

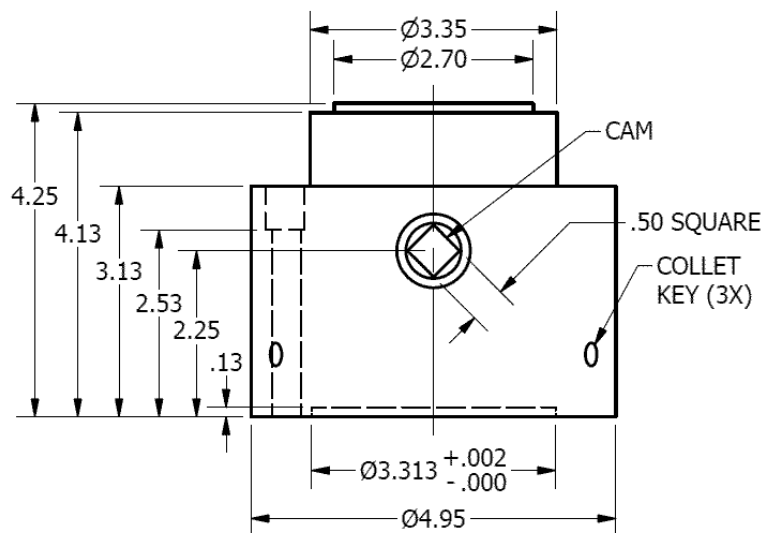
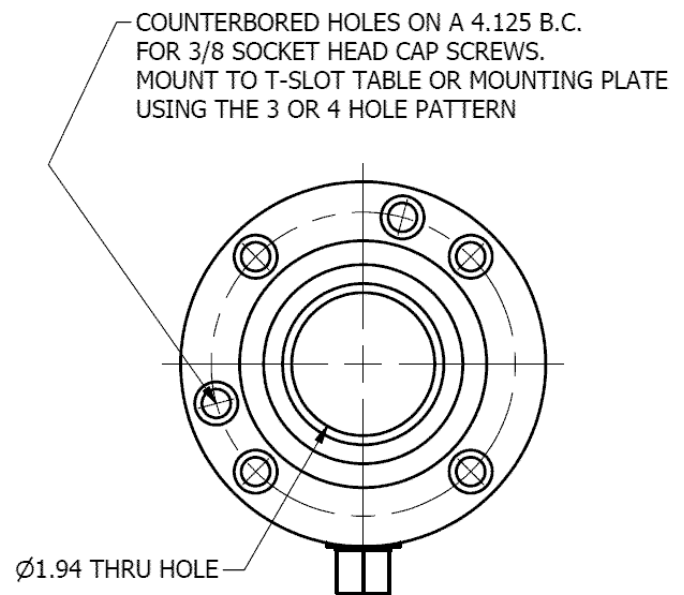
Part # 20013 3J MANUAL COLLET CLOSER

MOUNTING INSTRUCTIONS:

1. Clean back mounting surface and bore of collet closer thoroughly.
2. Clean rotary table or stationary fixture mounting surface thoroughly.
3. Mount collet closer using 3/8" socket head cap screws.

COLLET INSTALLATION INSTRUCTIONS:

1. Use the supplied cam wrench to turn cam and retract the sleeve. Cam can be turned in either direction.
2. Verify the three collet keys, located near the base of the collet closer are not protruding into the bore.
3. Take note where keyway is located on collet.
4. Thread collet into collet closer until collet angle contacts angle in sleeve.
5. Insert workpiece in collet and actuate sleeve by turning cam until collet grips the workpiece. If the collet does not grip the workpiece, the collet needs to be threaded further into the collet closer. If the collet grips the workpiece before the cam has rotated sixty to seventy degrees, the collet must be unscrewed slightly.
6. Once the proper tension is achieved, turn the cam to open the collet. Continue to thread collet in until keyway in collet lines up with the nearest collet key. Screw the collet key into the keyway until it bottoms out, then back collet key out a quarter turn. Do not leave the collet key bottomed out and use only one collet key to locate the collet.
7. Recheck the collet tension with a workpiece and collet key installed.



NOTE: Sleeve stroke= 1/8"

WARNING: Collet closer is designed for stationary and/or rotation of 2 rpm or less. This collet closer is not intended for use on lathes or grinders.