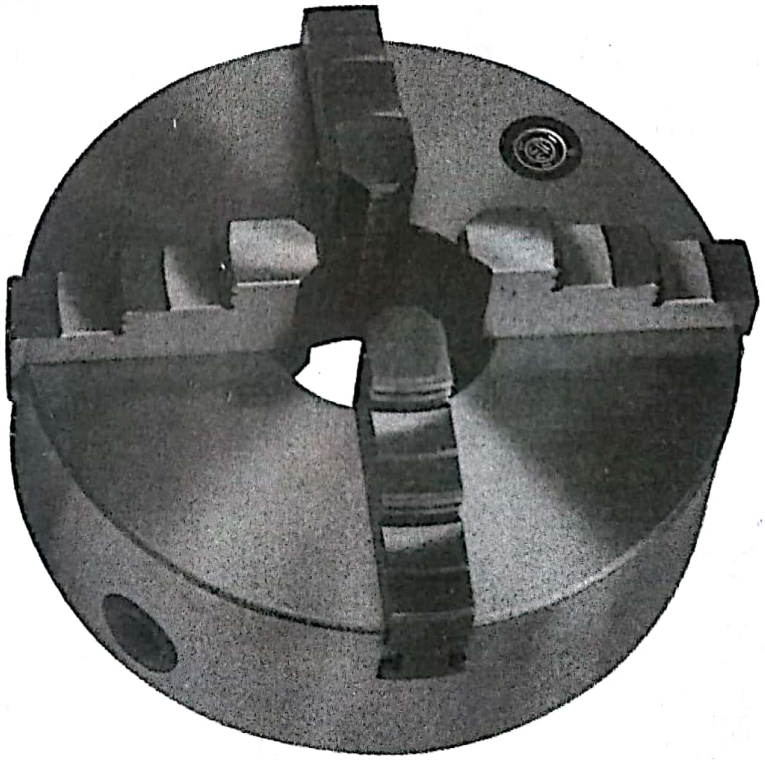
4-Jaw Self Centering Chuck

TECHNICAL DOCUMENT

OPERATION MANUAL
TEST CERTIFICATE
PACKING LIST



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OPERATION MANUAL

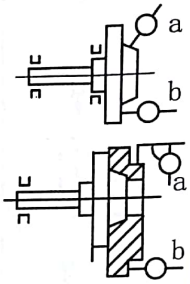
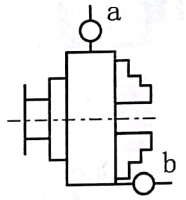
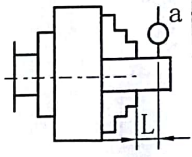
This chuck is suitable for use on various lathes, milling machines, ordinary internal and external grinding machines etc,and for holding workpiece so as to aid the machines to accomplish their cutting operation.

By means of a dial indicator, check up the adaptor on the spindle nose before mounting the chuck onto it to make sure that it runs correctly.

Do not hammer the workpiece gripped on the chuck so as to prevent possible impairment on the accuracy of the chuck or damage of its component parts.

Chips might get into the chuck during cutting operation.

Wash and clean the chuck regularly to preserve its accuracy and to avoid possible troubles.

No.	Inspection Items	Sketch showing method of test	Chuck Specification (mm)	Permissible error (mm)	
G0.	Radial runout of the outside diameter and axial runout of face of flange and adaptor		80～630	a 0.005	
			800～1000	a 0.01	
			80～630	b 0.005	
			800～1000	b 0.01	
G1.	Radial runout of outside diameter and end run out of the chuck			a	b
			⩽160	0.040	0.040
			200～250	0.055	0.060
			315～400	0.070	0.075
			500～630	0.085	0.100
			800～1000	0.100	0.100
G2.	Diameter run-out of testing bar clamped in the jaws of the chuck			L	a
			⩽160	50	0.080
			200	50	0.100
			250	75	0.100
			315～400	75	0.125
			500～630	100	0.160
			800~1000	125	0.250

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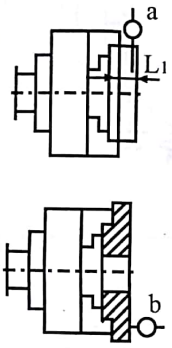
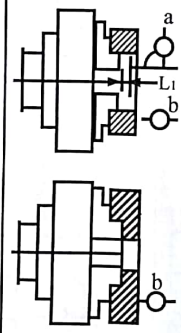
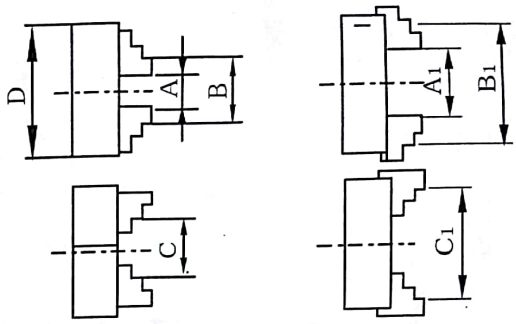
No.	Inspection Items	Sketch showing method of test	Chuck Specification (mm)	Permissible error (mm)	
				a	b
G3.	Runout of testing ring clamped on the inside stepped surface of the chuck		⩽160	0.075	0.040
			200～250	0.075	0.050
			315～400	0.100	0.060
			500～630	0.125	0.080
			800～1000	0.160	0.125
				L_1=12	
G4.	Runout of testing ring stretched on the outside stepped surface of the chuck			a	b
			⩽160	0.075	0.040
			200～250	0.075	0.050
			315～400	0.100	0.060
			500～630	0.125	0.080
			800～1000	0.160	0.125
				L_1=12	

Holding Range



mm

Diameter of chuck D	Internal jaws		External Jaws
	A~A1	B~B1	C~C1
80	2~22	25~70	22~63
100	2~30	30~90	30~80
125	2.5~40	38~125	38~110
130	3~40	40~130	40~120
160	3~55	50~160	55~145
165	3~55	50~165	55~150
190	4~70	65~190	65~190
200	4~85	65~200	65~200
240	6~110	80~240	90~240
250	6~110	80~250	90~250
315	10~140	95~315	100~315
320	10~140	95~320	100~320
325	10~140	95~325	100~325
380	15~210	120~380	120~380
400	15~210	120~400	120~400
500	25~280	150~500	150~500
630	50~350	170~630	170~630
800	150~450	300~800	300~800
1000	290~600	430~1012	430~1012

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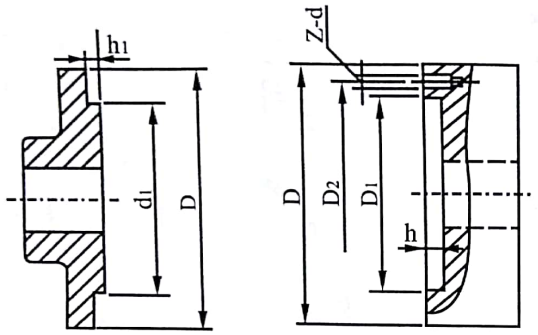
Connecting the 4-jaw chuck with the flange



mm

D	D1 (H7)	D2	h	d	Z	Reference Size	
						d1(Js6)	h1
80	55	66	3	M6	3	55	2.5
100	72	84		M8		72	
125	95	108				95	
130	100	115				100	
160	130	142	5			130	4
165	130	145				130	
190	155	172		M10		155	
200	165	180				165	
240	195	215		M12		195	
250	206	226				206	
315	260	285		M16		260	
320	270	290				270	
325	272	296				272	
380	325	350				325	
400	340	368				340	
500	440	465	6		6	440	5
630	560	595	7			560	6
800	710	760	8	M20		710	7
1000	910	950	8	M24		910	7

PACKING LIST

No.	Name	Quantity	Note
1	Chuck	1 Piece	
2	Socket head screws	3 Pieces	⩾Ø500 6 Pieces
3	Chuck wrench	1 Piece	
4	External jaw	4 Pieces	
5	Technical document	1 Piece	

Packed by: G

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