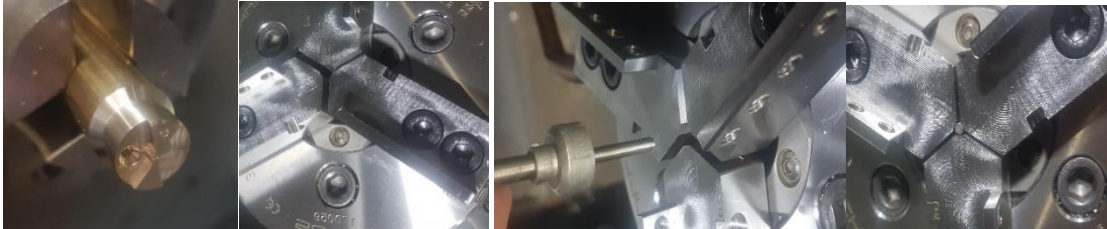
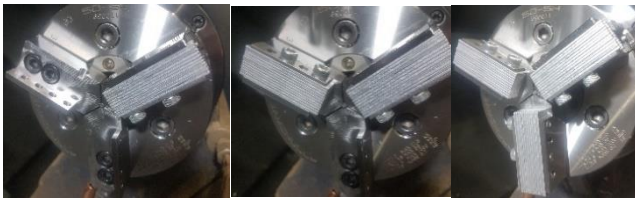


Setting up the Adaptive Jaws

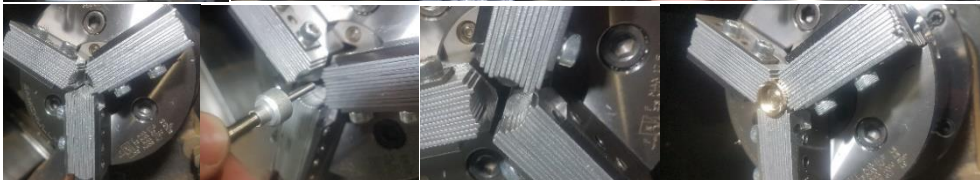
- After finishing the machining on side I. /Main side, set both side in the position where the transfer will occur. Mainly origin /home position of both "C" axis.



- Clamp a steel rod (that can be retrieved with the help of a magnet later) in the chuck. The size of this rod is to stop the Adaptive Jaws in the middle of their stroke and under the size of the part you wish to clamp with the Adaptive Jaws.



- Lock both spindle and / or apply the brakes to making sure they will not move during the setup.
- Dive up the second / sub spindle over the machined part or the area needs to be clamped so the face of the adaptive jaws are in the position where you wish the clamping to occur.
- Gently push the (pre-set) Jaw teeth onto the part's outside contour. Make sure that all teeth make contact with the contour. A small torx-key can be used to push the teeth individually .
- Lock the teeth into position by tightening the bolts supplied with the set .
- Make sure there are no tooth sticking out of the top face of jaws.
- To ensure accuracy the teeth must not exceed 1.5 times of their thickness when they sticking out compared to each other as they follow the parts contour. Otherwise deflection of the teeth will cause inaccuracy and unbalanced part.
- After tightening up all 6 bolts (2 of each jaw), drive the second spindle with the Adaptive Jaws back to it's Origin / Home position and remove the small bar with a magnet.



○ **Congratulations ! Setup's Done .**

During setup please ensure that:

- Teeth tightening Bolts Torque does not exceed torque described in the Instruction manual given with the set .
- Cover Inserts(the inserts that have 4 holes) are NEVER USED for clamping on workpiece !
- DO NOT weld on jaws or inserts or any other parts .
- Always use the cover inserts with the jaws .
- Always check any balance issue starting with low rpm slowly raising up to the desired rpm
- The jaws can not be used without the cover inserts.
- The cover inserts must be the last ones on the stack of inserts and must be placed in it's own pocket on the base jaws when it's being used.
- The 2 bolt / jaw must go through the cover insert and tighten up with the adequate torque when it is being used .
- Strictly use only the bolts supplied with the set.
- The bolts are 12.9 High tensile bolts given with the set.
- Always use 2 bolts/jaw.
- Inserts on each of the jaws must be the same material or in the same arrangement on each of the jaws when different inserts combined
- The bolts must go through the tapped holes to ensure proper clamping and causing no damage on the threads.
- Use thicker inserts near the cover insert side if it is possible.
- Inserts on each of the jaws must consume up the same space or have the same thickness when clamped together. Eg: Avoid having 24mm thickness on one jaw and 20-22mm on the others.
- The cover insert must be fully in its locating pocket and flush or below of the surface of the base/side surface.
- To achieve better clamping and avoid deflection, use the bolts as close to the part as possible.
- Before setting up for the desired shape make sure the shape could fit into the area when the jaws are in clamped position and the inserts are pushed back.
- To achieve better clamping and avoid deflection, use the bolts as close to the part as possible.
- The bolts must be in the same arrangement on all the jaws.
- Make sure the bolts on each jaw are in the same distance from the center of the chuck.
- Make sure the clamping pressure is turned down (below 5bar before apply initial clamping on the part)
- Clamping pressure must be adjusted according to part material and insert material used in the jaws to avoid any damage on inserts and risking loose clamping .
- Start the clamping pressure adjustment from the low range .