

Original version of assembly instructions



For	Components			
Spieth clamping sleeve (precision clamping sleeves)	IK 8.12	IL 8.12	IK 55.80	IL 55.80
	IK 10.15	IL 10.15	IK 60.85	IL 60.85
	IK 12.18	IL 12.18	IK 63.88	IL 63.88
	IK 14.20	IL 14.20	IK 65.90	IL 65.90
	IK 15.22	IL 15.22	IK 70.100	IL 70.100
	IK 16.22	IL 16.22	IK 75.105	IL 75.105
	IK 18.25	IL 18.25	IK 80.110	IL 80.110
	IK 20.32	IL 20.32	IK 85.115	IL 85.115
Series	IK 22.35	IL 22.35	IK 90.120	IL 90.120
	IK 25.37	IL 25.37	IK 95.125	IL 95.125
IK/IL	IK 28.40	IL 28.40	IK 100.130	IL 100.130
	IK 30.42	IL 30.42	IK 110.140	IL 110.140
	IK 32.48	IL 32.48	IK 120.150	IL 120.150
	IK 35.52	IL 35.52	IK 125.155	IL 125.155
	IK 40.56	IL 40.56	IK 130.160	IL 130.160
	IK 45.68	IL 45.68	IK 140.170	IL 140.170
	IK 50.72	IL 50.72	IK 150.180	IL 150.180

The Assembly Instructions are also available for download at www.spieth-me.de.

In case of any questions, please contact Spieth-Maschinenelemente GmbH & Co. KG directly.

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Assembly instructions for Spieth clamping sets

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1 Information about Spieth Clamping Sleeves

1.1 General information

Spieth clamping sleeves are precision parts and require careful handling. Follow the information in these assembly instructions and the operating instructions. Failing to comply with them may significantly impact functionality and service life.

Only initiate clamping if borehole and outer surfaces of the clamping sleeve are fully covered by the connecting components. It can be tolerated if the clamping sleeves protrude by a maximum value a (see design guide). Otherwise, damage such as ductile deformation may occur on the clamping sleeve and render it unusable.

Spieth-Maschinenelemente GmbH & Co. KG assumes no liability for damage from improper handling, incorrect installation, or unauthorised structural changes.

1.2 Safety notices

Spieth clamping sleeves are intended for use with friction-locked shaft-hub connections. Please follow all relevant safety notices.

Caution!

Any work carried out with or on the clamping sleeve needs to follow the "safety first" guideline!

During operation, keep your hands away from the working area of the clamping sleeve!

Prior to any assembly work, switch off all machine drives!

Secure the machine against accidental power-up!

Prior to commissioning the machine, install all safety devices!

Only expert personnel are allowed to perform assembly work on Spieth clamping sleeves. Using Spieth clamping sleeves is only admissible according to specifications. Spieth-Maschinenelemente GmbH & Co. KG assumes no liability for violations of the operating instructions or safety notices. This also applies to incorrectly interpreting or circulating these notices and to incorrect assembly or maintenance.

The clamping sleeves described here are state of the art at the time these assembly instructions are printed. Subject to changes based on evolved technologies.

For international deliveries, follow the safety regulations applicable in the target country.

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2 Description of Spieth Clamping Sleeves

2.1 Structure

Spieth clamping sleeve

Identifying features
(for original Spieth clamping sleeves)

Spieth logo

Name

Batch number

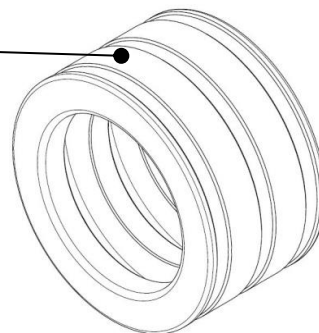


Fig. 1: Schematic representation similar to Spieth IK/IL series clamping sleeves

IK/IL series Spieth clamping sleeves have been designed for use on shafts with h5-tolerance zone. The clamping sleeve has been designed for external clamping initiation starting from the shaft. In contrast to tapered clamping sleeves, the one-piece cylindrical clamping sleeve has no joints and can therefore achieve a high degree of precision. Using connecting components to initiate axial clamping achieves a uniform lateral contraction thanks to the base body's special geometry. This results in a simple, safe, and rigid centering effect.

3 Assembling Spieth Clamping Sleeves

3.1 Preparing for assembly

Remove Spieth clamping sleeves from their packaging right before assembly. As hand perspiration can cause corrosion, ensure to keep your hands dry and clean and/or to always wear protective gloves for assembly.

Please note:

For environmental reasons, please comply with applicable statutory regulations and guidelines when disposing of packaging materials.

In case of damage to packaging components, check the clamping sleeves for damage and remove any contamination.

The preservative used is compatible with all conventional machine oils. If in doubt, check the preservative's compatibility.

For an optimum mode of action of Spieth clamping sleeves, remove the thin wax-like film of preservative from the contact surfaces using a lint-free cloth. Directly afterwards, use machine oil without friction-reducing additives to lightly oil the component and protect it from corrosion.

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3.2 Ambience

During assembly, ensure that...

- the assembly location is free from dust and clean,
- the components have no contact with corrosive media,
- foreign bodies such as sand, sawdust, fluff, etc. are kept away from the component,
- metal filings (in particular from machining tools such as files, etc.) are kept away from the component.

Caution!
Contamination can significantly impact the functionality and service life of Spieth clamping sleeves.

For best results, use a suitable, enclosed space for assembly and proceed swiftly. If this is not possible, make sure to protect the components from ambient contamination and from damage.

3.3 Automated operation

In automatic mode using, e.g., hydraulic actuation, the system's actual values may deviate from the table values because of a number of different parameters. For this application scenario, we strongly recommend that you verify the force or torque values required. In this application, care must be taken to ensure that the installation is completely free of axial clearance. To prevent fatigue failure and due to fretting corrosion risk, tension the clamping sleeve at a high clock frequency with a max. force of $0.75 \times F_{max}$.

Please see the relevant assembly instructions, available at www.spieth-me.de, for more information on assembly.

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3.4 Assembly process

Essentially, assembly is a 3-step process:

- 1. Cleaning and oiling
- 2. Joining
- 3. Clamping initiation

For an optimum mode of action of Spieth clamping sleeves, perform all three assembly steps in the specified order.

Caution!

Spieth clamping sleeves require friction-controlled clamping. The clamping force cannot be applied in relation to the clamping path. To avoid premature jamming, ensure you have a "free" functional path "C" (see design guide).

Caution!

Initiate clamping only if borehole and outer surface of the clamping sleeve are fully covered by the connecting components and/or project within admissible limits (see design guide).

Otherwise, damage such as plastic deformation may occur on the clamping sleeve and render it unusable.

In such a case, Spieth-Maschinenelemente GmbH und Co. KG assumes no liability or warranty.

Use only the following assembly process for assembling Spieth IK/IL series clamping sleeves:

3.4.1 Cleaning and oiling:

For optimum application, carefully clean clamping sleeve, shaft and hub borehole and lightly dab them with conventional fluid machine oil without friction-reducing additives.

3.4.2 Joining:

Join clamping sleeve and connecting components without applying too much force to ensure that the clamping set contact surfaces are fully covered.

3.4.3 Clamping initiation:

Initiate clamping force. Tension Spieth clamping sleeves only if borehole and outer surface of the clamping sleeve are fully covered by shaft and hub and/or project within admissible limits (see design guide).

Please note:

The AK series clamping sleeves are available as low-thrust models; their transmittable torques and axial forces are, however, only up to 0.5 times the table values (see design guide).

Following specified assembly, Spieth clamping sleeves are ready for use immediately.

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4 Disassembling Spieth Clamping Sleeves

If handled correctly, Spieth clamping sleeves can be reused several times. Undo the cylindrical clamping sleeve to return it into its original shape.

In case you used a Spieth clamping sleeve to friction-lock a shaft and a hub, due to the adjustments made you can only reconnect these two components after they have been disassembled.

To disassemble, proceed in reverse assembly order.

- 1. Release the clamping force.
- 2. The clamping sleeve relaxes and resumes its original shape. All the parts are once again freely movable. Due to the many possible ways of initiating the clamping force, this description can only be formulated in general terms.

To enable later reuse, clean, preserve, and store Spieth clamping sleeves correctly. Prior to reuse, proceed as detailed in Section "Preparing for assembly" ff.

If non-original Spieth spare parts are used, Spieth-Maschinenelemente GmbH & Co. KG assumes no liability or warranty.

5 Maintenance and servicing of Spieth clamping sleeves

Spieth clamping sleeves are low-maintenance. If used as intended, Spieth clamping sleeves provide permanently precise pretensioning and positioning of the bearing on a spindle shaft.

We recommend periodic visual inspections of the clamping sleeves for potential damage.

Follow general safety notices when using Spieth clamping sleeves.

Caution!

Never touch actively rotating components. Take protective measures against accidental contact.

If you notice irregularities with the Spieth clamping sleeves during operation, immediately switch off the machine's drive.

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