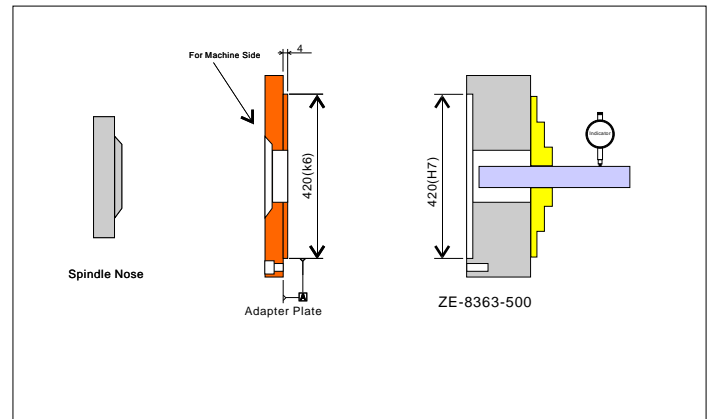
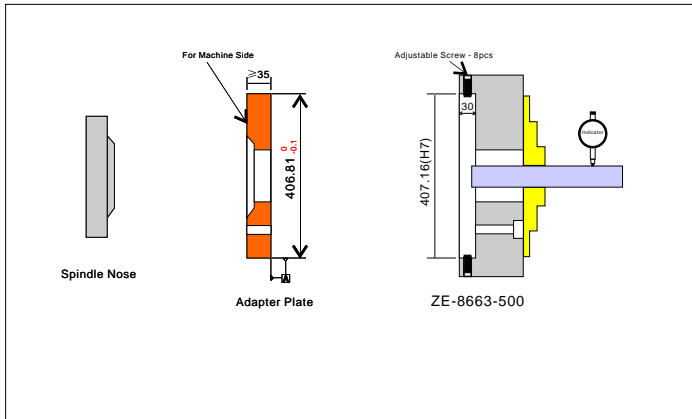


Chuck installation

Adjustable Chuck

DIN 6350 Standard Chuck



ZE-8663-500

Step 1

Mount the adapter on the spindle nose and then check runout of adapter on side A & B to make sure if the adapter correct installation, the runout should be $\leq 0.005\text{mm}$

**ZE-8363-500
DIN 6350**

Step 1

Mount the adapter on the spindle nose and then check runout of adapter on side A & B to make sure if the adapter correct installation, the runout should be $\leq 0.005\text{mm}$

ZE-8663-500

Do not adjust chuck center in step 2

Step 2

Mount the chuck on the adapter plate, and then screw the chuck mounting bolts to 95% tight, that means the chuck almost mount on the adapter, test the runout of chuck body face side B axial runout of chuck body to make sure the chuck mounting is flat, the runout side B should be $\leq 0.05\text{mm}$

**ZE-8363-500
DIN 6350**

Step 2

Mount the chuck on the adapter plate, the fitting between chuck and adapter plate are tight, it is H7/k6. Screwed chuck mounting bolts to finish the installation. To make sure the correct installation, please check the chuck body OD radial runout and face axial runout. The OD runout side A should be $\leq 0.10\text{mm}$. The face runout side B should be $\leq 0.05\text{mm}$

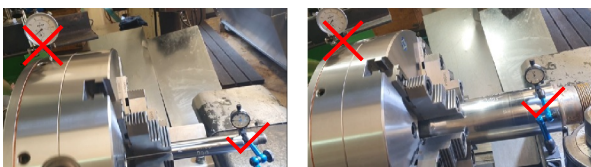
ZE-8663-500

Step 3

Clamping the workpiece and turn the adjust screw to make the workpiece runout within 0.01mm or 0.02mm, and then tight the chuck mounting screw to 100% tight.

Step 3

After correct chuck installation, we can start to check chuck clamping accuracy. Clamping the workpiece properly and then test it, the runout should be $\leq 0.10\text{mm}$ for any workpiece of chuck clamping range



Please take off the indicator from the chuck OD, the chuck body radial runout is not reference. Please adjust the workpiece to 0.01mm.