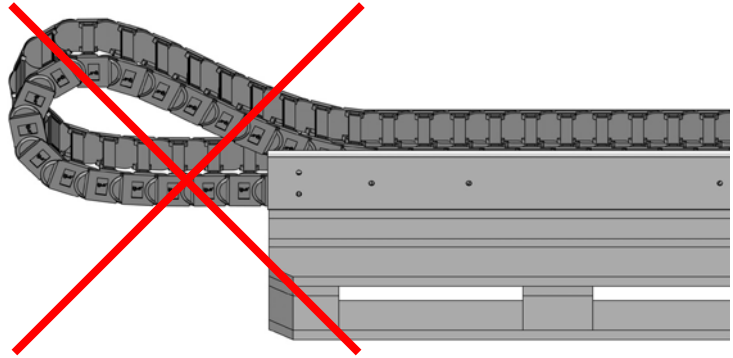
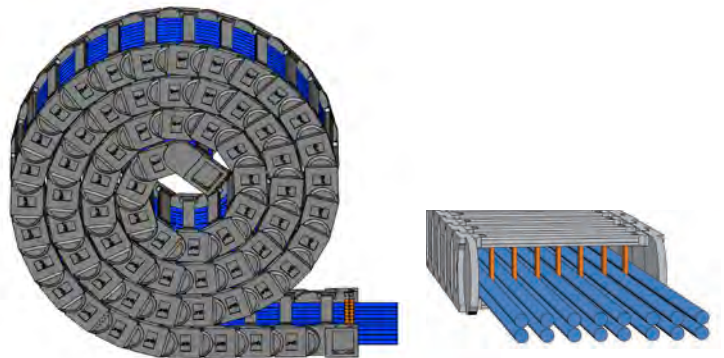


# Packing, Storing, Transporting

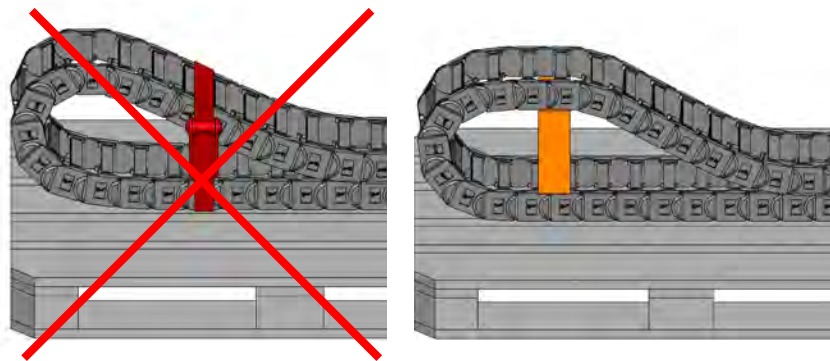
- 1** No free protrusion of the chain from the pallet.



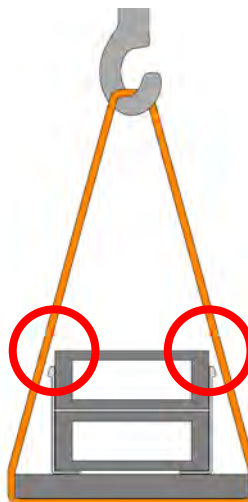
- 2** When rolling up the chain release the strain relief at one end.



- 3** Never fix the chain with a lashing strap! We suggest supporting the radius (see diagram to the right) and to fix with pallet wrap.



- 4** During transport on a strap (e.g. using a crane), the strap must not touch the crane or the guide trough.

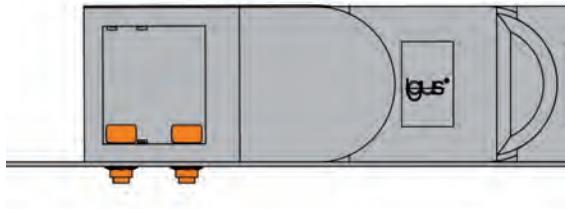


# Visual inspection of the installed e-chain®

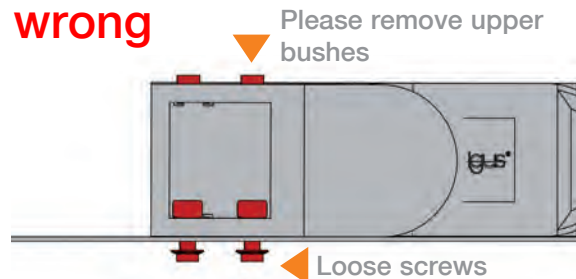
The e-chain shown here is the igus® E4/4 system but points also apply to the igus® E4.1 system.

- 1 Inspection of the bushes and screws at mounting bracket (fixed end/moving end). All screws tightened? All bushes flush?

right

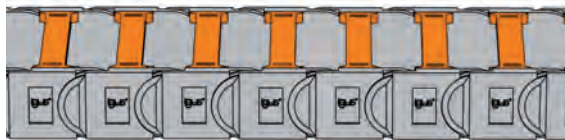


wrong



- 2 Inspection of the crossbars of the e-chain. All crossbars tight and correctly assembled?

right

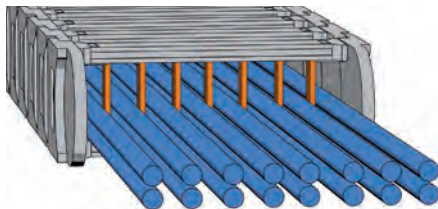


wrong

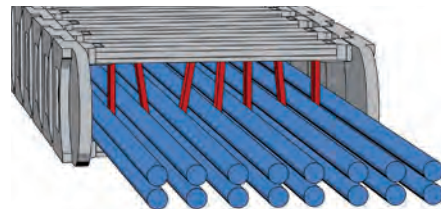


- 3 Inspection of the interior separation of the e-chain. All separators straight and clipped in correctly?

right



wrong



- 4 Wear inspection of the e-chain®. Gliding surfaces OK? If wear is too high, replace the e-chain®.



Art. No.	Exterior height	Min. height
280.XX	54 mm	52 mm
E4.32	54 mm	52 mm
380.XX	64 mm	62 mm
E4.42	64 mm	62 mm
400.XX	84 mm	82 mm
E4.56	84 mm	82 mm

Please make a sample inspection, e.g. every 5th chain link, of the gliding part of the e-chain. Please also check the gliding surfaces visually for wear. In case the exterior height [ha] of the e-chain is below the minimum exterior height [ha<sub>min</sub>] value, please replace the e-chain®.

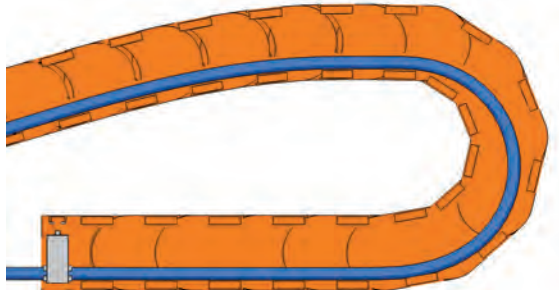
Reference value for other series:  $ha_{min} = Ha - 2$

\*also with crossbar every second link (H4.xx) and e-tube (R4.xx)  
ES4.xx = low-noise version with dampening pads on the outer radius

# Visual inspection of cables and hoses

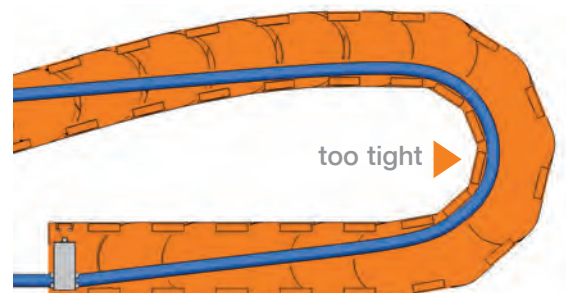
- 1 Check if all cables lie correctly in the energychain and can move freely.

right



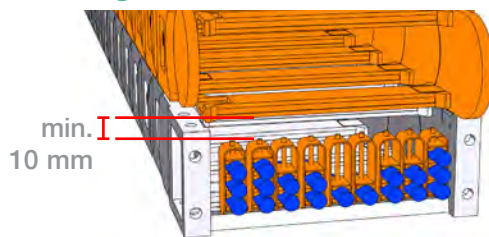
igus® chainflex® can be strain relieved directly at the mounting bracket!

wrong

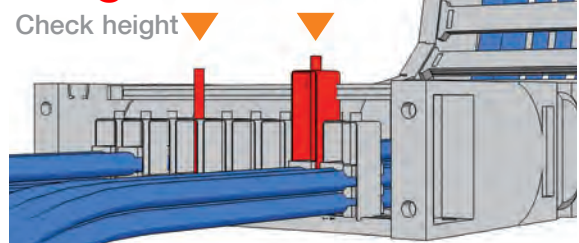


- 2 Check if the assembly of the strain relief clamps is correct and secured in the C-Profile of the mounting bracket. Any clamps missing? Cables correctly clamped? Please ensure that no clamps reach above the lower e-chain run otherwise they could foul on the upper run.

right

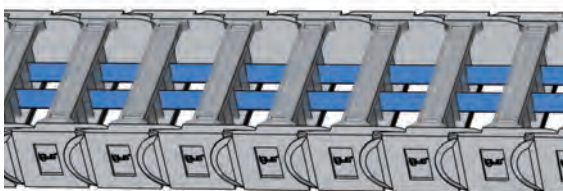


wrong



- 3 Check cables for correct path, damage or corkscrewing!

right



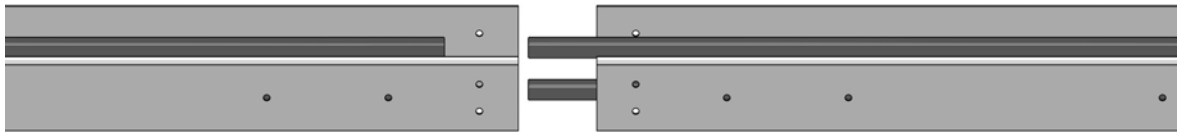
wrong





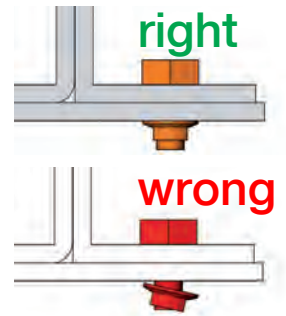
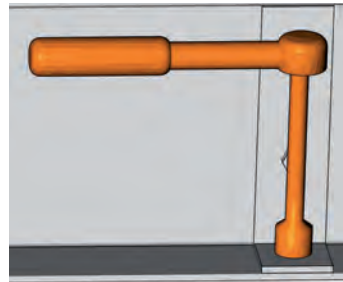
# Assembly and inspection of guide troughs

- 1 Do not cut glide bar flush: glide bars should ALWAYS overlap to the next trough section, using the given hole pattern.



- 2 Check the setting of the angle bracket, if necessary, tighten screws. Please note the required torque!

Thread size	Material	Torque
M6	8.8 /A2/A4-70	10 Nm
M8	8.8 /A2/A4-70	23 Nm
M10	8.8 /A2/A4-70	35 Nm
M12	8.8 /A2/A4-70	75 Nm
Fixation to plastic glide bar		
M10	8.8 /A2/A4-70	7 Nm

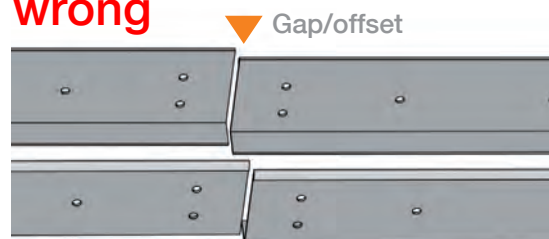


- 3 The trough system must not have any offset. Please align and fix!

right



wrong

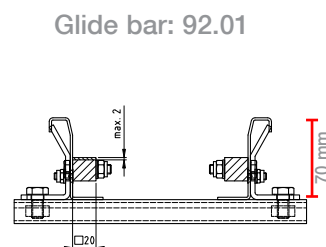


- 4 Inspection of the glide bar wear. If the wear is too high, turn the bars over or replace them.

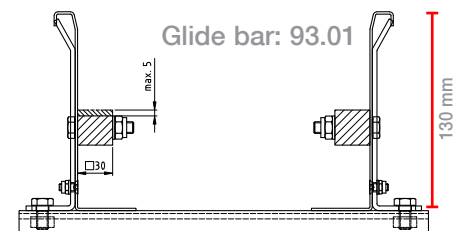
right



wrong

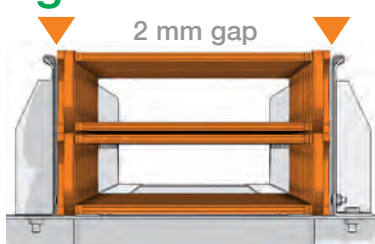


wrong



- 5 Check trough sections are parallel. Check width of the trough system. Gap must be ~2 mm on both sides (not more, not less).

right



wrong



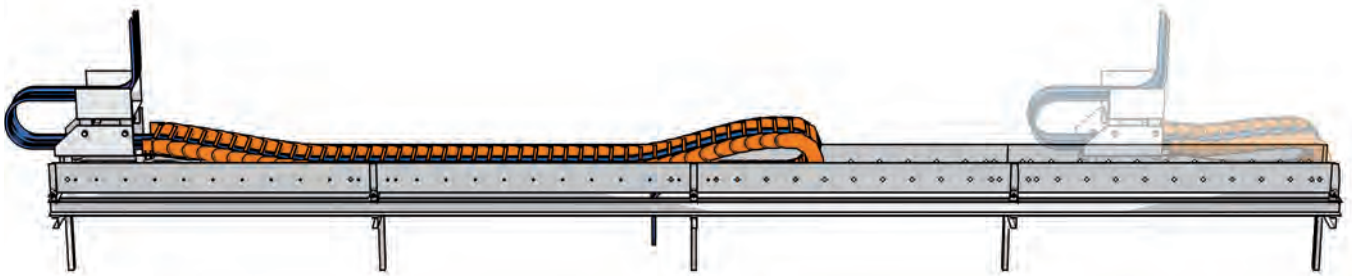
wrong



# Final inspection

Test run the e-chainsystem® at low speed, slowly increasing the speed, run to each end position:

- Check for sufficient e-chain® length: e-chain® must not be under mechanical stress or taught.
- Check complete e-chainsystem® is free from foreign objects or interfering edges.



[www.igus.de/E4.1](http://www.igus.de/E4.1)

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