

PACKING LIST

No.	Description	Note	Quantity
1	Chuck		1 Piece
2	Chuck Wrench	800 or 1000 chuck is supplied a wrench with external hexagonal head	1 Piece
3	Socket Head Cap Screws	Short Cylinder & Form A	4 Piece
			800~1000 8 Piece
4	Studs and Locknuts	Form C	5~8 4 Piece
			Nose No 11~15 6 Piece
5	Studs for Camlock and Socket Head Cap Screws	Form D	Nose No 5~15 6 Piece
6	Technical Document		1 Set

Packing Inspector: \_\_\_\_\_

Date: \_\_\_\_\_

MODEL K72 FOUR-JAW  
INDEPENDENT CHUCK

# Technical Documents

Operation Instruction

Test Certificate

Packing List

# OPERATION INSTRUCTION

## I. Uses and Features

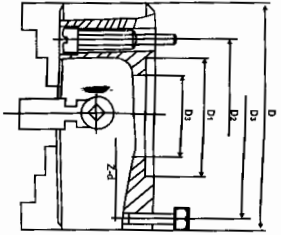
The Model K72 Four-Jaw Independent Chuck is suitable for use on universal lathes and internal and external grinding machines etc. for clamping workpieces to perform various cutting operations.

The jaws for clamping workpiece made of quality steel and have been subjected to hardening treatment, being high in wear and shock resistance, retentive of accuracy, and durable in service.

## II. Construction and parameters

The Model K72 Four-Jaw Independent Chuck is composed mainly of a body, jaws, lead-screws, and chucking rod.

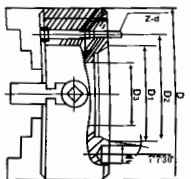
Basic parameters and installation dimensions of Four Jaw Independent Chuck is shown in the figures below:



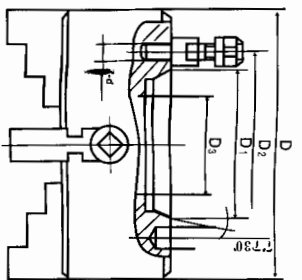
Short Cylinder

Diameter	D		D <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>	z-d
	mm	inch				
80	3	3	55	66	22	4-M6
100	4	4	75	88	25	
125	5	5	95	108	30	4-M8
160	6	6	130	145	40	
160A			53	71	45	4-M10
160T			65	95		
200			125	104.8	50	4-M10
200A	8	8	75	95	56	
200K			80	112		4-M12
250	10	10	100	120	65	
250A			110			4-M12
300	12	12	152	130	75	
320	13	13	140	165	95	4-M16
350	14	14	130	168	80	
400	16	16	160	185	125	4-M16
450	18	18	180	205	140	
500	20	20	200	236	160	4-M20
630	25	25	220	258	180	
800	32	32	250	300	210	4-M20
1000	40	40	320	370	260	
1000A			285	330	280	8-M20
1250	50	50	400	500	305	

Short taper  
Form A2 Mount with perforating screw

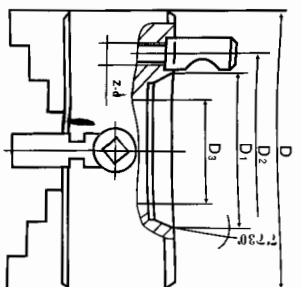


Size	D	No of spindle head	D <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>	z-d
200		4	63.513	82.6	56	4-M10
250						
200		5	82.563	104.8	56	4-M10
250						
320		6	106.375	133.4	75	4-M12
250						
320		8	139.719	171.4	95	4-M16
350						
400		11	196.869	235.0	125	4-M16
400						
250		15	285.775	330.2	180	8-M22
320						
400		20	412.775	463.6	280	8-M24
500						
630		241			241	8-M22
800						
1000		280			280	8-M20
1000T						
1250T		280			280	8-M22
1250						
1250		280			280	8-M24
1250						



Form C: Mounting with catch plate and locknuts

Size D	No of spindle head	D <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>	z-d
160	3	53.975	75.0	45	
160					3-M10
200	4	63.513	85.0	56	
200					4-M10
250	5	82.563	104.8	56	
250					4-M10
300	6	106.375	133.4	75	
300					4-M12
320	8	139.719	171.4	95	
320					4-M16
400	11	196.869	235.0	160	
400					6-M20
500	15	285.775	330.2	280	
500					6-M24



Form D: Mounting with connecting bar and camlocks

Size D	No of spindle head	D <sub>1</sub>	D <sub>2</sub>	D <sub>3</sub>	z-d
160	3	53.975	70.6	45	
160					3-M10 x 1
200	4	63.513	82.6	56	
200					6-M12 x 1
250	5	82.563	104.8	56	
250					6-M12 x 1
300	6	106.375	133.4	75	
300					6-M16 x 1.5
320	8	139.719	171.4	95	
320					6-M20 x 1.5
400	11	196.869	235.0	160	
400					6-M22 x 1.5
500	15	285.775	330.2	180	
500					6-M24 x 1.5

### III. Guide to Correct Handling and Maintenance

(1) After unpacking, remove the anti-rust grease and carefully clean the chuck before putting into service.

(2) The jaws of any size may be mounted facing inward or outward. The ranges of workpiece clamping are shown in the table below:

Clamping range	(unit: mm)														
	160	200	250	300	320	350	400	450	500	630	800	1000			
Positive jaw	8-	10-	15-	18-	20-	22-	25-	30-	35-	50-	70-	100-			
	80	100	130	160	170	180	250	275	300	400	540	680			
Negative jaw	50-	63-	80-	90-	100-	110-	118-	122-	125-	160-	200-	250-			
	160	200	250	300	320	350	400	450	500	630	800	1000			

(3) After dismounting the jaws for turning face about, it is imperative to remove chips and dirt before remounting. When the workpiece has been clamped, never rap it strongly, or the parts of the chuck will be damaged and accuracy lowered.

(4) Regularly clean the chuck to ensure the interior of the chuck tree from accumulated chips and dirt; otherwise, the chuck parts will be worn out before their time or troubles will occur.

(5) On moving the jaws with a spanner, it is inadvisable to add extension bars, which may bring about too great a torque and thus cause damage to the chuck body.

### TEST CERTIFICATE

#### FOUR-JAW INDEPENDENT CHUCK

Specification: K72-~~80~~      Manufacture No: \_\_\_\_\_

This product, manufactured according to the national standards JB/T6566-93 of the People's Republic of China has been tested and approved for dispatch.

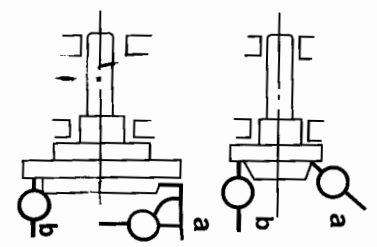
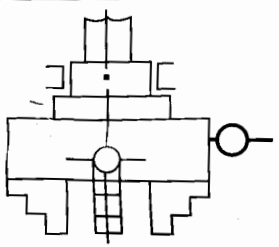
Director: 01

Chief of Quality Control Department: 02

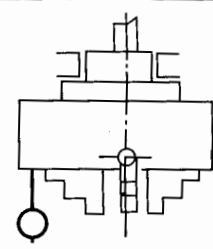
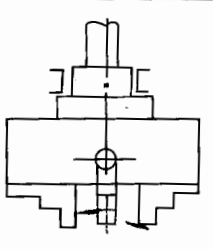
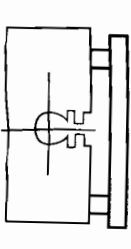
Inspector: 04

Date: 2008.5

Accuracy Test Standard

No:	Test item	Sketch	Size of chuck (mm)	permissible error (mm)
G <sub>0</sub>	Runout of nose of the testing spindle or connecting plate a. radial runout b. facial runout			a&b 0.005
G <sub>1</sub>	Radial runout of outer diameter of chuck		160	0.04
			200, 250	0.06
			300, 320 350, 400 450	0.075
			500, 630 800, 1000	0.10 0.125

Accuracy Test Standard

No:	Test item	Sketch	Size of chuck (mm)	permissible error (mm)
G <sub>2</sub>	Facial runout of end face of chuck		160	0.02
			200, 250 300, 320 350	0.03
			400, 450 500, 630	0.04
			800, 1000	0.06
G <sub>3</sub>	Facial runout of upper faces of jaws		160	0.03
			200, 250 300, 320 350	0.04
			400, 450 500, 630	0.05
			800, 1000	0.08
G <sub>4</sub>	Flatness of end face of chuck (deviations from flatness shall be of concave nature)		300, 320 350 400, 450	0.04
			500, 630	0.05
			800, 1000	0.06