

VEVOR®

TOUGH TOOLS, HALF PRICE

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LATHE CHUCK

MODEL: K72 80 K72 100 K72 125
K72 160 K72 200 K72 250

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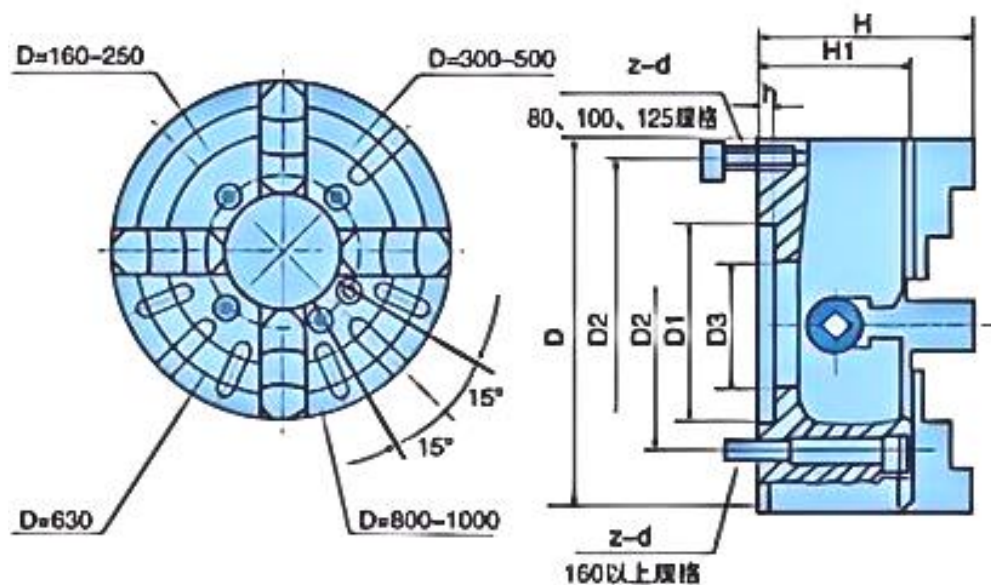
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SPECIFICATIONS



Dimension characteristic parameters

Size mm	D1	D2	D3	H1	h	z-d	Net WT kg	Max speed r/min
80	55	66	22	42	4	3-M6	2.5	4800
100	72	84	25	54	4	4-M8	3	4800
125	95	108	30	56	6	4-M8	5	4200
160	65	95	55	65	5	4-M10	9	3800
200	80	112	70	71	6	4-M10	15	2100
250	110	130	100	80	6	4-M12	23	1800

OPERATION INSTRUCTIONS

K72 independent four jaw chuck, each jaw can rotate independently, and the jaws can be turned forward or backward

Can process irregular products



Caution

- a) Don't add tube on the wrench when clamp workpiece to avoid the input torque exceed limit will break chuck.
- b) Don't clamp workpiece in the max clamping range if possible.
- c) Don't run at the max speed when approach to the max clamping limit.
- d) The chucks with "0" gear in clamping at last to ensure the accuracy.
- e) Don't exceed chuck max speed during operation.

Maintenance and inspection

- 1 Chucks should be maintained while the machine tools maintain.
- 2 Lubricate (at the grease cup) and clean (use the compressed air) the chucks every day, in order to maintain its accuracy and durability.
- 3 Wash and lubricate all the working surface of the chucks at least two times every year. When the using frequency of the machine tool grow or at the special operation conditions, add the maintenance times of the chucks.

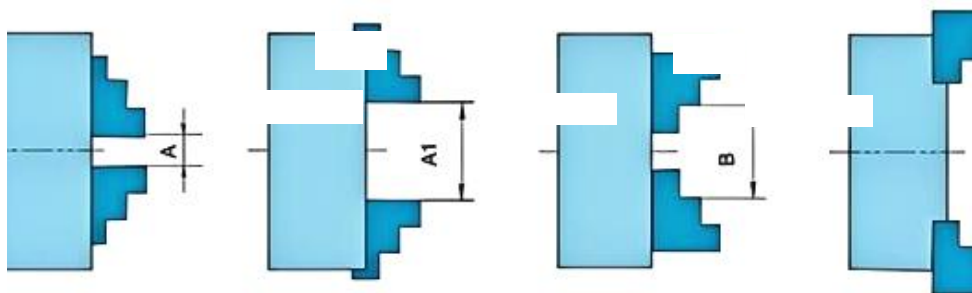
Troubleshooting

Troubleshooting and measurement see Table.5.

(Table 5)

Problem	Cause	Countermeasures
Insufficient clamping	The clamping are taper not conform with dimension	Replace jaws
	The axial clamping Length short	Increase clamping length
	The taper in workpiece	Process workpiece surface
	The input torque small	Increase the input torque
	Over the clamping range	Replace chucks
	Lubrication is poor	More lubricate
Poor accuracy	In using clamping are or working dirty	Maintenance jaws and workpiece clean when working
	When replace jaws, No. 1, 2, 3 jaws wrong	Mount the jaw in order
	Something wrong with the short-taper chucks	Adjust the chucks mounting position
	Short-taper surface dirty when mounting chucks	Maintain the short-taper clean
	Mounting adapter not conform the mounting dimension	Matched adapter conform to demand
	Mounting plates with thickness or section tolerance too large	Matched adapter conform to demand
	Impurity things in the top jaw and base jaw	Keep top jaws and base jaws mounting face clean when replace jaws
	The clamping arc taper not conform dimension	Replace jaws
Clear shall not work	Impurity thing in the chucks	Clean and lubricate
	Lubrication is poor	Lubricate

CLAMPING RANGE



Clamping Range

D Size	Intenal jaws clamping range	Extetal jaws clamping range
	A-A1	B-B1
80	5-35	35-80
100	6-45	40-100
125	7-57	48-125
160	8-80	50-160
200	10-100	63-200
250	15-130	80-250

STANDARD ACCESSORIES

K72 80 K72 100 K72 125
K72 160 K72 200 K72 250

PART NO.	DESCRIPTION	QTY
1	Key chuck	1
2	Screw	3

Manufacturer: Shanghaimuxinmuyeyouxiangongsi

Address: Shuangchenglu 803nong11hao1602A-1609shi, baoshanqu, shanghai 200000 CN.

Imported to AUS: SIHAO PTY LTD, 1 ROKEVA STREETEASTWOOD NSW 2122 Australia

Imported to USA: Sanven Technology Ltd., Suite 250, 9166 Anaheim Place, Rancho Cucamonga, CA 91730

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MANDRIN DE TOUR

MODÈLE : K72 80 K72 100 K72 125

K72 160 K72 200 K72 250

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LATHE CHUCK

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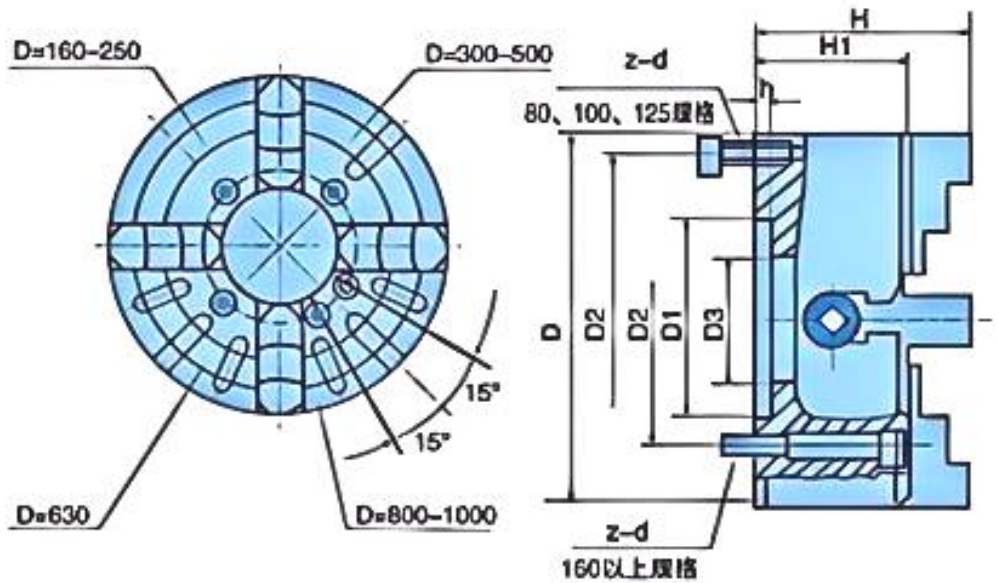
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SPECIFICATIONS



Paramètres caractéristiques des dimensions

Taille mm	D1	D2	D3	H1	h	zd	Poids net kg	Vitesse maximale tr/min
80	55	66	22	42	4	3-M6	2.5	4800
100	72	84	25	54	4	4-M8	3	4800
125	95	108	30	56	6	4-M8	5	4200
160	65	95	55	65	5	4-M10	9	3800
200	80	112	70	71	6	4-M10	15	2100
250	110	130	100	80	6	4-M12	23	1800

OPERATION INSTRUCTIONS

Mandrin indépendant à quatre mâchoires K72, chaque mâchoire peut tourner indépendamment et les mâchoires peuvent être tournées vers l'avant ou vers l'arrière

Peut traiter des produits irréguliers



Prudence

- a) Ne pas ajouter un tube sur la clé lors du serrage de la pièce pour éviter que le couple d'entrée ne dépasse la limite cassera le mandrin.
- b) Ne serrez pas la pièce dans le serrage maximal. portée si possible.
- c) Ne courez pas à la vitesse maximale à l'approche de la limite de serrage maximale.
- d) Les mandrins avec engrenage « 0 » en serrage enfin pour assurer l'exactitude.
- e) Ne pas dépasser la vitesse maximale du mandrin pendant le fonctionnement.

Entretien et inspection

- 1 Les mandrins doivent être entretenus pendant que la machine outils d'entretien.
- 2 Lubrifiez (au niveau du godet à graisse) et nettoyez (utilisez l'air comprimé) les mandrins tous les jours, dans afin de maintenir sa précision et sa durabilité .
- 3 Lavez et lubrifiez toutes les surfaces de travail de les mandrins au moins deux fois par an. Lorsque le en utilisant la fréquence de croissance de la machine-outil ou à les conditions particulières de fonctionnement, ajouter le temps de maintenance du mandrins. Dépannage

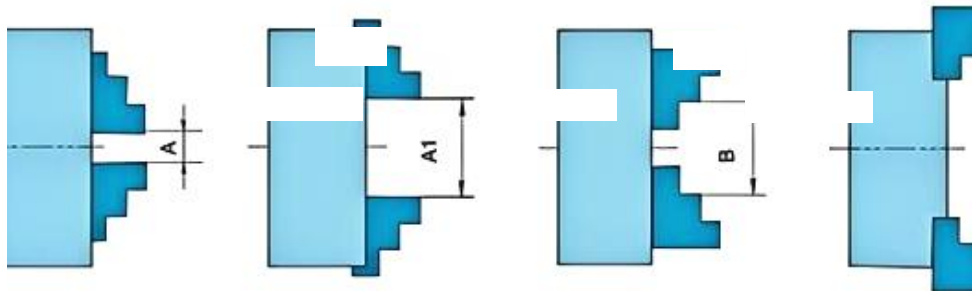
Dépannage et mesure, voir tableau 5.

(Tableau 5)

Problème	Cause	Contre - mesures
Serrage insuffisant	Les enroulements sont coniques et non conformes à la dimension	Remplacer les mâchoires
	La longueur de serrage axiale est courte	Augmenter la durée des claquements de mains
	Le cône dans la pièce à usiner	Traiter la surface de la pièce
	Le couple d'entrée est faible	Augmenter le couple d'entrée
	Sur la plage de serrage	Remplacer les mandrins
	La lubrification est mauvaise	Plus de lubrification
Pauvre précision	En utilisant des pinces ou en travaillant sale	Entretien des mâchoires et de la pièce à usiner propre pendant le travail
	Lors du remplacement des mâchoires, les mâchoires n° 1, 2, 3 sont incorrectes	Monter la mâchoire dans l'ordre
	Il y a un problème avec le mandrins à cône court	Régler les mandrins Position de montage
	Surface à cône court sale lorsque mandrins de montage	Maintenir le nettoyage à cône court
	la dimension n'onting	Adaptateur correspondant conforme exiger
	kapiar plats nith zhkn	Adaptateur correspondant

	orsetion tolsrae trop grand e	conforme exiger
	Des impuretés dans la mâchoire supérieure et la mâchoire inférieure	Gardez les mâchoires supérieures et les mâchoires de base propres lors du remplacement des mâchoires
	L'arc de serrage n'est pas conique dimension conforme	Remplacer les mâchoires
Cear shal l ne fonctionne pas	Impureté chose dans les mandrins	Nettoyer et lubrifier
	La lubrification est mauvaise	Lubrifier

CLAMPING RANGE



Plage de serrage

D Taille	Plage de serrage des mâchoires internes	Plage de serrage des mâchoires externes
	A-A1	B-B1
80	5-35	35-80
100	6-45	40-100
125	7-57	48-125
160	8-80	50-160
200	10-100	63-200

250	15-130	80-250
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STANDARD ACCESSORIES

**K72 80 K72 100 K72 125
K72 160 K72 200 K72 250**

PIÈCE N°	DESCRIPTION	Qté
1	Mandrin à clé	1
2	Vis	3

Fabricant : Shanghaimuxinmuyeyouxiangongsi

Adresse : Shuangchenglu 803nong11hao1602A-1609shi, baoshanqu, Shanghai 200000 CN.

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Importé aux États-Unis : Sanven Technology Ltd., Suite 250, 9166 Anaheim Place, Rancho Cucamonga, CA 91730

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DREHFUTTER

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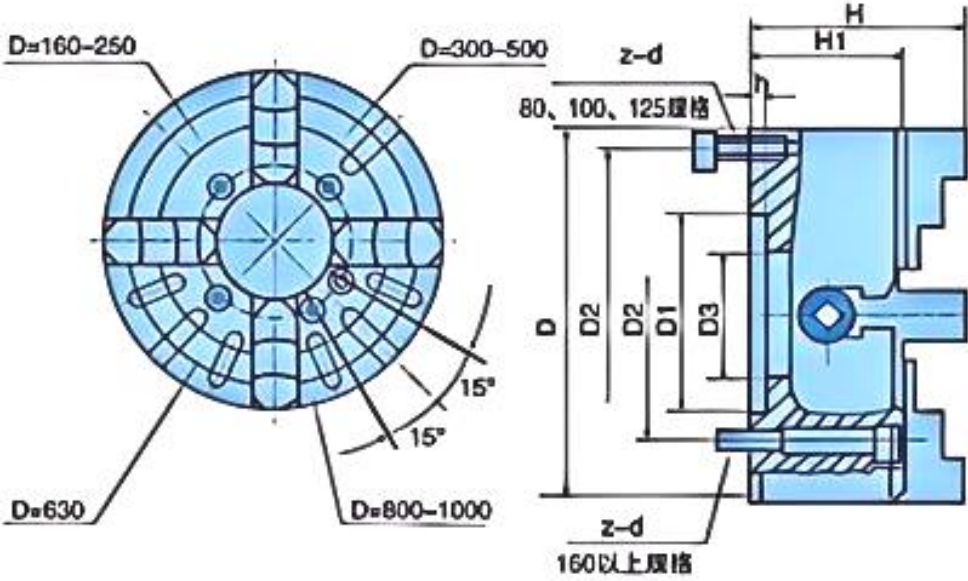
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SPECIFICATIONS



Dimensionsmerkmalparameter

Größe mm	T1 (T1)	T2 - Der zwe ite Tag	T3 - Die wun der bar e Wel t der Trä ume	H1	H	zd	Nettoge wicht kg	Maximalgeschwi ndigkeit U/min
80	55	66	22	42	4	3-M6	2.5	4800

100	72	84	25	54	4	4-M8	3	4800
125	95	108	30	56	6	4-M8	5	4200
160	65	95	55	65	5	4-M10	9	3800
200	80	112	70	71	6	4-M10	15	2100
250	110	130	100	80	6	4-M12	23	1800

OPERATION INSTRUCTIONS

K72 unabhängiges Vierbackenfutter, jede Backe kann unabhängig rotieren und die Backen können vorwärts oder rückwärts gedreht werden
Kann unregelmäßige Produkte verarbeiten



Vorsicht

- a) Nicht Setzen Sie beim Einspannen des Werkstücks das Rohr auf den Schraubenschlüssel, um ein Überschreiten des Eingangsdrehmoments zu vermeiden Das Futter wird durch die Begrenzung kaputt gehen.
- b) Werkstück nicht mit maximaler Spannkraft einspannen Bereich, wenn möglich.
- c) Laufen Sie nicht mit Höchstgeschwindigkeit, wenn Sie sich nähern die maximale Spanngrenze.
- d) Die Spannfutter mit "0"-Gang in endlich klemmen um die Genauigkeit sicherzustellen.
- e) Überschreiten Sie während des Betriebs nicht die maximale Spannfutterdrehzahl.

Wartung und Inspektion

- 1 Die Wartung der Spannfutter sollte bei laufender Maschine erfolgen. Werkzeuge warten.
- 2 Schmieren (an der Fettkammer) und reinigen (mit die Druckluft) die Chucks jeden Tag, In um die Genauigkeit und Haltbarkeit zu erhalten .
- 3 Waschen und schmieren Sie die gesamte Arbeitsfläche die Spannfutter mindestens zweimal jährlich. Nutzungshäufigkeit der Werkzeugmaschine steigen oder die speziellen Betriebsbedingungen, fügen Sie die Wartungszeiten der Spannfutter. Fehlerbehebung

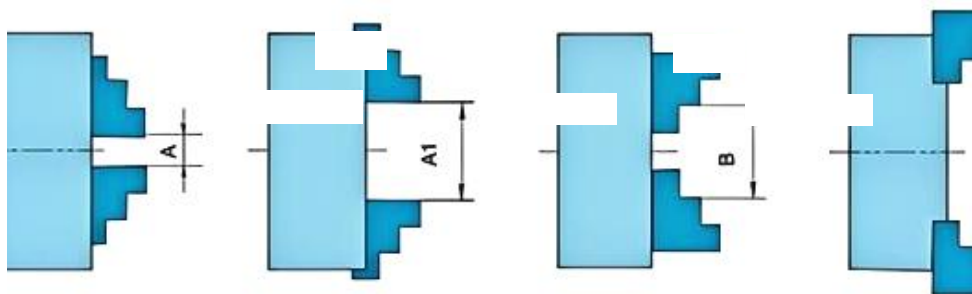
Fehlerbehebung und Messung siehe Tabelle 5.

(Tabelle 5)

Problem	Ursache	Gegenmaßnahmen
Unzureichende Klemmung	Die Kegelform entspricht nicht den Abmessungen	Backen ersetzen
	Die Achsklemmlänge ist kurz	Länge des Klatschens erhöhen
	Der Konus im Werkstück	Werkstückoberfläche bearbeiten
	Das Eingangsdrehmoment klein	Erhöhen Sie das Eingangsdrehmoment
	Über den Klemmbereich	Spannfutter ersetzen
	Die Schmierung ist schlecht	Mehr schmieren
Arm Genauigkeit	Bei der Verwendung von Spannvorrichtungen oder bei der Arbeit mit Schmutz	Wartungsbacken und Werkstückreinigung beim Arbeiten
	Beim Ersetzen der Backen sind die Backen Nr. 1, 2 und 3 falsch	Montieren Sie den Kiefer in der Reihenfolge
	Etwas stimmt nicht mit dem Kurzkegelfutter	Einstellen der Spannfutter Einbaulage
	Kurzkegelfläche verschmutzt bei Aufnahmehalter	Behalten Sie die Kurzkegel sauber
	Mbipiar acoer nt nach der Nicht - Dimension	Passender Adapter konform fordern
	Kapiar-Platten mit Zhkn orsetion tolsrae zu groß e	Passender Adapter konform fordern
	Verunreinigungen im Oberkiefer und	Halten Sie die Montagefläche der

	Unterkiefer	Ober- und Unterbacken sauber, wenn Sie die Backen austauschen.
	Der Klemmbogen verjüngt sich nicht Dimension anpassen	Backen ersetzen
Cear soll funktioniert nicht	Verunreinigung Sache in die Spannfutter	Reinigen und schmieren
	Die Schmierung ist schlecht	Schmieren

CLAMPING RANGE



Klemmbereich

D Größe	Innenbacken Spannbereich	Spannbereich der Außenbacken
	A-A1	B-B1
80	5-35	35-80
100	6-45	40-100
125	7-57	48-125
160	8-80	50-160
200	10-100	63-200
250	15-130	80-250

STANDARD ACCESSORIES

K72 80 K72 100 K72 125
K72 160 K72 200 K72 250

TEIL NR.	BESCHREIBUNG	Menge
1	Zahnkranzbohrfutter	1
2	Schrauben	3

Hersteller: Shanghaimuxinmuyeyouxiangongsi

Adresse: Shuangchenglu 803nong11hao1602A-1609shi, baoshanqu, Shanghai 200000 CN.

Nach AUS importiert: SIHAO PTY LTD, 1 ROKEVA STREETEASTWOOD NSW 2122 Australien

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MANDRINO DEL TORNIO

MODELLO: K72 80 K72 100 K72 125

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K72 250**



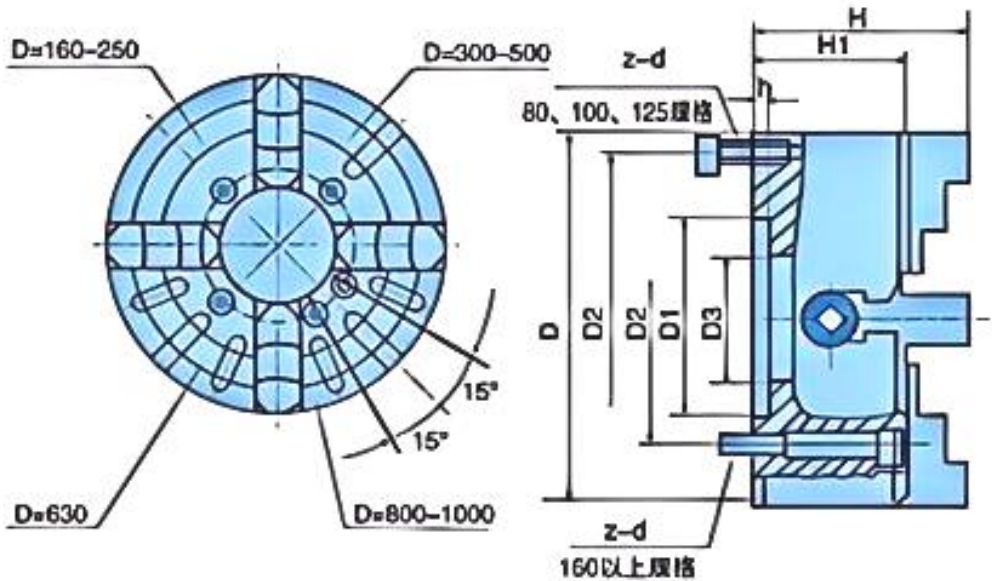
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SPECIFICATIONS



Parametri caratteristici dimensionali

Misurare mm	La 1a	La D2	La D3	H1	H	ora	Peso netto kg	Velocità massima giri/min
80	55	66	22	42	4	3-M6	2.5	4800
100	72	84	25	54	4	4-M8	3	4800
125	95	108	30	56	6	4-M8	5	4200

160	65	95	55	65	5	4-M10	9	3800
200	80	112	70	71	6	4-M10	15	2100
250	110	130	100	80	6	4-M12	23	1800

OPERATION INSTRUCTIONS

Mandrino a quattro griffe indipendente K72, ogni griffa può ruotare indipendentemente e le griffe possono essere girate in avanti o indietro
Può elaborare prodotti irregolari



Attenzione

- a) Non aggiungere il tubo sulla chiave quando si serra il pezzo per evitare che la coppia di ingresso superi il limite romperà Chuck.
- b) Non serrare il pezzo in lavorazione nella posizione di serraggio massima intervallo, se possibile.
- c) Non correre alla massima velocità quando ci si avvicina a il limite massimo di serraggio.
- d) I mandrini con ingranaggio "0" in serraggio alla fine per garantirne l'accuratezza.
- e) Non superare la velocità massima del mandrino durante il funzionamento.

Manutenzione e ispezione

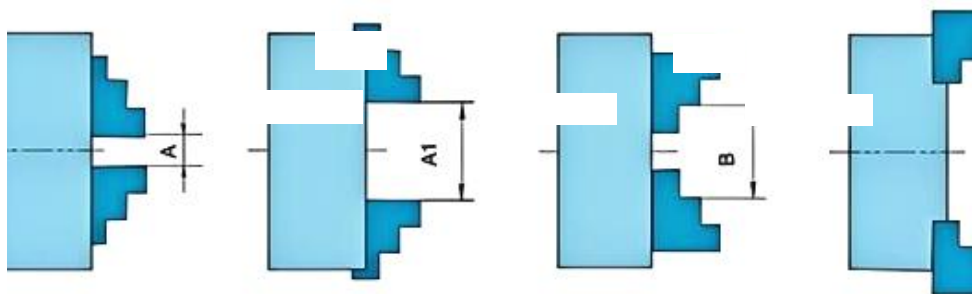
- 1 I mandrini devono essere sottoposti a manutenzione mentre la macchina gli strumenti mantengono.
- 2 Lubrificare (nella coppa del grasso) e pulire (utilizzare l'aria compressa) i mandrini ogni giorno, In per mantenerne la precisione e la durata .
- 3 Lavare e lubrificare tutta la superficie di lavoro della i mandrini almeno due volte all'anno.Quando il utilizzando la frequenza della macchina utensile crescere o a le condizioni operative speciali, aggiungere il tempi di manutenzione del mandrini. Risoluzione dei problemi
Per la risoluzione dei problemi e la misurazione, vedere la Tabella 5.

(Tabella 5)

Problema m	Causa	Contromisure
Serraggio insufficiente	Le sporgenze sono coniche e non conformi alle dimensioni	Sostituire le ganasce
	La lunghezza del serraggio ascellare è corta	Aumentare la lunghezza del claping
	La conicità nel pezzo da lavorare	Elaborare la superficie del pezzo
	La coppia di ingresso è piccola	Aumentare la coppia di ingresso
	Oltre l'intervallo di serraggio	Sostituire i mandrini
	La lubrificazione è scarsa	Più lubrificante
Povero accuratezza	Nell'uso del serraggio sono o lavorano sporchi	Manutenzione delle ganasce e del pezzo in lavorazione puliti durante il lavoro
	Quando si sostituiscono le ganasce, le ganasce n. 1, 2, 3 sono sbagliate	Montare la mascella in ordine
	Qualcosa non va con il mandrini a cono corto	Regolare i mandrini posizione di montaggio
	Superficie conica corta sporca quando mandrini di montaggio	Mantenere il pulizia a cono corto
	Mbipiar acomer nt onform the nonting dim en sion	Adattatore abbinato conforme chiedere
	kapiar plats nith zhkn orsetion tolsrae troppo grande	Adattatore abbinato conforme chiedere
	Impurità nella mascella superiore e nella mascella inferiore	Mantenere pulite le superfici di montaggio delle ganasce superiori

		e delle ganasce di base quando si sostituiscono le ganasce
	L'arco di serraggio non è conico conformare la dimensione	Sostituire le ganasce
La pulizia deve non funziona	Impurità cosa in i mandrini	Pulire e lubrificare
	La lubrificazione è scarsa	Lubrificare

CLAMPING RANGE



Campo di serraggio

D Misurare	Campo di serraggio delle ganasce interne	Campo di serraggio delle ganasce esterne
	Da AA1	B-B1
80	5-35	35-80
100	6-45	40-100
125	7-57	48-125
160	8-80	50-160
200	10-100	63-200
250	15-130	80-250

STANDARD ACCESSORIES

**MODELLO K72 80 MODELLO K72 100 MODELLO K72 125
MODELLO K72 160 MODELLO K72 200 MODELLO K72 250**

N. PARTE	DESCRIZIONE	Quantità
1	Mandrino per chiavi	1
2	Vite	3

Produttore: Shanghaimuxinmuyeyouxiangongsi

Indirizzo: Shuangchenglu 803nong11hao1602A-1609shi, baoshanqu, shanghai 200000 CN.

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MANDRIL DE TORNO

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K72 160 K72 200 K72 250**

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LATHE CHUCK

**K72 80 K72 100 K72 125
K72 160 K72 200 K72 250**



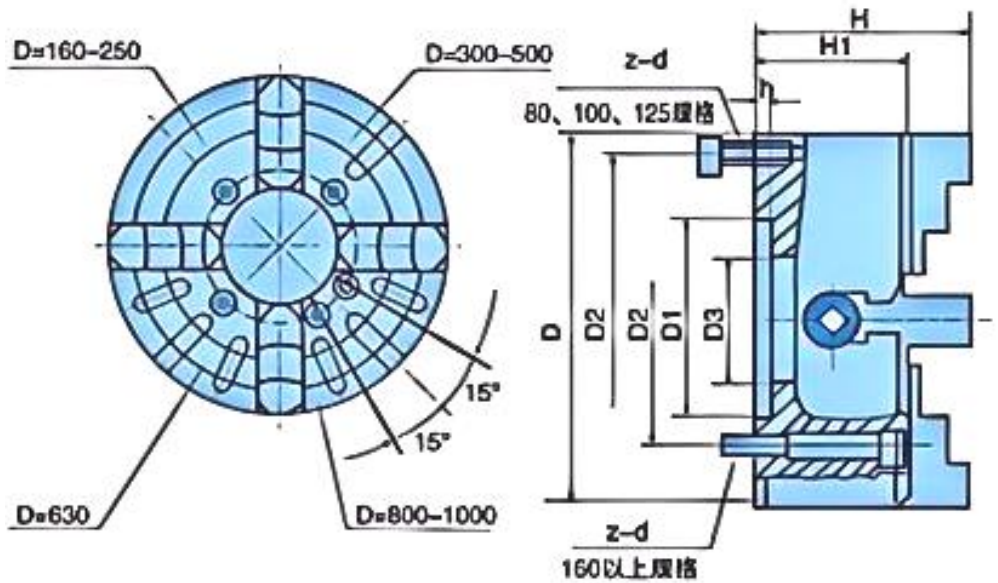
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SPECIFICATIONS



Parámetros característicos de dimensión

Tamaño mm	D1	D2	D3	H1	yo	Zd	Peso neto kilogra mo	Velocidad máxima revoluciones por minuto
80	55	66	22	42	4	3-M6	2.5	4800
100	72	84	25	54	4	4-M8	3	4800
125	95	108	30	56	6	4-M8	5	4200
160	65	95	55	65	5	4-M10	9	3800
200	80	112	70	71	6	4-M10	15	2100
250	110	130	100	80	6	4-M12	23	1800

OPERATION INSTRUCTIONS

Mandril de cuatro mordazas independiente K72, cada mordaza puede girar independientemente y las mordazas se pueden girar hacia adelante o hacia atrás

Puede procesar productos irregulares.



Precaución

- a) No lo haga. Agregue un tubo a la llave cuando sujete la pieza de trabajo para evitar que el torque de entrada exceda. El límite romperá el mandril.
- b) No sujete la pieza de trabajo con la sujeción máxima. alcance si es posible.
- c) No corras a la velocidad máxima cuando te acerques a el límite máximo de sujeción.
- d) Los mandriles con engranaje "0" en Sujetando por fin para garantizar la precisión.
- e) No exceda la velocidad máxima del mandril durante el funcionamiento.

Mantenimiento e inspección

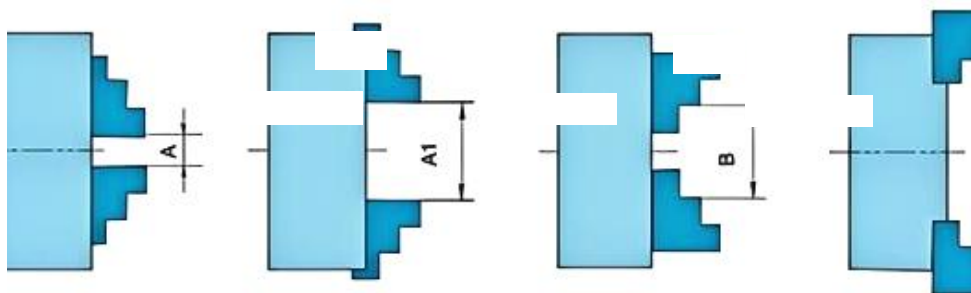
- 1 Los mandriles deben recibir mantenimiento mientras la máquina Herramientas de mantenimiento.
- 2 Lubrique (en el engrasador) y limpie (use el aire comprimido) los chucks todos los días, en para mantener su precisión y durabilidad .
- 3 Lave y lubrique toda la superficie de trabajo de los mandriles al menos dos veces al año. Cuando el utilizando la frecuencia de la máquina herramienta crece o al Las condiciones especiales de operación, agregan el tiempos de mantenimiento de la mandriles. Solución de problemas Para solución de problemas y medición consulte la Tabla 5.

(Tabla 5)

Problema	Causa	Contramedidas
Sujeción insuficiente	Las salidas son cónicas y no se ajustan a la dimensión .	Reemplazar las mordazas
	La longitud de sujeción axial es corta.	Aumentar la longitud de aplausos
	El cono en la pieza de trabajo	Procesar la superficie de la pieza de trabajo
	El par de entrada es pequeño .	Aumentar el par de entrada
	Sobre el rango de sujeción	Reemplazar mandriles
	La lubricación es deficiente	Más lubricación
Pobre exactitud	Al utilizar abrazaderas se ensucian o se trabaja con suciedad.	Mantener las mordazas y la pieza de trabajo limpias durante el trabajo
	Al reemplazar las mordazas, las mordazas n.º 1, 2 y 3 son incorrectas	Monte la mandíbula en orden
	Algo anda mal con el mandriles de cono corto	Ajuste los mandriles Posición de montaje
	La superficie cónica corta está sucia cuando mandriles de montaje	Mantener el cono corto limpio
	acomodarse no conformar la dimensión montando	Adaptador compatible exigir
	planos de planta con zhkn La tolerancia de la orsección es demasiado grande	Adaptador compatible exigir
	Cosas impuras en la mandíbula superior y la mandíbula base	Mantenga limpias las caras de montaje de las mordazas

		superiores y de la base cuando reemplace las mordazas
	El arco de sujeción no se estrecha dimensión conforme	Reemplazar las mordazas
Cear debe no funciona	Impureza cosa en Los mandriles	Limpiar y lubricar
	La lubricación es deficiente	Lubricar

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Rango de sujeción

D Tamaño	Rango de sujeción de las mordazas internas	Rango de sujeción de mordazas externas
	A-A1	B-B1
80	5-35	35-80
100	6-45	40-100
125	7-57	48-125
160	8-80	50-160
200	10-100	63-200
250	15-130	80-250

STANDARD ACCESSORIES

K72 80 K72 100 K72 125

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NÚMERO DE PIEZA	DESCRIPCIÓN	CANTIDAD
1	Portabrocas de llave	1
2	Tornillo	3

Fabricante: Shanghaimuxinmuyeyouxiangongsi

Dirección: Shuangchenglu 803nong11hao1602A-1609shi, baoshanqu, shanghai 200000 CN.

Importado a AUS: SIHAO PTY LTD, 1 ROKEVA STREETEASTWOOD NSW 2122 Australia

Importado a EE. UU.: Sanven Technology Ltd., Suite 250, 9166 Anaheim Place, Rancho Cucamonga, CA 91730

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UCHWYT TOKARSKI

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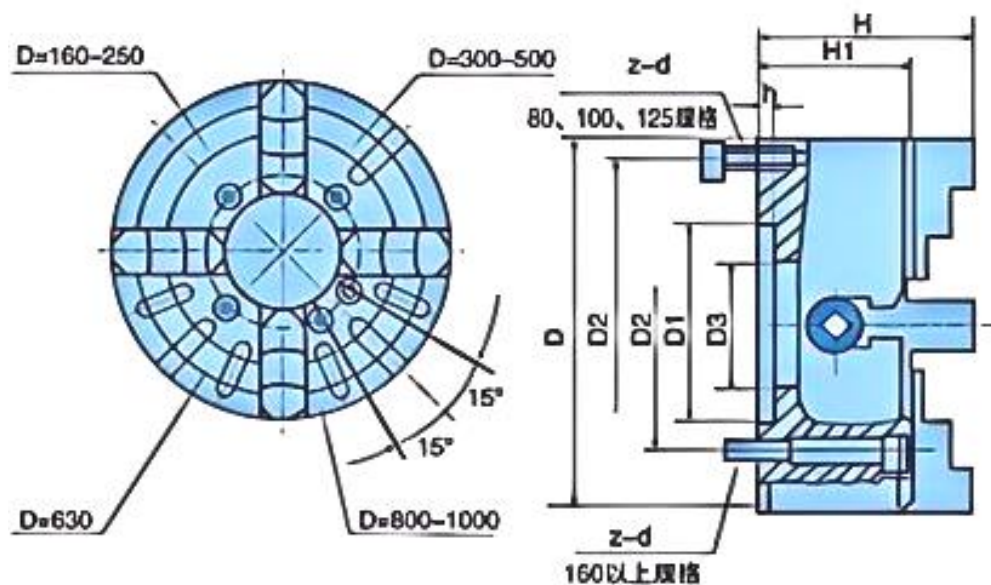
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SPECIFICATIONS



Parametry charakterystyczne wymiarów

Rozmiar mm	D1	D2	D3	H1	H	zd	Waga netto kg	Maksymalna prędkość obr./min
80	55	66	22	42	4	3-M6	2,5	4800
100	72	84	25	54	4	4-M8	3	4800
125	95	108	30	56	6	4-M8	5	4200
160	65	95	55	65	5	4-M10	9	3800
200	80	112	70	71	6	4-M10	15	2100
250	110	130	100	80	6	4-M12	23	1800

OPERATION INSTRUCTIONS

Niezależny uchwyt czteroszczękowy K72, każda szczęka może obracać się niezależnie, a szczęki można obracać do przodu lub do tyłu
Może przetwarzać produkty o nieregularnych kształtach



Ostrożność

- a) Nie dodaj rurkę do klucza, gdy zaciskasz obrabiany przedmiot, aby uniknąć przekroczenia momentu wejściowego limit złamie Chucka.
- b) Nie zaciskaj przedmiotu obrabianego w maksymalnym zacisku zasięg, jeśli to możliwe.
- c) Nie biegnij z maksymalną prędkością, gdy się do niego zbliżasz. maksymalny limit mocowania.
- d) Uchwyty z przełożeniem „0” zaciskanie na ko ńcu aby zapewnić dokładność.
- e) Nie przekraczać maksymalnej prędkości uchwytu podczas pracy.

Konserwacja i przeglądy

- 1 Uchwyty należy konserwować podczas pracy maszyny narzędzia utrzymują.
- 2 Nasmaruj (w pojemniku na tłuszcz) i wyczyść (używając (sprężone powietrze) Chucky każdego dnia, W aby zachować jego dokładność i trwałość .
- 3 Umyj i nasmaruj wszystkie powierzchnie robocze te uchwyty co najmniej dwa razy w roku. Kiedy wykorzystując częstotliwość narzędzia maszynowego rosnącą lub specjalne warunki operacyjne, dodaj czasy konserwacji uchwytu. Rozwiązywanie problemów

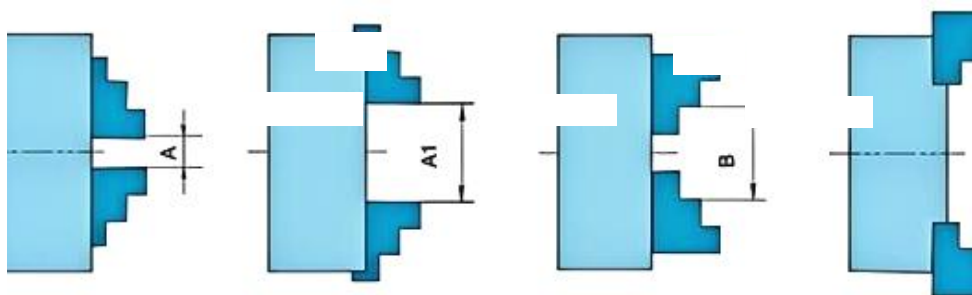
problemów i pomiary patrz tabela 5.

(Tabela 5)

Problem m	Przyczyna	Środki zaradcze
Niewystarczające mocowanie	Elastyczne stożki nie są zgodne z wymiarami	Wymień szczęki
	Długość zacisku osiowego s krótka	Zwiększ długość klaskania
	Stożek w przedmiocie obrabianym	Przetwarzaj powierzchnię przedmiotu obrabianego
	Mały moment wejściowy	Zwiększ moment wejściowy
	Ponad zakresem cęgowania	Wymień uchwyt
	Słabe smarowanie	Więcej smarowania
Słaby dokładność	Podczas korzystania z zacisków lub pracy brudnej	Szczęki konserwacyjne i obrabiany przedmiot czyszczone podczas pracy
	W przypadku wymiany szczęk, szczęki nr 1, 2, 3 są niesprawne	Zamontuj szczękę w kolejności
	Coś jest nie tak z uchwyt stożkowe krótkie	Wyreguluj uchwyt pozycja montażowa
	Powierzchnia stożkowa krótka jest brudna, gdy uchwyt montażowe	Utrzymuj czyszczenie z krótkim stożkiem
	Mbipiar acomer nt onform wymiaru nienadającego się	Dopasowany adapter jest zgodny żądać
	kapiar plats nith zhkn orsetion tolsrae za duży e	Dopasowany adapter jest zgodny żądać
	Rzeczy zanieczyszczające w górnej	Podczas wymiany szczęk utrzymuj

	szczęce i dolnej szczęce	powierzchnię montażową szczęk górnych i szczęk podstawowych w czystości.
	Stożek łuku zaciskowego nie wymiar zgodny	Wymień szczęki
Cear będzie i nie działa	Zanieczyszczenie rzecz w uchwyt	Wyczyść i nasmaruj
	Słabe smarowanie	Smarować

CLAMPING RANGE



Zakres zaciskania

D Rozmiar	Zakres zaciskania szczęk wewnętrznych	Zakres zaciskania szczęk zewnętrznych
	A-A1	B-B1
80	5-35	35-80
100	6-45	40-100
125	7-57	48-125
160	8-80	50-160
200	10-100	63-200
250	15-130	80-250

STANDARD ACCESSORIES

K72 80 K72 100 K72 125
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NR CZĘŚCI	OPIS	ILOŚĆ
1	Uchwyt na klucze	1
2	Śruba	3

Producent: Shanghaimuxinmuyeyouxiangongsi

Adres: Shuangchenglu 803nong11hao1602A-1609shi, baoshanqu, szanghaj 200000 CN.

Importowane do AUS: SIHAO PTY LTD, 1 ROKEVA STREETEASTWOOD NSW 2122 Australia

Importowane do USA: Sanven Technology Ltd., Suite 250, 9166 Anaheim Place, Rancho Cucamonga, CA 91730

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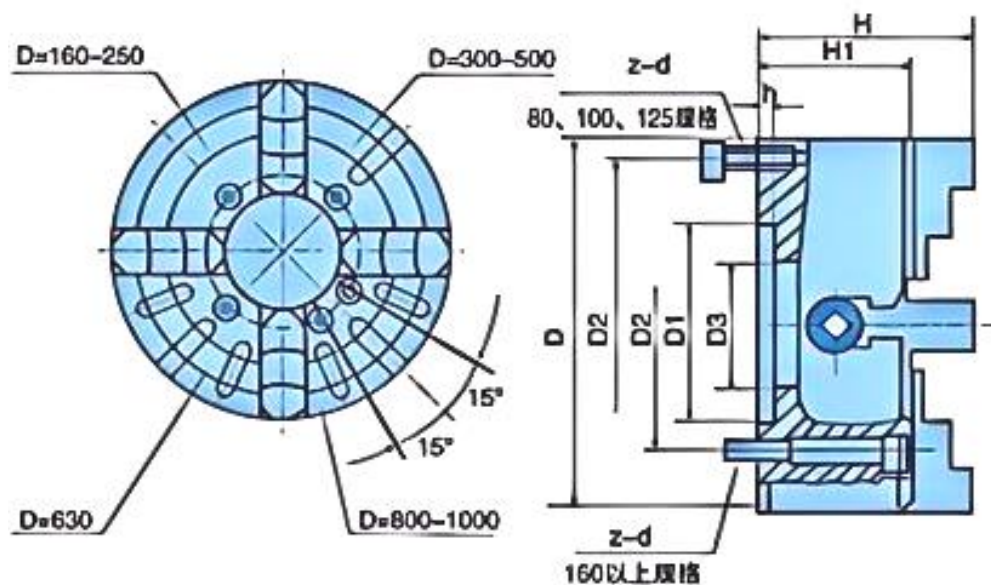
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SPECIFICATIONS



Dimensie karakteristieke parameters

Maat mm	D1	D2	D3	H1	H	zd	Netto gewicht kg	Maximale snelheid toerental/minu ut
80	55	66	22	42	4	3-M6	2.5	4800
100	72	84	25	54	4	4-M8	3	4800
125	95	108	30	56	6	4-M8	5	4200
160	65	95	55	65	5	4-M10	9	3800
200	80	112	70	71	6	4-M10	15	2100
250	110	130	100	80	6	4-M12	23	1800

OPERATION INSTRUCTIONS

K72 onafhankelijke vierklauwplaat, elke kaak kan onafhankelijk draaien en de kaken kunnen naar voren of naar achteren worden gedraaid

Kan onregelmatige producten verwerken



Voorzichtigheid

a) Niet doen Voeg een buis toe aan de sleutel wanneer u het werkstuk vastklemt om te voorkomen dat het invoerkoppel te hoog wordt limiet zal chuck breken.

b) Klem het werkstuk niet vast in de maximale klemkracht bereik indien mogelijk.

c) Ren niet met de maximale snelheid als je nadert de maximale klemlimiet.

d) De klauwplaten met "0"-tandwiel in eindelijk vastklemmen om de nauwkeurigheid te garanderen.

e) Overschrijd de maximale snelheid van de klauwplaat niet tijdens het gebruik.

Onderhoud en inspectie

1 De klauwplaten moeten worden onderhouden terwijl de machine draait gereedschappen onderhouden.

2 Smeer (bij de vetpot) en maak schoon (gebruik de samengeperste lucht) de chucks elke dag, in om de nauwkeurigheid en duurzaamheid ervan te behouden .

3 Was en smeer het hele werkoppervlak van de klauwen minstens twee keer per jaar. Wanneer de met behulp van de frequentie van de machinegereedschap groeien of op de speciale bedrijfsomstandigheden,

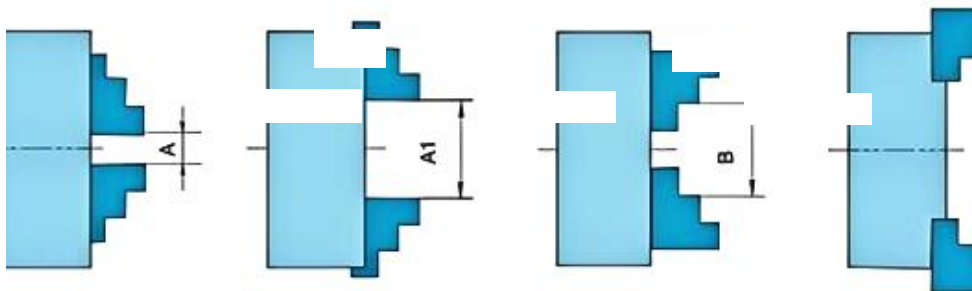
voeg de onderhoudstijden van de klauwen. Problemen oplossen
 Voor probleemoplossing en meting zie Tabel 5.

(Tabel 5)

Probleem	Oorzaak	Tegenmaten
Onvoldoende klemming	De uiteinden zijn taps toelopend en komen niet overeen met de afmetingen	Vervang de kaken
	De axiaalklemlengte is kort	Vergroot de klaplengte
	De tapsheid in het werkstuk	Werkstukoppervlak verwerken
	Het ingangskoppel is klein	Verhoog het ingangskoppel
	Over het klembereik	Vervang de klauwen
	Smering is slecht	Meer smeren
Arm nauwkeurigheid	Bij het gebruik van klemmen zijn of werken vuil	Onderhoudsbekken en werkstuk schoon tijdens het werken
	Bij het vervangen van de kaken zijn de kaken nr. 1, 2 en 3 verkeerd	Monteer de kaak in de juiste volgorde
	Er is iets mis met de korte taps toelopende klauwplaten	Pas de klauwen aan montagepositie
	Kort taps toelopend oppervlak vuil wanneer montageklauwen	Onderhoud de korte taps toelopende reiniging
	Mbipiar komt niet op de hoogte van de niet - dimensie	Passende adapter conform eisen
	kapiar plats nith zhkn orsetion tolsrae te groot e	Passende adapter conform eisen
	Onreinheden in de bovenkaak en de onderkaak	Houd de montagevlakken van de bovenkaken en de basiskaken

		schoon wanneer u de kaken vervangt
	De klemboog taps toeloopt niet conforme dimensie	Vervang de kaken
Cear zal I niet werken	Onzuiverheid ding in de klauwen	Schoonmaken en smeren
	Smering is slecht	Smeren

CLAMPING RANGE



Klembereik

D Maat	Klembereik binnenbekken	Klembereik van de externe bekken
	A-A1	B-B1
80	5-35	35-80
100	6-45	40-100
125	7-57	48-125
160	8-80	50-160
200	10-100	63-200
250	15-130	80-250

STANDARD ACCESSORIES

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ONDERDEELNR.	BESCHRIJVING	Hoeveelheid
1	Sleutelklem	1
2	Schroef	3

Fabrikant: Shanghaimuxinmuyeyouxiangongsi

Adres: Shuangchenglu 803nong11hao1602A-1609shi, baoshanqu, shanghai 200000 CN.

Geïmporteerd naar AUS: SIHAO PTY LTD, 1 ROKEVA
STREETEASTWOOD NSW 2122 Australië

Geïmporteerd naar de VS: Sanven Technology Ltd., Suite 250, 9166
Anaheim Place, Rancho Cucamonga, CA 91730

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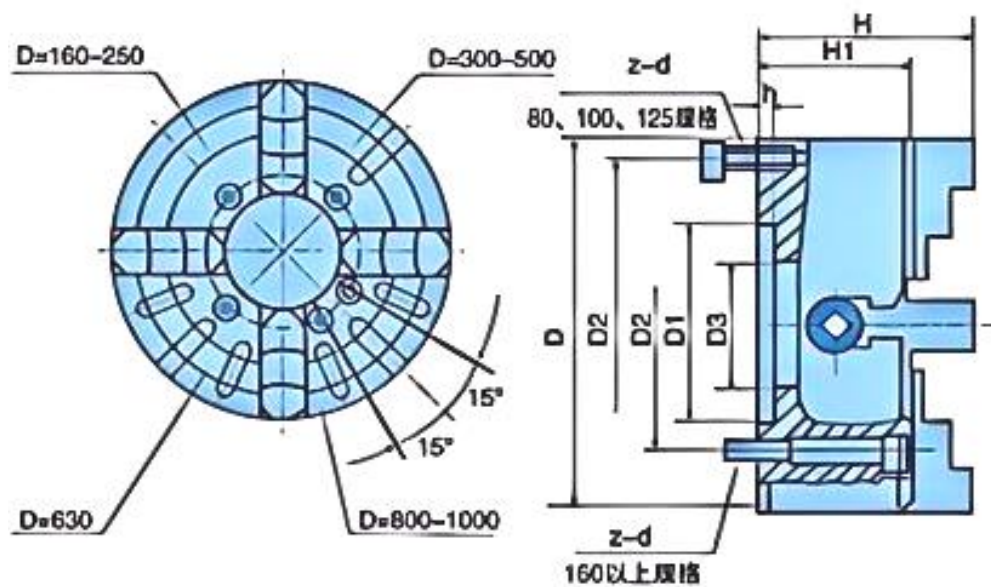
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SPECIFICATIONS



Dimensionskaraktärsparametrar

Storlek mm	D1	D2	D3	H1	h	zd	Net WT kg	Max hastighet r/min
80	55	66	22	42	4	3-M6	2.5	4800
100	72	84	25	54	4	4-M8	3	4800
125	95	108	30	56	6	4-M8	5	4200
160	65	95	55	65	5	4-M10	9	3800
200	80	112	70	71	6	4-M10	15	2100
250	110	130	100	80	6	4-M12	23	1800

OPERATION INSTRUCTIONS

K72 oberoende chuck med fyra käftar, varje käft kan rotera oberoende och käftarna kan vridas framåt eller bakåt

Kan bearbeta oregelbundna produkter



Försiktighet

a) Gör det inte lägg till ett rör på skiftnyckeln när arbetsstycket kläms för att undvika att det ingående vridmomentet överskrider limit kommer att bryta chuck.

b) Kläm inte fast arbetsstycket i max fastspänning räckvidd om möjligt.

c) Spring inte med maxhastigheten när du närmar dig den maximala klämgränsen.

d) Chuckarna med "0"-växel i äntligen klämma fast för att säkerställa noggrannheten.

e) Överskrid inte chuckens maxhastighet under drift.

Underhåll och inspektion

1 Chuckar bör underhållas medan maskinen verktyg underhålla.

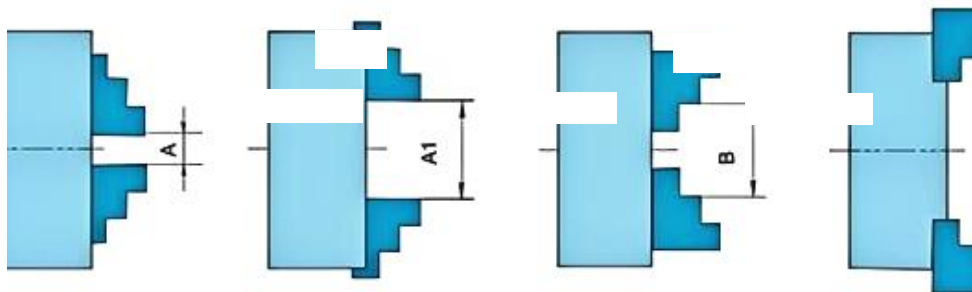
2 Smörj (vid fettkoppen) och rengör (använd tryckluften) chuckarna varje dag, i för att bibehålla dess noggrannhet och hållbarhet .

3 Tvätta och smörj hela arbetsytan på chuckarna minst två gånger varje år med hjälp av frekvensen av verktygsmaskinen växa eller vid de särskilda driftsvillkoren, lägg till underhållstider för chuckar. Felsökning
Felsökning och mätning se Tabell.5.

(Tabell 5)

Problem m	Orsaka	Mot mig försäkrar
Otillräcklig klämning	Elaapingarna är avsmalnande som inte överensstämmer med dimensionen	Byt ut käftarna
	Axelklämman Längd s hort	Öka klapplängden
	Konan i workpi ece	Bearbeta arbetsstycke.yta
	Det ingående vridmomentet är litet	Öka det ingående vridmomentet
	Över klämområdet	Byt ut chuckarna
	Smörjningen är dålig	Mer smörj
Dålig ac kuritet	Vid användning av klämning är eller arbetar smutsiga	Rengör käftarna och arbetsstycket under arbete
	Vid byte av käftar, nr 1,2,3 fel	Montera käften i ordning
	Något fel med korta chuckar	Justera chuckarna monteringsläge
	Kort konisk yta smutsig när montering av chuckar	Upprätthålla kort konisk ren
	onform nonting dimension	Matchad adapter att kräva
	kapiar plats nith zhkn orsetion tolsrae too large e	Matchad adapter att kräva
	Orenhet saker i överkäken baskäken	Håll toppkäftarna och baskäftarnas monteringsyta rena när käftarna byts ut
	Spännbågen avsmalnar inte överensstämman dimension	Byt ut käftarna
Cear skall l fungerar inte	Förorening sak i chuckarna	Rengör och smörj in
	Smörjningen är dålig	Smörja

CLAMPING RANGE



Spännområde

D Storlek	Spännområde för inre käftar	Spännområde för yttre käftar
	A-A1	B-B1
80	5-35	35-80
100	6-45	40-100
125	7-57	48-125
160	8-80	50-160
200	10-100	63-200
250	15-130	80-250

STANDARD ACCESSORIES

K72 80 K72 100 K72 125
K72 160 K72 200 K72 250

DELNR.	BESKRIVNING	ANTAL
1	Nyckelchuck	1
2	Skruva	3

Tillverkare: Shanghaimuxinmuyeyouxiangongsi

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Importerad till USA: Sanven Technology Ltd., Suite 250, 9166 Anaheim Place, Rancho Cucamonga, CA 91730

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Mainzer Landstr.69, 60329 Frankfurt am Main.

UK	REP
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