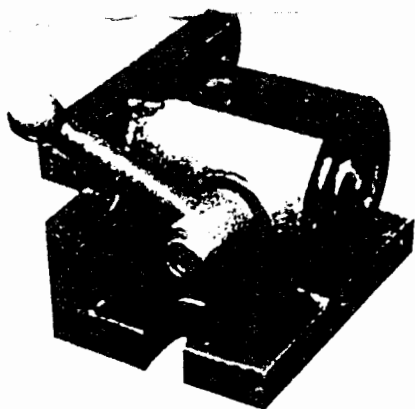


TYPE225—202C(HORIZONTAL
/VERTICAL)5C ANGLE COLLET FIXTURE

OPERATION INSTRUCTION



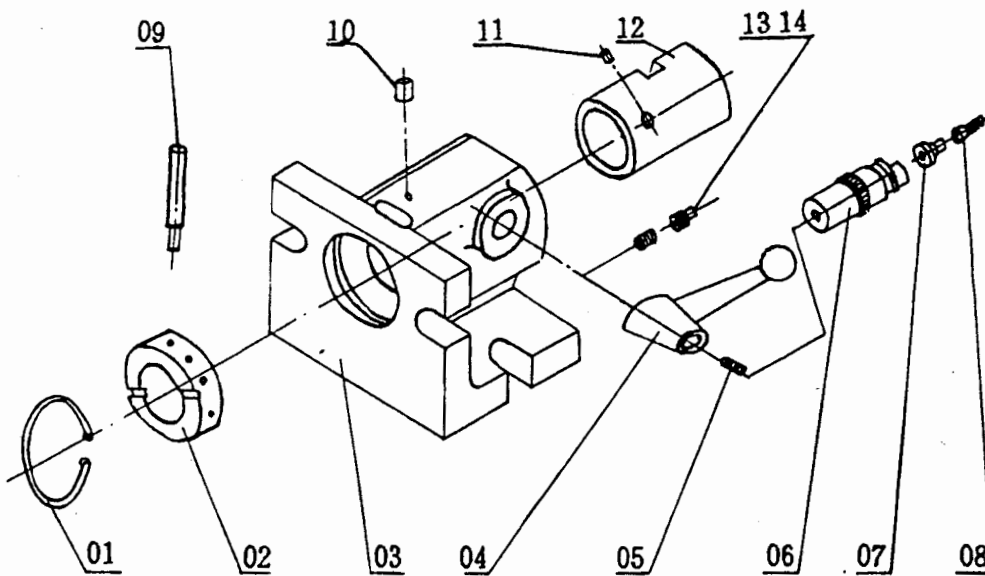
I. Application

This unit is applicable to complete with such machine tools as miller, grinder, and drill, etc. for the purpose of easy change over of workpieces with a 5C collet fitted on the unit.

II. Main technical specification

	64
Height of center (horizontal)	2.52
parallelism of center line of spindle to base surface (horizontal)	0.020
verticality of center line of spindle to base surface (vertical)	0.020
	0.0008

III. Structure



225 - 202 - 01 stop ring	225 - 202 - 08 screw
02 nut	09 stir pin
03 frame	10 pin
04 handle	11 pin
05 spring	12 5C sleeve
06 offset gear	13 screw
07 screw sleeve	14 screw

IV. Using method

1. First to select a proper 5C collet according to the arbor size of the workpiece to be machined. Insert the 5C collet into the opening of the 5C sleeve 12, with dia. of the collet aligned with the pin 11, then, stir the two slots on the nut 02, and turn the nut rightward to tighten the 5C collet properly.
2. Install the unit on the worktable of a machine tool horizontally or vertically according to requirements by the machining processes.
3. Move the handle 04 to a proper position and install a workpiece to be machined. Turn the handle 04 clockwise and stir the 5C sleeve to let the cone of the 5C sleeve contacting with and pressing tight the big cone of the 5C collet, that is to get a reliable clamping of the workpiece. When the workpiece could not be clamped tightly, stir the holes on the circular surface of the nut 02 properly with the stir pin to make the nut turning rightward. In case the handle 04 at a position after clamped of the workpiece interfering with machining operation of the processes, stir the holes on the circular surface of the nut 02 leftward or rightward with the stir pin 09 to move the handle 04 to a proper position, and in case a proper position of the handle 04 could not get by adjust of the nut 02, disassemble the screw 08, screw sleeve 07 and handle 04, for the handle 04 is geared with the offset gear 06, it can get a proper position by changing a different gearing position, and so, after adjusting to a proper position, reassemble the handle 04, the screw sleeve 07, and the screw 08.