



BBN International

SFP-550 Service Schedule

To be read in conjunction with the SFP-550 Maintenance Manual

Replace grease

Standard maintenance (Monthly, figure 1-2-1)

- 1) Pull the Turntable (RP55-01) up from the machine
- 2) Remove the Position Plate (RP55-04) from the Eccentric Drive Ring (RP55-05)
- 3) Wipe and clean both the Turntable and Eccentric Drive Ring
- 4) Apply new grease (FP-GS)

Note: Most important point is to keep the bottom surface of Turntable and top surface of Support Ring (RP55-03) greased; these surfaces touch during polishing.

Height dimension check

Standard maintenance (Every 3 months, figure 1-2-2)

- 1) Prepare FP-HG55 height inspection tool
- 2) Place two pcs of block gauge on level block as figure 1-2-2 and set "0" level
- 3) Place the tool to the machine
- 4) Read graduations

Spec : +/- 0.02mm for Fixed type polishing holder

Spec : +/-0.05mm for IPC type polishing holder (IPC holders can absorb unevenness)

If the dimension is out of specification then check spacer ring as follows:

- 1) Prepare Caliper and 4mm Hex wrench
- 2) Loosen the screw of the corner of base plate (see page 8 of manual)
- 3) Pull a corner post unit up from base plate
- 4) Measure the thickness of Spacer Ring (RP55-16)
- 5) Order Spacer Ring of suitable thickness (available 2.80~3.00mm)

Pressurising unit check

Standard maintenance (Every 6 months, figure 1-2-3)

- 1) Prepare Caliper, 5mm and 2.5mm Hex wrench
- 2) Loosen the two screws on Clamp Rod (RP55-17) with 2.5mm wrench
- 3) Loosen top screw inside Clamp Pin (RP55-18) with 5mm wrench
- 4) Remove the screw from the Clamp Pin and then the Spring (RP55-20) will come out with the screw
- 5) Carefully measure the length of spring

Spec : 14.5 mm minimum

If the spring is out of specification then replace as follows:

- 1) Insert the spring to clamp pin
- 2) Insert the screw to clamp pin and tighten with 5mm wrench until height difference between Clamp Pin and the screw head is 5.0 +/-0.1mm. (See Page 9 of manual for detail)
- 3) Tighten the two screws on Clamp Rod

Note: If the two screws on Clamp rod are tightened unevenly then the Clamp lever will not move smoothly. Please tighten these screws evenly.

Treatment of all gear units

Full service (Once a year or if unusual sounds occur from inside)

- 1) Prepare 2.5mm wrench and Pliers for C-ring
- 2) Replace grease (see above)
- 3) Remove the 4 screws on Support Ring (PH55-03) with 2.5mm Hex wrench
- 4) Remove the Support Ring from base plate
- 5) Remove the 100T Gear Unit from base plate

Note: This process is a little difficult because there is no special tool to remove 100T gear unit from base plate. Use some "L" shape hex wrenches to lever the unit out.

- 6) Check the colour of grease inside the unit, if it is not green then it needs to be replaced.
- 7) Remove the 3pcs of C-ring with C-ring pliers
- 8) Disassemble the 100T gear unit
- 9) Wipe and clean all parts and reassemble the gear unit
- 10) Apply new grease to base plate and gear unit