Assembly and Operating Manual
Jaw turning rings
ADR-C / ADR-C2 / ADR-S

Superior Clamping and Gripping

SCHUNK®

Imprint

Technical changes:

We reserve the right to make alterations for the purpose of technical improvement.

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Dear Customer,

Thank you for trusting our products and our family-owned company, the leading technology supplier of robots and production machines.

Our team is always available to answer any questions on this product and other solutions. Ask us questions and challenge us. We will find a solution!

Best regards,

Your SCHUNK team

Customer Management

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cms@de.schunk.com

Please read the operating manual in full and keep it close to the product.

Table of Contents

1 General

1.1 About this manual

This manual contains important information for a safe and appropriate use of the product.

This manual is an integral part of the product and must be kept accessible for the personnel at all times.

Before starting work, the personnel must have read and understood this operating manual. Prerequisite for safe working is the observance of all safety instructions in this manual.

In addition to these instructions, the documents listed under ▸ 1.1.3 [🗋 6] are applicable.

NOTE: The illustrations in this manual are intended to provide a basic understanding and may deviate from the actual version.

1.1.1 Presentation of Warning Labels

To make risks clear, the following signal words and symbols are used for safety notes.

⚠ DANGER

Dangers for persons!

Non-observance will inevitably cause irreversible injury or death.

⚠ WARNING

Dangers for persons!

Non-observance can lead to irreversible injury and even death.

⚠ CAUTION

Dangers for persons!

Non-observance can cause minor injuries.

NOTICE

Material damage!

Information about avoiding material damage.

1.1.2 Definition of Terms

The term "product" replaces the product name on the title page in this manual.

1.1.3 Applicable documents

- General terms and conditions*
- Contractual agreements
- Assembly and operating manual of the lathe chuck used

The documents labeled with an asterisk (*) can be downloaded from **schunk.com**.

1.2 Warranty

If the product is used as intended, the warranty is valid for 12 months from the date of delivery from the production facility.

1.3 Scope of delivery

ADR-C

The scope of delivery includes

1 Jaw turning ring Ø 33 mm (ID 6100002)
1 Jaw turning ring Ø 76 mm (ID 6100003)
1 Jaw turning ring Ø 120 mm (ID 6100004)
1 Jaw turning ring Ø 164 mm (ID 6100005)
1 Jaw turning ring Ø 208 mm (ID 6100006)
2 ADR-C clamping pin set (ID 122175)
1 ADR-C locking pin (ID 6100001)
1 Transport protection (ID 9957984)
1 Assembly and Operating Manual (ID 0189701)

ADR-C2

The scope of delivery includes

1 Jaw turning ring Ø 33 mm (ID 6100002)
1 Jaw turning ring Ø 76 mm (ID 6100003)
1 Jaw turning ring Ø 120 mm (ID 6100004)
1 ADR-C clamping pin set (ID 122175)
1 ADR-C locking pin (ID 6100001)
1 Transport protection (ID 9957984)
1 Assembly and Operating Manual (ID 0189701)

ADR-S

The scope of delivery includes

1 Jaw turning ring Ø 252 mm (ID 6100007)
1 Jaw turning ring Ø 317 mm (ID 6100008)
1 Jaw turning ring Ø 382 mm (ID 6100009)
1 Jaw turning ring Ø 447 mm (ID 6100010)
6 Clamping pin M8, h = 7.5 mm (ID 6100011)
6 Clamping pin M8, h = 15 mm (ID 6100020)
6 Clamping pin M8, h = 22.5 mm (ID 6100012)
6 Clamping pin M8, h = 30 mm (ID 6100021)
1 Transport protection (ID 9957985)
1 Assembly and Operating Manual (ID 0189701)

2 Basic safety notes

2.1 Intended use

- The product is used for turning or grinding soft and highly tempered chuck jaws.
- The product may only be used and applied within the scope of the information in the technical data, ▸ 3 [🗋 13].
- The product may only be used and operated with suitable, prescribed or approved attachment parts.
- The product is intended for industrial use.
- Appropriate use of the product includes compliance with all instructions in this manual.

2.2 Inappropriate use

The product is not being used as intended if, for example:

- The product is not clamped correctly.
- Hard chuck jaws must be turned or ground.
- The clamping pins on the product do not fully rest against the chuck jaws during clamping.
- The information in the technical data is not observed when using and operating the product ▸ 3 [🗋 13].
- The product is used and operated with non-approved attachment parts.
- The product is used in corrosive media.
- The maintenance and storage instructions are not observed ▸ 7 [🗋 28].

2.3 Constructional changes

Implementation of structural changes

By conversions, changes, and reworking, e.g. additional threads, holes, or safety devices can impair the functioning or safety of the product or damage it.

- Structural changes should only be made with the written approval of SCHUNK.

2.4 Spare parts

Use of unauthorized spare parts

Using unauthorized spare parts can endanger personnel and damage the product or cause it to malfunction.

- Use only original spare parts or spares authorized by SCHUNK.

2.5 Environmental and operating conditions

Required ambient conditions and operating conditions

Incorrect ambient and operating conditions can make the product unsafe, leading to the risk of serious injuries, considerable material damage and/or a significant reduction to the product's life span.
See also ▸ 3.3 [🗋 13].

2.6 Personnel qualification

Inadequate qualifications of the personnel

If the personnel working with the product is not sufficiently qualified, the result may be serious injuries and significant property damage.

- All work may only be performed by qualified personnel.
- Before working with the product, the personnel must have read and understood the complete assembly and operating manual.
- Observe the national safety regulations and rules and general safety instructions.

The following personal qualifications are necessary for the various activities related to the product:

Qualified personnel	Due to its technical training, knowledge and experience, qualified personnel is able to perform the delegated tasks, recognize and avoid possible dangers and knows the relevant standards and regulations.
Instructed person	Instructed persons were instructed by the operator about the delegated tasks and possible dangers due to improper behaviour.
Service personnel of the manufacturer	Due to its technical training, knowledge and experience, service personnel of the manufacturer is able to perform the delegated tasks and to recognize and avoid possible dangers.

2.7 Personal protective equipment

Use of personal protective equipment

Personal protective equipment serves to protect staff against danger which may interfere with their health or safety at work.

- When working on and with the product, observe the occupational health and safety regulations and wear the required personal protective equipment.
- Observe the valid safety and accident prevention regulations.
- Wear protective gloves to guard against sharp edges and corners or rough surfaces.
- Wear heat-resistant protective gloves when handling hot surfaces.
- Wear protective gloves and safety goggles when handling hazardous substances.
- Wear close-fitting protective clothing and also wear long hair in a hairnet when dealing with moving components.

2.8 Notes on safe operation

- Install and clamp the product according to the specifications in this manual.
- Maintain and service the product on a regular basis.
- All repair work must be performed by SCHUNK.
- The operational safety and function of the product must not be impaired by external influences.

Incorrect handling of the personnel

Incorrect handling and assembly may impair the product's safety and cause serious injuries and considerable material damage.

- Avoid any manner of working that may interfere with the function and operational safety of the product.
- Use the product as intended.
- Observe the safety notes and assembly instructions.
- Do not expose the product to any corrosive media. This does not apply to products that are designed for special environments.
- Eliminate any malfunction immediately.
- Observe the care and maintenance instructions.
- Observe the current safety, accident prevention and environmental protection regulations regarding the product's application field.

2.9 Transport

Handling during transport

Incorrect handling during transport may impair the product's safety and cause serious injuries and considerable material damage.

- When handling heavy weights, use lifting equipment to lift the product and transport it by appropriate means.
- Secure the product against falling during transportation and handling.
- Stand clear of suspended loads.

2.10 Malfunctions

Behavior in case of malfunctions

- Immediately remove the product from operation and report the malfunction to the responsible departments/persons.
- Order appropriately trained personnel to rectify the malfunction.
- Do not recommission the product until the malfunction has been rectified.
- Test the product after a malfunction to establish whether it still functions properly and no increased risks have arisen.

2.11 Disposal

Handling of disposal

The incorrect handling of disposal may impair the product's safety and cause serious injuries as well as considerable material and environmental harm.

- Follow local regulations on dispatching product components for recycling or proper disposal.

2.12 Fundamental dangers

General

- Observe safety distances.
- Never deactivate safety devices.
- Before commissioning the product, take appropriate protective measures to secure the danger zone.
- Disconnect power sources before installation, modification, maintenance, or calibration. Ensure that no residual energy remains in the system.
- If the energy supply is connected, do not move any parts by hand.
- Do not reach into the open mechanism or movement area of the product during operation.

2.12.1 Protection during handling and assembly

Incorrect handling and assembly

Incorrect handling and assembly may impair the product's safety and cause serious injuries and considerable material damage.

- Have all work carried out by appropriately qualified personnel.
- For all work, secure the product against accidental operation.
- Observe the relevant accident prevention rules.
- Use suitable assembly and transport equipment and take precautions to prevent jamming and crushing.

Incorrect lifting of loads

Falling loads may cause serious injuries and even death.

- Stand clear of suspended loads and do not step into their swiveling range.
- Never move loads without supervision.
- Do not leave suspended loads unattended.

2.12.2 Protection during commissioning and operation

Falling or violently ejected components

Falling and violently ejected components can cause serious injuries and even death.

- Take appropriate protective measures to secure the danger zone.
- Never step into the danger zone during operation.

3 Technical data

3.1 ADR-C/ADR-C2

Designation	ADR-C	ADR-C2
ID	189500	189800
Maximum permissible clamping force	30 kN	30 kN
Suitable lathe chuck	2-jaw chuck 3-jaw chuck 6-jaw chuck	2-jaw chuck 3-jaw chuck 6-jaw chuck
Tightening torques for clamping pins	5 Nm	5 Nm
Clamping range	Ø 30 mm to Ø 250 mm in 2 mm increments	Ø 30 mm to Ø 160 mm in 2 mm increments

Jaw turning rings for ADR-C / ADR-C2

Jaw turning ring	ADR 1	ADR 2	ADR 3	ADR 4	ADR 5
ID	6100002	6100003	6100004	6100005	6100006
Diameter	33 mm	76 mm	120 mm	164 mm	208 mm

3.2 ADR-S

Designation	ADR-S
ID	189600
Maximum permissible clamping force	65 kN
Suitable lathe chuck	2-jaw chuck 3-jaw chuck 6-jaw chuck
Tightening torques for clamping pins	25 Nm
Clamping range	Ø 250 mm to Ø 505 mm in 5 mm increments

Jaw turning rings for ADR-S

Jaw turning ring	ADR 6	ADR 7	ADR 8	ADR 9
ID	6100007	6100008	6100009	6100010
Diameter	252 mm	317 mm	382 mm	447 mm

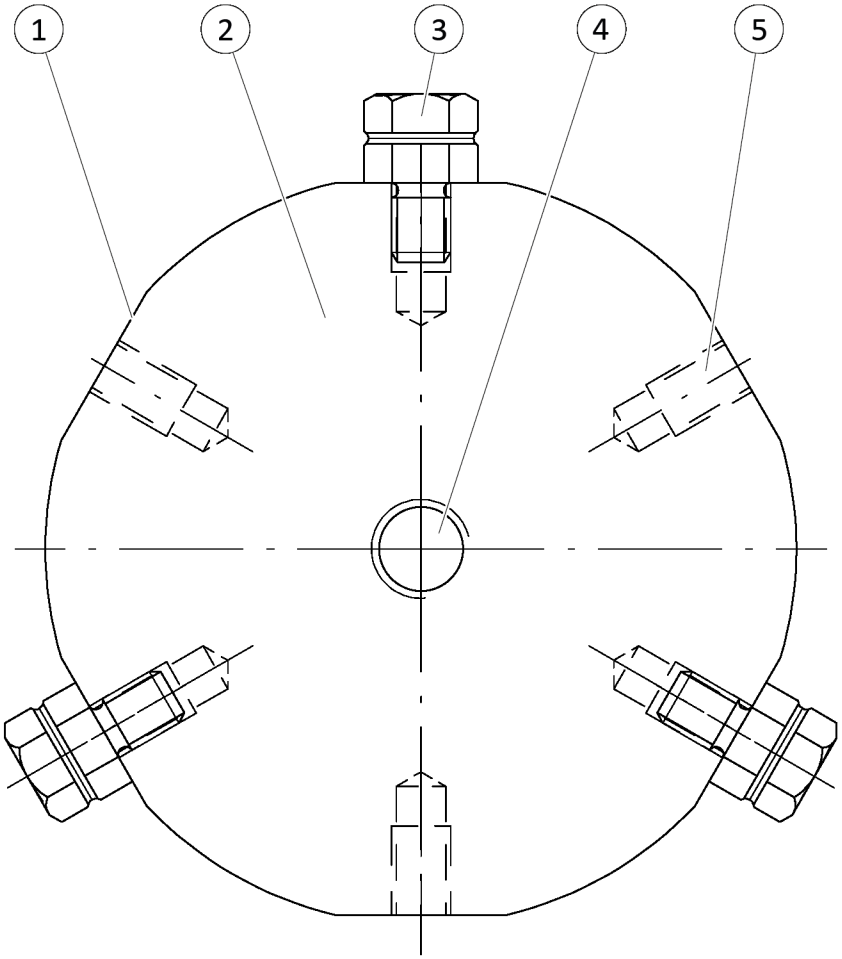
3.3 Ambient conditions and operating conditions

The specified temperatures always refer to the product.

Storage temperature	+20°C ±10°C

4 Design and description

4.1 Design



NOTE: The illustration may differ from the actual design.

1	Flat areas
2	ADR jaw turning ring
3	Clamping pin (if mounted)
4	Thread for locking pin (only for ADR-C / ADR-C2)
5	Thread for clamping pin

4.2 Description of function

The product is used for preloading soft and highly tempered chuck jaws. After preloading, the chuck jaws can be turned.

By using clamping pins, different clamping diameters can be covered.

5 Assembly

5.1 Basic information

⚠ WARNING

Risk of injury due to incorrect assembly of the clamping pins.

If the clamping pins are assembled incorrectly, the product may be flung out during rotation, causing severe injuries.

- Observe the specified tightening torques for the clamping pins.
- Regularly check the fastening of the clamping pins.
- Take suitable protective measures to secure the danger zone.
- Wear suitable protective equipment.

⚠ WARNING

Risk of injury if the product falls during transport, assembly or disassembly.

Due to the oily surface required to preserve it, the product can slip through your hands, resulting in injury.

- Take appropriate safety measures to prevent the product from falling.
- Wear suitable protective equipment, especially protective gloves and safety boots.

⚠ CAUTION

Risk of crushing and impact when assembling and disassembling the clamping pins.

- Do not reach in between the product and the clamping pins.
- Wear suitable protective equipment.

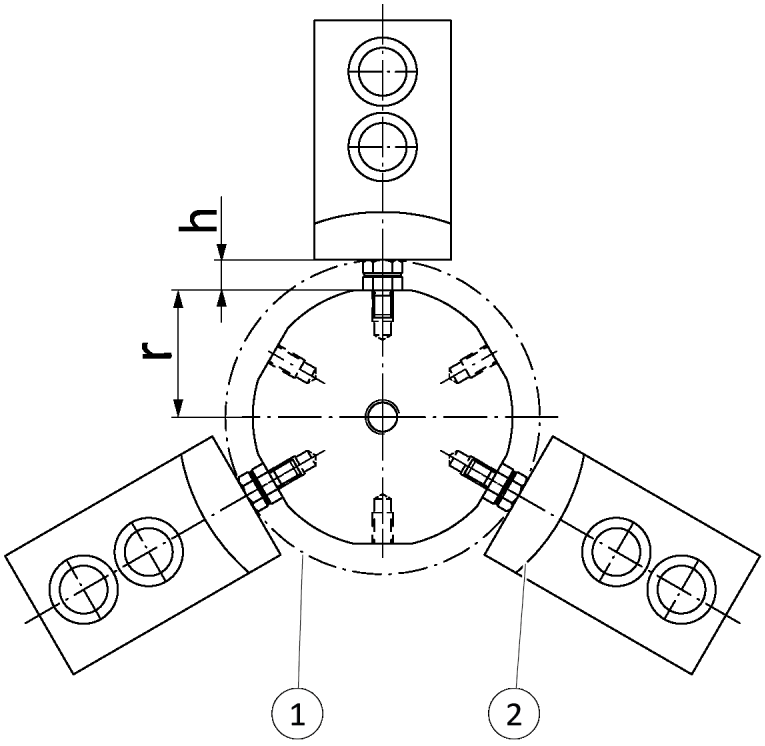
NOTICE

Possibility of material damage due to clamping pins of different lengths.

If the wrong clamping pins are mounted, a large imbalance and an inaccurate turning result can occur during turning.

- Ensure that the height difference between the clamping pins is less than 3 mm.

5.2 Assembling the clamping pins



1	ADR clamping diameter
2	Workpiece clamping diameter

Formula when using **3 clamping pins of the same height**:
ADR clamping diameter = (r + h) x 2

Depending on the required ADR clamping diameter, the product can either be used directly or fitted with clamping pins.

1. Select suitable jaw turning ring and clamping pins:
   - ✓ For combination specifications ADR-C/ADR-C2, see ▸ 5.2.1 [🗋 18].
   - ✓ For combination specifications ADR-S, see ▸ 5.2.2 [🗋 22].
2. Screw the clamping pin into the jaw turning ring as far as the stop. Observe the specified tightening torques for the clamping pins ▸ 3 [🗋 13].

NOTE: For more finely graduated intermediate diameters, the clamping pins can be milled. The clamping pins can be reordered as spare part sets.

Examples of using clamping pins of different heights

- To clamp the chuck jaws of a lathe chuck to a diameter of 370 mm, ADR and clamping pins must be combined as follows, in accordance with the combination specifications ▶ 5.2.1 [🗋 18]: 1 x jaw turning ring with Ø 317 mm, 2 x clamping pins with height h = 30 mm.
- To clamp the chuck jaws of a lathe chuck to a diameter of 196 mm, ADR and clamping pins must be combined as follows, in accordance with the combination specifications ▶ 5.2.2 [🗋 22]: 1 x jaw turning ring with Ø 164 mm, 2 x clamping pins with height h = 18 mm, 1 x clamping pin with height h = 15 mm. **IMPORTANT! The height difference between the clamping pins must not exceed 3 mm!**

5.2.1 Combination specifications ADR-C / ADR-C2

Clamping diameter	Jaw turning ring	Clamping pins		
		SB 1	SB 2	SB 3
30 mm	ADR 1	-	-	-
32 mm	ADR 1	A	-	-
33 mm	ADR 1	-	-	-
34 mm	ADR 1	A	A	-
36 mm	ADR 1	A	A	A
38 mm	ADR 1	A	A	B
40 mm	ADR 1	A	B	B
42 mm	ADR 1	B	B	B
44 mm	ADR 1	B	B	C
46 mm	ADR 1	B	C	C
48 mm	ADR 1	C	C	C
50 mm	ADR 1	C	C	D
52 mm	ADR 1	C	D	D
54 mm	ADR 1	D	D	D
56 mm	ADR 1	D	D	E
58 mm	ADR 1	D	E	E
60 mm	ADR 1	E	E	E
62 mm	ADR 1	E	E	F
64 mm	ADR 1	E	F	F
66 mm	ADR 1	F	F	F
68 mm	ADR 1	F	F	G
70 mm	ADR 1	F	G	G
72 mm	ADR 1	G	G	G
74 mm	ADR 2	-	-	-
76 mm	ADR 2	A	-	-
78 mm	ADR 2	A	A	-
80 mm	ADR 2	A	A	A
82 mm	ADR 2	A	A	B
84 mm	ADR 2	A	B	B
86 mm	ADR 2	B	B	B
88 mm	ADR 2	B	B	C
90 mm	ADR 2	B	C	C
92 mm	ADR 2	C	C	C
94 mm	ADR 2	C	C	D
96 mm	ADR 2	C	D	D
98 mm	ADR 2	D	D	D

Combination specifications ADR-C / ADR-C2

Clamping diameter	Jaw turning ring	Clamping pins		
		SB 1	SB 2	SB 3
100 mm	ADR 2	D	D	E
102 mm	ADR 2	D	E	E
104 mm	ADR 2	E	E	E
106 mm	ADR 2	E	E	F
108 mm	ADR 2	E	F	F
110 mm	ADR 2	F	F	F
112 mm	ADR 2	F	F	G
114 mm	ADR 2	F	G	G
116 mm	ADR 2	G	G	G
118 mm	ADR 3	-	-	-
120 mm	ADR 3	A	-	-
122 mm	ADR 3	A	A	-
124 mm	ADR 3	A	A	A
126 mm	ADR 3	A	A	B
128 mm	ADR 3	A	B	B
130 mm	ADR 3	B	B	B
132 mm	ADR 3	B	B	C
134 mm	ADR 3	B	C	C
136 mm	ADR 3	C	C	C
138 mm	ADR 3	C	C	D
140 mm	ADR 3	C	D	D
142 mm	ADR 3	D	D	D
144 mm	ADR 3	D	D	E
146 mm	ADR 3	D	E	E
148 mm	ADR 3	E	E	E
150 mm	ADR 3	E	E	F
152 mm	ADR 3	E	F	F
154 mm	ADR 3	F	F	F
156 mm	ADR 3	F	F	G
158 mm	ADR 3	F	G	G
160 mm	ADR 3	G	G	G
162 mm	ADR 4	-	-	-
164 mm	ADR 4	A	-	-
166 mm	ADR 4	A	A	-
168 mm	ADR 4	A	A	A
170 mm	ADR 4	A	A	B

Combination specifications ADR-C / ADR-C2

Clamping diameter	Jaw turning ring	Clamping pins		
		SB 1	SB 2	SB 3
172 mm	ADR 4	A	B	B
174 mm	ADR 4	B	B	B
176 mm	ADR 4	B	B	C
178 mm	ADR 4	B	C	C
180 mm	ADR 4	C	C	C
182 mm	ADR 4	C	C	D
184 mm	ADR 4	C	D	D
186 mm	ADR 4	D	D	D
188 mm	ADR 4	D	D	E
190 mm	ADR 4	D	E	E
192 mm	ADR 4	E	E	E
194 mm	ADR 4	E	E	F
196 mm	ADR 4	E	F	F
198 mm	ADR 4	F	F	F
200 mm	ADR 4	F	F	G
202 mm	ADR 4	F	G	G
204 mm	ADR 4	G	G	G
206 mm	ADR 5	-	-	-
208 mm	ADR 5	A	-	-
210 mm	ADR 5	A	A	-
212 mm	ADR 5	A	A	A
214 mm	ADR 5	A	A	B
216 mm	ADR 5	A	B	B
218 mm	ADR 5	B	B	B
220 mm	ADR 5	B	B	C

Combination specifications ADR-C / ADR-C2

Clamping diameter	Jaw turning ring	Clamping pins		
		SB 1	SB 2	SB 3
222 mm	ADR 5	B	C	C
224 mm	ADR 5	C	C	C
226 mm	ADR 5	C	C	D
228 mm	ADR 5	C	D	D
230 mm	ADR 5	D	D	D
232 mm	ADR 5	D	D	E
234 mm	ADR 5	D	E	E
236 mm	ADR 5	E	E	E
238 mm	ADR 5	E	E	F
240 mm	ADR 5	E	F	F
242 mm	ADR 5	F	F	F
244 mm	ADR 5	F	F	G
246 mm	ADR 5	F	G	G
248 mm	ADR 5	G	G	G

5.2.2 Combination specifications ADR-S

Clamping diameter	Jaw turning ring	Clamping pins		
		SB 1	SB 2	SB 3
250 mm	ADR 6	-	-	-
255 mm	ADR 6	A	-	-
260 mm	ADR 6	A	A	-
265 mm	ADR 6	A	A	A
270 mm	ADR 6	B	-	-
275 mm	ADR 6	B	B	-
280 mm	ADR 6	B	B	B
285 mm	ADR 6	C	-	-
290 mm	ADR 6	C	C	-
295 mm	ADR 6	C	C	C
300 mm	ADR 6	D	-	-
305 mm	ADR 6	D	D	-
310 mm	ADR 6	D	D	D
315 mm	ADR 7	-	-	-
320 mm	ADR 7	A	-	-
325 mm	ADR 7	A	A	-
330 mm	ADR 7	A	A	A
335 mm	ADR 7	B	-	-
340 mm	ADR 7	B	B	-
345 mm	ADR 7	B	B	B
350 mm	ADR 7	C	-	-

Combination specifications ADR-S

Clamping diameter	Jaw turning ring	Clamping pins		
		SB 1	SB 2	SB 3
355 mm	ADR 7	C	C	-
360 mm	ADR 7	C	C	C
365 mm	ADR 7	D	-	-
370 mm	ADR 7	D	D	-
375 mm	ADR 7	D	D	D
380 mm	ADR 8	-	-	-
385 mm	ADR 8	A	-	-
390 mm	ADR 8	A	A	-
395 mm	ADR 8	A	A	A
400 mm	ADR 8	B	-	-
405 mm	ADR 8	B	B	-
410 mm	ADR 8	B	B	B
415 mm	ADR 8	C	-	-
420 mm	ADR 8	C	C	-
425 mm	ADR 8	C	C	C
430 mm	ADR 8	D	-	-
435 mm	ADR 8	D	D	-
440 mm	ADR 8	D	D	D
445 mm	ADR 8	-	-	-
450 mm	ADR 9	A	-	-
455 mm	ADR 9	A	A	-
460 mm	ADR 9	A	A	A
465 mm	ADR 9	B	-	-
470 mm	ADR 9	B	B	-
475 mm	ADR 9	B	B	B
480 mm	ADR 9	C	-	-
485 mm	ADR 9	C	C	-
490 mm	ADR 9	C	C	C
495 mm	ADR 9	D	-	-
500 mm	ADR 9	D	D	-
505 mm	ADR 9	D	D	D

6 Operation

6.1 Basic information

⚠ WARNING

Risk of injury when the product is rotating, due to the possibility of parts flying off!

- Do not exceed the maximum permissible clamping force.
- Make sure that the clamping pins are mounted and seated correctly.
- Ensure that the flat areas or clamping pins are in full contact with the chuck jaws.
- Remove the locking pins before turning.
- Take suitable protective measures to secure the danger zones.
- Wear suitable protective equipment.

⚠ WARNING

Danger of crushing, impact and cutting when clamping and unclamping the product!

- When clamping and unclamping the product, do not reach between the product and the chuck jaws.
- Prevent unintentional actuation of the lathe chuck.
- Remove sharp edges on the chuck jaws after turning.
- Wear suitable protective equipment, especially gloves.

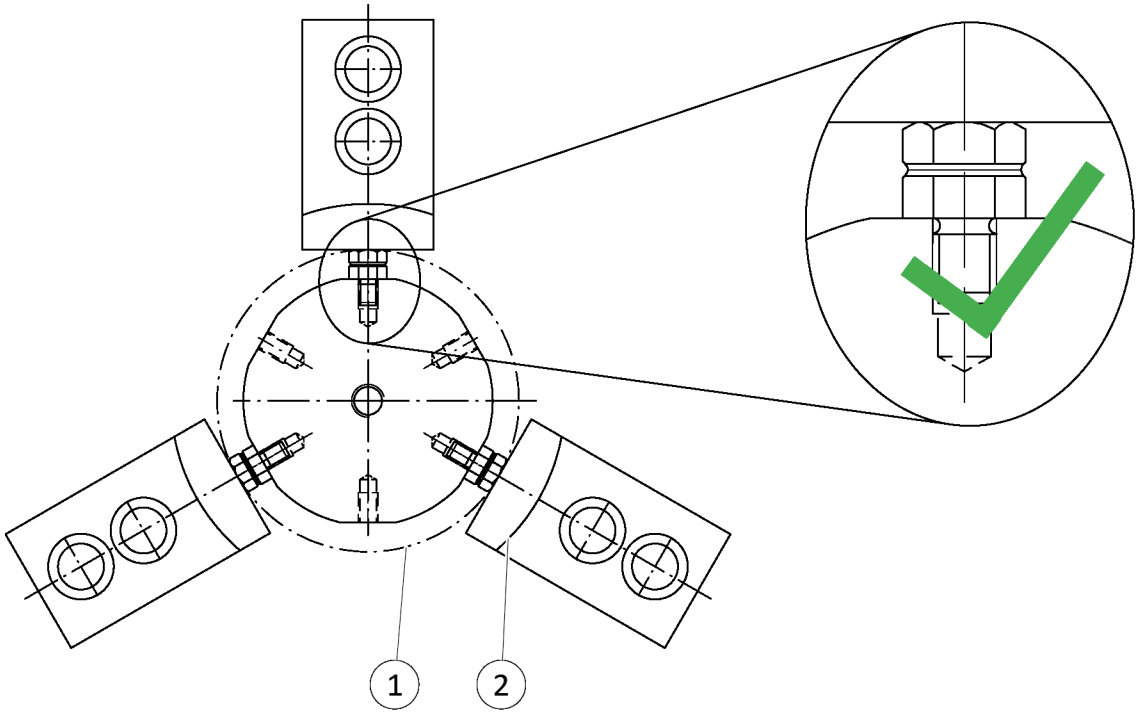
NOTICE

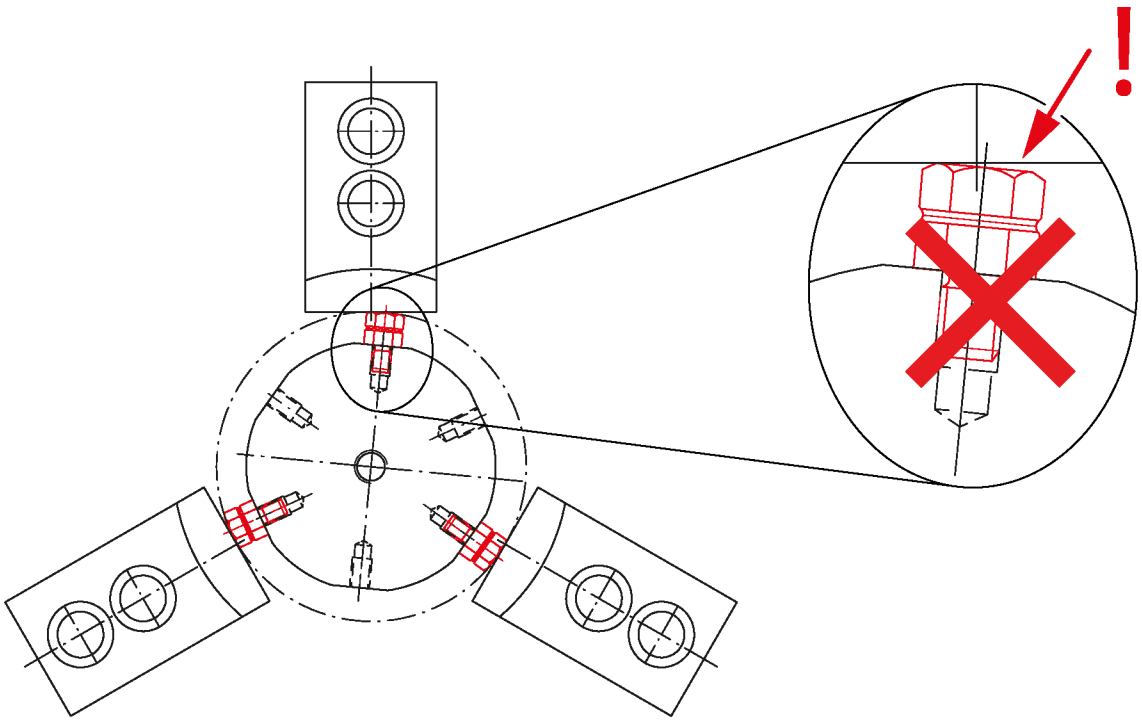
Possible material damage due to incorrect loading of the clamping pins.

If the clamping pins are loaded laterally, they can be damaged or sheared off.

- Ensure that the clamping pins are in full contact with the chuck jaws.
- Do not load the clamping pins laterally.

6.2 Clamping the product





1	ADR clamping diameter
2	Workpiece clamping diameter

When clamping the product, observe the following points:

- Ensure that the product is clamped by the chuck jaws and not by the base jaws of the lathe chuck.
- Turn or grind the product in the lathe chuck under the same clamping force as the subsequent workpiece. Do not exceed the maximum permissible clamping force ▸ 3 [🗋 13].
- The flat areas or clamping pins must be in full contact with the chuck jaws.

For clamping, proceed as follows:

1. Mount the chuck jaws to be turned according to the specifications in the operating manual of the lathe chuck used.
2. Unclamp the lathe chuck according to the specifications in the operating manual of the lathe chuck used.
3. If used, ensure that the clamping pins are mounted correctly ▸ 5 [🗋 15].
4. Screw the locking pin into the axial thread (only for ADR-C/ ADR-C2).
5. Insert the product into the lathe chuck in the correct position. **NOTE:** Make sure that the product (or the clamping pins) is/are in full contact with the chuck jaws and not with the base jaws of the lathe chuck!
6. Clamp the lathe chuck according to the specifications in the operating manual of the lathe chuck used. Do not exceed the maximum permissible clamping force ▸ 3 [🗋 13].
7. Remove locking pin (only for ADR-C/ADR-C2).

   ✓ The product is reliably clamped. The chuck jaws can be turned.

IMPORTANT! Sharp burrs can occur when turning chuck jaws! Deburr the chuck jaws after turning!

6.3 Unclamping the product

1. Secure the product against falling.
2. Unclamp the lathe chuck according to the specifications in the operating manual of the lathe chuck used.
3. Remove the product.

7 Maintenance

7.1 Basic information

⚠ CAUTION

Injury of the eyes by dirt particles

When cleaning with compressed air, the eyes may be injured by flying dirt particles.

- Wear suitable protective equipment, particularly protective goggles.

For trouble-free, long-lasting use, clean, maintain and check the functionality of the product regularly.

Repair work may only be carried out by SCHUNK!

If you have any questions regarding maintenance and servicing, our technical
customer service is available during our business hours:
Service telephone: +49-7133-103-2956
service.toolholder@de.schunk.com

7.2 Intervals and tasks

Operation	Interval period
Cleaning and testing the product	after every clamping procedure

The specified maintenance intervals are based on practical experience gathered by SCHUNK and are recommended. Depending on the ambient and operating conditions, as well as the clamping frequency of the product, the maintenance intervals must be adapted and noted accordingly. For maintenance intervals with two or more specifications, the valid specification is the one that applies first.

7.2.1 Cleaning and testing the product

1. Disassemble clamping pin ▶ 8 [🗋 29].
2. Clean the entire product and attachments with compressed air.
3. Wipe all surfaces dry with a clean cloth.
4. Check the product and attachments, in particular the contact surfaces, for deformation, damage or wear. Replace if necessary.

NOTE: Damage or wear can compromise the functioning of the product. If non-replaceable parts of the product are worn or damaged, return the product to SCHUNK for inspection.

8 Disassembly

8.1 Basic information

⚠ WARNING

Risk of injury if the product falls during transport, assembly or disassembly.

Due to the oily surface required to preserve it, the product can slip through your hands, resulting in injury.

- Take appropriate safety measures to prevent the product from falling.
- Wear suitable protective equipment, especially protective gloves and safety boots.

⚠ CAUTION

Risk of crushing and impact when assembling and disassembling the clamping pins.

- Do not reach in between the product and the clamping pins.
- Wear suitable protective equipment.

8.2 Disassembling the clamping pins

1. Unclamp the product ▸ 6.3 [🗋 27].
2. Unscrew and remove the clamping pins.

NOTE: To avoid scratches, only place the product on a clean and soft surface.

9 Storage

When storing the product for a longer period of time, observe the following points:

- Clean the product and attachments and lubricate lightly.
- Store the product and attachments in a suitable transport container.
- Only store the product and attachments in dry rooms.
- Protect the product and attachments from major temperature fluctuations.
- Comply with the storage temperature specified in the technical data.

NOTE: Before reassembling, clean the product and all attachments ▶ 7.2.1 [🗋 28], and check for damage, functionality and tightness.

10 Spare parts list

ADR-C/ADR-C2

ID	Designation
122175	ADR-C clamping pin set
6100001	ADR-C clamping pins
9957984	Transport protection

ADR-S

ID	Designation
6100011	Clamping pin M8, h = 7.5 mm
6100020	Clamping pin M8, h = 15 mm
6100012	Clamping pin M8, h = 22.5 mm
6100021	Clamping pin M8, h = 30 mm
9957985	Transport protection

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