



**DUNHAM AIR COLLET CHUCK
MODELS ACC5C4T, 16C, 3J
MOUNTING AND OPERATING INSTRUCTIONS**

MOUNTING INSTRUCTIONS

- 1) Dunham Air Collet Chuck Assemblies are designed for both Rotary and Stationary applications, i.e CNC Rotary Tables, Lathes, Surface and Cylindrical Grinders, Dial Index Machines, Torque Test Stands and innumerable other applications.
- 2) When specified for Rotary applications, the Dunham Air Collet Chuck Assembly is usually provided to you with a Dunham Spindle or Rotary Table Mounting Adapter specified by you for your specific machine application, or blank machinable adapter (ACC-ADPT-BLANK). The Dunham Spindle Mounting Adapter is designed and manufactured for easy setup and concentricity (and perpendicularity) adjustment. The Dunham Spindle Mounting Adapter typically features a 'pilot diameter' or other 'face mount' configuration to mate with the spindle face configuration of your machine. The Dunham Spindle Mounting Adapter also typically features a 3.98" diameter 'boss' to mate with the back face of the Dunham Air Collet Chuck Assembly which has a 4.0" diameter counter bore. The Dunham Air Collet Chuck is face mounted to the Dunham Spindle Mounting Adapter with 4 SHCS 5/16-18.
- 3) The Dunham Air Collet Chuck Assembly is equipped with 4 cross Set Screws that permit concentricity adjustment between the Dunham Air Collet Chuck and the Dunham Spindle Mounting Adapter.
- 4) When specified for Stationary applications (non-rotating) there is typically no requirement for a Spindle Mounting Adapter Plate.
- 5) When used in Rotary applications, the Dunham Air Collet Chuck has no 'Thru Hole' capability. When used in Stationary applications the Dunham Air Collet Chuck can be equipped with an optional 'Thru Hole' capability.

****NOTE:** For Tilting Rotary Table applications, we offer Rotary Unions which are lower profile to insure no interference with the Tilting Rotary Table.

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OPERATING INSTRUCTIONS

Inserting Collet:

- 1) With Piston in forward or released position, back off Collet Key, enabling you to rotate the Collet into the Piston's female collet threads without interference from the Collet Key.
- 2) Place Collet in Air Collet Chuck. Rotate Collet clockwise until male taper of collet lightly engages with female taper of Air Collet Chuck.
- 3) Re-align Collet Key with Keyway in your Collet. Please note that there are 4 cross holes provided for the retention and alignment of the Collet Key with your Collet; once you have engaged the Collet Threads with the Piston, determine which Collet Key cross hole is best located for Collet Key with your Collet keyway. ; Re engage the Dunham Collet Key with your Collet Keyway to prohibit free rotation of the Collet.

How to control holding force:

- 1) By using the regulator and gage, start with air pressure of 40 lbs.; increase pressure gradually until part is held sufficiently in the Collet for machining operation (standard maximum 120 psi).
- 2) The Dunham Air Collet Chuck permits even gripping pressure although workpiece may have diameter variation. Holding force can be adjusted for any type of machining or collet work holding by increasing or decreasing the air pressure.

Maintenance:

- 1) Little or no maintenance is required. This Dunham Air Collet Chuck has no bearings. All components are standard.

Installing an air cleaner and lubricator in line is advisable, but not essential.

*****SAFETY*****

The purchaser or end user of this retrofit unit is fully responsible for the fabrication and application of special protective guarding to cover any moving parts.

FAILURE TO COMPLETE THE PROPER INSTALLATION AS INSTRUCTED ABOVE CAN RESULT IN OPERATOR INJURY OR PREMATURE WEAR ON THE UNIT.

MANUALS/AIR COLLET CHUCK INSTRUCTIONS ALL MODELS