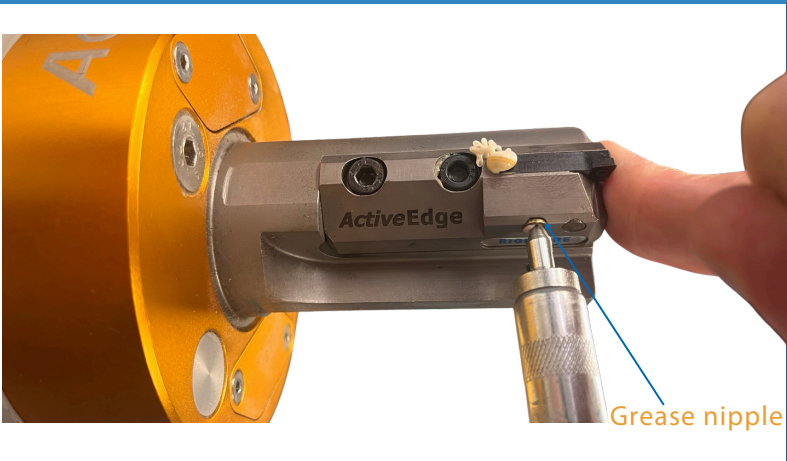


ActiveEdge

CARTRIDGE MAINTENANCE

ActiveEdge cartridges require regular maintenance to ensure optimal performance and durability, especially when machining cast iron



Greasing Process

The greasing process is designed to flush out small chips and machining dust that may build up in the cartridge mechanism.

Grease should be pumped into the cartridge via the grease nipple until it emerges clean from around the slide as shown. Place your finger on the outer side of the insert to ensure that the grease is forced into the cartridge

The correct operation and micron accuracy of the adjustment will be negatively affected unless the schedule below is adhered to.

Essential WEEKLY Maintenance

Material	Heavy Use	Medium Use	Light use
Ferrous (Cast Iron) - no coolant	3 / week	2 / week	1 / week
Ferrous (Cast Iron)	2 / week	1 / week	1 / week
Ferrous (Steel)	1 / week	1 - 2 weeks	1 / month
Non-ferrous	1 - 2 weeks	1 / month	6 / year

Grease Applicator



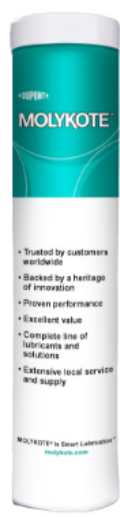
Grease applicator / gun can be purchased from Rigibore.

Part Number: AE-G00 Grease Gun & Refill

Part Number: AE-G00RFL Grease Refill

Grease

Rigibore uses Dupont MOLYKOTE® P-1042 Adhesive Grease Paste



Our grease applicator is supplied with a refill with approx 100g of grease.

<https://www.dupont.com/products/molykote-p-1042-adhesive-grease-paste.html#headingacc5>