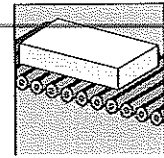
- Minimum lubricant quantity:
2.5 g = 1 stroke with the hand lever grease gun

Lubricant	Grease DIN 51825 HOMAG No. 4-017-02-0035
Hand-lever grease gun	4-014-07-0042 + 4-014-07-0043

**Caution:**

Dry end seals on the wheel nozzle guide and/or dry guide rail tracks are indications of insufficient lubrication. Apply more lubricant without fail or lubricate more frequently.



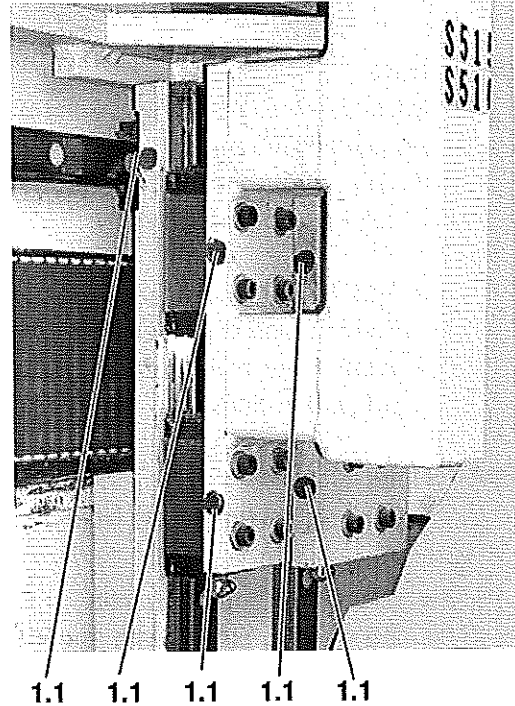


Note:

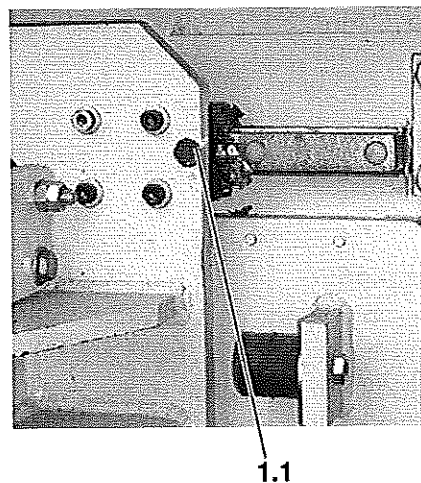
- Clean all lubrication nipples thoroughly before greasing. No dirt is allowed to enter the nipple opening.

Lubricating points are located

6 lubricating points on the gripper unit

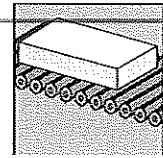


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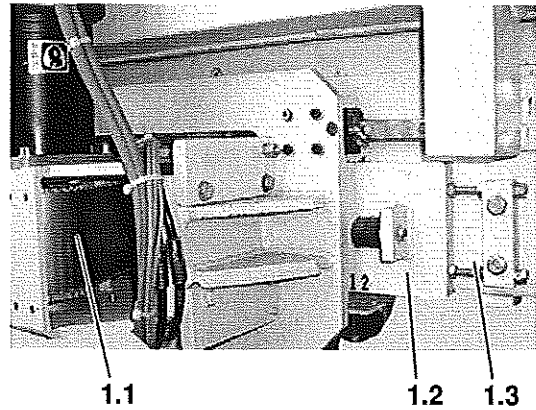
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1.2 Inspect toothed belt

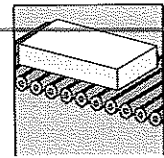
- Inspect toothed belt **1.1** every month for cracks
- Check belt tensioner **1.2** at the same time
- Ensure that clamping screws **1.3** are seated securely
- Defective toothed belts should only be  replaced by **SERVICE**

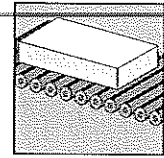


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1.1	Toothed belt
1.2	Belt tensioner
1.3	Clamping screws

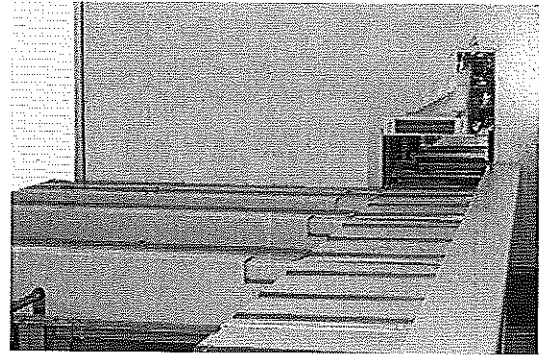






The beam is automatically transported out and to one side with the outfeed roller table.

Features	Values
P=	0.75 kW
Stroke	600 mm
Lateral ejection speed	0 ≈ 3.0 m/min

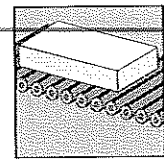


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Contents:

1	Maintenance work	2
1.1	Tighten chain:	3





1 Maintenance work



Tighten chain	A	1.1
	B	
	C	
	D	
	E	
	F	
	G	
	H	
	I	
	J	



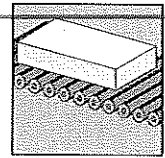
Note:

- All maintenance information is based on a 1-shift operation (8 hours).
- Routine maintenance may only be performed by professionally trained personnel and/or professional electricians.

20__		Completed by:
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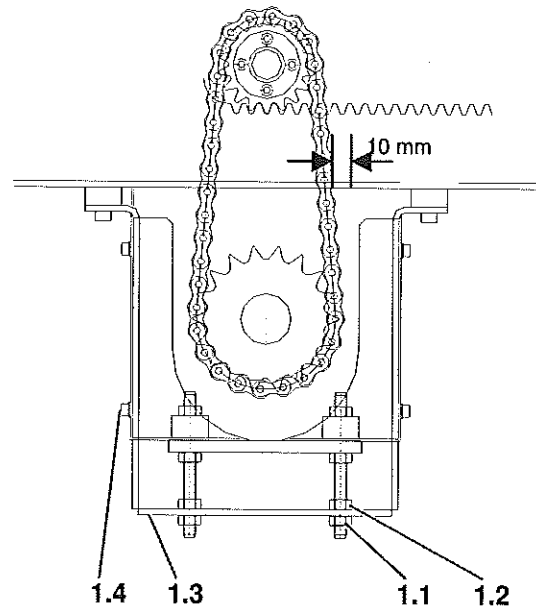
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1.1 Tighten chain:

- Remove cover hood 1.3 by loosening hex screws 1.4
- Loosen hex nut 1.1
- Adjust hex nut 1.2 so that the chain sag is approx. 10 mm. (adjust all nuts by the same amount!)
- Tighten hex nut 1.1 again.
- Mount cover hood 1.3 again



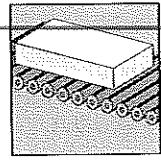
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1.1	Hex nut
1.2	Hex nut
1.3	Cover hood
1.4	Hexagon bolt





Outfeed roller table



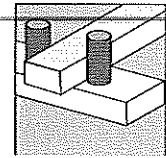
6.1.7

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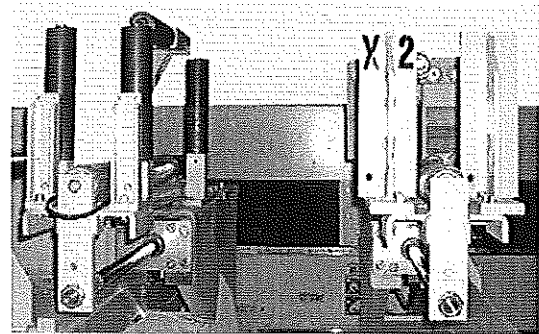
Clamp
WBZ

LANARK HOMES LT PROFI WBZ150/12 0-390-01-0049

6.2.3

The clamp is used to position and secure the workpiece precisely.

Features	Values
Vertical clamping range	200 mm
Horizontal clamping range	420 mm
Vertical clamping force	1700 N
Horizontal clamping force	2700 N
Travel route X ₂ approx.	1360 mm

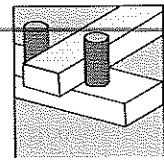


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Contents:

1	Maintenance work	2
1.1	Clean toothed rack.....	3
1.2	Clean drive unit	3





1 Maintenance work



Clean toothed rack	A	1.1
Clean drive unit	B	1.2
	C	
	D	
	E	
	F	
	G	
	H	
	I	
	J	



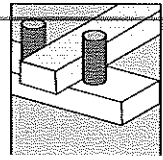
Note:

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- Routine maintenance may only be performed by professionally trained personnel and/or professional electricians.

20__		Completed by:	
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20__		Completed by:	
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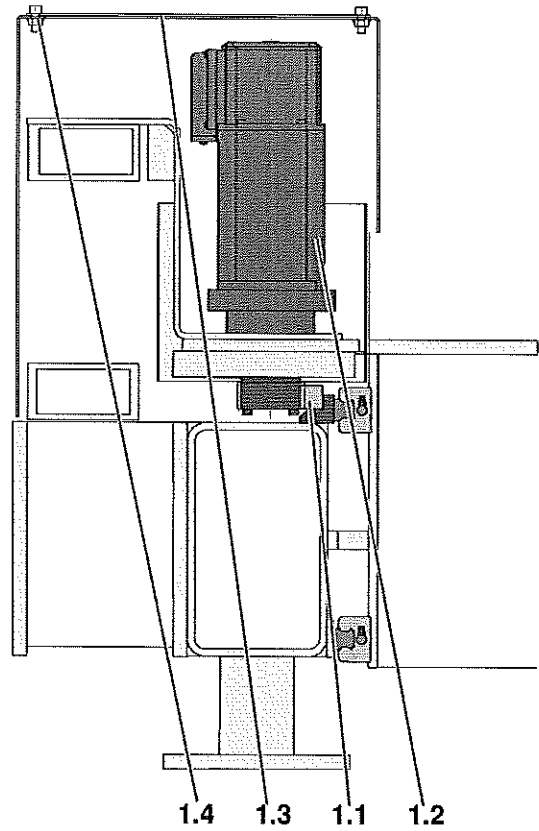


1.1 Clean toothed rack

- Remove protective cover 1.3 by loosening hex screws 1.4
- Vacuum toothed rack 1.1

1.2 Clean drive unit

- Remove protective cover 1.3 by loosening hex screws 1.4
- Vacuum drive unit 1.2



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1.1	Toothed rack
1.2	Drive unit
1.3	Protective cover
1.4	Hexagon bolt





Clamp

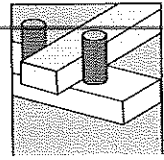
WBZ

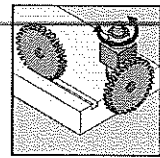
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PROFI WBZ150/12

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6.2.3

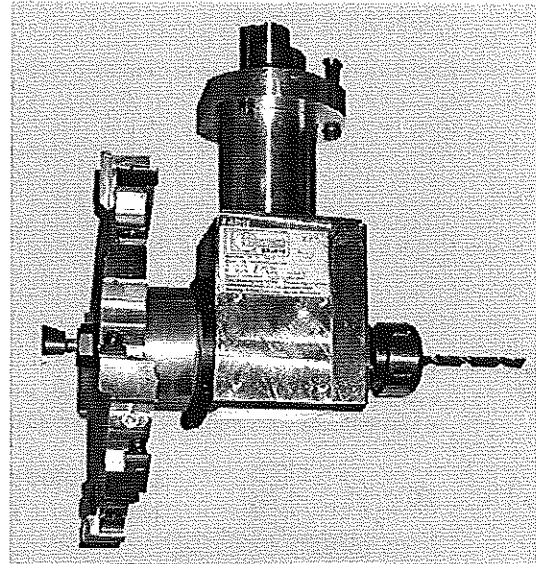




The combination unit is equipped with one tool chuck each for

- sawing or grooving and
- for drilling or trimming

Features		Values
Input speed	max.	12000 1/min
Gear ratio		1 : 3,5
Output speed	max.	3400 1/min
Direction of rotation		CW / CCW rotation
C-axis swivel range		± 360 °
Tool data		
Center drill hole		55 mm ^{H7}
Shaft tool 1		
Collet chuck		DIN 6499 ER32
Shaft dimensions		Ø 20x40 mm
Shaft tool 2		
Collet chuck		C25DIN6388
		Ortlieb system
Shaft dimensions		Ø 20x40 mm
Oil grade		SAE 80W90

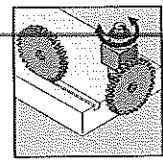


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Contents:

1	Maintenance work	2
1.1	Checking the unit.....	3
1.2	Changing the oil.....	3





1 Maintenance work



Checking the unit	A	1.1
Changing the oil	B	1.2
	C	
	D	
	E	
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	G	
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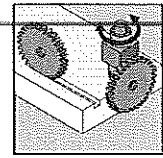


Note:

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20__		Completed by:	20__		Completed by:
		Name Date			Name Date
1			27		
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3			29		
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5			31		
6			32	AB	
7			33		
8	AB		34		
9			35		
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15			41		
16	AB		42		
17			43		
18			44		
19			45		
20			46		
21			47		
22			48	AB	
23			49		
24	AB		50		
25			51		
26			52		





1.1 Checking the unit

The angle head should be inspected at least after every 200 hours of operation. It is especially important to evaluate the amount of noise and play in the teeth.

If you have any questions → ☎ SERVICE

1.2 Changing the oil

**Danger:**

Danger of burning from hot transmission oil.

→ Risk of injury!

**Note:**

Before changing the oil, place suitable receptacles under the oil drainage hole.

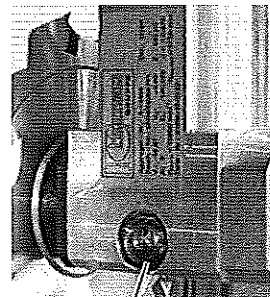
The gearbox of the sawing unit is lubricated with oil. Change the oil after 200 working hours. Document the oil change.

- Unscrew oil sight glass 1.1
- Drain oil completely
- Fill with oil through the opening left by the oil sight glass 1.1

Note:

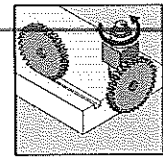
Oil grade: SAE 80W90

- Screw in and tighten oil sight glass 1.1

**1.1**

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**Note:**

The oil level in the gearbox chamber is ideal when the oil sight glass 1.1 is half covered while the spindle is vertical.

- After a test run, check the oil level again

**Danger:**

Do not allow transmission oil to remain in prolonged contact with skin. If any does come into contact with the skin, wash off thoroughly.

➔ **Danger to your health!**

**Note:**

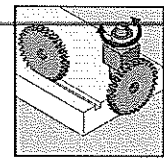
Avoid spilling transmission oil!

- Take steps to ensure that spilled oil is caught.

Disposal

Transmission oils are subject to local statutory regulations.





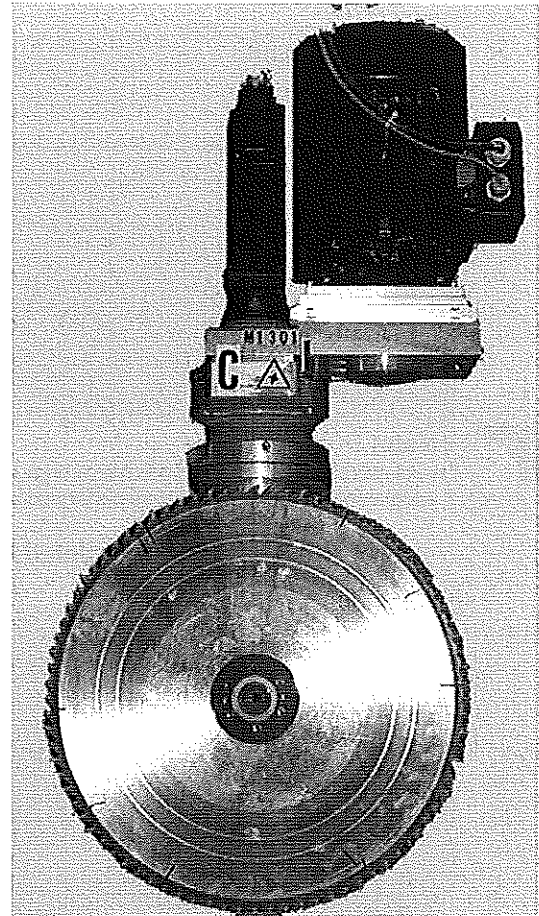
Fixed sawing unit
with automatically adjustable A-axis

LANARK HOMES LT PROFI WBZ150/12 0-390-01-0049

6.4.2

With this sawing unit, saw cuts can be made in various beam dimensions. They are used for processing construction parts and cutting construction parts to size.

Features	Values
Cutting depth max.	200 mm
Transferable power	7.5 KW
Torque max.	20 Nm
Saw blade diameter	max. 550 mm
Swivel range C-axis	90 °
Max. swivel range A axis	+ 90 to 0 °
Oil grade	SAE 80W90

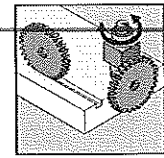


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Contents:

1	Maintenance work	2
1.1	Checking the unit.....	3
1.2	Changing the oil.....	3
1.3	Change the belt	5





1 Maintenance work



Inspect the unit	A	1.1
Change the oil	B	1.2
Change the belt	C	1.3
	D	
	E	
	F	
	G	
	H	
	I	
	J	



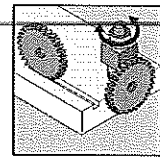
Note:

- All maintenance information is based on a 1-shift operation (8 hours).
- Maintenance work may only be performed by professionally trained personnel and/or professional electricians.

20__		Completed by:
		Name Date
1		
2		
3		
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20__		Completed by:
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32	ABC	
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40	ABC	
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43		
44		
45		
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47		
48	ABC	
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50		
51		
52		





1.1 Checking the unit

The angle head should be inspected at least after every 500 hours of operation. It is especially important to evaluate the amount of chatter and play in the teeth.

If you have any questions → SERVICE!

1.2 Changing the oil

**Danger:**

Danger of burning from hot transmission oil.

→ Risk of injury!

**Note:**

Before changing the oil, place suitable receptacles under the oil drainage hole.

The gearbox of the sawing unit is lubricated with oil. Change the oil after 500 working hours. Document the oil change.

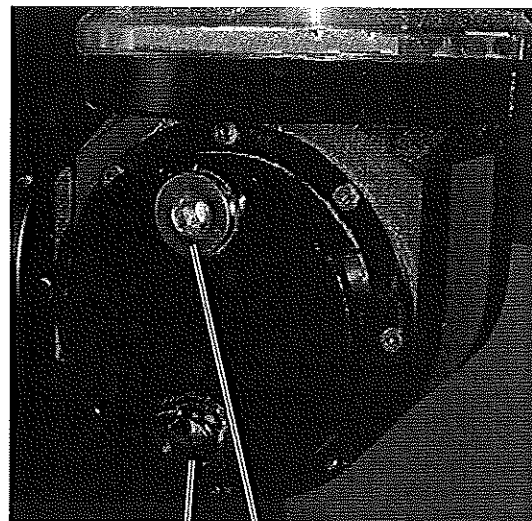
- Unscrew drain plug/oil sight glass 1.1 and filling screw 1.2
- Drain oil completely
- Screw in and tighten drain plug/oil sight glass 1.1
- Fill with oil through the opening left by the filling screw 1.2

**Note:**

Oil sump lubrication

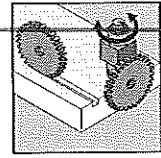
Oil grade: SAE 80W90

- Screw in and tighten filling screw 1.2



1.1 1.2

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**Note:**

The oil level in the gearbox chamber is ideal when the oil sight glass 1.1 is half covered while the spindle is vertical.

- After a test run, check the oil level again

**Danger:**

Do not allow transmission oil to remain in prolonged contact with skin. If any does come into contact with the skin, wash off thoroughly.

➔ **Danger to your health!**

**Note:**

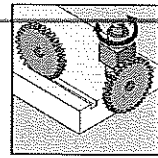
Avoid spilling transmission oil!

- Take steps to ensure that spilled oil is caught.

Disposal

Transmission oils are subject to local statutory regulations.

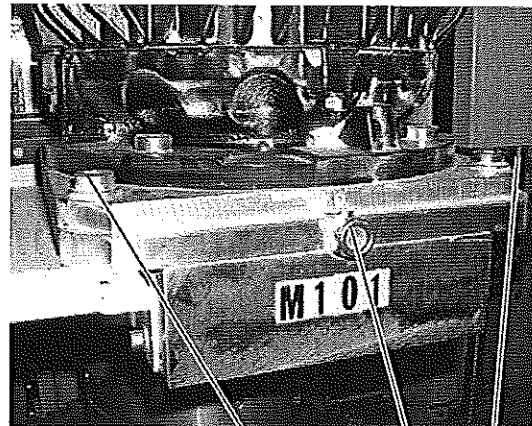




1.3 Change the belt

- Loosen clamping screw **1.3**
- Remove fixing screw **1.4** (4 screws)
- Take off the motor
- Remove the belt and fit the new belt
- Place the motor back on top, ensuring that the belt is correctly seated
- Tighten fixing screw **1.4**
- Tighten clamping screw **1.3** (torque 25 Nm)

If you have any questions →  **SERVICE!**



1.4

1.3

1.4

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Fixed sawing unit
with automatically adjustable A-axis

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6.4.2

