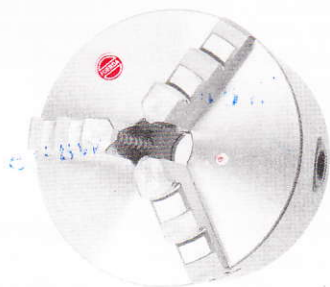


FUERDA

HAND-OPERATED SELF-CENTERING CHUCKS



No: T2008003

OPERATION MANUAL

Lathe chucks are manufactured in two versions:

Version 1 - mounted by means of a mounting plate to GOST 3889-90

Version 2 - mounted on a spindle end directly to GOST 12593-70

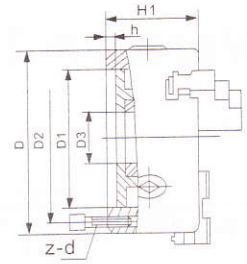
The jaws of the self-centering chucks have two makes:

Make 1- Solid jaw: One chuck has each set of Outside jaws and Inside jaws, which can be used separately.

Make 2- two-piece jaw : which is comprise master jaws and reversible top jaws. The two-piece jaws can perform as Outside jaws or Inside jaws through adjustment.

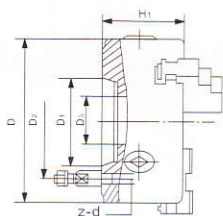
1. Grease must be emptied out from the threaded holes of chuck before mounting.
2. Wash and lubricate the chuck regularly in order to maintain its accuracy and durability.
3. After the work piece is clamped, do not knock it with hammer for preventing the chuck accuracy from being affected and the parts

Version 1



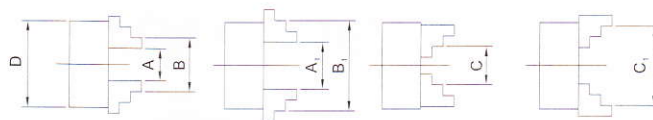
SIZE D	D1	D2	D3	H1	h	Z-d
80	55	66	16	50	4	3-M6
100	72	86	22	55	3	3-M8
125	95	108	30	58	4	3-M8
160	130	142	45	65	5	3-M8
200	165	180	65	75	5	6-M10
250	210	226	80	80	5	6-M12
315	270	290	100	90	6	6-M12
400	340	368	130	100	6	6-M16
500	440	465	210	115	6	6-M16
630	560	595	252	135	7	6-M16

Version 2



SIZE D	short taper	D1	D2	D3	H1	z-d
100	3	53.975	75	20	60	3-M10
125	3	53.975	75	30	63	3-M10
	4	63.513	85	30	63	3-M10
160	3	53.975	75	40	76	3-M10
	4	63.513	85	40	70	3-M10
	5	82.563	104.8	40	73	4-M10
	6	106.375	133.4	40	73	4-M12
200	3	53.975	75	50	84	3-M10
	4	63.513	85	50	84	3-M10
	5	82.563	104.8	50	84	4-M10
	6	106.375	133.4	50	84	4-M12
250	5	82.563	104.8	70	98	4-M10
	6	106.375	133.4	70	98	4-M12
	8	139.719	171.4	80	98	4-M16
315	6	106.375	133.4	100	113	4-M12
	8	139.719	171.4	100	113	4-M16
	11	196.869	235	100	115	6-M20
400	6	106.375	133.4	130	126	4-M12
	8	139.719	171.4	130	126	4-M16
	11	196.869	235	130	126	6-M20
500	8	139.719	171.4	135	145	4-M16
	11	196.869	235	190	145	6-M20
630	8	139.719	-	135	165	4-M16
	11	196.869	235	190	165	6-M20
	15	285.775	330.2	252	165	6-M24

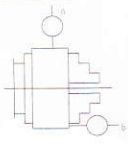
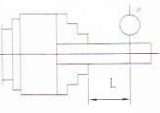
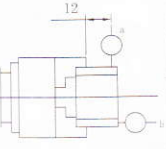
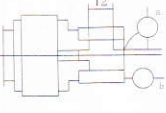
Clamping Range



SIZE D	Outside jaw		Inside jaw
	A-A ₁	B-B ₁	C-C ₁
80	2-22	25-70	22-63
100	2-30	30-90	30-80
125	2.5-40	38-125	38-110
160	3-55	50-160	55-145
200	4-85	65-200	65-200
250	6-110	80-250	90-250
315	10-140	95-315	100-315
400	15-210	120-400	120-400
500	25-280	150-500	150-500
630	50-350	170-630	170-630

CHUCKS ACCURACY

Unit:mm

Diagram of test	Test item	Chuck Dia.				
		80 125 100 160	200 250	315 400	500 630	
	a	0.03	0.04	0.06	0.08	
	b	0.03	0.04	0.06	0.08	
	a	0.04 L=50	0.06 L=50 L=75	0.08 L=75	0.10 L=100	
	a	0.04	0.06	0.08	0.10	
	b	0.02	0.03	0.05	0.06	
	a	0.04	0.06	0.08	0.10	
	b	0.02	0.03	0.05	0.06	

PACKING LIST

No.	Description	Quantity	Note
1.	Chuck	1 pce.	
2.	Inside jaws	1 set	For solid jaw
3.	Chuck wrench	1 pce.	With spring
4.	Mounting screw	3 pce.(≤400) 6 pce.(≥500)	
5.	Hex wrench	1 pce.	
6.	Technical Document	1 pce.	

TEST CERTIFICATE

Model & Size

7100-0035 □

**This chuck has been tested
and found qualified for delivery**

Director : Chen

Wang

Chief of Inspection Dept. : _____

Inspector : 2

Packer : 2 Serial No. : 2011 11-26