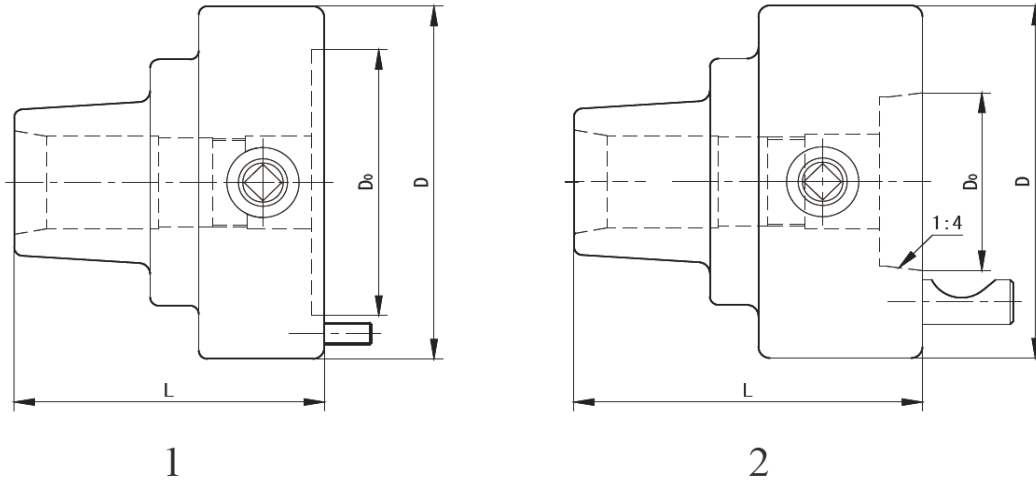


**41-256-series-5C CHUCK
TECHNICAL DOCUMENTS
OPERATION MANUAL**



I. Technical Data



ORDER NO.	D	D0	L	CLAMPING RANGE			FIGURE
				ROUND	SQUARE	HEX	
41-256-002	5C	126	95	107			1
41-256-005	D3	126	53.975	120.5			2
41-256-004	D4	126	63.513	120.5	1-28mm 3/64-1-1/8"	3-19mm 1/8-3/4"	
41-256-006	D5	140	82.563	143.5			
41-256-003	D6	165	106.375	143.5			
41-256-007	D8	210	139.719	145.5			

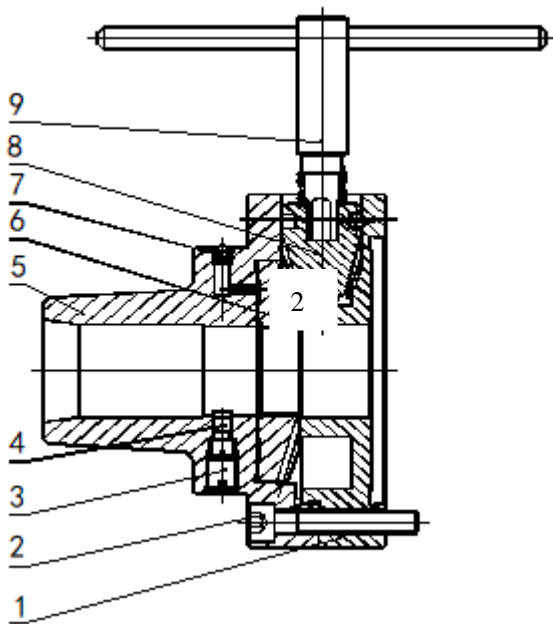
II. FEATURE:

Accept 5C collets, to mount the chuck with a suitable backplate to your lathe. Easy operation, accurate system.

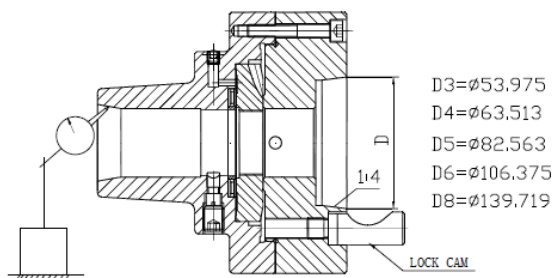
III. Main part list

- | | |
|--------------------------|---------------------------|
| 01. Adaptor | 02. Hex head socket screw |
| 03. Hex socket cap screw | 04. Pin |
| 05. Chuck body | 06. Big taper gear |
| 07. Oil cup | 08. Small taper gear |
| 09. Spanner | |

125 Type

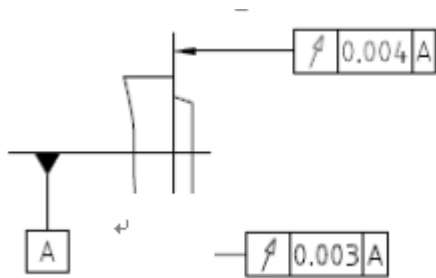


D Type

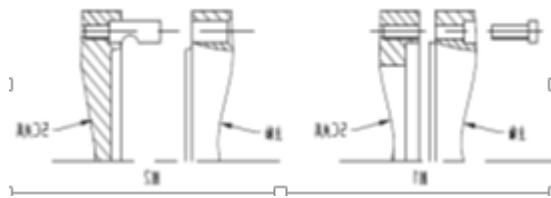


IV. Operation step:

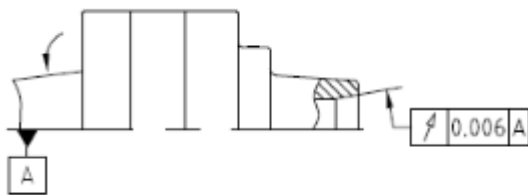
1. Check the runout of lathe spindle first, control the runout value of nose within 0.004mm; of cylinder or taper within 0.003mm shown as following:



Then put the 5C chuck onto the lathe spindle nose, with the setting hole in the right position for fixing each other..Pic 1 is screw lock, Pic 2 is Cam lock.



For example type D: Use cam lock to fix the chuck on the spindle nose. Note to tighten the cam screws in multiple strokes crossly. Touch the surface of taper hole with a micron indicator, then rotate the spindle slowly. Tighten the cam screws when there is a low stable TIR value. This is very importance for setting a runout value within 0.006mm.



2.Choose a 5C collet, put it into the collet chuck along the pin inside.

3. Put workpiece inside the 5C collet, tighten the spanner to tighten the workpiece.

VI. Maintenance

Slide part and swivel part shall be cleaned and lubricated periodically. Put into plastic bag for long time store.