

Operating Instruction

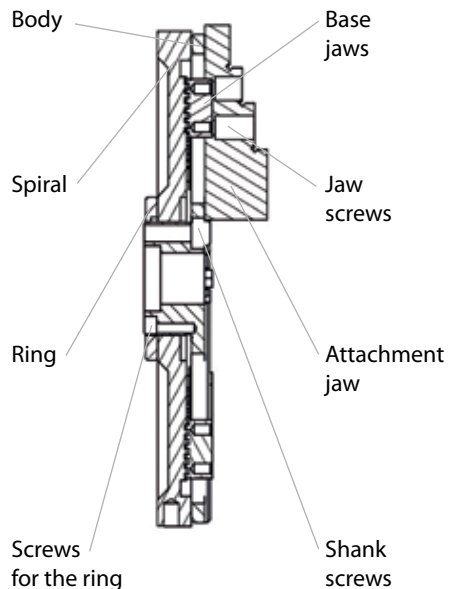
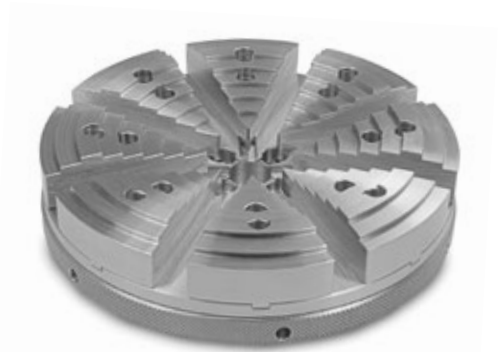
CHUCK JF ultra-flat

Safety instructions

- Read this operating instruction before the chuck is put into operation.
- Size and weight of the workpiece have to be adjusted to the chuck or jaws in question.
- Stop the work immediately if the chuck functions incorrectly or is damaged.
- Remove the key/split pin before starting the machine tool.
- Key/split pin extensions can result in damage to the chuck.
- Do not effect any hammer blows to the clamping jaws or other parts of the chuck. At the initial fitting stage a plastic-faced hammer can be used for setting concentricity.
- Take notice of the jaw clamping ranges before use!
- Only use original MAPROX replacement parts.
- Ensure with all chucks that the entire jaw cogging meshes into the flat spiral.
- In addition to the safety instructions included in this operating instruction, the user is to follow the local safety regulations.

Applications

- The chucks are used for clamping and/or processing workpieces on lathes, grinding, milling and measuring machines. They are also suited for deployment on dividers.



Fitting the chuck on the machine spindle

An adapter flange or a shank is used to install the chuck on the machine. The chuck is fitted on the adapter flange or shank once fitting has occurred on the machine spindle. Consult the drawing or the dimensions table on the right for the connection sizes.

Using the adapter flange or shank to install the chuck

Attach the chuck on the adapter flange or shank. Carefully tighten all the screws connecting the chuck with the flange/shank. Fit a dial gauge on the external diameter of the chuck body. Use a plastic-faced hammer to set the concentricity and then firmly tighten the fastening screws between flange/shank and chuck.

Installing the attachment jaws

DO NOTE. The attachment jaws are numbered (1, 2, 3, 4, 5, 6, 7, 8) and must only be fitted on the base jaws with an identical number. Using a torque screwdriver brings benefits.

The torque can be between 2 and 15 Ncm. (Only engage the screws).

Maintenance

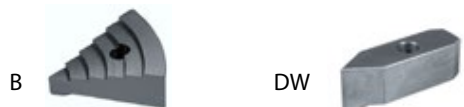
The base and attachment jaws, spirals and guides are to be regularly cleaned and greased. Machine oil or WD40, which also ensure smooth running, are suitable for using on measuring machines.

Original MAPROX replacement parts

- Attachment jaws A
- Attachment jaws B
- Attachment jaws C
- Attachment jaws D (hardened and ground)
- Attachment jaws DW
- Attachment jaws W



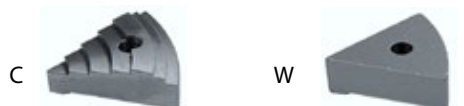
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- Jaw screws



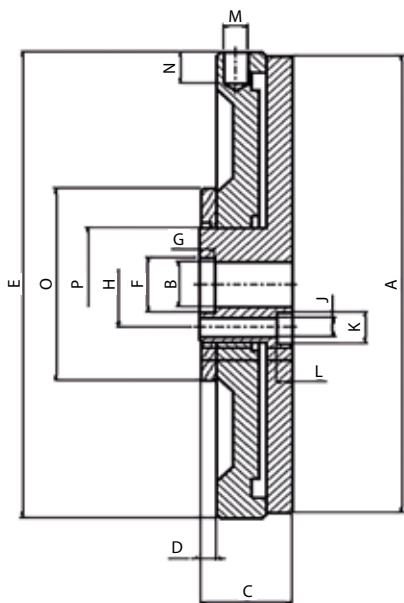
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- Screws for the ring

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- Shank screws

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- Base jaws:
3-jaw chuck no. 2, 4, 6
or 1, 3, 5
and 6- / 8-jaw chuck no. 1-6 / 1-8



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- Special jaws on request



Chuck JF 8D 150

Dimensions table

JF Ø	55	70	85	100	125	150
No. of jaws	3/6	3/6	6	3/6	8	8
A	55	70	85	100	125	150
B H7	8	8	10	10	16	16
C	13.8	15.7	16.5	18.2	21.2	21.2
D	2.8	3.2	3.2	3.2	4.2	4.2
E	57	72	87	102	127	152
F 0/+ 0.010	10	11	12	12	20	20
G	2.5	2.5	3	3	3.8	3.8
H	14.5	17	18.8	18.8	28	28
J	3 x 3.1	3 x 3.6	3 x 4.0	3 x 4.0	4 x 5.1	4 x 5.1
K	5.2	5.2	6.1	7.2	9	9
L	3.6	4.8	5.5	6	6.2	6.2
M	-	-	-	5	5	5
N	-	-	-	7	7	7
O	32	37	42	42	50	50
P	20	22	25	25	35	35
Travel Ø	13	22	32	36	-	48
Weight in kg, approx.	0.3	0.5	0.9	1.1	2.5	2.8
Permitted rotational speed	2500	2500	2000	2000	1800	1800

GUARANTEE CONDITIONS

We expressly refer you to our General Terms and Conditions at:
www.maprox.ch

