

PWG 65-230

Spring spare parts package

Repair Instructions

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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	PWG 65-230				
	65	90	130	170	230
Compression spring [pcs.]	2	2	2	2	2
Cylindrical pin [pcs.]	2	2	2	2	2
Complete sealing kit [pcs.]	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.

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!

In the case of a defect, parts may be under spring tension and could be ejected during dismantling and cause injury.

- Before dismantling, clamp the gripper between position "A" and "B" into a clamping device. Make sure that the cover (2) is also clamped.
- Carefully dismantle the grippers.

5 Tools/auxiliary tools

- Hexagon socket wrench
- Safety ring pliers
- 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

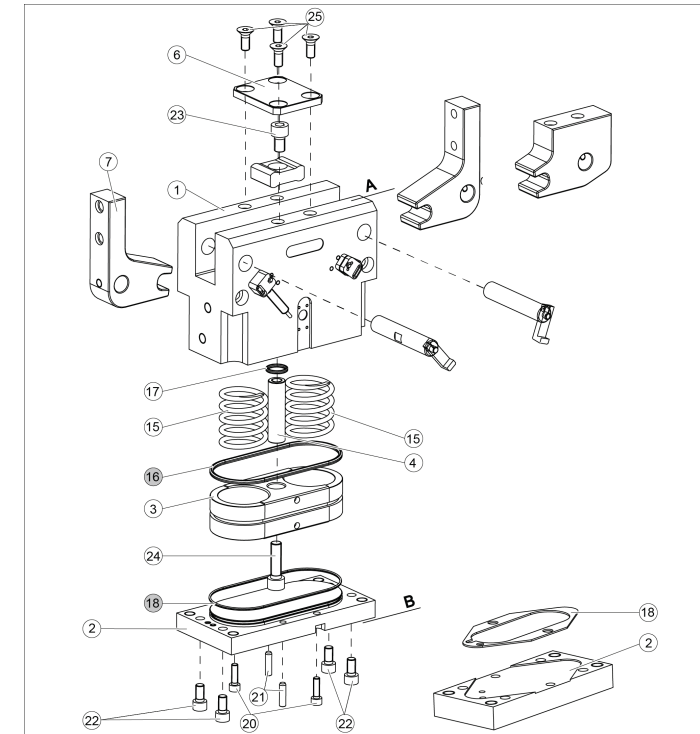
7 Tightening torque

Item	Designation	PWG 65-230				
		65	90	130	170	230
20	Screw [Nm]	-	-	-	10	25
22	Set-screw [Nm]	1.2	3.1	10	-	-
23	Screw [Nm]	2.1	11	43	85	150
24	Screw [Nm]	2.1	11	43	85	150
25	Screw [Nm]	1.2	3.1	10	25	49

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.
- Unscrew and remove the screws (25) and remove the plate (6).
- **WARNING! The housing (1), cover (2) and piston (3) are under spring tension.** Clamp the housing and cover between "A" and "B" into a clamping device.
- Unscrew the screws (22). (With PWG 170 and 230, also unscrew the screws (20)). Unclamp slowly.
- Clamp again between "A" and the bottom of the piston (3).
- Secure screw 23 against twisting and carefully loosen screw 24. Unclamp slowly.
- Remove piston (3) and springs (15). Mark the installation position of the piston.

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 shown in gray in the picture.
- Insert piston (3) and springs (15) into the housing (1).
- Clamp the housing between "A" and the piston into a clamping device.
- Secure screw 23 against twisting and screw in screw 24. Carefully open clamping device
- Place cover (2) on and screw in the screws (22). (With PWG 170 and 230, also screw in the screws (20)).
- Fasten screws (23).
- Fasten plate (6) with screws (25).
- Assemble gripper on the machine/automated system.
- Secure all compressed air lines.