

# How to mount a B200 series chuck to your spindle nose

## Preparation

- The drawtube and cylinder should already be installed on the machine
- Ensure the thread and spindle nose are clean and free from defects
- Ensure you use the correct safe lifting equipment for the size and weight of chuck you are fitting
- Ideally have two lengths of threaded guide bars or threaded studding to suit the chuck and spindle nose mounting threads to help guide the chuck onto the spindle nose

## Step One

- Remove the soft jaws if fitted
- Lower the cylinder input pressure, this helps when screwing the draw nut onto the drawtube
- If possible, lock the spindle to stop it from rotating
- Ensure the drawtube is in the forward position
- If the chuck has been supplied with an indirect chuck adaptor fit this to the spindle first
- Fit the two threaded guide bars onto the spindle nose
- Lift the chuck and align centrally to the spindle. If threaded guides have been fitted slide the chuck onto the guides maintaining support of the chuck with the lifting equipment
- Remove the dust cover in the centre of the chuck
- Insert the joint handle supplied with the chuck
- Attach the chuck to the drawtube using the joint handle provided to screw the draw nut onto the drawtube. Warning- Do not screw the nut fully onto the drawtube, at this stage leave a gap of approx. 3/4mm from the end. Fully screwing the nut onto the drawtube could result in the draw nut locking onto the drawtube.

## Step Two

- Remove the joint handle
- Screw in the mounting bolts provided removing any threaded guide bars that were previously fitted
- Remove the chuck lifting equipment
- Tighten the bolts to the correct torque setting shown in the manual

## Step Three

- Re-insert the joint handle.
- Ensure the drawtube is still in the forward position
- Check the jaw stroke indicator located on the side of Master Jaw No.1 against the stroke mark on the face of the chuck
- Actuate the chuck open and closed to check the jaw stroke. If required, the stroke can be altered by screwing or unscrewing the draw nut
- Re-set the cylinder input pressure to the correct setting for the cylinder/chuck combination
- Ensure chuck is fully greased using the recommended grease

## Troubleshooting

- If the connection of the draw nut to the drawtube is difficult check the thread is correct. Do not use any force as this could cause damage to the chuck parts and could result in affecting the accuracy and actuation of the chuck.