



INSTALLATION AND SERVICE INSTRUCTIONS

I.D. AND O.D. GRIP COLLET CHUCKS



WWW.FORKARDT.US



Main Office

2155 Traversefield Drive
 Traverse City, Mi. 49686
 E-mail: sales@forkardt.us
 800-544-3823 Toll Free
 231-995-8300 Phone
 231-995-8361 Fax

IL, IA, NE, WI, MN, ND, SD

Chris Brown
 Office: 231-995-8327
 Mobile: 231-557-5295
cbrown@forkardt.us

IN, TN, KY, OH, WV

Jim Farrell
 Office: 231-995-8334
 Mobile: 248-765-9456
jfarrell@forkardt.us

KS, MO, AR, TX, LA, OK, NM, AZ, CA

Jeremy Michael
 Office: 231-995-8338
 Mobile: 713-306-4619
jmichael@forkardt.us

AL, GA, MS, NC, SC, VA, FL

Mark Zimmerman
 Mobile: 248-361-7443
mzimmerman@forkardt.us

MA, VT, NH, ME, RI, NJ, MD, DE, PA, NY

Bob Holtz
 Mobile: 860-481-1948
bholtz@forkardt.us

Michigan and all other states not listed

Forkardt
 Direct: 231-995-8300
 Fax: 231-995-8361
sales@forkardt.us

Ontario, Canada

Brian Braden
 Office: 231-995-8337
 Mobile: 248-361-9616
bbraden@forkardt.us

For Quebec, Canada

Bob Holtz
 Mobile: 860-481-1948
bholtz@forkardt.us

For Mexico

Sergio Echegoyen
 Dinamarca 209 INT 3
 Las Mercedes
 San Luis Potosi, S.L.P.
 Mexico 78394
 Office: 52 1 444-824-9955
 Mobile: 52 1 444-131-4376
 Fax: 52 1 444-824-9955

China

Kevin Dong
 1F, Bldg 2#, 458 Fute Rd. (N.),
 Shanghai Waigaoqiao F.T.Z.
 200131 P.R.C.
 Office: 86-021-58682809-110
 Mobile: 86-15000302788
kdong@forkardt.us

Brazil

Andre Silva
 Kare Tools
 R-Capitao Rabello, 113 Guarulhos
 Brazil, 070630
 Office: 55-11-2937-9646
 Mobile: 55-11-7733-8697

General Safety Instructions

Assembling the collet chuck

When assembling the chuck to the machine, the following safety requirements must be observed:

- Do not start the machine spindle until the part has been securely clamped.
- Do not unclamp the chuck until the machine spindle has completely stopped rotating
- In the case of loss of power, the workpiece must remain securely clamped until the spindle has completely stopped rotating.

Functional Test

After assembling the chuck, check for proper functioning before operating.

- Clamping Force– the specified drawbar force must be achieved to insure proper clamping force.
- Stroke– the stroke of the drawbar must allow a safety zone at each end of its stroke to insure that the chuck can reach its full travel and not be restricted by the drawbar.

Speed

If the maximum speed of the lathe is higher than the recommended max RPM of the chuck, the machine must be equipped with a speed limiting device.

Maintenance

- Only operate the chuck when all safety devices are in place.
- Check the chuck at least once per shift for visible damage.
- After a collision, the chuck should be thoroughly examined for damage prior to being put back into operation.



Please observe safety during the transportation and handling of chucks of considerable weight.



Do not make any alterations to this chuck without contacting your sales representative. Alterations, improper repair, or use of incorrect spare parts will result in voidance of warranty.



Always make sure spindle has come to a complete stop before removing or changing parts.

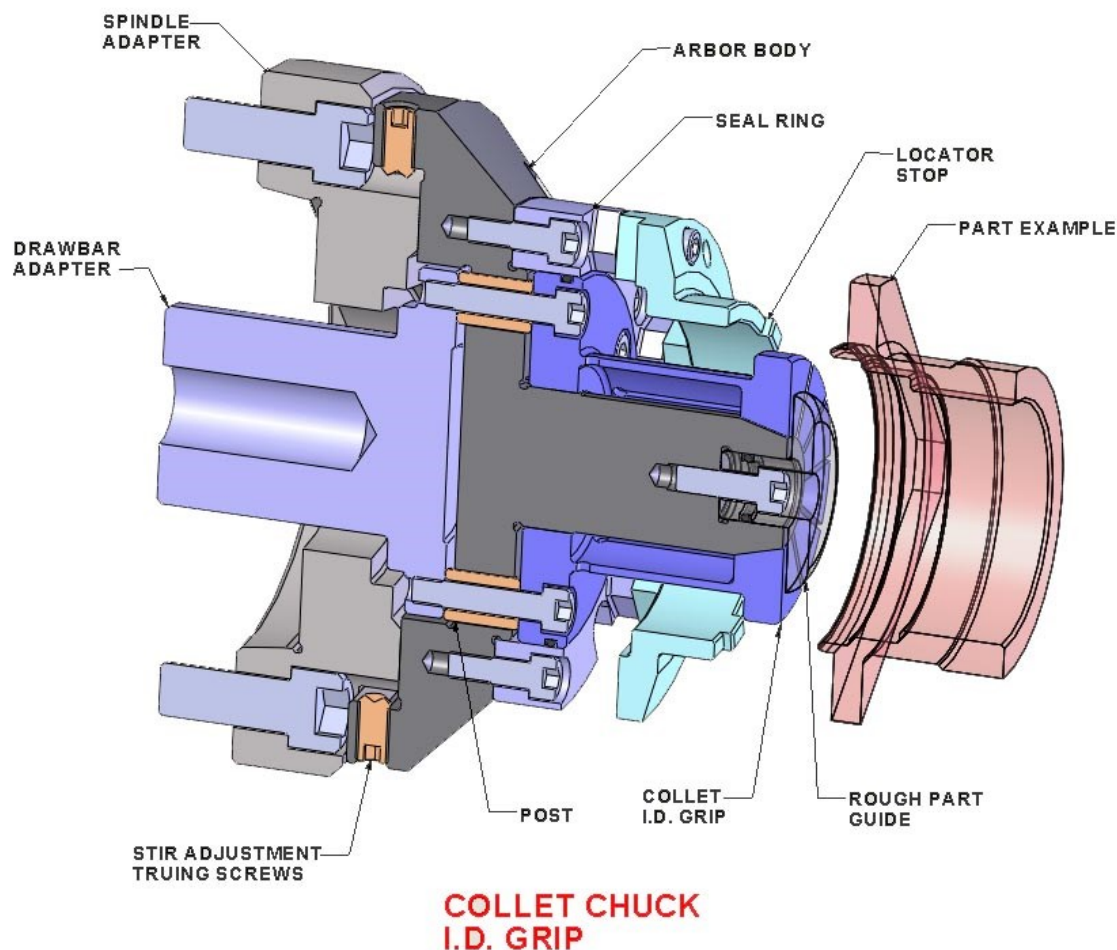
ID Grip Collet Chucks Installation

The chuck assembly must be true on the machine for best concentricity results when machining parts. The following procedures should be used when indicating the chuck assembly on the spindle.

1. Mount machine adapter to spindle with the correct number of spindle mounting screws, making sure all mating surfaces are free of nicks, burrs, dirt, etc.
2. Carefully screw drawbar adapter onto the drawbar and tighten.
3. Put the body on, securing with correct number of screws until snug only. (Do not torque mounting bolts completely yet)
4. With an indicator on the taper of the body or indicating band, adjust the stir screws on the O.D. of the body to run true. This should run at 0.0002" or better.
5. Torque mounting bolts completely and double check run-out. Repeat step 4 if needed.

You are now ready to assemble top tooling collet, locator and cover plate.

1. Be sure the collet is free of all nicks, burrs, dirt, etc. Using a liberal amount of lube on the pilot and taper of the collet, line bolt holes in the collet to bolt holes in the body. Place socket head cap screws into the bolt holes and tighten down.
2. When mounting the locator, you must line up the roll-pin, if so equipped, in the body to the hole in the locator to ensure the air sensing holes are in place. Use socket head cap screws to secure the locator in place.



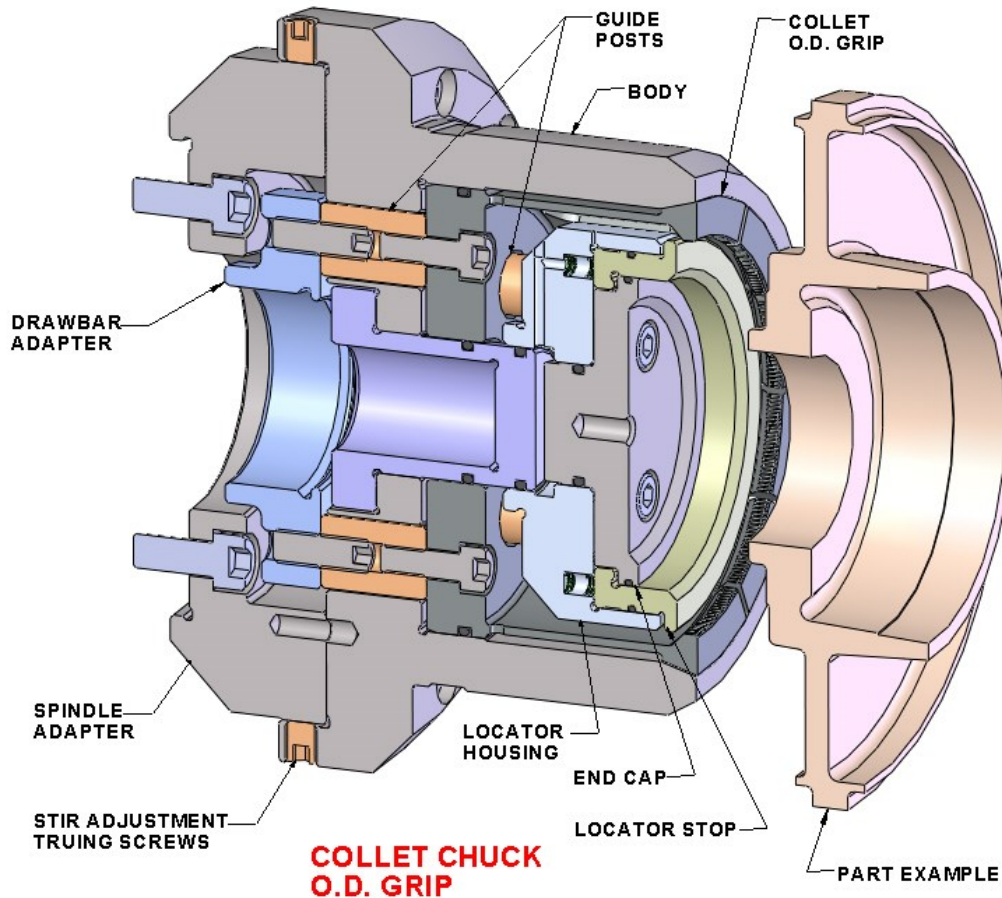
OD Grip Collet Chucks Installation

The chuck assembly must be true on the machine for best concentricity results when machining parts. The following procedures should be used when indicating the chuck assembly on the spindle.

1. Mount machine adapter to spindle with the correct number of spindle mounting screws, making sure all mating surfaces are free of nicks, burrs, dirt, etc.
2. Carefully screw drawbar adapter onto the drawbar and tighten.
3. Put the body on, securing with correct number of screws until snug only. (Do not torque mounting bolts completely yet)
4. With an indicator on the taper of the body or indicating band, adjust the stir screws on the O.D. of the body to run true. This should run at 0.0002" or better.
5. Torque mounting bolts completely and double check run-out. Repeat step 4 if needed.

You are now ready to assemble top tooling collet, locator and cover plate.

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Troubleshooting

Problem	Possible Cause	Solution
Workpiece is eccentrically out of tolerance	Chuck is not concentric	Check concentricity and adjust as necessary
Workpiece is out of tolerance	Soiled coupling or taper Worn Collet	Remove clamping head and clean coupling area
Not enough stroke or chuck does not open	Soiling between draw mechanism and chuck body Drawtube adapter or draw mechanism is out of tolerance Inadequate drawbar stroke	Remove clamping head, move drawtube back and clean slot in coupling area Check drawtube adapter or draw mechanism position and adjust as needed
Workpiece out of shape	A workpiece is bent during clamping process. After machining it should go back to its original shape	Use starting material that is less prone to deformation.
Marks on part surface	Point or linear work piece clamping Wrong clamping head type	The difference between the workpiece diameter and the clamping head ID is too large Change from serrated to smooth bore clamping head
Not enough clamping pressure	Workpiece is undersize/ oversize Not enough hydraulic pressure at the cylinder Defective cylinder or blocked drawtube	Change to clamping head that fits properly Check cylinder inlet pressure on machine Contact machine builder

Alterations or improper repair of chuck could void your warranty. Please contact our repair department if you need repair of this chuck. If the chuck is out of warranty, our full service repair department can repair your chuck using original manufacturer parts.

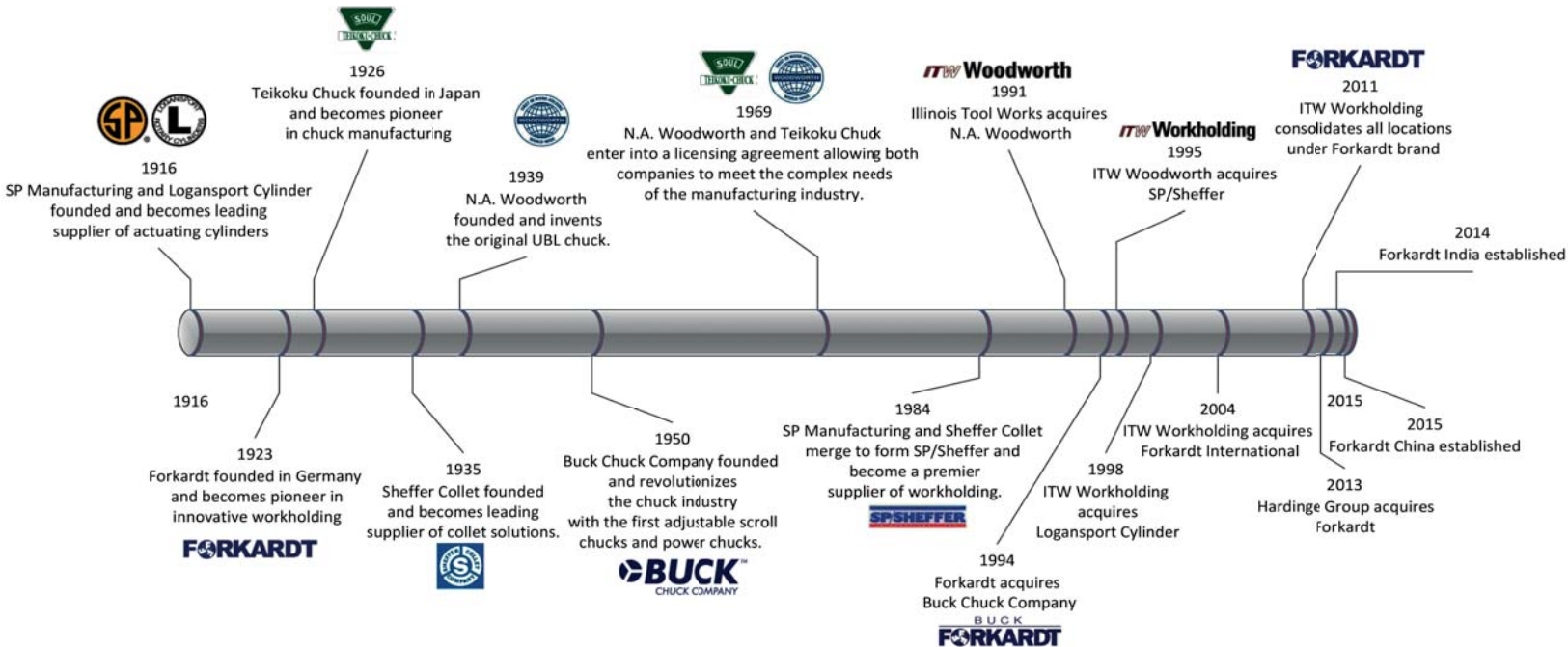
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OUR BRANDS



FORKARDT MAIN OFFICE

2155 Traversefield Dr
 Traverse City, MI 49686
 Tel: (+1) 800-544-3823
 Fax: (+1) 231-995-8361
 E-Mail: sales@forkardt.us

FORKARDT DEUTSCHLAND GMBH
 Heinrich-Hertz-Str. 7
 D-40699 Erkrath
 Tel: (+49) 211-25 06-0
 Fax: (+49) 211-25 06-221
 E-Mail: info@forkardt.com

FORKARDT FRANCE S.A.R.L.
 28 Avenue de Bobigny
 F-93135 Noisy le Sec Cédex
 Tel: (+33) 1-4183 1240
 Fax: (+33) 1-4840 4759
 E-Mail: forkardt.france@forkardt.com

FORKARDT CHINA
 Building, No.209, Taigu Road
 Shanghai Waigaoqiao F.T.Z.
 200131 P.R.C
 Tel: 86-021-58683689
 E-mail: info@forkardt.cn.com

FORKARDT INDIA L.L.P.
 P No. 39, No. 5-5-35/187
 Ayyanna Ind Park IE Prashant Nagar
 Kukatpally, Hyderabad, AP. 500072
 Tel: 040-40020571
 Fax: 040-40020576
 E-mail: info@forkardtindia.com

WWW.FORKARDT.COM