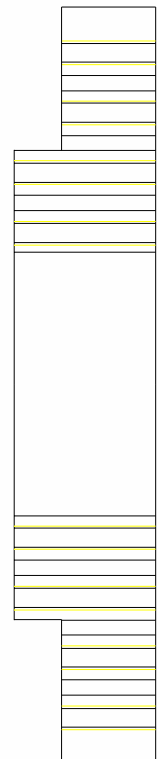
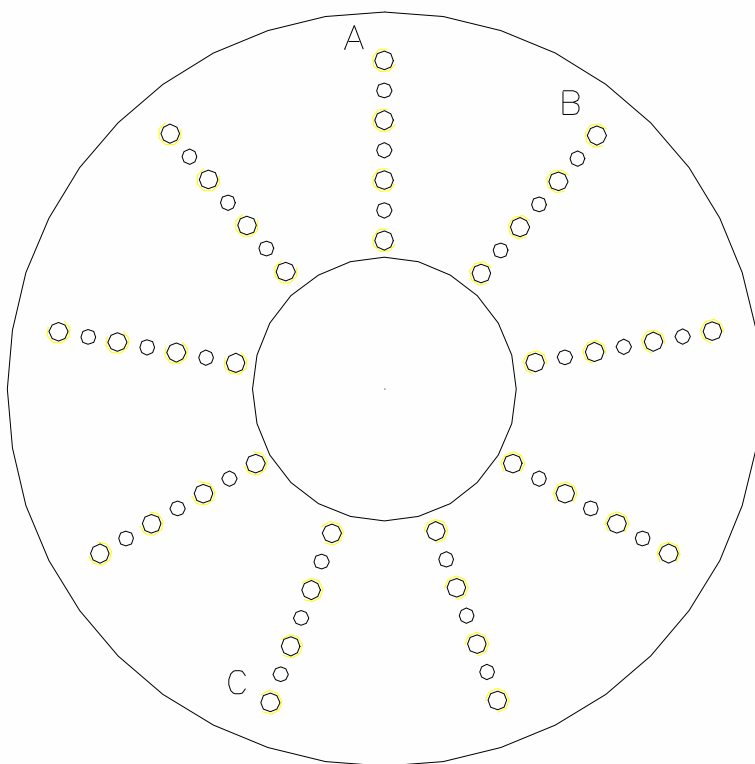


Jaw turning fixtures for APC-chuck with dowel pins Operating manual



General description

Our jaw turning fixtures mirror the locating pattern of standard air chucks. They are used to turn blank top jaws on a machine, which is not equipped with the MicroCentric chuck. For example you can do the rough cutting on a turning machine with any available chuck and then you finish the top jaws on a grinding machine with a MicroCentric air chuck.

To achieve the best accuracy, it is necessary to make the finish cut of top jaws on the air chuck, on which you will manufacture your workpieces afterwards.

Fixtures consist of

The jaw turning fixtures consist of a steel plate (bored and ground) and the following accessories:

Chuck type	Cylindrical screws	Dowel pins (1 pc. spare part)
3-50-3 / 3-50C-3	3 St. 912-M5x12	7 St. 1/8 x 3/8
4-40-3 / 4-120-3	6 St. 912-M5x16	10 St. 1/8 x 3/8
4-360-3	6 St. 912-M5x16	10 St. 1/8 x 3/8
6-40-3 / 6-120-3	12 St. 912-M5x16	10 St. 1/8 x 3/8
6-360-3	12 St. 912-M5x16	10 St. 1/8 x 3/8
8-120-3	6 St. 912-M10x25	10 St. 1/4 x 3/4
8-380-3	6 St. 912-M10x25	10 St. 1/4 x 3/4
10-220-3	6 St. 912-M10x25	10 St. 1/4 x 3/4
10-400-3	6 St. 912-M10x25	10 St. 1/4 x 3/4
HST 3-3	6 St. 912-M5x16	7 St. 1/8 x 3/8
HST 4-3	6 St. 912-M5x16	10 St. 1/8 x 3/8
HST 6-3	12 St. 912-M5x16	10 St. 1/8 x 3/8

Clamp positions

The following clamp positions are machined into the jaw turning fixtures:

Jaw stroke in diameter	Position A	Position B	Position C
1,0 / 1,2	Middle position	-	-
2,0 / 2,5	0,5 from closed	0,5 from opened	-
3,0 / 5,5	0,5 from closed	Middle position	0,5 from opened
9,0 / 9,6 / 10,1	1,0 from closed	Middle position	1,0 from opened

For chucks with 1,0 mm jaw stroke (4-40-3 und 6-40-3) is only the position A applied (= middle position at jaw stroke 1 mm). For chucks with 1,2 mm jaw stroke (3-50-3 / 3-50C-3) the jaw turning fixture mirror the locating pattern in middle position.