Assembly instructions (Original: de)
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1604c
[8059336]

Indexing conversion kit DADM-CK

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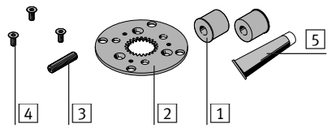
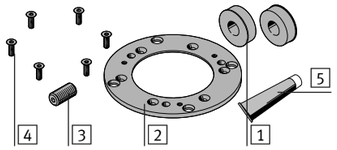
1. Parts lists

1a. Parts list DADM-CK-65/-90



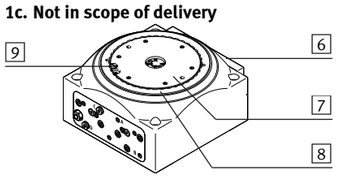
1	Spacing bolt[1)]	(2x)
2	Index plate	(1x)
3	Stop bolt[1)]	(1x)
4	Screw	(3x)
5	Special grease LUB-E1 (free of silicone)	(1x)

1b. Parts list DADM-CK-140/-220



1	Spacing bolt[1)]	(2x)
2	Index plate	(1x)
3	Stop bolt[1)]	(1x)
4	Screw	(6x)
5	Special grease LUB-E1 (free of silicone)	(1x)

1c. Not in scope of delivery



6	Rotary indexing table DHTG	(1x)
7	Rotating plate	(1x)
8	Clamping ring	(1x)
9	Screw	(1x)

2. Intended use

Indexing conversion kit DADM-CK:
Conversion of the rotary indexing table 6 to a different spacing.

3. Safety instructions and notes on mounting

- Switch off compressed air before mounting work.
- Exhausting rotary indexing table 6.
- Observe tightening torques (➔ Section 6).

Information copies

Applicable documents ➔ www.festo.com/sp
➔ Rotary indexing table DHTG operating instructions
➔ Assembly instructions for energy throughfeed DHTG-P4

4. Preparations for mounting

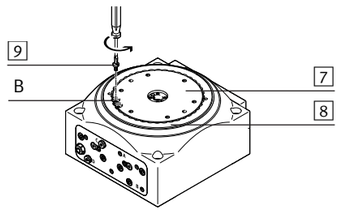
- Disassemble the energy throughfeed DHTG-P4 (➔ applicable documents).
- Grease all movable parts of the indexing conversion kit using the grease 5.

The rotary table 7 must be turning freely.
To unlock:
- Pressurise port “A” with minimum 4 bar.

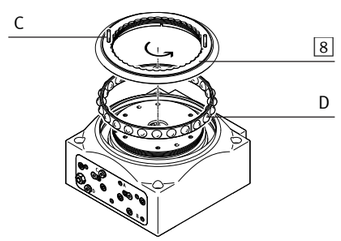
[1)] With DADM-CK-65-2, DADM-CK-90-2, DADM-CK-140-3, DADM-CK-220-3 there are no spacing bolts 1 included in the scope of delivery (➔ Section 7).

5. Mounting

5a. Disassembly of the rotary table 7



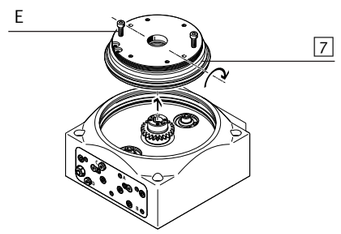
- Mark the rotary table 7 and the clamping ring 8 at the notch (B) that corresponds to the countersink of the screw 9.
- Untighten screw 9.



- Turn open the clamping ring 8 with the help of 2 cylindrical dowel pins (C)[2)].

Sizes for cylindrical dowel pins (C):
DHTG-65: 2 x 2m6
DHTG-90 ... -220: 2 x 3m6

- Remove the caged ball bearings (D).

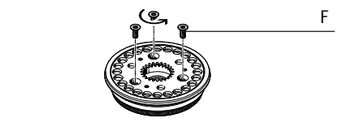


- Pull the rotary table 7 up and out with the help of 2 screws (E)[3)] .

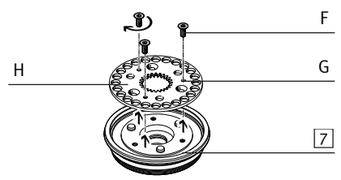
Thread for screws (E):
DHTG-65/-90: M4
DHTG-140: M6
DHTG-220: M8

- Turn the rotating plate 7.

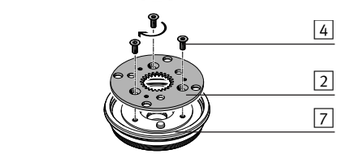
5b. Assembly of the index plate 4.



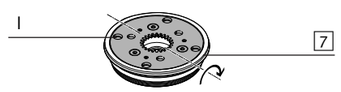
- Unscrew screws (F).



- Tighten the screws (F) in the threads (G).
- Force away the index plate (H) from the rotating plate 7 by means of the screws (F).

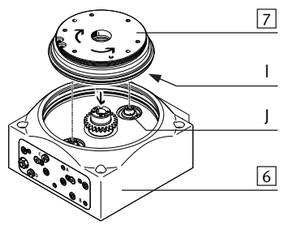


- Position the index plate 2 on the rotating plate 7.
- Fasten the index plate 2 with the screws 4.



- Observe the index holes (I).
- Turn the rotating plate 7.

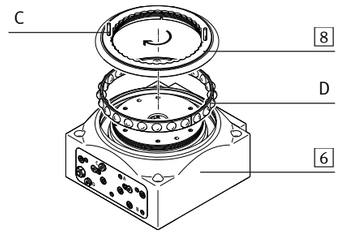
5c. Assembly of the rotary table 7



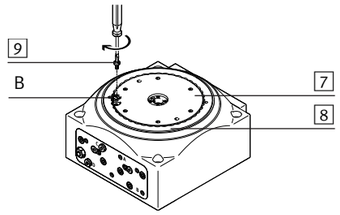
Check: The index holes (I) are located above the index bolts (J).

- Place the rotating plate 7 on the rotary indexing table 6.

[2)] The cylindrical dowel pins (C) are not included in the scope of delivery.
[3)] The screws (E) are not included in the scope of delivery.



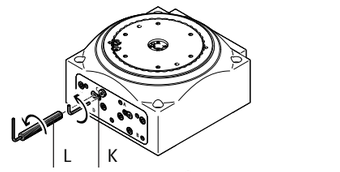
- Place the ball bearing cage (D) in the rotary indexing table 6.
- Tighten the clamping ring 8 by means of the cylindrical dowel pins (C).
- Untighten and remove the cylindrical dowel pins (C).



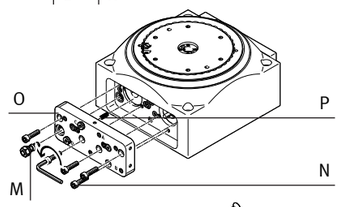
Check: The marks on the rotating plate 7 and on the clamping ring 8 match at the notch (B).

- Tighten screw 9.

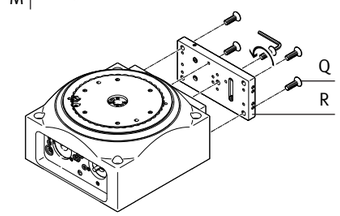
5d. Assembly of spacing bolt 1



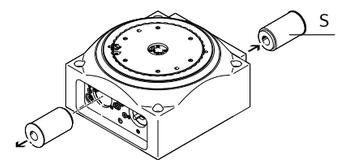
- Turn open the clamping component (K) by 1 turn.
- Unscrew the stop screw (L).



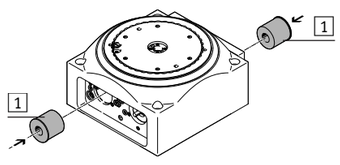
- Unscrew flow control valve (M).
- Untighten screw (N).
- Carefully remove the sub-base (O). Make sure not to lose the compression spring (P) and the seals.



- Unscrew screws (Q).
- Carefully remove the stop plate (R). Make sure not to lose the seals.



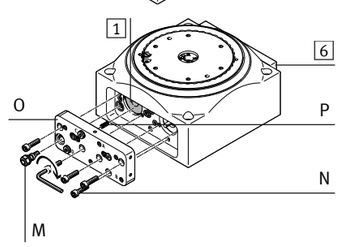
- Remove the split pins (S) from the hole to their left.



- Push the existing split pins 1[1)] into the holes on the left (➔ section 7).

With the split pins inserted 1[1)]:

- Position the compression spring (P) in the hole of the sub-base (O).



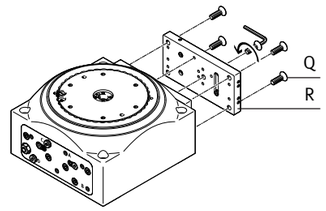
Without the split pins 1[1)] inserted:

- Remove the compression spring (P)[4)] .

Check: Correct fit of the seals.

- Fasten the sub-base (O) using screws (N).

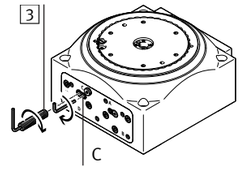
[4)] Without the split pin 1 mounted, no counter pressure is acting on the compression spring (P), which causes function failure of the rotary indexing table 6.



- Screw in and tighten the throttle valve (M).

Check: Correct fit of the seals.

- Fasten the stop plate (R) using the screws (Q).



- Screw in the existing stop bolt 3 (➔ Section 7).

Check: The required cushioning is achieved.

- Tighten the clamping component (K).
- Pressurise the rotary indexing table 6.

The rotary table must not turn freely.
To lock:

- Pressurise port “B” with minimum 4 bar.

If the rotary table 7 is still rotating freely:

- Manually turn the rotary table 7 until the index bolts (I) engage.

6. Screw sizes and tightening torques M_A[5)]

DADM-CK-			65	90	140	220
(K)	Clamping component	⊂	2.5		4	
		[Nm]	0.8		2.5	
(M)	Flow control valve		GRLA-M5-B		GRLA-G1/8	
		[Nm]	1.5		5.5	
(N)	Screw		M4x16		M6x16	M6x25
		[Nm]	3		10	
(Q)	Screw		M4x16	M5x16	M6x16	M6x20
		[Nm]	1.5	3	6	
4	Screw		M4x8	M5x12	M5x16	M6x16
		[Nm]	2	4		7
9	Screw		M3x6			
		[Nm]	0.6			

7. Lengths of the split pins 1 and stop bolts 3[1)]

DADM-CK-			65	90	140	220
Spacing	Pin					
2	1	[mm]	–	–	–	–
	3	[mm]	12	12	–	–
3	1	[mm]	11.31	15.71	–	–
	3	[mm]	23.3	28	14	19
4	1	[mm]	16.96	23.56	12.57	25.13
	3	[mm]	29	35.5	26.5	44.1
6	1	[mm]	22.62	31.42	25.13	50.27
	3	[mm]	34.6	43.5	39	69.3
8	1	[mm]	25.45	35.34	31.42	62.83
	3	[mm]	37.5	47.5	45.5	81.8
12	1	[mm]	28.27	39.27	37.7	75.4
	3	[mm]	40.3	51.5	51.5	94.4
24	1	[mm]	31.1	43.2	43.98	87.97
	3	[mm]	45	55.5	58	107

8. Prior to commissioning

Cushioning setting and commissioning (➔ applicable document).

[5)] Tolerances for tightening torques M_A without tolerance details
M_A > 0.6 ... 1. Nm: ± 30 %
M_A > 1. Nm: ± 20 %