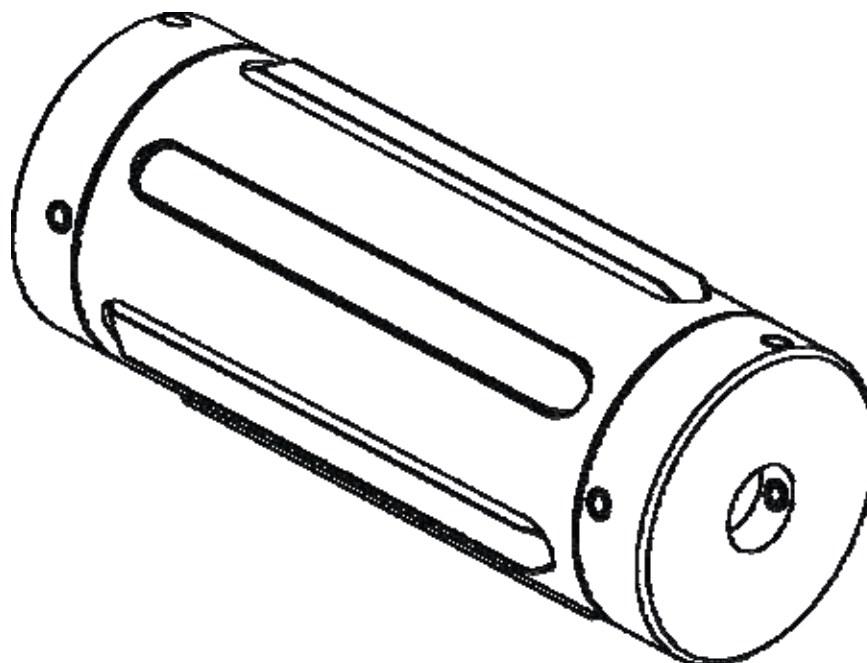




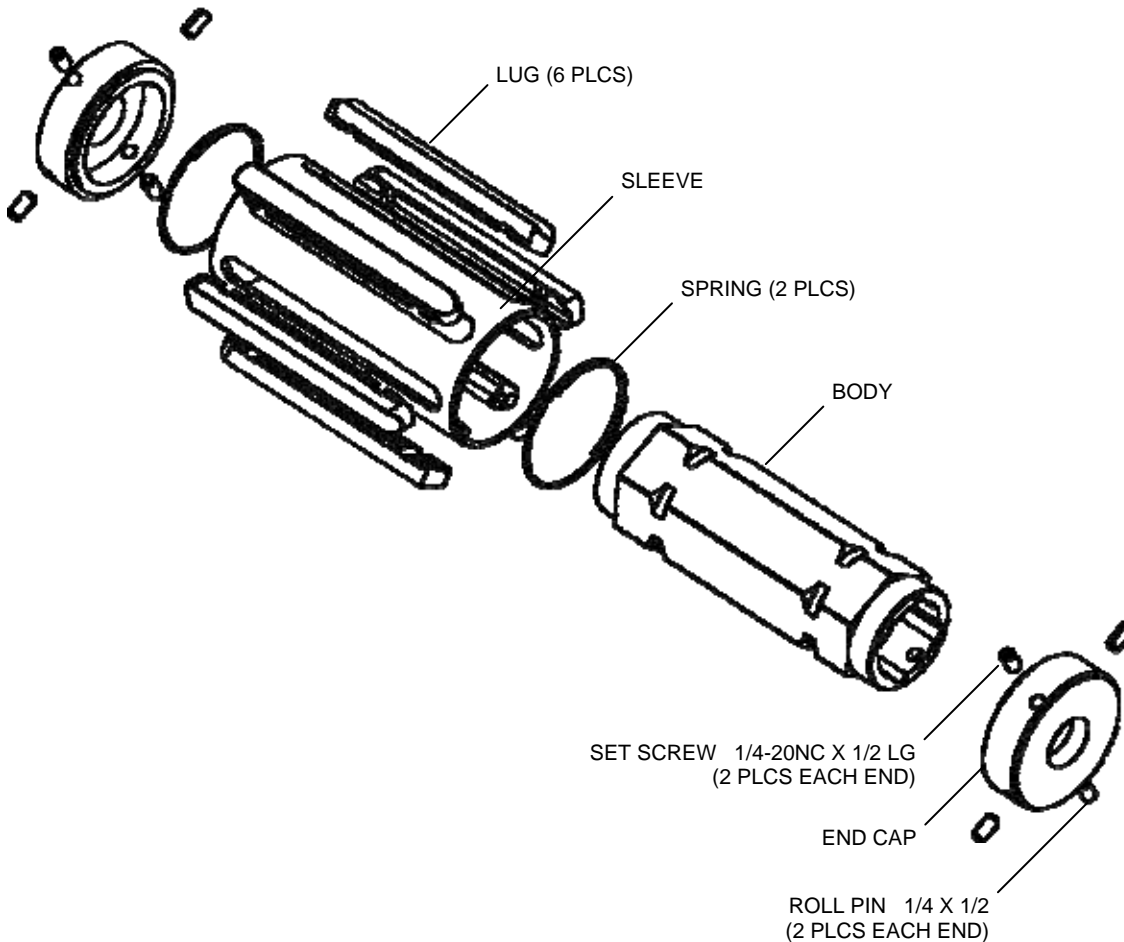
# Model AL Automatic Lug Chuck

Installation, Operation and Maintenance

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## ASSEMBLY DIAGRAM AND PARTS LIST



## INSTALLATION AND OPERATION

The Model AL Core Holder is designed specifically for bar mounted die cut and trim removal operations.

1. Install the core holder onto the mounting shaft.
2. Make sure the setscrews (located 90° apart) are installed in each end cap and tightened against the support shaft. Torque to 5.4 ft·lb (7.3 N·m).
3. Place core on the core holder.

### NOTICE

Maximum chuck operating speed is 800 fpm (244 mpm).  
Maximum roll weight is 600 lb (272 kg).

## MAINTENANCE

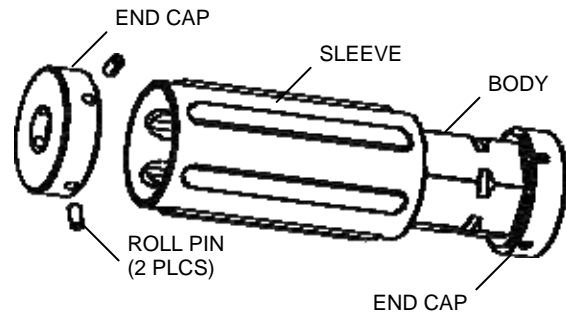


**Wear eye protection.**

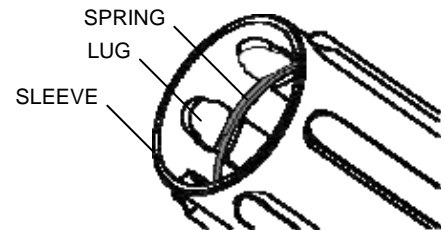
- Use compressed air to remove dust and debris from the shaft during the operating shift.
- Keep shaft sleeve, end caps and lug free of scratches and burrs.
- Remove residue buildup with a mild solvent and a soft cloth.

## DISASSEMBLY

1. Remove core holder from support shaft by loosening two set screws on each end of the core holder.
2. Remove **one** end cap by driving the two roll pins through the end cap.
3. Pull the body and other end cap from the sleeve as one unit. The lugs and spring will remain inside the sleeve.



4. Remove the springs and the lugs from inside the sleeve.



5. Clean all parts with small amount of soap and water. Dry thoroughly.
6. Inspect all parts for damage or excessive wear. Replace as required.

### **Note:**

**If the body or end caps require replacement Tidland recommends replacing the complete core holder. The roll pin holes are match drilled to each body during manufacturing and end caps are not interchangeable.**

### **Reassemble the Core Holder**

1. Insert the six lugs into the sleeve from the inside.
2. Reinstall the springs in the lugs.
3. Reinstall the body and end cap as one unit into the sleeve.
4. Align the two roll pin holes in the end cap with the holes in the body.
5. Drive the remaining two roll pins flush to 1/8" below surface to secure the end cap.

**Check operation of the core holder before returning to service.**

## IMPORTANT SAFETY INSTRUCTIONS

When using this Tidland product, basic safety precautions should always be followed to reduce the risk of personal injury. Your company's safety instructions and procedures should always be followed. When using this product with any other equipment or machinery, all safety requirements stipulated by that equipment or machinery manufacturer must be followed. Compliance with local, state, and federal safety requirements is your responsibility. No part of these or the following instructions should be construed as conflicting with or nullifying the instructions from other sources. Be familiar with the hazards and safety requirements in your work environment and always work safely.

1. Read and understand all instructions and shaft design application limits before operation.
2. Never use this product for a purpose or in a machine that it was not specifically designed for. See Product Safety Data Sheet (PSDS).
3. Do not exceed the operation loads for this shaft as noted on its PSDS, Product Safety Data Sheet.
4. Follow all warnings and instructions marked on the product and on the PSDS.
5. Inspect the shaft for wear and/or other safety and functional deficiencies daily, before each use.
6. Wear safety glasses or proper eye protection when inflating or deflating or otherwise operating the air system.
7. Do not remove or otherwise alter any setscrews or fastening devices prior to using this product.
8. Do not operate this product if any setscrews or fastening devices are missing.
9. Do not lift shaft manually if it is beyond your capacity. Loads over 1/3 your body weight may be prohibitive. Consult your company safety policy.
10. When lifting a shaft, use proper lifting techniques, keeping back straight and lifting with the legs.
11. Do not carry or lift this product over wet or slippery surfaces.
12. Use appropriate mechanical lifting devices, such as a hoist or shaft puller, for heavier shafts.
13. When performing maintenance or repair procedures, do not pressurize the shaft if journal setscrews are loose or missing.
14. When performing maintenance procedures, do not pressurize the shaft if the journal is missing.
15. All replacement parts used on this product should be made to original Tidland specifications.
16. All maintenance and repair procedures performed on this product should be done to Tidland specifications by qualified personnel.



**Tidland Corporation**  
2305 SE 8<sup>th</sup> Avenue  
Camas, WA 98607 USA  
Phone: 1-800-426-1000  
1-360-834-2345  
Fax: 1-360-834-5865  
E-mail: [tidland@tidland.com](mailto:tidland@tidland.com)  
Web: [www.tidland.com](http://www.tidland.com)

**Maxcess Europe**  
Fifestrasse 1, D-65779  
Kelkheim/Ts., Germany  
Phone: (49) 6195-7002-433  
Fax: (49) 6195-7002-933  
E-mail: [info@maxcess.eu](mailto:info@maxcess.eu)

**Maxcess Asia**  
300 Orchard Road No. 15-05  
Orchard Towers  
Singapore 238875  
Phone: (65) 9620-3883  
Fax: (65) 6235-4818  
E-mail: [asia@maxcessintl.com](mailto:asia@maxcessintl.com)