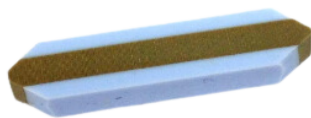


In order to keep your ActiveEdge tooling in optimal condition, it is important that you follow the recommended maintenance procedures



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. Place your finger on the outside edge of the insert to force the grease around the cartridge.

Grease Applicator



Grease applicator / gun can be purchased from Rigibore.

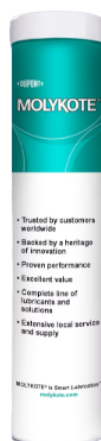
Part Number: AE-G00
Grease Gun & Refill

Part Number: AE-G00RFL
Grease Refill



Grease

Rigibore uses Dupont MOLYKOTE® P-1042 Adhesive Grease Paste



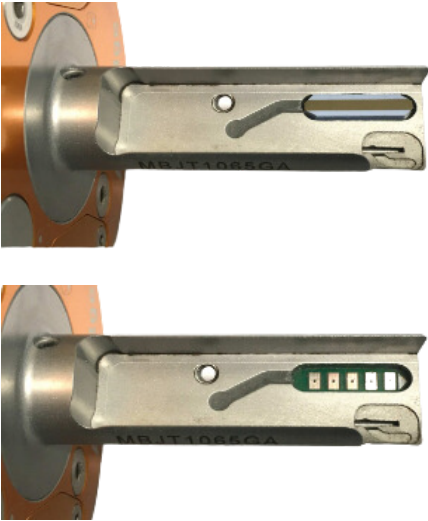
Our grease applicator is supplied with a refill with approx 100g of grease.

https://www.dupont.com/products/molykote-p-1042-adhesive-grease-paste.html#heading_acc5

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



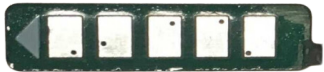
Essential SIX MONTHLY Maintenance

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



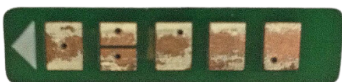
Condition: POOR

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



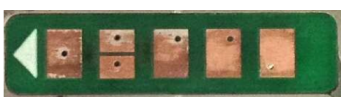
Condition: POOR

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

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.

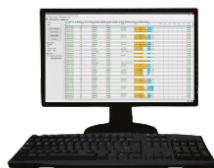
ActiveEdge tools should be stored horizontally. If this is not possible, the cartridges should be removed from the tool and stored horizontally. Batteries should be removed from the tool to prevent battery corrosion over longer periods of time. Shut the tool down using ActiveNet or the AE-Linkbox.

Caring for AE tools in your tool crib

AE-Link



ActiveNet



Caring for AE tools in your tool crib

If ActiveEdge tools or cartridges are not in use and stored in the tool crib for long periods of time it is essential that at least every six months the tools are activated.

At least two adjustments of 100 microns both up and down the range must be performed using a Linkbox or ActiveNet. This will activate the motor and move the grease around. If you are storing spare cartridges these will need to be assembled in a bar to be tested.

Failure to carry out this essential maintenance will invalidate the warranty and chargeable service and repair may be required.

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.