

KALAMAZOO INDUSTRIES, INC.

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Operating Instructions for 1CC Collet Chuck

Product Overview

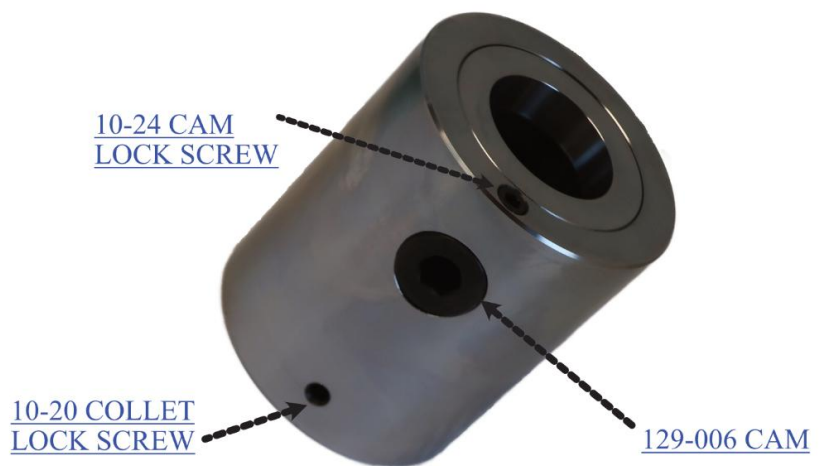
The 1CC is a dead-length, non-lateral movement 5C collet chuck designed for holding the outer diameter (O.D.) of a workpiece. It can be used in both manual and power chucks, or fixture-mounted using the four 1/4-20 tapped holes and 1.5" x 1/4" recess.

Material & Finish: Hardened and ground

Runout Accuracy:

Approximately 0.0015" TIR

Note: Actual accuracy depends on the condition of the collet, the workpiece, and the TIR of the chuck. Boring of the chuck jaws may be necessary for optimal performance.



Operating Instructions for the 1CC 5C Collet Fixture (Page 2)

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Installation & Operation

1. Collet Installation

- Thread the collet into the spindle until the workpiece can be inserted and removed with minimal clearance.
- Adjust the collet in or out to achieve a proper grip and release the workpiece.

(4) 1/4-20



2. Locking the Collet

- Use the provided 3/8" hex key to lock or release the collet.
- Only 1/2 turn or less is required to lock the collet securely.
- When properly adjusted, you will feel the cam slightly go over center and stop—this indicates a secure lock.

3. Locking Set Screw

A locking set screw with a brass tip is provided to secure the collet in place.

CAUTION: Always release the set screw before attempting to remove the collet to avoid damage.