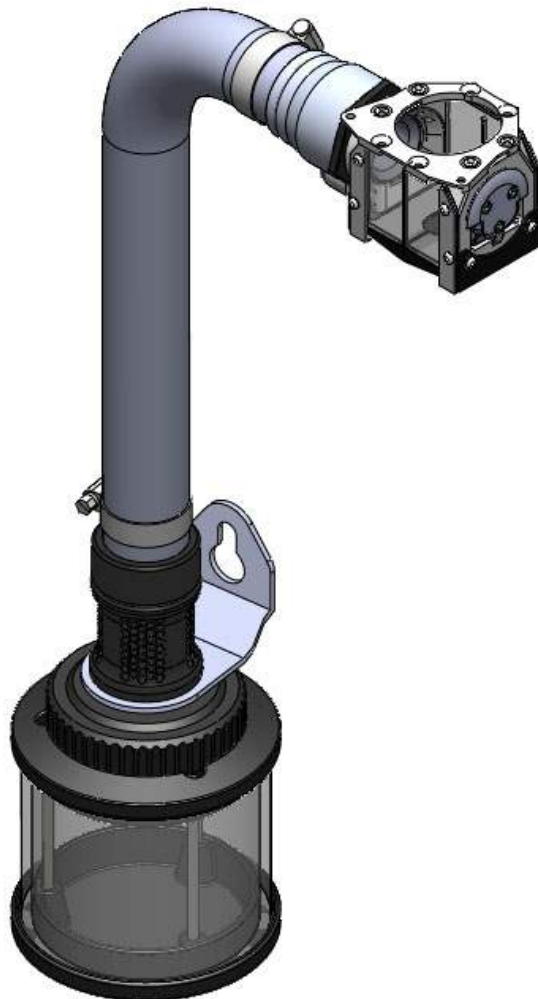




CVC4 Chip Collector

Instruction Manual

Please read this manual thoroughly before starting use, and use the product correctly.



REVISION

Revision history

Version	Date	Contents
First edition	03.08.2017	First edition issue
Revised edition	03.05.2019	Change Contacts page Change of address in China
Revised edition	May.2019	Format change

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1. Precautions

■FEATURES

When used with a dresser manufactured by Kyokutoh, this chip collector will efficiently collect the chips that are generated during dresser operation.

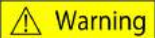

※It cannot be attached to any dressers other than the specified models.

Supported models



CD-D-F type, CDK-R type, CD-SVR type, CDK-BAYO type, CDK-SG type, etc.

■SYMBOLS

This following symbols “Warning” and “Caution”, are used indicate possible hazards and to prevent their occurrence.

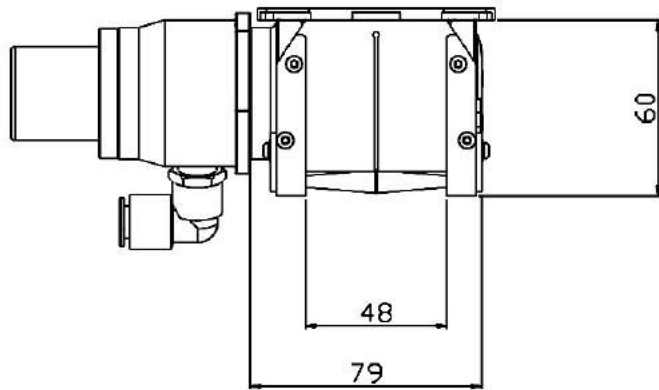
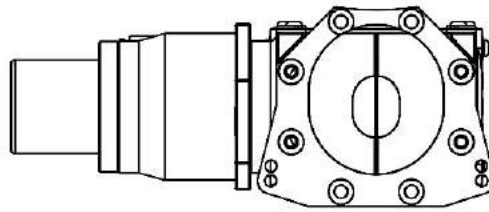
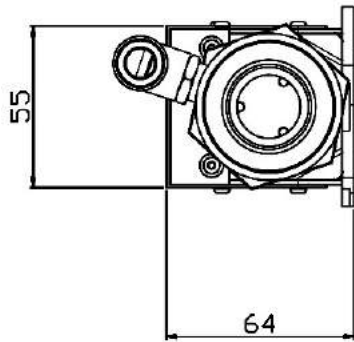
 Warning	Be careful to follow directions as specified, as an error could lead to possible injury or death.
 Caution	Be careful to follow direction as specified, as an error could lead to malfunction and serious damage.

■The following symbols are explained below.

	This symbol indicates operations that should not be done.
	This symbol indicates operation that should be done.

※After reading, please the manual to the place where you can check the manual.

2. External Dimensions



Precautions regarding shape

※The shape of the CVC4 may vary depending on the supported model.

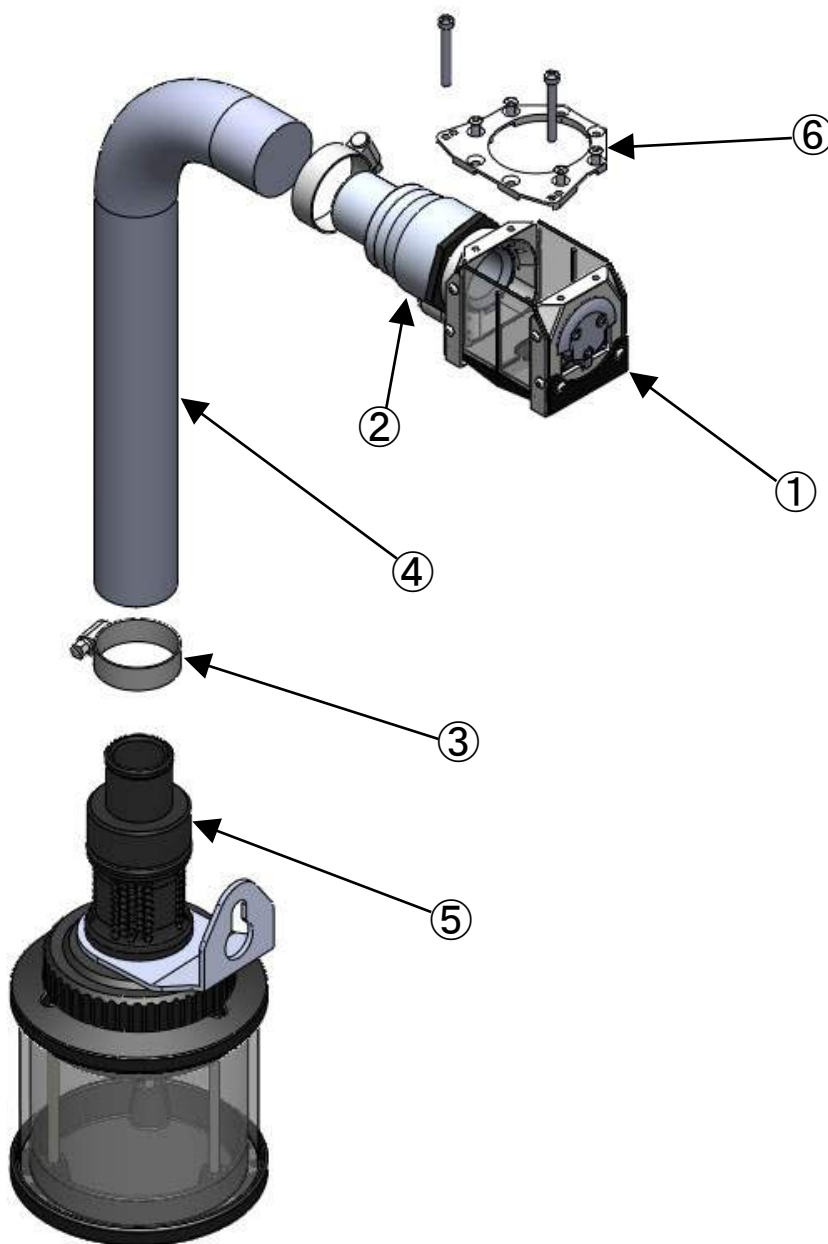
※Make the maximum width of the gun that can be inserted into the CVC4 38 mm or less (when inserted from the front).

※Even if the gun width is 38 mm, depending on the gun shape and the angle of insertion, interference may occur in some cases, so that it is only possible to use the product with a narrower gun.

※Depending on the dresser model that the product is attached to and the insertion angle of the gun, the gun's insertion width for an oblique insertion layout may be significantly affected by interference. As a guideline, use a gun width of 30 mm as the maximum.

3. Component Details

No	Name	Model	QTY
1	CVC4 main unit set	CVC4-SET	1
2	Vacuum set	CD-VAC2	1
3	Hose band	40	2
4	Hose (1 m)	Ø32 (Inner diameter)	1
5	Dust box	DB-01-SET	1
6	Adapter set for each machine	Will vary depending on the dresser	1



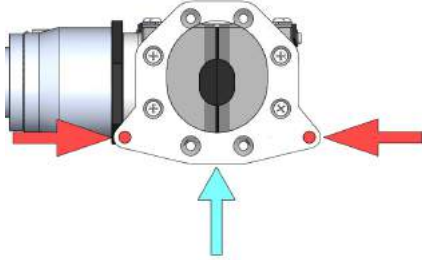
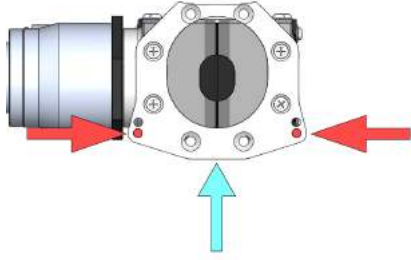
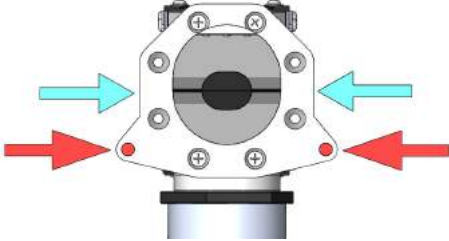
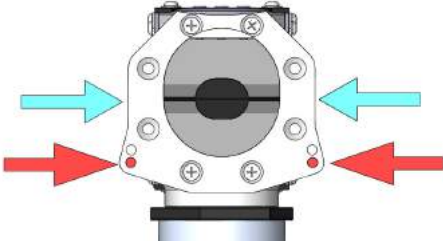
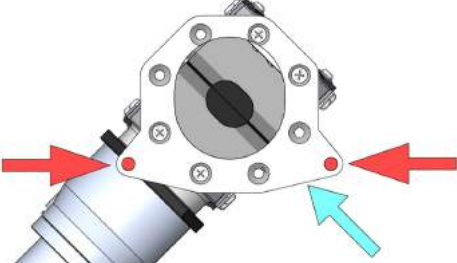
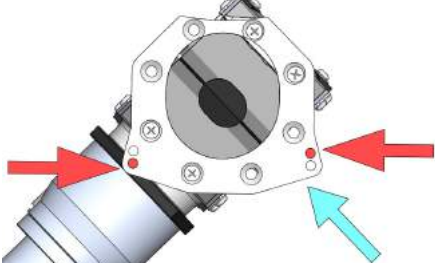
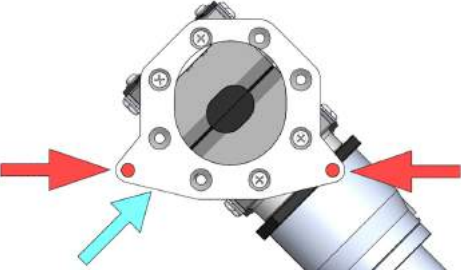
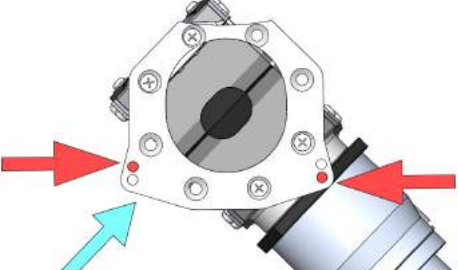
※This diagram is the CVC4 assembly diagram for the K type.

4. Assembly Procedure

■ Referring to Table below, check the gun insertion procedure, and assemble the CVC4.

1. Installation model (dresser) and gun insertion direction

※ The blue arrows indicate the gun insertion direction, and the red circles indicate the positions for connection to the dresser.

Dresser	For CD-D-F	For CDK-R
Set model	CVC4-D-1M	CVC4-K-1M
Screw	SUS cap bolt M4-L28-M4 nut	SUS cap bolt M4-L30 + SW + flat washer
Insertion direction	 <p>The vacuum unit can also be attached to the right side</p>	 <p>The vacuum unit can also be attached to the right side</p>
Right and Left	 <p>The gun can be inserted from both right and left</p>	 <p>The gun can be inserted from both right and left</p>
Diagonally right forward	 <p>Note) In the case of CD-D-F, attachment may sometimes not be possible owing to interference with the body</p>	 <p>The attachment screw holes are different on the right and left</p>
Diagonally left forward	 <p>Note) In the case of CD-D-F, attachment may sometimes not be possible owing to interference with the body</p>	 <p>The attachment screw holes are different on the right and left</p>

2. Assembling to the dresser

Assemble to the dresser using the included screws, placing them in the attachment holes on the adapter shown in Table above.

If there are already any screws at the assembly positions for the dresser, remove them, and replace them with the included screws.

There are models for which the screw holes that are to be used for assembly to a dresser will vary depending on the insertion direction. Confirm the corresponding dresser type thoroughly, and then attach to the main unit.

3. Attaching the hose and hose band (Common to all models)

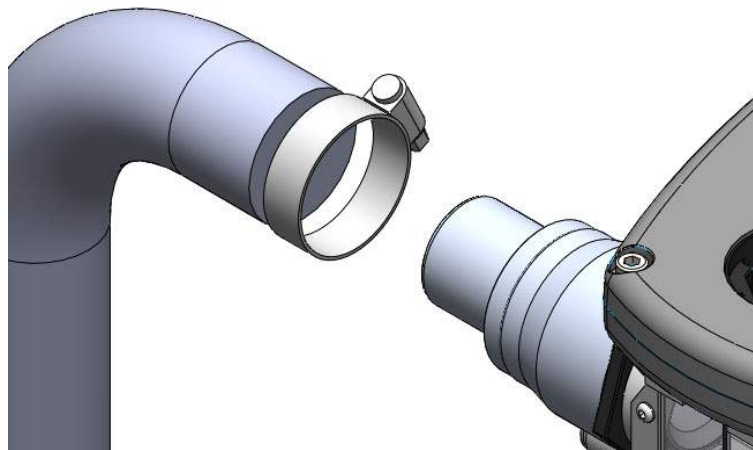
For the hose, a standard 1-m hose comes included. Cut it before use if it is too long.

If you use the hose with it bent at an acute angle, it may cause chip clogging or hose damage, so please use it with an appropriate bend angle (100R or more).

Although flame-retardant materials have been used for the hose, it will not be able to withstand extreme heat.

Do not use it in an environment where it is conceivable that something could ignite.

※If you use the hose with a length of more than 1m, the product may not be able to demonstrate its proper performance due to lowering the suction force.



4. Attach the dust box, hose and hose band (common to all models)



5. Completion

Connect the air hose to the nipple on the vacuum unit, and it is ready to use.

Use an air hose with an outer diameter $\varnothing 10$.

Also, use the product in an environment with an air source pressure of 0.5 MPa or more. If the pressure at the source is less than that, the product may not be able to demonstrate its full suction capacity.



※Example of connection to a K type dresser manufactured by Kyokutoh.

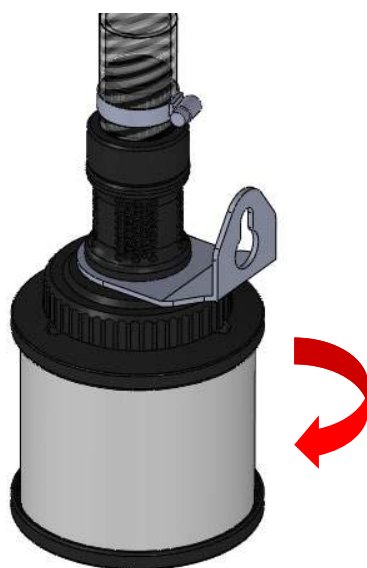
5. DB-01-SET Chip Disposal Procedure

■Precaution

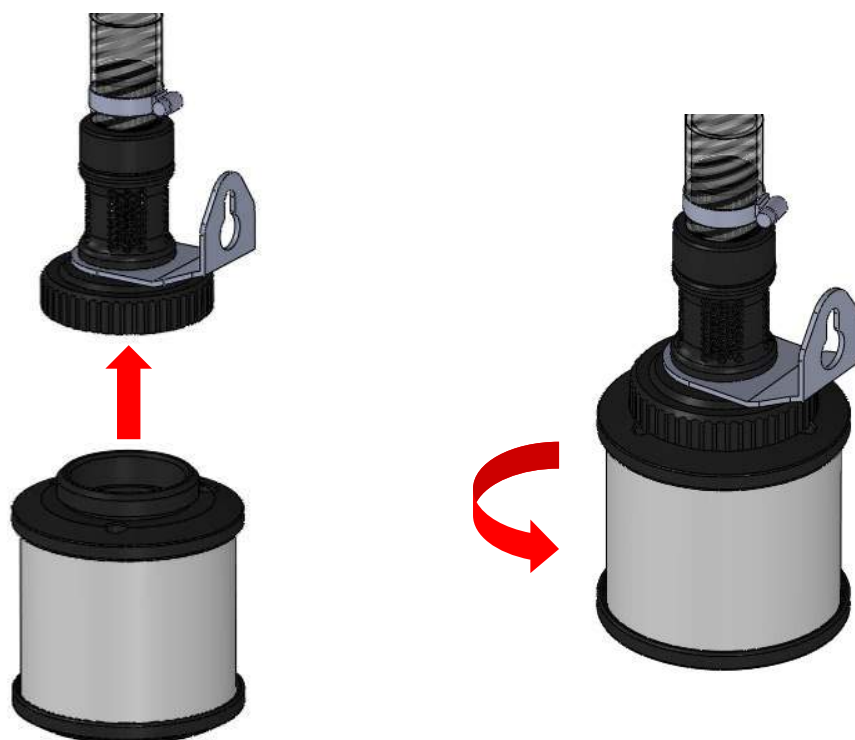
ダストボックス DB-01 に切粉が完全に詰まる前にゴミの排出を行ってください。製品や使用状況により異なりますが、一般的な $\phi 16$ チップ約 1500 回研磨で満タンとなります。切粉を廃棄せず溜まったまま本製品を使用しますと、吸引不良の原因となります。

■Procedures

- 1) Remove the dust box.

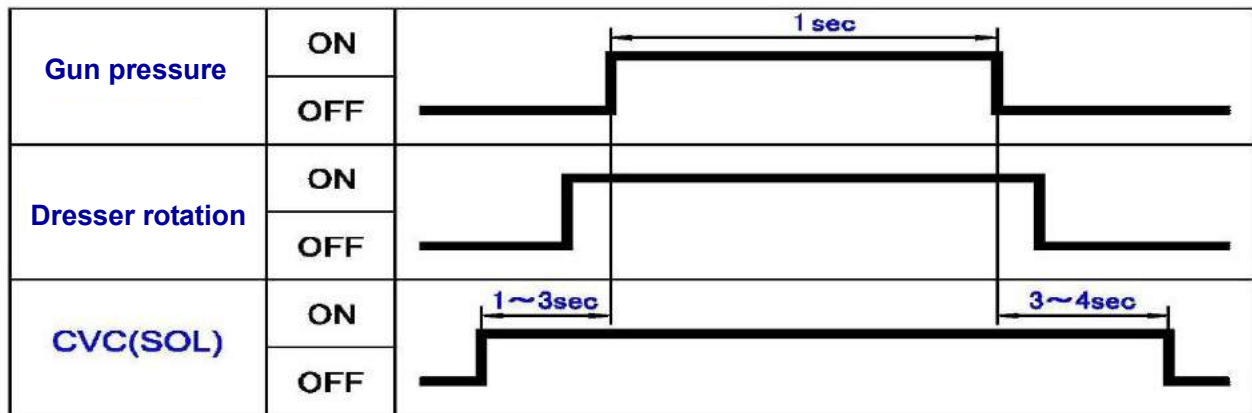


- 2) Dispose of the chips and assemble the dust box.



6. Timing Chart

■ Timing



Make adjustments as necessary, referring to the above.

If you are using a hose that is 1 m or longer for the hose from CVC to the dust box, adjust the CVC (SOL) suction time so that it is a fairly long time.

7. Maintenance

If any damage to the transparent sheet or brush is confirmed, refer to the appendix, "Diagram of consumable parts," and replace them.

Periodically check that chips are not getting clogged up inside the CVC, and if any clogging, dust, etc., is confirmed, remove it.

8. Troubleshooting

■ Suction is poor

1. Check the air pressure. (Recommended: 0.5 MPa.)
2. If the recommended air pressure has been confirmed, check whether the source pipe and the CVC main unit are connected by a single pipe. When doing so, also check the hose diameter (Ø10 or more).

※If the pipe branches midway, it will not provide a suction power of 0.5 MPa, and the suction power will be insufficient.

3. If the hose is bent at an acute angle, the product may not be able to demonstrate its proper performance.

It may also cause a fault, so use the hose with a moderate curvature (R150 or less).

Furthermore, check that chips have not built up in the chip receiving section (DB-01).

9. Supplement

● Required specs for the solenoid valve

→ One with a Cv value of 1.0 or more

● Recommended solenoid valve type

→ SMC: VP342-5G1-02A

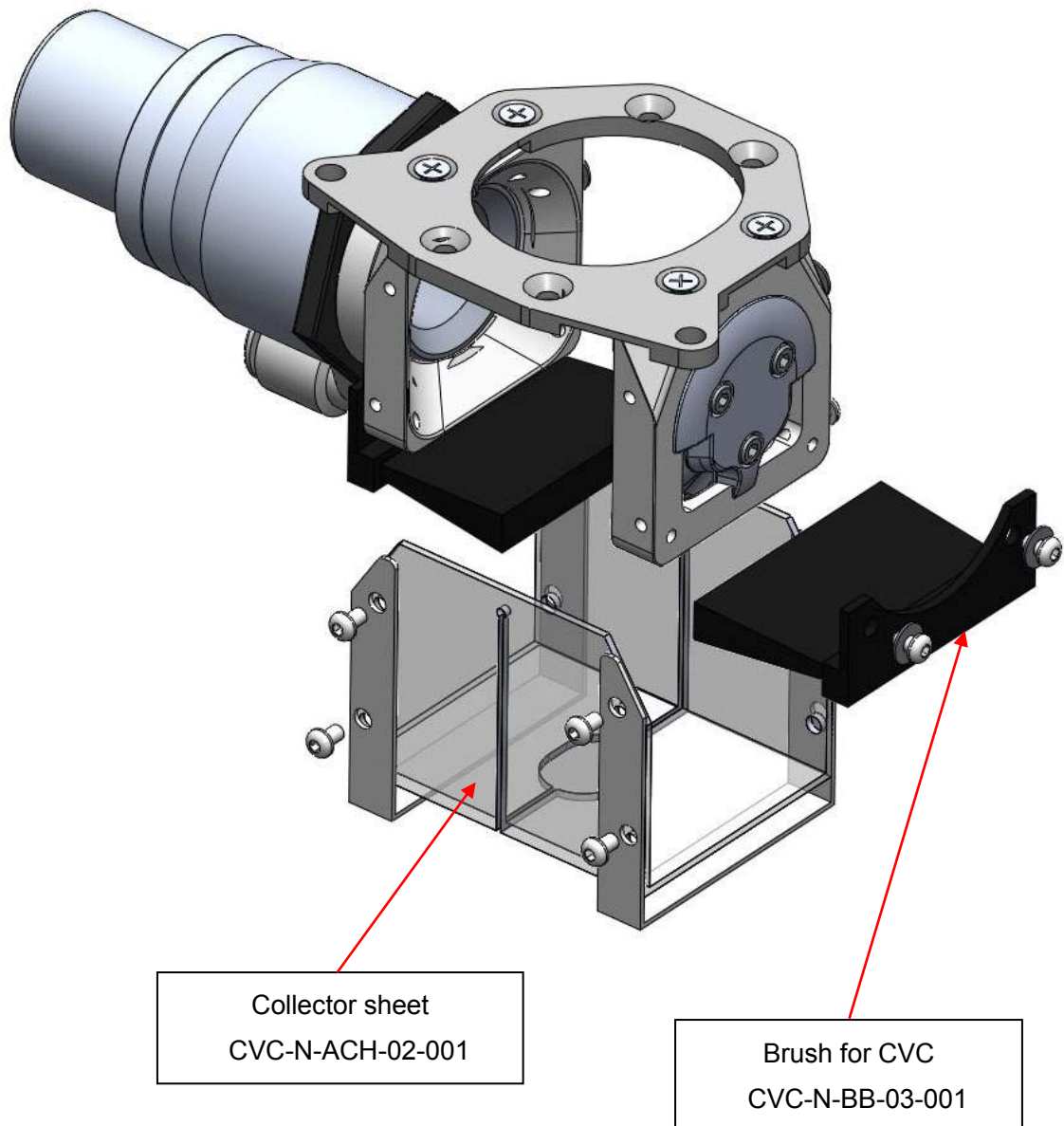
● Diameter for the hose from the solenoid valve to the CVC

→ Ø10 or more

● Diameter for the hose from the CVC to the dust box

→ Ø32 (Inner diameter)

10. Consumption Parts



※One chip collector sheet and two brushes are required for one chip collector.

※Screws for attachment do not come included with each part.

MEMO

Contacts

Contact us if there is any damage or machine defects in our products.



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