

# PGN 50-380

## Spring spare parts package

### Repair Instructions

SCHUNK GmbH & Co. KG | Spann- und Greiftechnik  
D-74348 Lauffen/Neckar | Bahnhofstr. 106 – 134  
Tel. +49-7133-103-0 | Fax +49-7133-103-2399  
info@de.schunk.com | www.schunk.com

Superior Clamping and Gripping



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#### Technical changes

We reserve the right to make alterations for the purpose of technical improvement.

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## 1 Intended use

If the gripping force without attached compressed air decreases, the spring needs to be changed and the product tested for wear.

## 2 Scope of Delivery

Designation	PGN								
	50	64	80	100	125	160	200	300	380
Compression spring [pcs.]	1	1	1	1	1	1	1	1	1
Complete sealing kit [pcs.]	1	1	1	1	1	1	1	1	1

## 3 Applicable documents

- Catalog data sheet of the product \*
- Assembly and operating manual of the product \*

The documents marked with an asterisk (\*) can be downloaded on our homepage [www.schunk.com](http://www.schunk.com).

## 4 Notes on particular risks



### WARNING

#### Risk of injury due to sudden movements!

If the energy supply is switched on or if residual energy is still present in the system, this can cause components to move unexpectedly, which may result in serious injuries.

- Switch off energy supply and secure against re-connection.
- Ensure that no residual energy remains in the system.



### WARNING

#### Risk of injury due to spring forces!

The lid is under spring tension.

- Carefully disassemble the product.

## 5 Tools/auxiliary tools

- Hexagon socket wrench
- Clamping device

## 6 Recommended lubricants

Lubricant point	Lubricant
Metallic sliding surfaces	microGLEIT GP 360
All seals	Renolit HLT 2
Bores on the piston	Renolit HLT 2

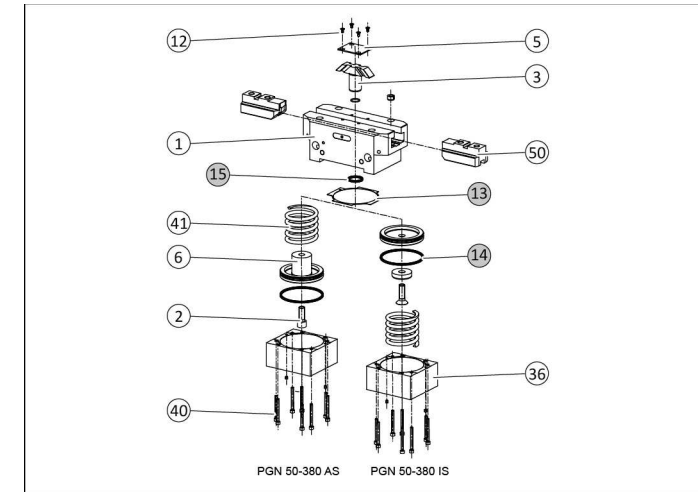
## 7 Tightening torque

Item	Designation	PGN								
		50	64	80	100	125	160	200	300	380
10	Countersunk screw [Nm]	0.8	5.8	12	12	20	49	75	75	75
11	Countersunk screw [Nm]	1.9	1.9	4.9	4.9	2.9	1.9	4.9	4.9	10
39	Screw [Nm]	2.7	14	24	24	57	67	116	116	200
40	Screw [Nm]	2.2	2.2	4.9	4.9	6.0	4.9	10	10	10

## 8 Threadlocker

If not stated otherwise, screws can be secured using Loctite 243 or a similar adhesive.

## 9 Changing the springs



### Dismantling

- Remove all compressed air lines.
- Disassemble gripper from the machine/automated system.
- **AS variant:** Unscrew screws (40).
- Remove covers (36).
- Clamp the product between housing (1) and cylinder piston (6) into the clamping device.
- **WARNING! Cylinder piston (6) is under spring tension. Remove carefully.** Unscrew screw (2) and open the clamping device wide enough so that the spring (41) is no longer under tension.
- Remove spring (41) from the housing (1).
- **IS variant:** Clamp the product between the housing (1) and cover (36) into a clamping device in such a way that the screws (40) can be removed.
- Unfasten and remove the screws (40).
- **WARNING! Cover (36) is under spring tension. Remove carefully.** Open clamping device and remove the cover (36).
- Remove spring (41) from the housing (1).

### Assembly

When assembling, use the parts from the spare part package.

- Clean all parts thoroughly, check for damage and wear and grease with a lint-free cloth or brush.
- If necessary, replace seals, illustrated in gray in the graphic.
- **AS variant:** Insert spring (41) into the housing (1).
- Fasten the cylinder piston (6) with the screw (2).
- Fasten cover (36) with the screws (40).
- **AS variant:** Insert spring (41) into the housing (1).
- Fasten cover (36) with the screws (40).
- Assemble gripper on the machine/automated system.
- Secure all compressed air lines.