

MAINTENANCE

- Good lubrication is essential to ensure faultless operation and the long life of a chuck.
- The performances given in the tables are valid for well lubricated chucks that are correctly maintained.
- The chuck should be lubricated with KLUBER Altemp QNB 50 (or equivalent) grease every 500 operations and at least once a week.
- The chuck is dynamically balanced to G . 2.5. Uneven lubrication can cause unbalance. Inject the same quantity of grease into each lubricator.
- Pay special attention to the cleanliness of the jaw serrations and the master jaws.

DISASSEMBLY

Disassemble, clean and examine the chuck at least once a year when it is in general use. If used for shift work or for machining aggressive materials the chuck should be examined more frequently.

With the chuck dismantled from the machine, proceed as follows (Fig. 1):-

- . Dismantle the swarf guard (a) (screw b),
- . Unscrew lubricators (c),
- . Unscrew flat screws (d),
- . Unscrew full dog point screws (e),
- . Unscrew screws (f),
- . Extract pins (g) according to the arrow (h): use a bronze rod and a mallet.

After having placed the chuck on a bench (Fig. 2), the lowering of the levers enables the master jaws to be extracted according to the arrow (j), the levers to be removed in the direction of arrow (k) and the drawsleeve to be removed in the direction of arrow (l).

All parts including the body of the chuck must have the grease removed with TRICHLOROETHYLENE or PETROL: Never use paraffin or white spirit.

Replace any faulty parts.

REASSEMBLY

All sliding surfaces of the above parts must be coated in KLUBER LUBRIFICATION - ALTEMP QNB 50 grease (or equivalent).

To reassemble proceed in the reverse order to disassembly and lubricate by means of the lubricators with the same quantity of grease in order not to interfere with the chuck's balance.

