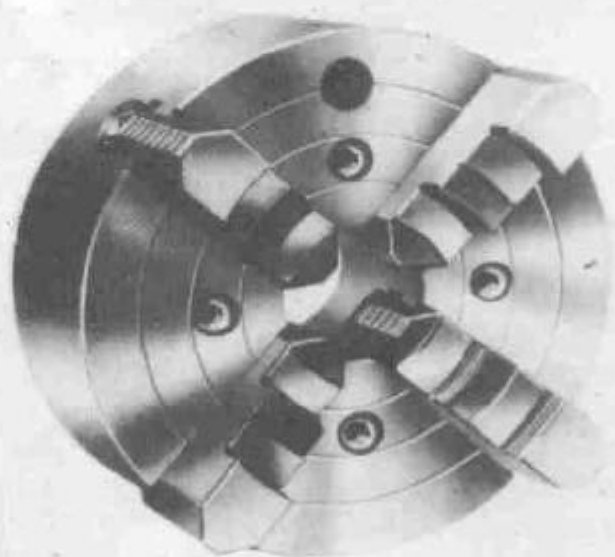


FOUR-JAW INDEPENDENT CHUCK

KN SERIES



OPERATION MANUAL

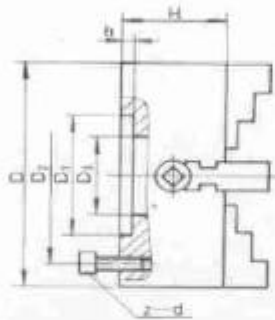
I . Operation Instructions

1. The KN series four-jaw independent chucks are of cylindrical center mounting connected to the spindle nose by the adapters.

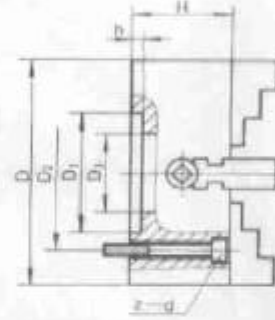
2. Regular cleaning of the chuck is recommended and should be a part of periodic machine maintenance.

This is the thing you can do to insure accuracy and long-life in your chuck.

II . Installation Dimensions



DRAWING I

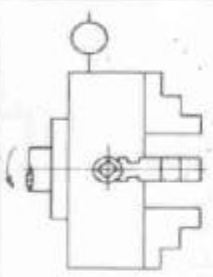
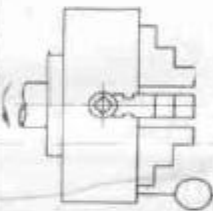
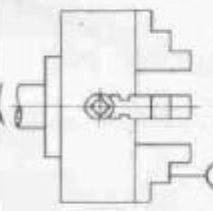
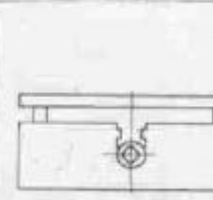


DRAWING II

D	D ₁	D ₂	D ₃	H	h	z-d	NOTE
mm/inch							
80/3	55/2.1654	66/2.5984	22/0.8661	42/1.6535	3/0.12	4-M6	DRAWING I
100/4	72/2.8346	84/3.3071	25/0.9842	54/2.1260	3.5/0.14	4-M8	
125/5	95/3.7402	108/4.2520	30/1.1811	56/2.2047	4.5/0.18		
160/6	65/2.5591	95/3.7402	45/1.7717	65/2.5591	5/0.20	4-M10	DRAWING II
200/8	80/3.1496	112/4.4094	56/2.2047	75/2.9528			
250/10	110/4.3307	130/5.1181	75/2.9528	80/3.1496			
300/11 $\frac{3}{4}$	152/5.9843	130/5.1181				4-M12	
315/12 $\frac{3}{8}$	140/5.5118	165/6.4961	95/3.7402	90/3.5433	6/0.24	4-M16	
320/12 $\frac{5}{8}$							
350/13 $\frac{3}{4}$	130/5.1181	168/6.6142					
400/16	160/6.2292	185/7.2835	125/4.9213	95/3.7402	8/0.31	4-M20	
500/20	200/7.8740	236/9.2913	160/6.2992	106/4.1732			
630/25	220/8.6614	258/10.1575	180/7.0866	118/4.6457	10/0.39		
800/32	250/9.8425	300/11.8110	210/8.2677	132/5.1969	12/0.47	8-M20	
1000/40	320/12.5984	370/14.5669	250/10.2362	150/5.9055	15/0.59		

III. Chuck Test Standard

mm/inch

Diagram of Test	Chuck Size							
	≤160/6	200/8 250/10	300/11 $\frac{3}{4}$ 320/12 $\frac{5}{8}$	315/12 $\frac{3}{8}$ 350/13 $\frac{3}{4}$	400/16	500/20 630/25	800/32 1000/40	
	0.040/ 0.0016	0.060/ 0.0024	0.075/ 0.0030			0.100/ 0.0039	0.125/ 0.0049	
	0.020/ 0.0008	0.030/ 0.0012			0.040/ 0.0016	0.060/ 0.0024		
	0.030/ 0.0012	0.040/ 0.0016			0.050/ 0.0020	0.080/ 0.0031		
 ※			0.040/ 0.0016			0.050/ 0.0020	0.060/ 0.0024	
	Concavation							

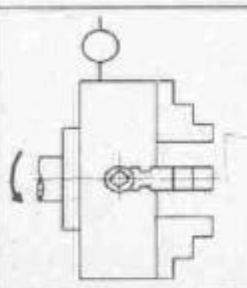
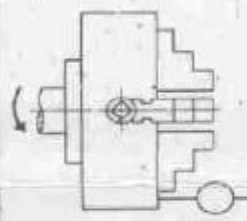
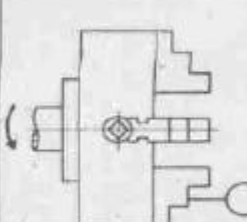
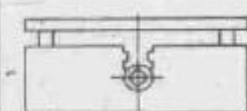
※ Planeness of the front face of chuck

TEST CERTIFICATE

Model & Size

Q-80

mm/inch

Diagram of Test	Chuck Size						
	$\leq 160/6$	200/8	300/11 $\frac{3}{4}$	315/12 $\frac{3}{8}$	400/16	500/20	800/32
		250/10	320/12 $\frac{5}{8}$	350/13 $\frac{3}{4}$		630/25	1000/40
	0.032/ 0.0013	0.048/ 0.0019	0.060/ 0.0024			0.080/ 0.0031	0.100/ 0.0039
	0.016/ 0.0006	0.024/ 0.0009			0.032/ 0.0013	0.048/ 0.0019	
	0.024/ 0.0009	0.032/ 0.0013			0.040/ 0.0016	0.064/ 0.0025	
*			0.032/ 0.0013			0.040/ 0.0016	0.048/ 0.0019
	concavation						

* Planeness of the front face of chuck

The chuck conforms to the built-in standard and is qualified for delivery

INSPECTOR

51

20121996

DATE

PACKING LIST

ITEM NO.	DESCRIPTION	QUANTITY
1	CHUCK	1 PC.
2	CHUCK WRENCH	1 PC.
3	SOCKET HEAD CAP SCREW	SIZE 800 8 PCS. 1000
		OTHER SIZE 4 PCS.
4	OPERATION MANUAL	1 COPY
5	TEST CERTIFICATE	1 COPY

PACKER

1271