

# Engraving machine four axis chuck combination

## User Guide

### Maintenance instructions

1. In order to ensure that the machine chuck still has good accuracy after being used for a long time, lubrication is very important.
2. Molybdenum disulfide grease (black in color) needs to be applied after each shift, and the grease is poured into the jaws of the chuck until the grease overflows the jaw surface or the inner hole of the chuck, but if the chuck is highly rotated or has a large amount of water When cutting oil is used for processing, it needs more lubrication, which must be determined according to different situations.
3. Be sure to use an air gun or similar tools to clean the chuck body and the slide surface when the operation is completed.
4. Remove the chuck at least every 6 months for disassembly and cleaning, keep the sliding surface of the jaws clean and lubricate, so that the life of the chuck is prolonged. However, if the cutting cast iron is thoroughly cleaned at least once or several times every 2 months, check the parts for cracks and wear, and replace them with new ones immediately. After the inspection is completed, it must be fully oiled before assembly.
5. The use of cutting oil with anti-rust effect can prevent rust inside the chuck, because the rust of the chuck will reduce the clamping force, and the workpiece cannot be clamped.

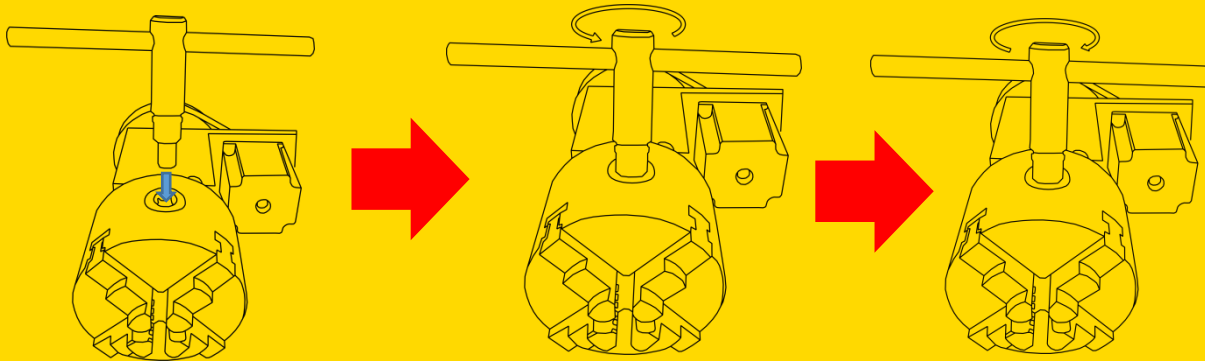
# Instructions

1. First of all, it is necessary to confirm whether the workpiece to be processed needs a positive claw or a reverse claw. The positive claw can hold a solid workpiece with a diameter of 48mm, a hollow pipe of 100mm, and the reverse claw can hold a workpiece with a diameter of 112mm. The replacement steps are as follows.:

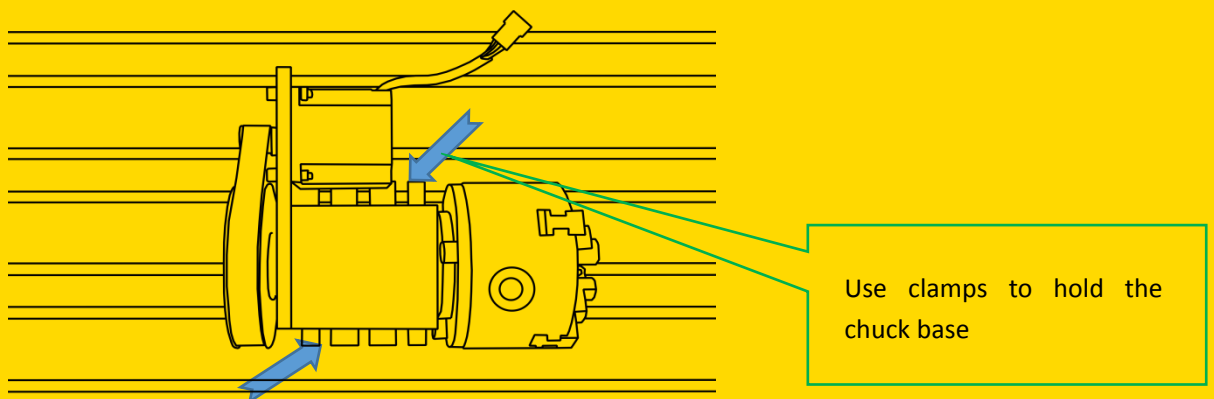
Insert the chuck wrench  
into the chuck

Rotate the chuck wrench counterclockwise  
to take out the front and back jaws

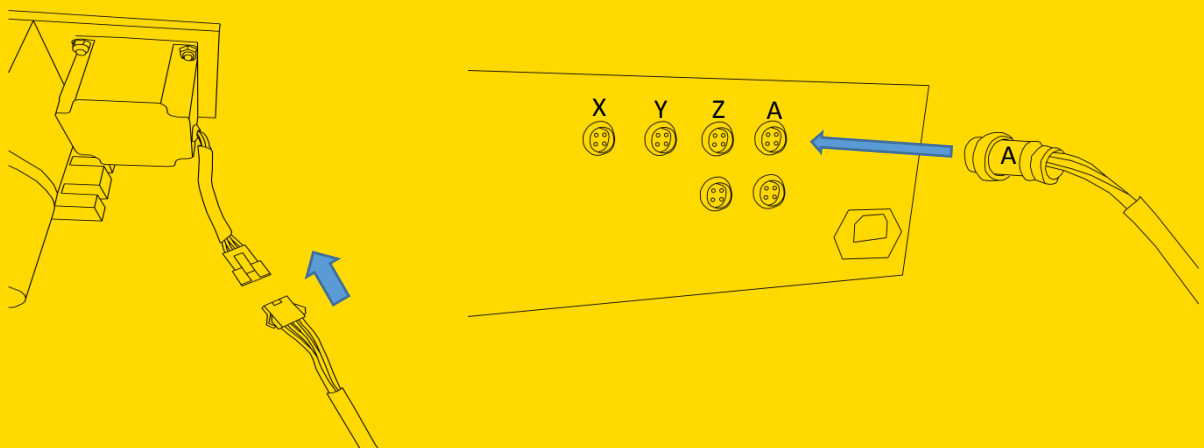
Rotate the chuck wrench clockwise to  
install the front and back jaws



2. Fix the chuck to the processing table and clamp the workpiece to be processed.



3. Insert and lock both ends of the cable respectively.



4. When the above work is ready, you can start processing. The screws in the accessories are spare screws and do not need to be used unless there are special circumstances.