

KI Kalamazoo Industries Inc.

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Model 1CC parts and instructions

The 1CC is a dead-length/non-lateral movement 5C collet chuck designed for holding the O.D. In a power or manual chuck. It can also be fixtured mounted with the four 1/4-20 tapped holes and 1.5" x 1/4" recess.

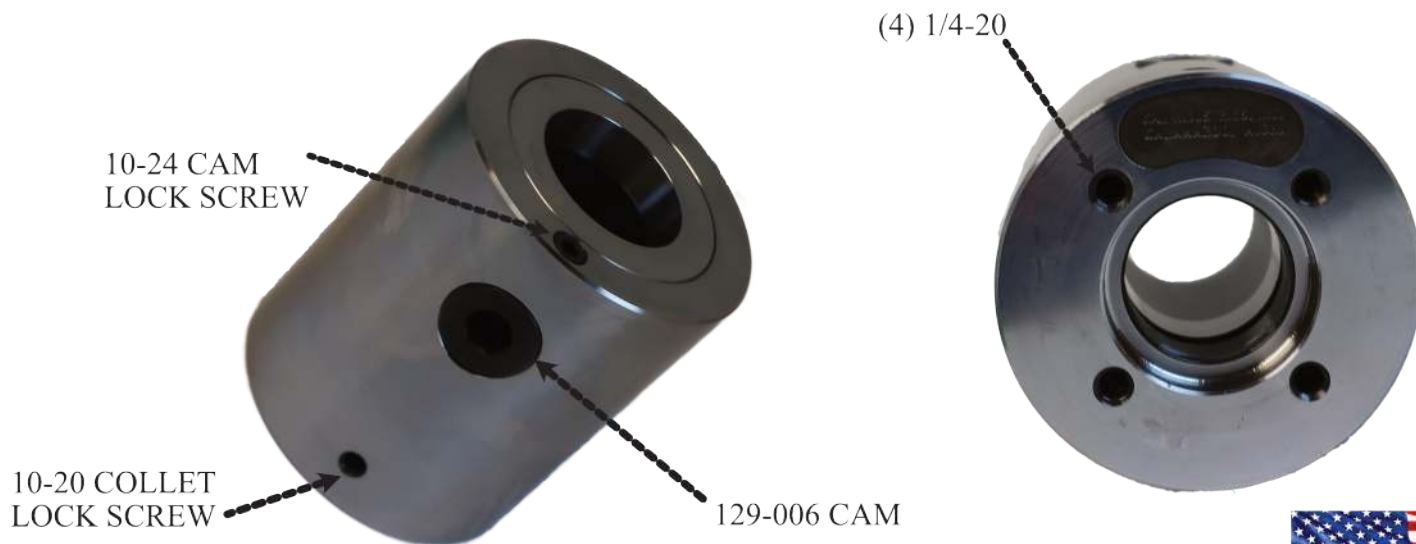
The unit is hardened and ground to approximate .0015 TIR. Accuracy depends on the collet condition, work piece and TIR of the chuck. Boring of the chuck jaws may be required.

Operation

Thread the collet into the spindle until the work piece goes in and out of the collet with just enough clearance.

Thread collet in/out to achieve good grip/release of the work piece. Lock/release collet with the 3/8" hex key provided. Only 1/2 turn or less is required to lock the collet. With correct adjustment you will feel the cam go slightly over locking center and stop. A locking set screw with a brass tip is provided if needed to lock in the collet.

CAUTION: Release set screw before removing collet.



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