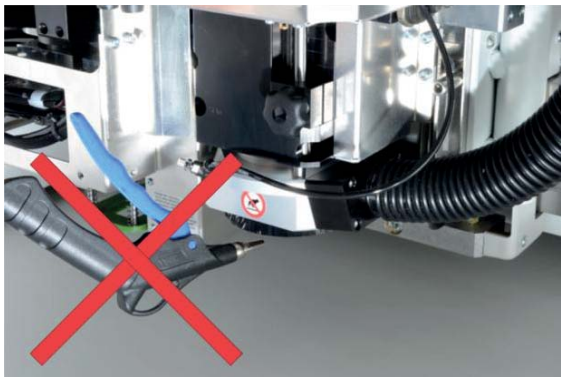
Release the lock to allow the suction house moving down to its down position.



Regularly, perform a chuck holder and chuck cleaning, following the dedicated procedure.

Note:
Never apply compressed air for cleaning.

8.8.6.2 If a bit is stuck

If a bit is stuck in the chuck, the probable cause is low air pressure.

To release a router bit from the chuck, a pressure of approximately 7 bar is required.

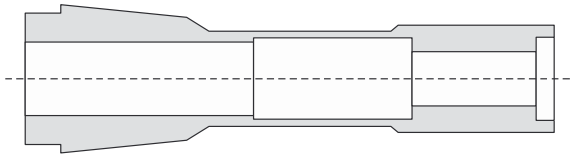
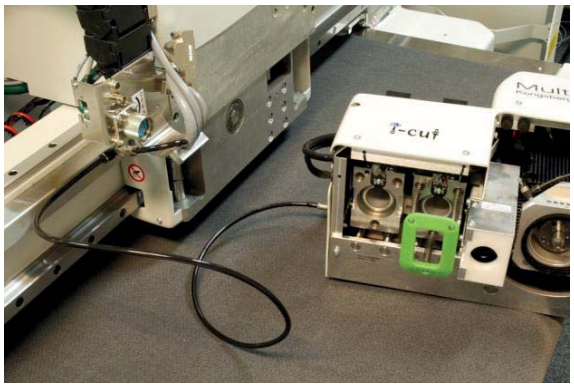
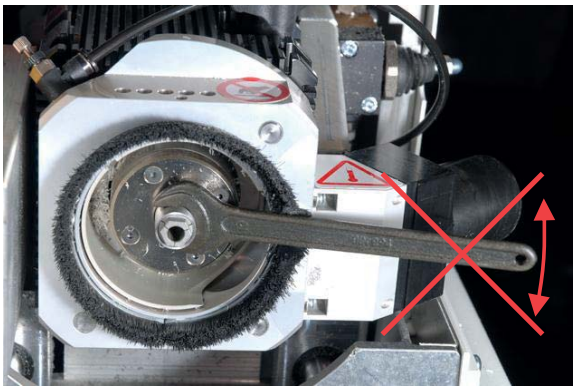
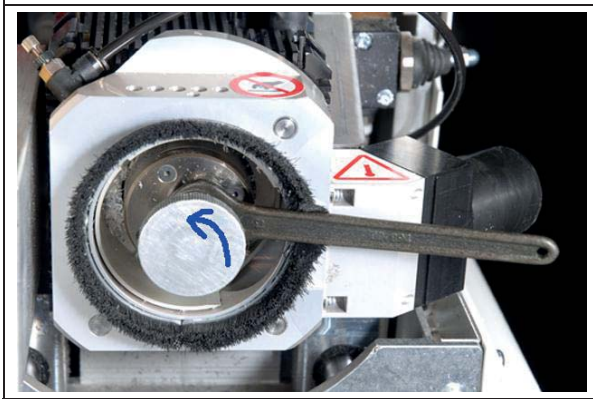
If necessary, check the table regulator setting, or the pressurized air source.

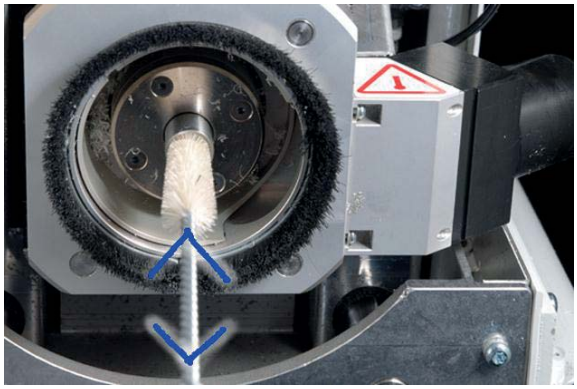
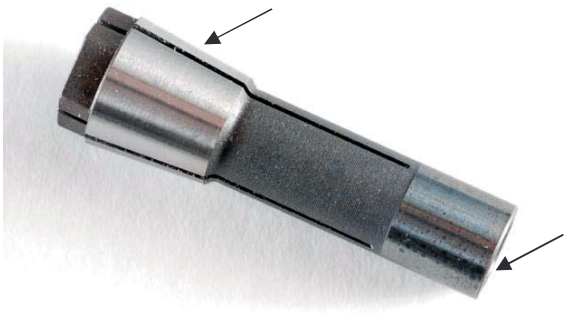
If the bit is still stuck, see the *Chuck change and clean* section how to unscrew the chuck.

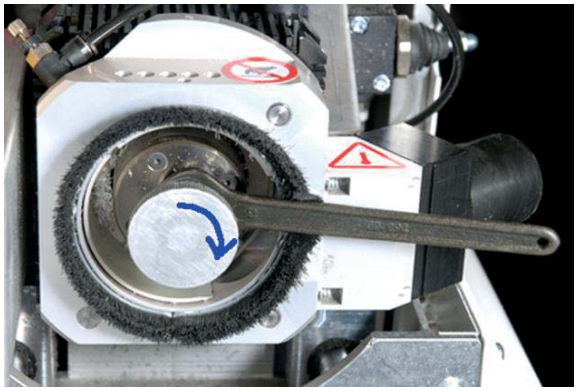
8.8.7 Chuck change and clean

Clean the taper and the chuck regularly for proper operation and optimum life time of spindle and chuck; at least once a week, but more often if necessary. Follow the procedure strictly.

Normally, the chuck has a long lifetime. Extended vibrations or impacts may hurt the chuck, and cause bad milling results. Trying a new chuck is the easiest way to identify if the chuck is the problem. Running with a bad chuck will also increases the spindle wear.

	The IBAG chuck is lockable, meaning it needs no adjustment when entering the bit.
	Place the tool head on the table. Open the chuck and remove any bit. Note: Never apply compressed air for cleaning.
	Apply the 13 mm (17 mm for MultiCUT-HP) key to hold the spindle rotor. Note: Do not turn the rotor when in CHUCK OPEN position. This might damage the spindle.
	Enter the chuck tool with a dummy bit to the chuck.
	Hold the rotor with the 13 mm (17 mm for MultiCUT-HP) key and unscrew the chuck with the chuck tool. Note: If you can not move the chuck with the chuck tool, another 10 mm (12 mm for MultiCUT-HP) key might be used, together with a bit, to **unscrew** the chuck. This procedure might be necessary if a bit is stuck.

	Apply the taper brush to clean the taper.
	Push the air clean button to help remove contamination.
	Clean the chuck.
	Apply small quantities of grease to the threads of the chuck when necessary. Avoid the clamping area. Do not use oil, as it could enter the clamping area and reduce the clamping force. Also apply small quantities of grease to the outer cone of the chuck.

	Torque up the chuck by hand, using the chuck tool and a dummy bit. (Maximum torque 2 Nm, 18 lbf-in). Hold the rotor with the 13 mm/17 mm key.
	Close the chuck on a dummy bit.

	Chuck maintenance kits are available on the Esko web shop, www.esko.com.