Mounting and operating instructions *vb Dock-Lock® 1 To.*

For *DL* clamping plates from mark 8

1. Determine the spacing (distance of the *DL* cylinders).
2. Define the *DL* cylinder position on the machine table.
3. Now place the *DL* cylinders, each with 4 brackets onto the machine table. (drawing 751 906)
4. Clamp the setup-plug, 751 590, or a dial gage into a chuck and, for centering, move the assembly approx. 1mm into the plug holding ∅ 32 of the first *DL* cylinder. Then tighten the brackets.
5. Repeat step 4 for all *DL* cylinders using the spacing defined.
6. Shorten and bend the hydraulic tubes depending on the spacing (tubes will reach approx. 4-5mm into fitting). Following this step, deburr and clean out the tubes.
7. Connect the pipes to the *DL* cylinders (drawing 751 906).
8. To check the system for leaks, place your fixture or clamping pallet fitted with plugs onto the installed system. The plugs must be mounted with M8 bolts, class 12.9, and a torque of 25Nm.
9. The hydraulic pump 758 800 is set to operating pressure, any other hydraulic source must be set at 60 to 65 bar Oil pressure.
10. The system is now pressurized by the hydraulic pump (758 800) (ON = unclamping). As a result the clamping pallet fitted with plugs lowers into the DL cylinders. (The pump is factory set to a max. pressure of 65 bar) As a rule only pressurize the system for unclamping the devices (no operator-no pressure)
11. Unless a leak is found, the system can now be pressure-released to zero by the switch on the hydraulic pump (OFF = clamping). Make sure the gauge reading is zero. vb Dock-Lock is now operational.
12. For safety, always pressure release and disconnect the hydraulics during operation.

Hint: Pallets made up for fixtures or work pieces, used on Dock-Lock, must be rigid in design and thickness to avoid distortion.

Caution:
maximum operating pressure 70bar
maximum loading capacity per cylinder is 400 kg

Warning:
Puff blowing of the ball-bearing cage with pressurized air can cause a malfunctioning of the system. Chips must only be removed by a chip vacuum-cleaner.

Weekly maintenance
For secure clamping it is necessary that the environment of the clamping chamber is clean and free of chips. In case of dirt accumulation: Circlip (751 00091) and collet (752 00090) must be demounted, cleaned, checked and if necessary replaced. Only use original spare parts.

Dimension <A> to be checked without clamping bolt:	**with oil-pressure:**	**27.6mm ±0.2**
	without oil-pressure:	**32.1mm ±0.2**

In case of malfunctioning due to inappropriate mounting or handling by unauthorized persons *vb* denies all responsibility.

vb Dock-Lock®
Set-up changes fast and easy