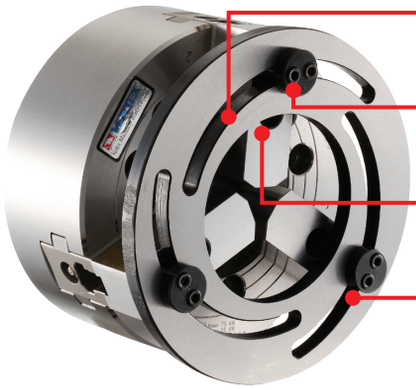
Soft Jaw Forming Ring



The size can be adjusted against the helical slot.

Bias pin can be rotated 180 degree for different size to extend a clamping range.

Don't need to drill new hole. The hole on the soft jaws can be used directly for bias pin.

The material, which is hardened and ground, can last for a long time.

FAETURES

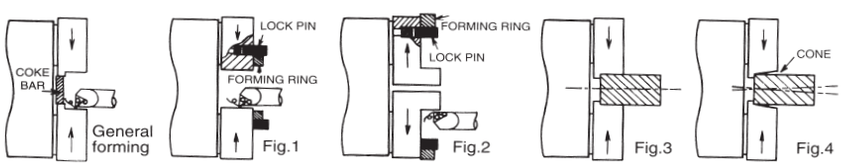
THE CHUCK NOT INCLUDING

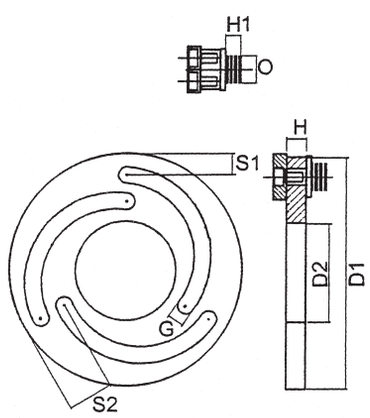
- Forming ring is available for5″ ,6″,8″,10″&12″ power chuck.
- The clamping force is increasing. the roundness and vibration caused by eccentricity can be improved. The cutting accuracy is much better because of no taper hole(as fig.3) and less vibration.
- Both Clamping(as fig.1) and extension (as fig. 2) are available. Meanwhile,the size adjusting is at will, the operation is easy and endurable.
- More improvement for used chuck to have high accuracy & strong clamping force .

INSTRUCTION

Because the forming ring is used for cutting soft jaws by clamping and with extending. through-hole could increase the accuracy of clamping work piece. (please refer to fig.1.2&3)

As fig.4, the soft jaw is made without forming ring. So that the cone has created, moreover, the Bad accuracy, run-out, vibration occur when clamping force is not stable.

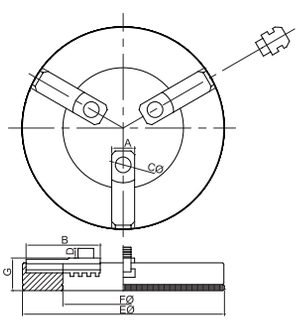




ORDER NO.	SUIT TO SK-CHUCK SIZE	H	D1	D2	S1	S2	G	H1	O	KGS	CODE NO.
VFR-05	5″	12	140	60	12	28	10	9	13.5	1	5002-360
VFR-06	6″	12	168	80	12	32	10	9	16.5	1.5	5002-361
VFR-08	8″	12	218	115	17	36	10	9	18.5	2.4	5002-362
VFR-10	10″	12	258	150	15	40	10	9	18.5	3	5002-363
VFR-12	12″	15	316	188	21	50	10	9	21.5	5	5002-364
VFR-15	15″	20	380	230	23	52	12	16	31	10.1	5002-365

Soft Jaw Forming Unit

NEW



FAETURES

- Suit for CNC lathe
- Soft jaws can be made smaller sizes by this unit easily. With only some simple process, soft jaws can be bored.
- This type with a continuous micro sdjustment is to provide accurate position to reduce the abrasion of soft jaws.
- With counterclockwise clock, the machining field can be easily espended.

The operation process as following:

1.Set the jaw for correct position.
2.Adjust the Jaw Boring Fixtures to fit the bolt holes, and turn opposite direction of the chuck clamping force.
3.Lock the chuck to clamp the Jaw forming unit.
4.Machining the required size.
5.Unicok chuck, and remove the Jaw forming Fistures.
6.If these steps are operated correctly, the part will be accurated & better T.I.R.

Unit:mm

ORDER NO.	SUIT FOR CHUCK	A-B	CØ	D	EØ	FØ	G	JAW STROKE EACH	MAX.GRIPPING FORCE kgs	MAX.SPEED R.P.M.	KGS	CODE NO.
VFR-06-S	5",6",8" 130,160,180	19-61	13	7	170	100	26	7.4	1500	800	2.7	5002-370
VFR-08-S	6",8",10" 160,200,250	19-61	16.3	8	200	125	26	7.4	1500	700	3.5	5002-371
VFR-10-S	8",10",12" 200,250,300	24-80	18.3	8	248	160	31	8.5	1750	600	5.6	5002-372