SOLIDClean
Chip fan

APPLICATION

· The **SOLID**Clean fan may be clamped
  on the 20 mm or ¾" in a standard collet
  or Weldon-style chuck.

· The **SOLID**Clean fan is stored just like
  a common tool in the tool magazine and
  selected automatically via CNC program.

· Proir to the actual cleaning process workpieces
  and fixtures can be cleanded with coolant
  using the supply through the spindle.
  (No rotation of the spindle!)

686160   686260   686330

Ident-no.		686160	686260	686330
Version	mm	Ø 160	Ø 260	Ø 330
Shaft	mm	Ø 20	Ø 20	Ø 20
Maximum speed	U/min /rpm	12.000	8.000	8.000
Spare part kit	Ident-no.	686161	686261	686331

CLEANING PROCESS

1. Rinsing
If possible, first flush away chips over IKZ and stationary spindle.

2. Drying
Accelerate the spindle in two steps. Start with 500 rpm. Then accelerate the spindle to the required and permissible speed.

The **SOLID**Clean fan already cleans efficiently in the medium rpm range.

MAXIMUM SPEED*

Turn the **SOLID**Clean fan (clockwise) with sufficient distance. Please note that the interfering contour and thus also the risk of collision changes dynamically when the spindle accelerates (wings fold out) and when the spindle stops (wings fold in). Keep sufficient distance to the workpiece at all times.

SAFETY NOTICE

The **SOLID**Clean fan must be used in enclosed machining centers only.

ASSEMBLY INSTRUCTION

1. Remove the M10-screws (4 pcs.) with a 5 mm Allen key. Then remove the pins.

2. Attach the spring first at the spring-holder and then put the new wing into the groove of the body. Now push the Ø 3 mm pin through the drilling holes of the wing and the body. In a final step tighten the M10-screws again to secure the pins.

3. After assembly, please check the function of the wings. Open the wings by hand and release. The wings must close automatically and smoothly to the resting position.

M10-screw

Wings in operating position

Attach spring to spring-holder

Wing in resting position
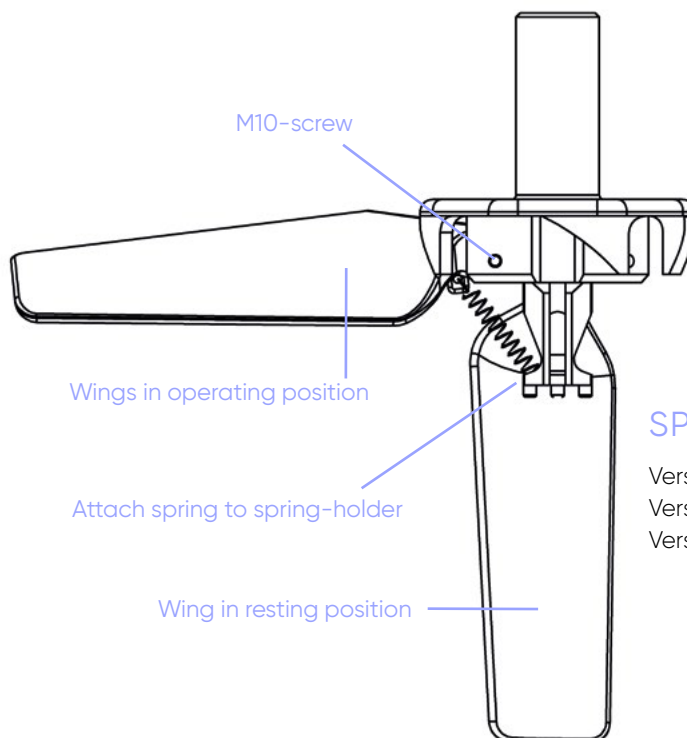
SPARE PART KIT

Version 160: *Item no.:* 686161
Version 260: *Item no.:* 686261
Version 330: *Item no.:* 686331