



RAMPA®

Good idea. Let's make it!

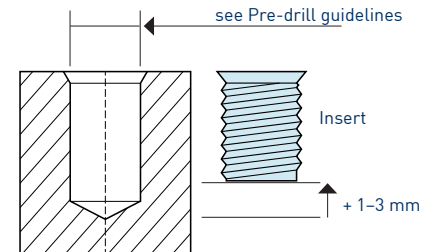
DRIVER INSTRUCTIONS TYPE 515

Dear RAMPA customer,

we are pleased that you have chosen our high-quality RAMPA Driver Type 515 and would like to point out some technical details before using it for the first time.

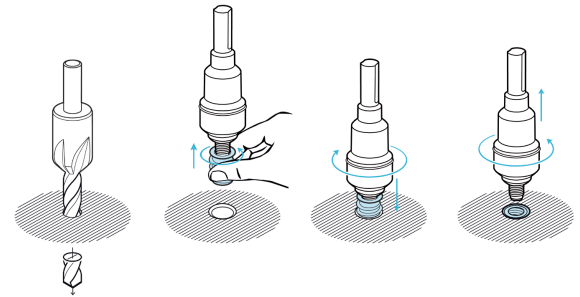
Preparatory measures before use

- Pre-drilled borehole required for all RAMPA inserts. Recommendations for correct pre-drilling can be found in our product range on the corresponding product pages or in our online shop www.rampa.com.
- For simplifying the assembling process, we recommend to use a countersink of at least 0,3 x 45° for the pre-drilled borehole.
- For an easy RAMPA insert assembling, we recommend tools like:
 - cordless screwdrivers
 - cordless drills
 - processing machines (the suitability of box column drills is limited)
- If a box column drill is used, make sure that the threading attachment has an automatic reversing rotation function.
- The use of an automatic assembling feed is not allowed!



Processing instructions

1. Clamp the RAMPA Driver Type 515 in your tool.
2. The RAMPA insert must be mounted via the internal thread. Take into account that the RAMPA insert has no inner hexagon drive.
3. Make sure that the RAMPA insert is fully screwed on (until the insert is attached to the rotary sleeve)
4. The axis of rotation of the machine must be aligned with the central axis of the pre-drilled borehole. The max rotation axis tilt should not exceed an angle of 3°.
5. The RAMPA inserts exhibit a thread with clockwise direction by default (clockwise rotation)
6. After finishing the assembling process, switch into counterclockwise rotation. The RAMPA Driver Type 515 detaches itself from the RAMPA insert.
7. The assembling speed of 250 min⁻¹ should not be exceeded. The shorter the insert, the slower it should be assembled.



FAQs – Frequently Asked Questions

Fault / Problem	Solution / Tip
Set screw loose	- Check the set screw
RAMPA insert sticks continuously on the driver	- Reduce the assembling speed - Screw the insert on completely - Tripping torque is too high - Depth stop releases too late - Threaded pin of the driver is worn out - Degrease the threaded pin of the driver
Tilted RAMPA insert	- Check the machine alignment - Pre-drilled borehole has a countersink - Cordless screwdriver is positioned obliquely - Insert is not screwed on completely
Driver makes clattering noises	- Check the free movement/mobility of the axial bearing
Spring ring has ruptured	- Set screw is turned out too far