

Support Bulletin: RASD-SB00042

Model: Roland MDX-540A/SA or ZAT-540 Automatic Tool Changer Unit

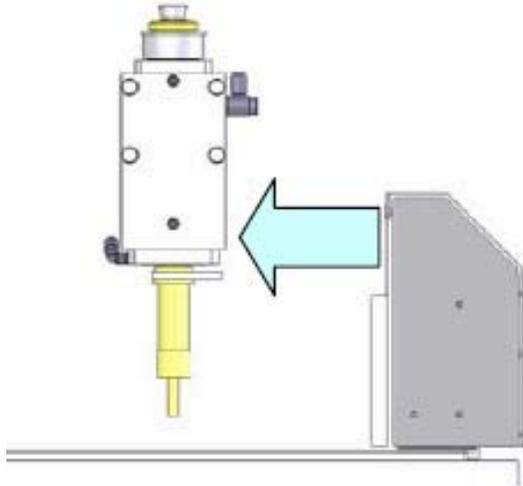
Subject: Tool Holder Stuck in Spindle

Date: 10/14/2007

Author: PG

How to remove Tool Holder Stuck in Spindle:

1. Turn off power and manually move the spindle to the left.



2. Turn on the power and press [CLEAR] button to do a force release and pull down on the tool holder.



3. Press the [CLEAR] button to do a force release and hit the root of the tool holder from its front with a plastic hammer lightly.

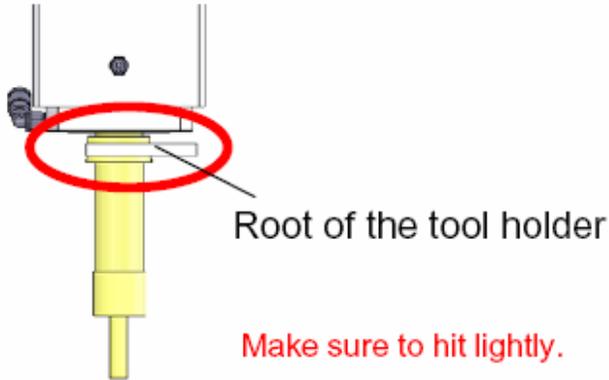
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4. If the tool holder can not be removed, remove the ATC spindle from machine, use a hand press machine (or something similar) to push in the top of the spindle which will release the tool holder.



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Attention

When using a hammer, do not hit the part that is far from the root of the tool holder. It can give a bad effect on the spindle or the tool holder.

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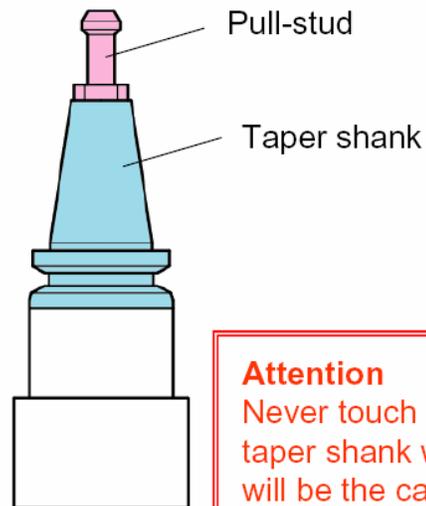
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Reasons for Tool Holder sticking in Spindle:

1. Tool Holder gets stuck due to rust or scratches on taper shank.
2. Metals stick together by oxide film generated by heat of long milling time or high spindle loads.



Attention

Never touch the pull-stud or taper shank with your hands. It will be the cause of rusting.

How to prevent Tool Holder sticking in Spindle (Tool Holder Maintenance):

1. The tool holder is originally supplied with antirust oil applied. The oil will evaporate after being removed from its original packaging. Remove holder from original packaging and remove antirust oil.



2. Apply silicone spray on the Tool Holder and wipe it clean.
3. As a daily maintenance, apply silicone spray to the tool holder and taper portion of the tool holder and wipe it clean.

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Advanced Solutions Division

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Silicone Spray will provide the following benefits.

1. Keeps object dry prevents dust from accumulating on it.
2. Silicone oil film prevents rust and scratches.
3. Silicone oil film prevents oxide film from being generating from long milling time or high spindle loads.



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