VEVOR®

TOUGH TOOLS, HALF PRICE

Technical Support and E-Warranty Certificate www.vevor.com/support

3-JAW SELF CENTERING CHUCK

MODEL:K11-100, K11-125, K11-160, K11-200A, K11-250A

We continue to be committed to provide you tools with competitive price.
"Save Half", "Half Price" or any other similar expressions used by us only represents an estimate of savings you might benefit from buying certain tools with us compared to the major top brands and doses not necessarily mean to cover all categories of tools offered by us. You are kindly reminded to verify carefully when you are placing an order with us if you are actually saving half in comparison with the top major brands.

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NEED HELP? CONTACT US!

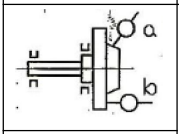
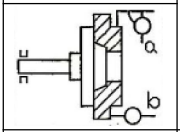
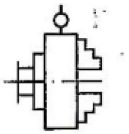
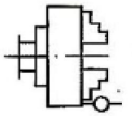
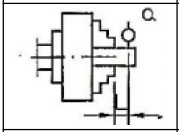
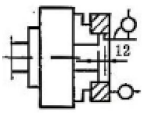
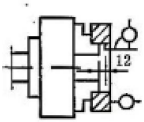
Have product questions? Need technical support? Please feel free to contact us:

CustomerService@vevor.com

This is the original instruction, please read all manual instructions carefully before operating. VEVOR reserves a clear interpretation of our user manual. The appearance of the product shall be subject to the product you received. Please forgive us that we won't inform you again if there are any technology or software updates on our product.

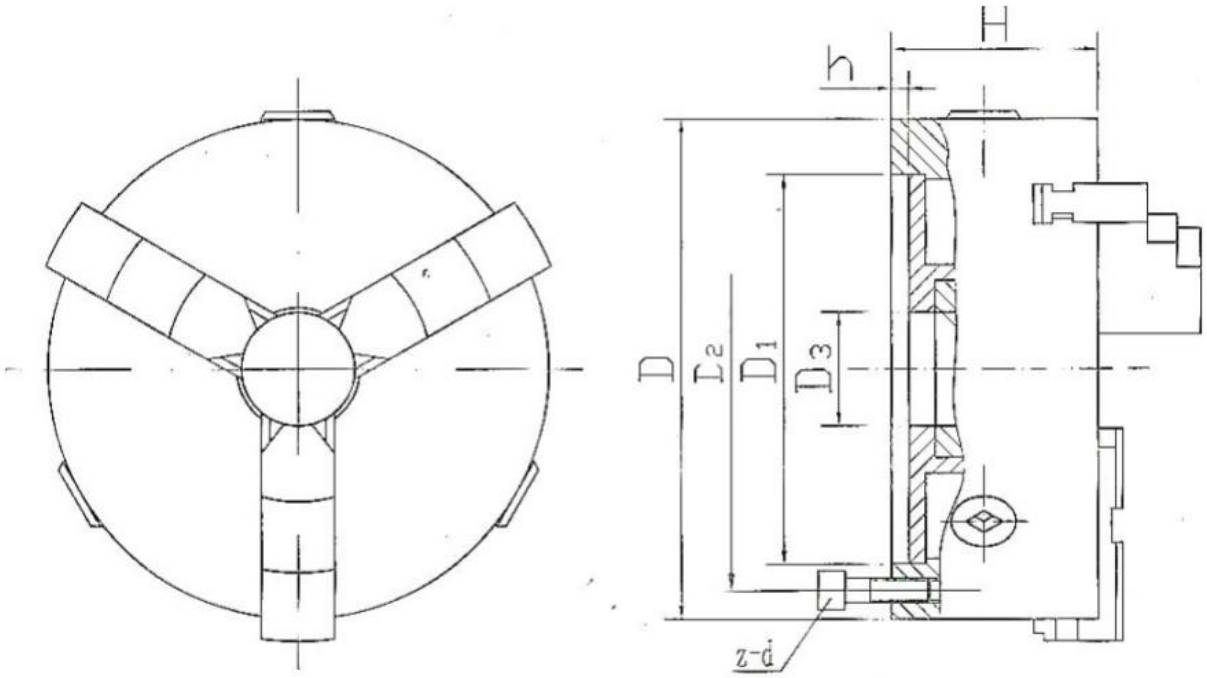
Geometry accuracy (mm)

(table 6) mm

Diagram of test	Test item	Chuck Diameter				
		≤165	200~250	315~400	00~630	800~1000
 	a.Radial run-out b.axial run out	a:0.005 b:0.005				
	Radial run-out chuck	0.040	0.050	0.060	0.080	0.100
	Axial run out chuck	0.050	0.050	0.060	0.080	0.100
	Radial run-out of test bar	α=0.08 L=50	α=0.080 L=50(75	α=0.100 L=75	α=0.125 =100	α=0.160 L=100
	Radial run-out of test ring	0.060	0.060	0.080	0.100	0.120
	Axial run-out of test ring	0.032	0.040	0.048	0.064	0.080
	Radial run-out of test ring	0.060	0.060	0.080	0.100	0.120
	Axial run-out of test ring	0.032	0.040	0.048	0.064	0.080

SPECIFICATIONS

SEPC. /MODEL	D1	D2	D3	H	H1	H2	h	z-d
K11 80	55	66	16	66	50	-	3. 5	3-M6
K11 100	72	84	22	74. 5	55	-	3. 5	3-M8
K11 125	95	108	30	85	58	-	4	3-M8
K11 130	100	115	30	85	58	-	4	3-M8
K11 160	130	142	40	95	65	-	5	3-M8
K11 160A	130	142	40	109	65	71	5	3-M8
K11 165	130	145	40	95	65	-	5	3-M8
K11 165A	130	145	40	109	65	71	5	3-M8
K11 190	155	172	55	109	75	-	5	3-M10
K11 190A	155	172	55	122	75	80	5	3-M10
K11 200	165	180	65	109	75	-	5	3-M10
K11 200A	165	180	65	122	75	80	5	3-M10
K11 240	195	215	70	120	80	-	8	3-M12
K11 240A	195	215	70	133	80	85	8	3-M12
K11 250	206	226	80	120	80	-	5	3-M12
K11 250A	206	226	80	133	80	85	5	3-M12
K11 315	260	285	100	142. 5	90	-	6	3-M16
K11 315A	260	285	100	155. 5	90	96. 5	6	3-M16
K11 320	270	290	100	142. 5	90	-	6	3-M16
K11 320A	270	290	100	155. 5	90	96. 5	6	3-M16
K11 325	272	296	100	142. 5	90	-	6	3-M16
K11 325A	272	296	100	155. 5	90	96. 5	6	3-M16
K11 380	325	350	130	155. 5	100	-	6	3-M16
K11 380A	325	350	130	170. 5	100	96. 5	6	3-M16
K11 400	340	368	130	155. 5	100	-	6	3-M16
K11 400A	340	368	130	170. 5	100	108. 5	6	3-M16
K11 500	440	465	200	176	115	-	6	6-M16
K11 500A	440	465	200	203	115	123	6	6-M16
K11 630	560	595	260	192	130	-	7	6-M16
K11 630A	560	595	260	218	130	138	7	6-M16
K11 800A	710	760	385	249	148	158	8	6-M20
K11 1000A	910	950	460	266	165	-	8	6-M24
K11 1250A	910	950	500	281	180	-	10	6-M24



(Fig. 2)

OPERATION INSTRUCTIONS

The jaws of the series chucks have two types:

①Model k11 is of solid jaw. One chuck has a set of internal and external jaws which can be used separately.

② Model K11A(or K11C) is of two-piece jaw, which is composed of Base jaw and reversible top jaw. The two-piece jaws can perform. As internal or external jaws through adjustment. According to chucking diameters, soft top jaws can bere-machined so as to achieve ideal clamping accuracy. The connection dimensions for two-picce jaws of model K11A conform to GB4346 (IS03442) Standards.

⚠Caution

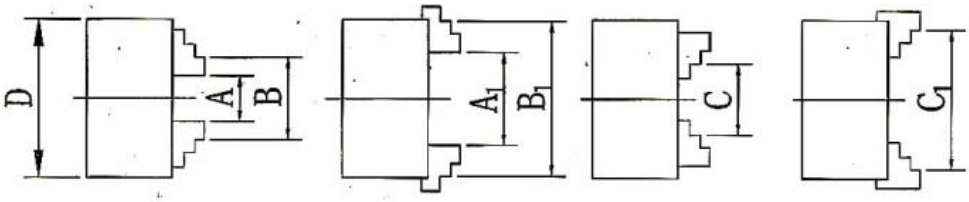
a)Don't add a tube on the wrench when clamping the workpiece to avoid the input torque exceeding the limit will break the chuck.
b)Don't clamp the workpiece in the max clamping range if possible.
c)Don't run at the max speed when approaching the max clamping limit.
d)The chucks with "0"gear in clamping at last to ensure 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 surfaces 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 notconform with dimension	Replace jaws
	The axial clamping Length short	Increase clamping length
	The taper in workpiece	Process workpiece surface
	The input torque is small	Increase the input torque
	Over the clamping range	Replace chucks
	Lubrication is poor	More lubricate
Poor accuracy	In using clamping or working dirty	Maintenance jaws and workpiece clean when working
	When replacing jaws,No.1,2,3 jaws are 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
	Addpter accuracy not conform the mounting dimension	Matched adapter conforms to demand
	Adapter plate with chucks connection tolerance too large	Matched adapter conforms to demand
	Impurity things in the top jaw and base jaw	Keep top jaws and base jaws mounting face clean when replacing jaws
	The clamping arc taper does not conform dimension	Replace jaws
Cear shall not work	Impurity thing in the chucks	Clean and lubricate
	Lubrication is poor	Lubricate



CLAMPING RANGE

D MODELD Size	Internal Jaws		External Jaws
	Clamping range A-A1	Clamping range B-B1	Clamping range C-C1
80	2~22	25~70	22~63
100	2~30	30~90	30~80
125	2.5~40	38~125	38~110
130	3~40	40~130	40~120
160	3~55	50~160	55~145
165	4~60	52~165	55~150
190	4~70	65~190	65~190
200	4~85	65~200	65~200
240	6~100	80~250	90~250
250	6~110	80~250	90~250
315	10~140	95~315	100~315
320	10~140	95~320	100~320
325	10~140	95~325	100~325
380	15~210	120~380	120~380
400	15~210	120~400	120~400
500	25~280	150~500	150~500
630	50~350	170~630	170~630
800	150~450	300~800	300~800
1000	290~600	430~1000	430~1000

STANDARD ACCESSORIES

PART NO.	DESCRIPTION	QTY
1	**Key chuck**	1
2	Screw	3
3	**Reverse jaws（3 pieces）**	1

K11-100, K11-125, K11-160

PART NO.	DESCRIPTION	QTY
1	**Key chuck**	1
2	Screw	3
3	**Hexagon wrench**	1

K11-200A, K11-250A

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