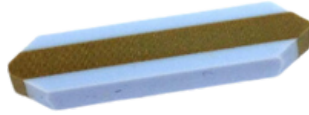


TOOL MAINTENANCE

In order to keep your ActiveEdge tooling in optimal condition, it is important that you follow the recommended maintenance procedures



Cartridge



Zebra Strip



Electrical Contacts



Zebra Strip in place

Tool Components

Cartridge: Supplied in several styles dependent on bore size and insert type.

Zebra Strip: This is a flexible component that connects the cartridge electrically to the tool. The strip is placed into the contact pockets before fitting the cartridge

Electrical Contacts: The cartridges are fitted to dedicated pockets with integral electrical contacts

Essential WEEKLY Maintenance

MATERIAL	HEAVY USE	LIGHT USE
Ferrous- cast iron No coolant	1 /week	1 /week
Ferrous - cast iron	1 /week	1 /week
Ferrous - steel	1 /week	1 /month
Non-ferrous	2 /month	1 /month



Pump grease into the cartridge until it emerges clean from the back & front of the insert holder (as above)

Grease Applicator



Grease applicator / gun can be purchased from Rigibore.

Part Number: UFGP-00 Grease Gun & Refill

Part Number: UFGP-00RFL Grease Refill



Grease

Rigibore recommends Castrol Tribol GR 100-1 PD

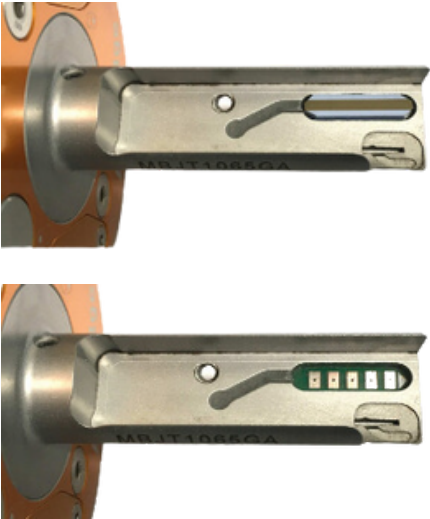


Our grease applicator is supplied with a refill with approx 120g of grease.

TOOL MAINTENANCE

In order to keep your ActiveEdge tooling in optimal condition, it is important that you follow the recommended maintenance procedures

Essential SIX MONTHLY Maintenance



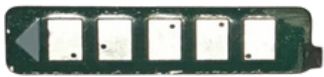
Essential SIX MONTHLY Maintenance

Periodic inspection and maintenance of the electrical contacts is essential to the operation of the tool.

This involves removing the cartridge from the pocket, discarding the zebra strip, inspecting and cleaning the contacts (if required), putting in a new zebra strip & returning the cartridge to the tool.

Depending on the condition of the electrical contacts, you may need to return the tool to Rigibore for refurbishment.

Electrical Contacts



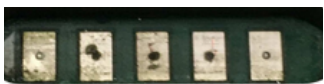
Condition: GOOD

Silver/Reflective appearance. Good electrical connection assured



Condition: POOR

Grey/matt appearance. Contacts must be polished with an ultra-fine polishing compound



Condition: POOR

Coolant residue/contamination. Contacts must be cleaned and polished



Condition: BAD

Silver coating badly worn. Return to Rigibore for refurbishment



Condition: BAD

Copper badly exposed. Return to Rigibore for refurbishment

Electrical Contact Cleaning & zebra strip replacement

Undo the M4 or M5 securing screw (s) and remove the cartridge from the tool.

Discard the zebra strip.

Inspect the electrical contacts in the tool pocket and on the cartridge (see above left) to ensure that they are undamaged.

Clean & polish the electrical contacts on both the tool and cartridge. We recommend **ECSP Electrolube** and a regular cotton bud for cleaning.

Fit a new zebra strip (Part Number: AE-PCN01) and re-assemble the cartridge to the tool.

Grease the cartridge.

Switch on the tool and perform a tool check with ActiveNet or AE-Linkbox



TOOL MAINTENANCE

In order to keep your ActiveEdge tooling in optimal condition, it is important that you follow the recommended maintenance procedures

Perform a tool check

ActiveNet



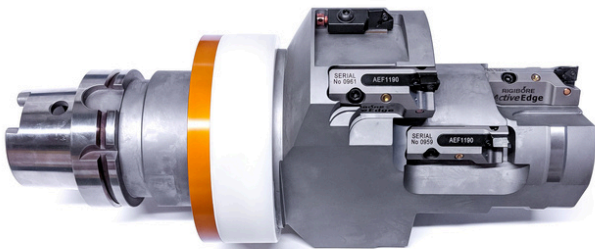
AE-Link



In ActiveNet press the check tool status button on the main menu.. The tool ID will appear and the light in the yoke will illuminate to show that the tool is active and communicating.

Using a Linkbox, open the COM port and enter the tool ID. The Linkbox sends a signal to the tool to activate it and the light in the yoke will illuminate to show that it is active and communicating.

Tool Storage



Tool Storage

If the tools are not going to be used for more than 30 days, it is strongly recommended that the ActiveEdge cartridges are greased before storing.

This forces out any coolant from the precision slide and internal components which may otherwise dry out and adversely affect the tool's performance.

ActiveEdge tools should be stored horizontally. If this is not possible, the cartridges should be removed from the tool and stored horizontally.

Shut the tool down using ActiveNet or the AE-Linkbox.

Tool Re-commissioning



Tool Re-commissioning

After prolonged storage, carry out the tasks as described in the essential six monthly maintenance section.

If the battery power is less than 30% it would be advisable to fit new batteries.