

JAC-15 Cylinder-Integrated Collet Chuck

User's Manual Read first before installing Collet Chuck

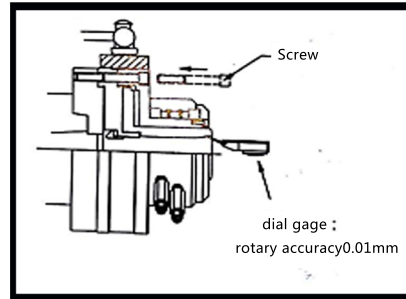
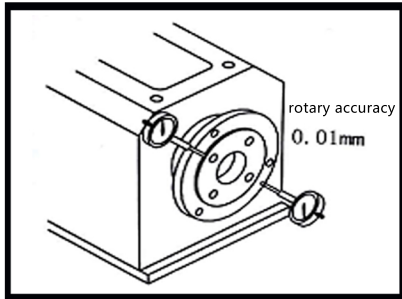
JAC-15 Chuck installation consists of 2 steps:

- ☒ Mounting and Machining the Spindle Adaptor.
- ☒ Mounting the Chuck.

Mounting and Machining the Spindle Adaptor

1. Before mounting the spindle adaptor, please inspect the accuracy of your spindle. The run-out of the spindle will affect the final chucking TIR.
2. After mounting the spindle adaptor, fine finish it to make it closely fit with the chuck (please refer to the Note below for more information). Since the run-out of the spindle adaptor might also influence the final chucking accuracy, we suggest that the radial run-out should be controlled within 0.005mm (.0002"), and the face run-out should be controlled within 0.003mm (.00012").

Spindle Adaptor Accuracy Inspection as below:



Note

When machining the outer flange of the spindle adaptor, we suggest you leave a 0.5mm (.0020") clearance for TIR fine adjustment in the future. TIR can be minimized by the following steps:

1. Semi-loosen the mounting screws between the chuck and the spindle adaptor.
2. Measure the radial run-out of the tapered sleeve with a dial indicator.
3. Tapping the chuck slightly with a plastic hammer till the run-out is adjusted to the required range.
4. Re-tighten the mounting screws and inspect the Run-out again.

This chapter contains information on how to install the collet into the chuck. The topics include:

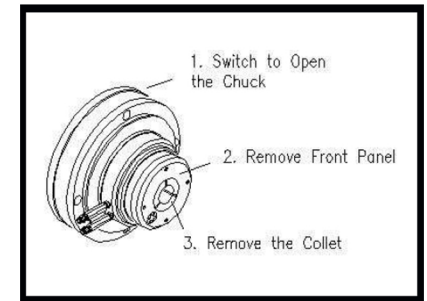
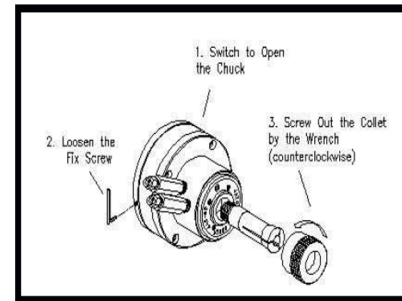
- ☒ Collet Removal
- ☒ Collet Installation

Collet Removal

JAC-15 Cylinder-Integrated Collet Chuck works with standard YB-15. JAC-15 Collet Chuck is designed to allow users to change collets easily and quickly.

Collet Removal

1. For your own safety, with safety in mind make sure that the machine has come to a complete stop before removing the collet.
2. Switch the control valve to open the chuck (sleeve is being pulled back).
3. Screw out the collet counter clock wise with the collet wrench enclosed with the package.
4. Remove the collet from the chuck.



JAC-15 Collet Installation

1. Clean the tapered sleeve with an air nozzle.
2. Switch the control valve to open the chuck (sleeve is being pulled back).
3. Screw the collet into the chuck body with the collet wrench. The internal diameter of the collet might decrease as the collet is being engaged. Make sure the internal diameter is large enough to allow the insertion of the work-piece.
4. Tighten the fixing screw lightly with a hexagon key to fix the collet from moving.
5. Remove the hexagon key after the collet is fixed. Turn on the air to the operating pressure and test if the chuck works

