

## LANARK HOMES LT

PROFI WBZ150/12

0-390-01-0049



		Preventive maintenance schedule	
	5.1.6	Main spindle WBZ	8-483-51-6020
	5.5.4	12-part tool holder	8-483-55-4020
	5.5.4	12-Part tool holder	9-083-55-4130
No.	5.5.5	Cooling Unit For Tool Changing Spindle	8-483-55-5010
	6.1.3	Conveyor belt	8-483-61-3010
33533653563	6.1.7	Infeed roller table	8-483-61-7060
30000000	6.1.7	Outfeed roller table	8-483-61-7070
	6.2.3	Clamp WBZ	8-483-62-3090





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6.3.4

Heavy duty sawing unit

8-483-64-1050



6.4.2

Fixed sawing unit

8-483-64-2070

with automatically adjustable A-axis



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5.1.6



The main spindle serves as tool holding fixture. In combination with the C axis slewing-motion actuator it is used as a driving unit for machining units that rotate around the Z axis.

Features	<b>\</b>	/alues		
Power max. (according to main spindle rating plate)	7,5 14,5 [S6]	12	21	kW
Infinitely	0 -	750 -	0 -	
variable	18000	18000	30000	rpm
speed				
Tool clamper			11000	N
Voltage max.		380	520	V
Direction of rotation Gooling of		Right	and left	
motor and bearings	- Wate	r cooling	system	
Front sealing	1	_abyrinth	sealing	
Filter grade			8	μm
Coolant				
temperature			1545	°C



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#### Contents:

1	Serv	/ice	2
	1.1	Inspection	3
	1.2	Cleaning clamping set	2
		Visual control clamping set and HSK contact surface	





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#### 1 Service

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#### Note:

- The indications regarding service refer to 1-shift operation (8 hours)!
  Service work must be carried out only by trained personnel and/or skilled electricians!

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#### 1.1 Inspection

The machine must be inspected by a WEINMANN technician. This implies, for example, checking the clamping force of the plate spring assembly.

If it is lower than 10 kN, the plate spring assembly must be replaced by the manufacturer.

For this reason the complete spindle in the machine must be replaced.



#### Danger:

The replacement of the complete spindle must only be executed by a WEINMANN service team or by authorized and trained personnel!





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#### 1.2 Cleaning clamping set

Each time a tool/unit is changed, wood dust gets into the clamping set, which may result in gumming and influence the clamping force.



#### Danger:

Have the following work only carried out by WEINMANN service or persons who have been accordingly instructed by WEINMANN service personnel.

- > Open the protective door
- ➤ Set key-operated switch on the control panel or on the tool changer to tool changer
- > Release the spindle tension (button on the tool changer)



#### Note:

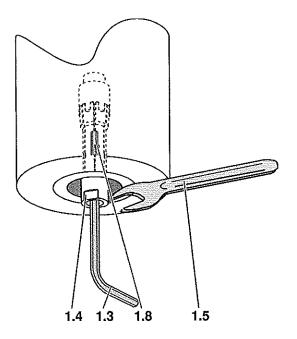
The spindle tension must always be released during this procedure.

- ➤ Secure clamping cone 1.4 to prevent twisting by means of fork wrench 1.5 (SW18).
- ➤ Loosen locking screw 1.8 by means of Allen key 1.3 (SW4)
- ➤ Loosen clamping cone 1.4 at the flat by means of fork wrench 1.5 (SW18)



#### Note:

The clamping cone is secured with Loctite: Warm up with hot air fan, if necessary.



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1.3	Allen	key	(SW4	<b>l</b> )				
1.4 1.5	Clam Fork				8)			
1.8	Lock	ing s	crew					





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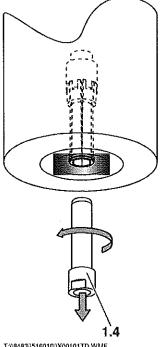
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5.1.6

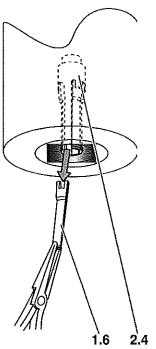


> Unscrew clamping cone 1.4



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- 1.4 Clamping cone
- > Remove all 6 clamping elements 1.6 successively using pointed pliers of the clamp.Remove holding-down device 2.4
- > Clean the clamping elements with a clean and soft cloth.



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- 1.6 Clamping elements
- 2.4 Holding-down device





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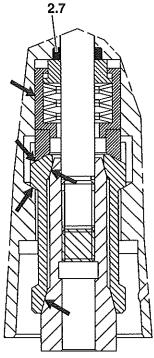
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5.1.6



- Check O-ring 2.7. (The O-ring must be installed, otherwise the lubricant is blown out)
- ➤ Grease the clamping elements and the holding-down device slightly with HOMAG special lubricant no. 4-017-02-0043 at the points marked with an arrow

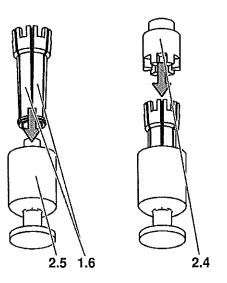


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**2.7** O-ring

#### Assembly

- ➤ Insert the 6 clamping elements 1.6 into the mounting holder 2.5
- > Place the holding-down device 2.4 on top



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2.5	Мо	untin	g ho	lder			





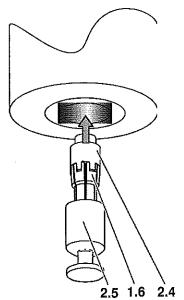
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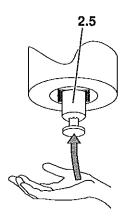
➤ Press the clamping elements 1.6 located in the mounting holder 2.5 together and insert them together with the holding-down device 2.4 into the spindle



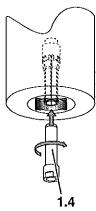
5.1.6

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➤ Lock the clamping elements into place by knocking slightly on the mounting holder 2.5



- > Remove mounting holder 2.5
- > Screw in clamping cone 1.4



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1.4 Clamping cond	9
1.6 Clamping elen	
2.4 Holding-down	device
2.5 Mounting hold	er



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> Check ejection dimension A with depth value 1.10 - it must be 10,5+0,1 mm

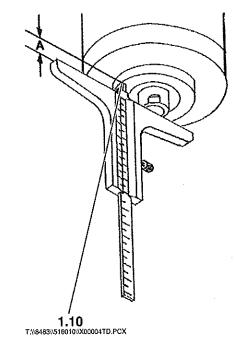
> Unscrew and clean locking screw 1.8 and moisten it with Loctite 221. Integrate locking screw 1.8 in the clamping cone 1.4 > Adjust ejection dimension A by screwing

> Tighten the locking screw 1.8 with Allen key 1.3 (SW4) against the draw bar 1.7 (secure the clamping cone 1.4 to prevent twisting by means of fork wrench 1.5

the clamping cone 1.4 in or out

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1:10 Depth value

> Clamp the spindle again (button on the tool changer)





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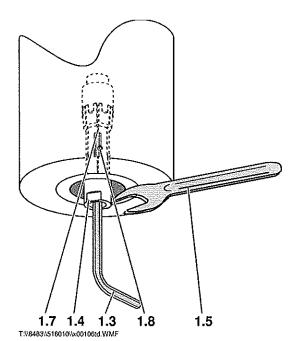
5.1.6

#### Functional check

- > Clamp and release the spindle tension about 100x (button on the tool changer)
- ➤ Check if the clamping cone 1.4 is tightened firmly
- ➤ Check ejection dimension A again and readjust it, if necessary

#### Caution:

- ➤ Check if the clamping cone 1.4 is tightened firmly by means of fork wrench 1.5 (SW18) and Allen key 1.3 (SW4).
- Observe the setting time of Loctite before commissioning the spindle!



1.3	Aller	ı key (	SW4			
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> Set key-operated switch on the control panel or on the tool changer to zero position again





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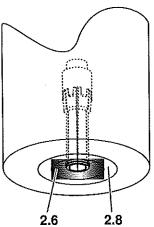
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5.1.6

## 1.3 Visual control clamping set and HSK contact surface

- ➤ Check the clamping set 2.6 visually for soiling and damage
- > Clean the clamping set in case of soiling (see chapter Clean clamping set).
- ➤ Renew the clamping set in case of damage. (See chapter Clean clamping set for information on removal and installation).
- ➤ Check HSK contact surface 2.8 as regards damage



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2.6	Clan	nping	set				
2.8	HSK	cont	act s	surfa			





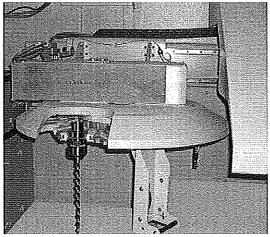
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0-390-01-0049 **5.5.4** 



In the 12-part tool holder, tools and units are made available for automatic changing in the main spindle.

Features	Values
Tool chuck	HSK-F63
Unit chuck	HOMAG inter- face
	9-002-04-3360
Number of slots	12
Pitch circle Ø	540 mm
Total weight of tool load	
max.	60 kg
Weight per tool / Unit	
max.	10 kg
Tool / unit Ø	
max.	300 mm
Tool/unit height	
(from HSK) max.	320 mm



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#### Contents:

1	Mair	ntenance work	2
	1.1	Cleaning tool chuck	. 3
	1.2	Checking the tool chuck	. 3
		Replacing the tool chuck	



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#### 1 Maintenance work

Check tool chuck	A	1.2
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- All maintenance information is based on a 1-shift operation (8 hours).
  Routine maintenance may only be performed by professionally trained personnel and/or professional electricians.

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5.5.4

#### 1.1 Cleaning tool chuck

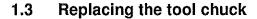
When replacing a unit/tool by hand ensure that the recessed grip on the tool chuck and the groove in the HSK chuck on the tool are both free of oil and grease.

Oil and grease contamination in the recessed grip impairs the gripping force of the tool chuck!

#### 1.2 Checking the tool chuck

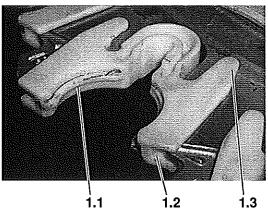
- > Check chuck jaws 1.1 for wear
- > Replace worn tool chucks

Otherwise there is a risk that the tool cannot be properly inserted into or removed from the tool holder.



Tool chucks **1.2** must be completely replaced if they become worn early or if their gripping force is significantly reduced, and in any case at least every 2 years.

- Removal force on the HSK chuck: At least 50 N
  - Measuring equipment: Spring balance
- Lift clip 1.3 with a screwdriver and pull the tool chuck out towards the front
- Slide in a new tool chuck until the clip engages



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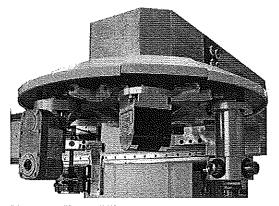
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Number of slots	12
Pitch circle Ø	540 mm
Total weight of tool load	Control Contro
ma	ax. 60 kg
Weight per tool / unit_ma	ax. 10 kg
Tool / unit Ø ma	ax. 300 mm
Tool/unit height	TO CONTROL OF THE CON
(from HSK) ma	ax. 320 mm



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#### Contents:

1	Rou	tine maintenance	2
	1.1	Lubricating the guide rails	. 3
		Cleaning the tool chuck	
	1.3	Check the tool chuck	. 4
	1.4	Replacing the tool chuck	. 4









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#### 1 Routine maintenance

Lubricating the guide rails	A	1.1
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	er G	
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#### Note:

- All maintenance information is based on 1-shift operation (8 hours)!
  Routine maintenance may only be performed by professionally trained personnel and/or professional electricians!

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5.5.4

#### 1.1 Lubricating the guide rails

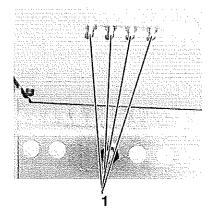


#### Note:

Only necessary for drive up tool holders!

Lubricate guide rails on the lubrication nipples 1.

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1 Lubrication nipple



#### Note:

Clean lubrication nipple 1 thoroughly before lubricating.

No dirt is allowed to enter the nipple opening!

## 1.2 Cleaning the tool chuck

When changing a unit / tool manually, make sure that the recessed grip of the tool chuck as well as the groove in the tool's HSK chuck are free of oil and grease.

⇒ Oil and grease on the recessed grip lowers the retaining force of the tool chuck.

2005-06-03





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PROFI WBZ150/12

0-390-01-0049



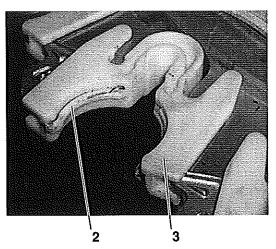
#### 1.3 Check the tool chuck

- ➤ Check the mounting crosspieces 2 for wear
- > Replace the worn tool chucks
  Otherwise, there is the danger that the tool cannot be properly stored in or removed from the tool holder.



The tool chucks 3 must be completely replaced if they are prematurely worn, or if their tension force has been significantly reduced, but at the latest, they must be completely replaced every 2 years.

- Extraction force on the HSK chuck : at least 50 N
  - Measuring equipment: Spring scale



5.5.4

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- 2 Mounting crosspiece
- 3 Tool chuck





For Tool Changing Spindle LANARK HOMES LT PF

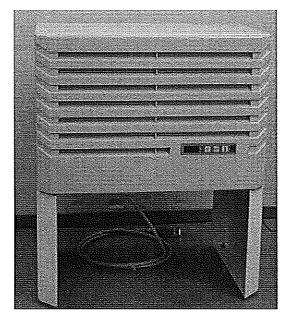
PROFI WBZ150/12

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The cooling unit is an air-cooled water cooler.

Features	Values
Nominal voltage	230 Volt
Line frequency	50 / 60 Hz
Coolant volume	2
Pump capacity	3 litres/min
Cooling liquid	75 % Water
	25% Ethylene
	glycol
Ambient tempera-	min. 10 ° C
ture	max. 40 ° C
Weight	46 kg



5.5.5

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#### Contents:

1	Main	Clean the cooling fins	Maintenance work		
	1.1	Clean the cooling fins	. Э		





For Tool Changing Spindle

LANARK HOMES LT

PROFI WBZ150/12

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5.5.5

#### 1 Maintenance work

Clean the cooling fins		Ă	1.1
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Check coolant level		С	1.3
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#### Note:

- All maintenance data refers to 1 shift operation (8 h)l
  Maintenance work must only be carried out by suitably qualified personnel and/or electricians!

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For Tool Changing Spindle

LANARK HOMES LT

PROFI WBZ150/12

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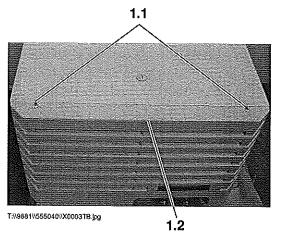
Clean the cooling fins every 100 hours. For this purpose switch off the unit and unplug from the electricity supply.

- > By unscrewing the bolts 1.1 open the trim 1.2 on the unit
- > Remove the trim 1.2
- ➤ Using a compressed air gun, clean the entire fin area 1.3 from the inside out by moving the gun back and forward
- > After cleaning securely refit the protective cap 1.3
- > Then refit the trim 1.2

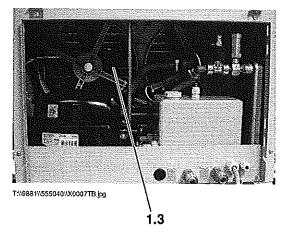


#### Note:

The cleaning intervals are to be adapted to the environment (dust production).



5.5.5



## 1.2 Change the coolant

The refrigerant is to be replaced every year.





For Tool Changing Spindle

LANARK HOMES LT

PROFI WBZ150/12

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#### 1.3 Check coolant level

Check the coolant level every 100 hours. For this purpose switch off the unit and unplug from the electricity supply.

- > By unscrewing the bolts 2.1 open the trim 2.2 on the unit
- > Remove the trim 2.2
- > Open protective cap 2.3
- > Visually check the level through the opening 2.4
- > If necessary top up with coolant
- > Securely refit the protective cap 2.3
- > Then refit the trim 2.2

#### Topping up coolant

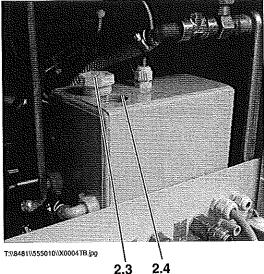
- > Fill one 0.5 I can of ethylene glycol and 1.5 I water through the opening 2.4 (in total 2 I coolant)
- > After filling, re-fit housing

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2.1

5.5.5



2.3

#### Caution:

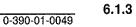
- · Do not run the unit dry or without antifreeze!
- Do not overfill the tank!
- If a pumping action is not produced, switch off unit immediately and check for faults!





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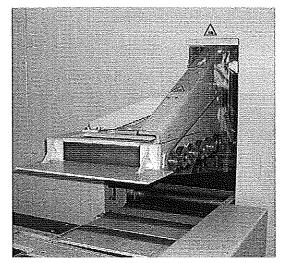
PROFI WBZ150/12





The conveyor belt transports the workpiece out of the unit

Features	Values
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	POR PARTE EN RECORDA ARREADA PARA POR LA CARRO POR A CARRO POR A CARRO POR LA CARRO POR LA CARRO POR LA CARRO P
Power	0,37 kW
O. 1	000
Stroke	230 mm
	THE RESERVE THE PROPERTY OF TH
Pressing force max.	1800 N
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Transport speed	30 m/min
No. 2012 201 - 1 (2012)	0 6
Pressure set at factory	z Dai



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#### Contents:

1	Main	tenance work	2
	1.1	Checking the belt	. 3





PROFI WBZ150/12 LANARK HOMES LT

6.1.3 0-390-01-0049



#### 1 Maintenance work

Checking the belt	Λ	1.1
	- <b></b>	
	D E	
	F G	
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#### Note:

- All maintenance information is based on a 1-shift operation (8 hours).
  Maintenance work may only be performed by professionally trained personnel and/or professional electricians.

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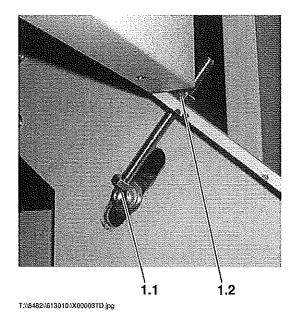
6.1.3

#### 1.1 Checking the belt

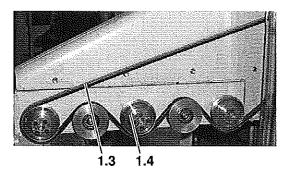
- > Visual inspection of the belt
- ⇒ If damage is noted, replace the belt

#### Replacing the belt

- > Turn back clamping screw 1.2
- > Loosen screw 1.1



- > Remove belt 1.3
- ➤ Examine belt wheels 1.4 for damage and ensure free running
- > Mount new belt
- > Secure belt with clamping screw 1.2
- > Tighten screw 1.1



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6.1.3









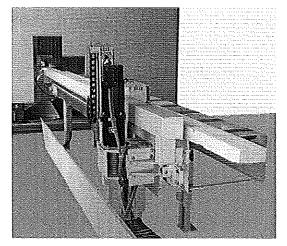
LANARK HOMES LT

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The infeed roller table feeds the workpiece into the processing center automatically.

Features	Values
Feed speed	120 m/min
Clamping force approx.	3000 N



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#### Contents:

1	Main	tenance work	2
	1.1	Lubricating the wheel nozzle guide	. З
		Inspect toothed beit	





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6.1.7

#### 1 Maintenance work

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- All maintenance information is based on a 1-shift operation (8 hours).
  Routine maintenance may only be performed by professionally trained personnel and/or professional electricians.

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PROFI WBZ150/12

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6.1.7

# 1.1 Lubricating the wheel nozzle guide



#### Note:

All lubrication points are indicated with a **RED DOT** 

- ➤ Place hand lever grease gun on lubricating nipple
- > Squeeze in the required amount



#### Note:

Pack with grease only while the wheel nozzle guide is moving!

- This will distribute the grease between the ball bearings more evenly
- Add more lubricant until grease escapes from the end and side seals
- Wipe away any escaping grease with a soft, clean cloth.



#### Note:

Do not use solvent of any kind!

Minimum lubricant quantity:
 2.5 g = 1 stroke with the hand lever grease gun

Lubricant									5	
					ì					
					2					
Hand-lever grease					7-					
gun										
					7-					



#### Caution:

Dry end seals on the wheel nozzle guide and/or dry guide rail tracks are indications of insufficient lubrication. Apply more lubricant without fail or lubricate more frequently.





\_\_ 6.1.7

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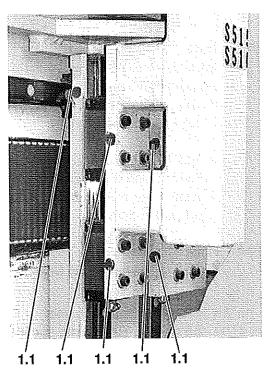


#### Note:

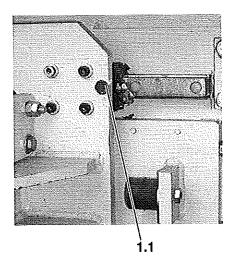
➤ Clean all lubrication nipples thoroughly before greasing. No dirt is allowed to enter the nipple opening.

Lubricating points are located

6 lubricating points on the gripper unit



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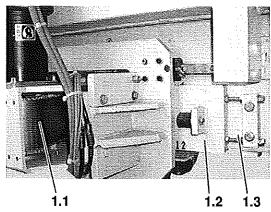
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#### 1.2 Inspect toothed belt

- ➤ Inspect toothed belt 1.1 every month for cracks
- > Check belt tensioner 1.2 at the same time
- ➤ Ensure that clamping screws 1.3 are seated securely
- ➤ Defective toothed belts should only be 

  replaced by Service



6.1.7

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1.1	Too	lhed t	elt			
1.2	Belt	tensi	oner	, arbenias		
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6.1.7







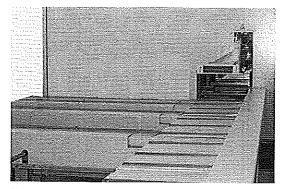
LANARK HOMES LT

PROFI WBZ150/12

<del>0-390-01-0049</del> **6.1.7** 

The beam is automatically transported out and to one side with the outfeed roller table.

Features	Values
P= Stroke	0.75 kW 600 mm
Lateral ejection speed	0 ≈ 3.0 m/min



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1 Maintenance work 1.1 Tighten chain:			2
	1.1	Tighten chain:	.3





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6.1.7

#### 1 **Maintenance work**

Tighten chain	A	1.1
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- All maintenance information is based on a 1-shift operation (8 hours).
  Routine maintenance may only be performed by professionally trained personnel and/or professional electricians.

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LANARK HOMES LT

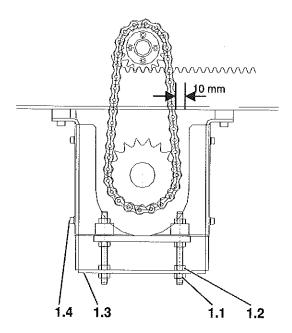
PROFI WBZ150/12

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# 1.1 Tighten chain:

- ➤ Remove cover hood 1.3 by loosening hex screws 1.4
- ➤ Loosen hex nut 1.1
- ➤ Adjust hex nut 1.2 so that the chain sag is approx. 10 mm. (adjust all nuts by the same amount!)
- > Tighten hex nut 1.1 again.
- > Mount cover hood 1.3 again



6.1.7

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1.1 F		W.
1.2 H		
1.3 C	ver hood	
1.4 H	xagon bolt	





LANARK HOMES LT PROFI WBZ150/12

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# Clamp

WBZ

LANARK HOMES LT

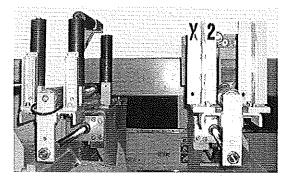
PROFI WBZ150/12

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The clamp is used to position and secure the workpiece precisely.

Features		Valu	IAS:	
				Mariana.
Vertical clampin	g range	2	200	mm
Horizontal clamp	oing		20	mm
range				
Vertical clampin	g force	17	'00	N
Horizontal	clamping	27	'00	N
force				
Travel route X <sub>2</sub>	approx.	13	860	mm



6.2.3

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1	Maintenance work						
	1.1	Clean toothed rack	. 3				
	1.2	Clean drive unit	. 3				





# Clamp

WBZ

LANARK HOMES LT

PROFI WBZ150/12





6.2.3

#### 1 Maintenance work

Clean toothed rack	<b>A</b> 1.1
Clean drive unit	<b>B</b> 1.2
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- All maintenance information is based on a 1-shift operation (8 hours).
  Routine maintenance may only be performed by professionally trained personnel and/or professional electricians.

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# Clamp WBZ

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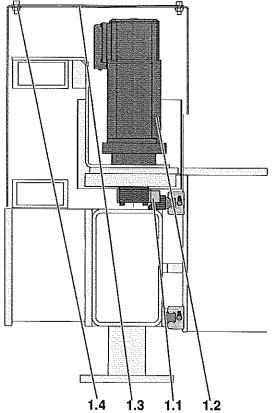


#### 1.1 Clean toothed rack

- > Remove protective cover 1.3 by loosening hex screws 1.4
- > Vacuum toothed rack 1.1



- > Remove protective cover 1.3 by loosening hex screws 1.4
- > Vacuum drive unit 1.2



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1.2	Dı	ive	uni	[					
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Clamp

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6.2.3





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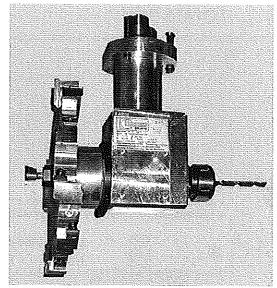
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The combination unit is equipped with one tool chuck each for

- sawing or grooving and
- for drilling or trimming

Features	in termina	Values
Input speed	max.	12000 1/min
Gear ratio		1:3,5
Output speed	max.	3400 1/min
Direction of rotation		CW / CCW rotation
C-axis swivel range		±360 °
Tool data		
Center drill hole		55 mm <sup>H7</sup>
Shaft tool 1		
Collet chuck		DIN 6499 ER32
Shaft dimensions		Ø 20x40 mm
Shaft tool 2		
Collet chuck		C25DIN6388
		Ortlieb system
Shaft dimensions		Ø 20x40 mm
Oil grade		SAE 80W90



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1	Maintenance work					
	1.1	Checking the unit	5			
	1.2	Changing the oil				







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6.3.4

### 1 Maintenance work

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### Note:

- All maintenance information is based on a 1-shift operation (8 hours).
- Maintenance work may only be performed by professionally trained personnel and/or professional electricians.

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LANARK HOMES LT PROFI WBZ150/12

0-390-01-0049 **6.3.4** 



# 1.1 Checking the unit

The angle head should be inspected at least after every 200 hours of operation. It is especially important to evaluate the amount of noise and play in the teeth.

If you have any questions -> SERVICE

# 1.2 Changing the oil



### Danger:

Danger of burning from hot transmission oil.

→ Risk of injury!



### Note:

Before changing the oil, place suitable receptacles under the oil drainage hole.

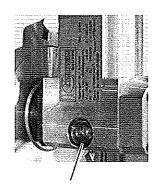
The gearbox of the sawing unit is lubricated with oil. Change the oil after 200 working hours. Document the oil change.

- > Unscrew oil sight glass 1.1
- > Drain oil completely
- > Fill with oil through the opening left by the oil sight glass 1.1

### Note:

Oil grade: SAE 80W90

> Screw in and tighten oil sight glass 1.1



**1.1** T:\\8482\\641050;\X00010TD.jpg





6.3.4

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### Note:

The oil level in the gearbox chamber is ideal when the oil sight glass 1.1 is half covered while the spindle is vertical.

> After a test run, check the oil level again



### Danger:

Do not allow transmission oil to remain in prolonged contact with skin. If any does come into contact with the skin, wash off thoroughly.

→ Danger to your health!



### Note:

Avoid spilling transmission oil!

> Take steps to ensure that spilled oil is caught.

# Disposal

Transmission oils are subject to local statutory regulations.

2005-06-03





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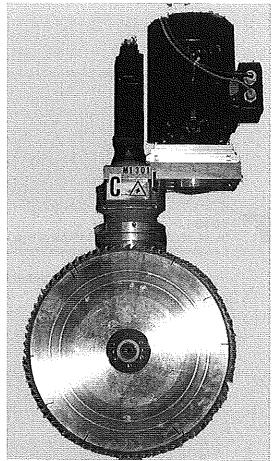




6.4.2

With this sawing unit, saw cuts can be made in various beam dimensions. They are used for processing construction parts and cutting construction parts to size.

Features	Values
Cutting depth ma	x. 200 mm
Transferable power	7.5 KW
Torque ma	x. 20 Nm
Saw blade diameter	max. 550 mm
Swivel range	90 °
C-axis	AGAMENTALIS
Max, swivel range A	+ 90 to 0 °
axis	Processor
Oil grade	SAE 80W90



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1	Main	Maintenance work			
	1.1	Checking the unit	3		
	1.2	Changing the oil	. 3		
	1.3	Change the helt	E		





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6.4.2

### 1 Maintenance work

Inspect the unit	A	1.1
Change the oil	В	1.2
Change the belt	C	1.3
	D E	
	F G	
	H	
	J	



### Note:

- All maintenance information is based on a 1-shift operation (8 hours).
- Maintenance work may only be performed by professionally trained personnel and/or professional electricians.

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2005-06-03



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PROFI WBZ150/12

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6.4.2



# 1.1 Checking the unit

The angle head should be inspected at least after every 500 hours of operation. It is especially important to evaluate the amount of chatter and play in the teeth.

If you have any questions → SERVICE!

# 1.2 Changing the oil



### Danger:

Danger of burning from hot transmission oil.

→ Risk of injury!



### Note:

Before changing the oil, place suitable receptacles under the oil drainage hole.

The gearbox of the sawing unit is lubricated with oil. Change the oil after 500 working hours. Document the oil change.

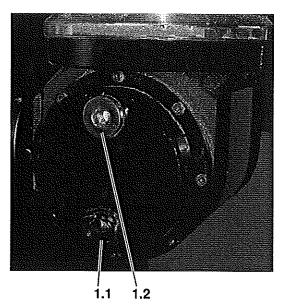
- Unscrew drain plug/oil sight glass 1.1 and filling screw 1.2
- > Drain oil completely
- ➤ Screw in and tighten drain plug/oil sight glass 1.1
- Fill with oil through the opening left by the filling screw 1.2



### Note:

Oil sump lubrication
Oil grade: SAE 80W90

> Screw in and tighten filling screw 1.2



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6.4.2





### Note:

The oil level in the gearbox chamber is ideal when the oil sight glass 1.1 is half covered while the spindle is vertical.

> After a test run, check the oil level again



### Danger:

Do not allow transmission oil to remain in prolonged contact with skin. If any does come into contact with the skin, wash off thoroughly.

→ Danger to your health!



#### Note:

Avoid spilling transmission oil!

> Take steps to ensure that spilled oil is caught.

### Disposal

Transmission oils are subject to local statutory regulations.

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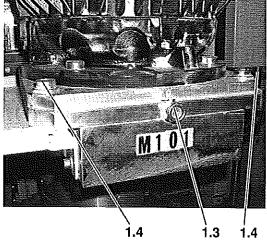


6.4.2

# 1.3 Change the belt

- > Loosen clamping screw 1.3
- > Remove fixing screw 1.4 (4 screws)
- > Take off the motor
- > Remove the belt and fit the new belt
- > Place the motor back on top, ensuring that the belt is correctly seated
- > Tighten fixing screw 1.4
- > Tighten clamping screw 1.3 (torque 25 Nm)

If you have any questions → SERVICE!



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6.4.2

