

VEVOR®

TOUGH TOOLS, HALF PRICE

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

LATHE CHUCK

**MODEL: K11-80, K11-100, K11-125, K11-160, K11-200, K11-250
K11-160A, K11-200A, K11-250A, K12-160, K12-200 K12-250, K11-160A
(1-1/2-8) , K11-200A (2-1/4-8) , K13-160A (D1-4) , K13-160A**

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LATHE CHUCK

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K11-160A, K11-200A, K11-250A, K12-160, K12-200 K12-250, K11-160A
(1-1/2-8) , K11-200A (2-1/4-8) , K13-160A (D1-4) , K13-160A



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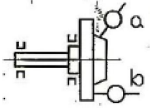
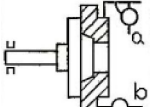
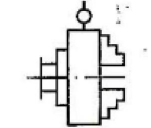
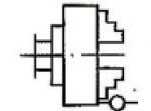
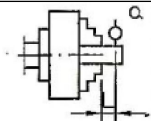
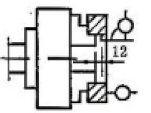
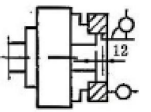
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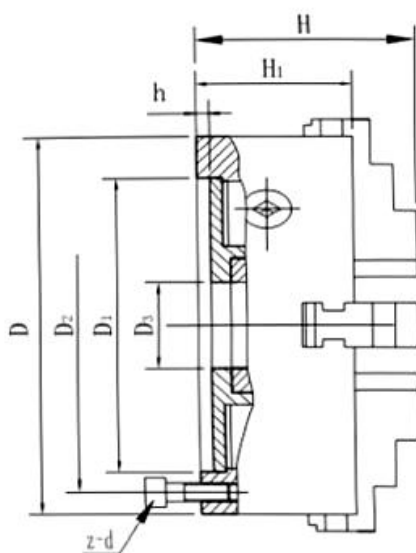
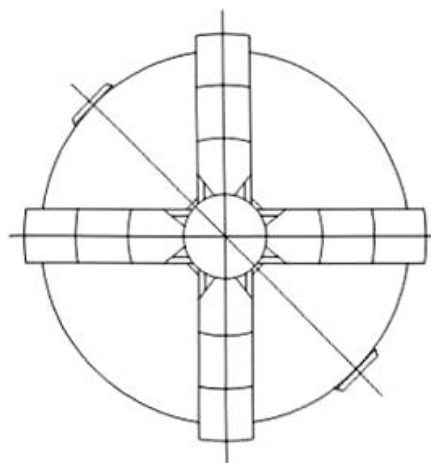
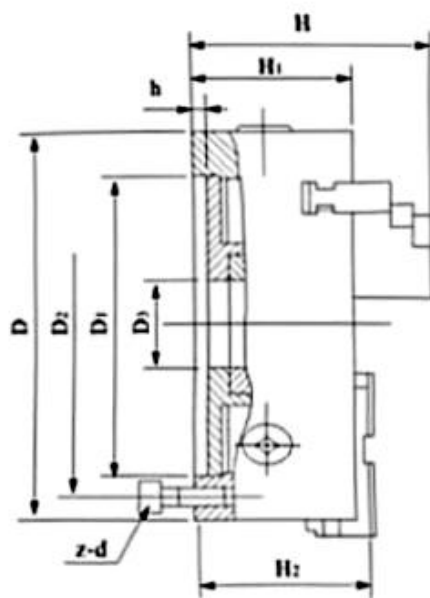
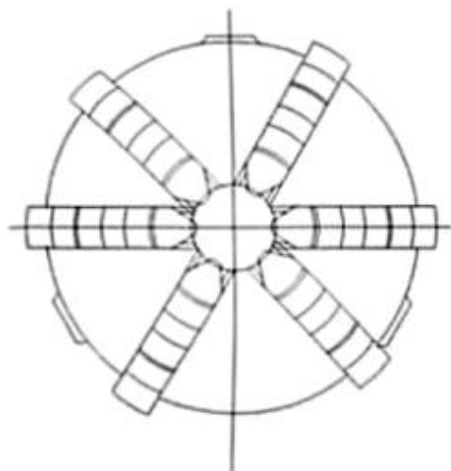
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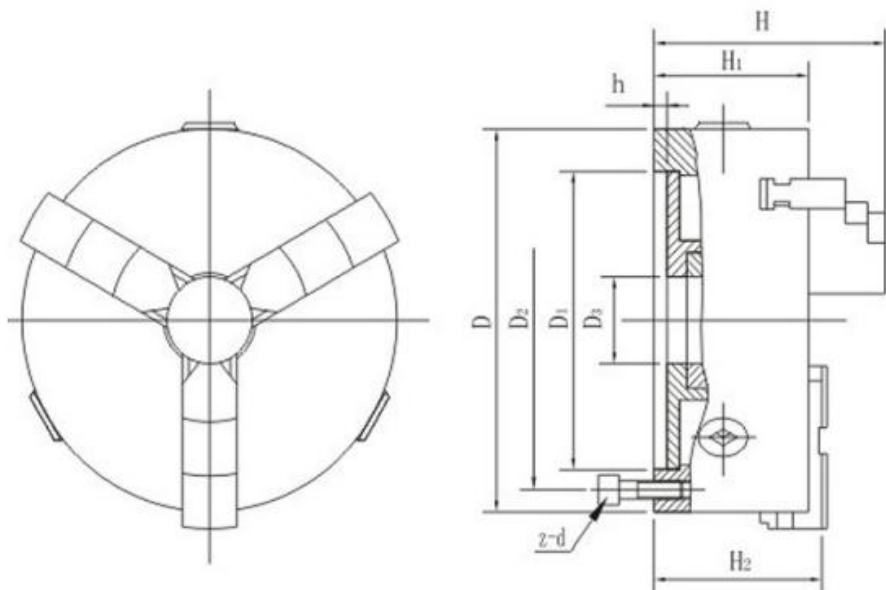
Geometry accuracy (mm)

(table) mm

Diagram of test	Test item	Chuck Diameter				
		≤165	200~250	315~400	00~630	800~1000
	a.Radial run-out	a:0.005 b:0.005				
	b.axial run out					
	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	$\alpha=0.08$ L=50	$\alpha=0.080$ L=50(75)	$\alpha=0.100$ L=75	$\alpha=0.125$ =100	$\alpha=0.160$ 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





Specifications

SEPC. /MODEL	D1	D2	D3	H	H1	H2	h	z-d
K1180	55	66	16	66	50	-	3.5	3-M6
K11100	72	84	22	74.5	55	-	3.5	3-M8
K11125	95	108	30	85	58	-	4	3-M8
K11130	100	115	30	85	58	-	4	3-M8
K11160	130	142	40	95	65	-	5	3-M8
K11160A	130	142	40	109	65	71	5	3-M8
K11165	130	145	40	95	65	-	5	3-M8
K11165A	130	145	40	109	65	71	5	3-M8
K11190	155	172	55	109	75	-	5	3-M10
K11190A	155	172	55	122	75	80	5	3-M10
K11200	165	180	65	109	75	-	5	3-M10
K11200A	165	180	65	122	75	80	5	3-M10
K11240	195	215	70	120	80	-	8	3-M12
K11240A	195	215	70	133	80	85	8	3-M12
K11250	206	226	80	120	80	-	5	3-M12
K11250A	206	226	80	133	80	85	5	3-M12

OPERATION INSTRUCTIONS

The jaws of the series chucks have two types:

- ① Model K11、K12、K13 is of solid jaw. One chuck has each set of internal and external jaws which can be used separately.
- ② Model K11A(or K11C) 、K12、K13 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 be re-machined so as to achieve ideal clamping accuracy. The connection dimensions for two-piece jaws of model K11A conform to GB4346 (ISO3442) Standards.



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

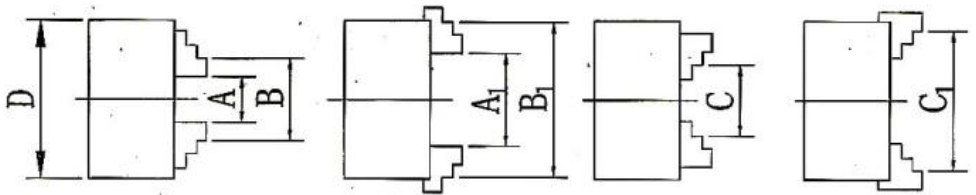
- 1 Chucks should be maintained while the machine tools maintain.
- 2 Lubricate (at the grease cup) and clean (use the compressed air) the chucks every day, in order to maintain its accuracy and durability.
- 3 Wash and lubricate all the working surface of the chucks at least two times every year. When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

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
	Mismatched adapter not conform the mounting dimension	Matched adapter conform to demand
	Adapter plates with thickness or section 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
Gear shall not work	Impurity thing in the chucks	Clean and lubricate
	Lubrication is poor	Lubricate



CLAMPING RANGE

D MODEL D Size	Internal Jaws		External Jaws
	Clamping range	Clamping range	Clamping range
	A-A1	B-B1	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

K11-80 ,K11-100, K11-125, K11-160,K11-200, K11-250

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

K11-200A K11-250A

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

K11-160A (1-1/2-8)

PART NO.	DESCRIPTION	QTY
1	Key chuck	1
2	Screw	3
3	Back plate 1 1/2 8'	1

K11-200A (2-1/4-8)

PART NO.	DESCRIPTION	QTY
1	Key chuck	1
2	Screw	3
3	Back plate 2 1/4 8'	1

K12-200 (1-1/2-8)

PART NO.	DESCRIPTION	QTY
1	Key chuck	1
2	Screw	3
3	Reverse jaws(4pieces)	1
4	Back plate 1 1/2 8'	1

K13-160A (D1-4)

PART NO.	DESCRIPTION	QTY
1	Key chuck	1
2	M8Screw	3
3	M6Screw	3
4	Tie rod screw	3
5	Back plate D1-4	1

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

EC	REP
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E-CrossStu GmbH
Mainzer Landstr.69, 60329 Frankfurt am Main.

UK	REP
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YH CONSULTING LIMITED.
C/O YH Consulting Limited Office 147, Centurion House,
London Road, Staines-upon-Thames, Surrey, TW18 4AX





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MANDRIN DE TOUR

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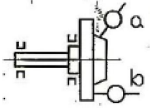
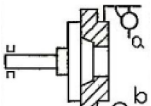
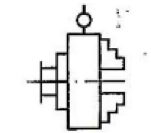
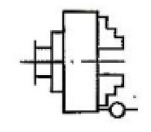
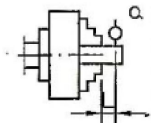
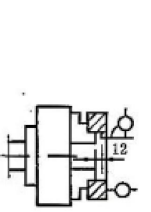
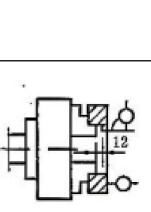
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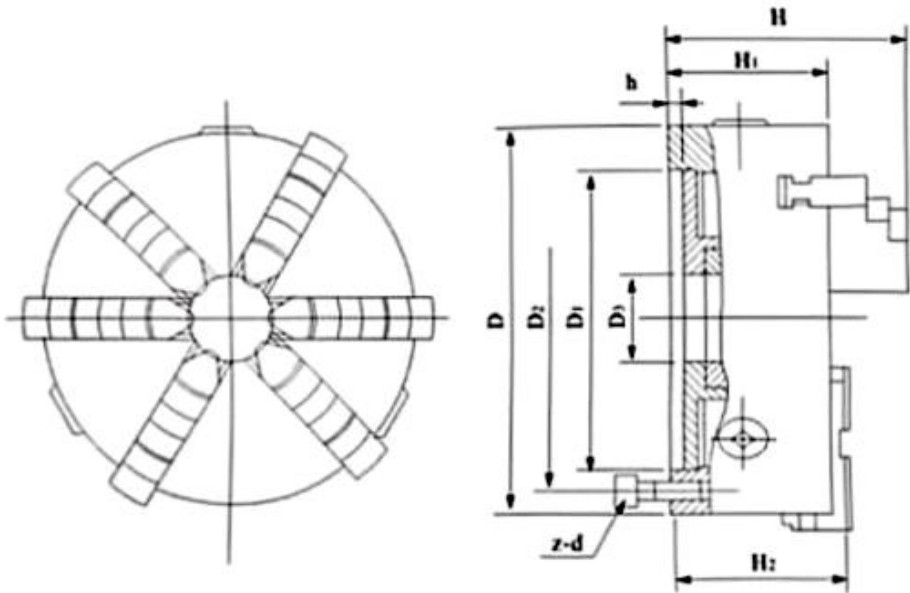
Précision géométrique (mm)

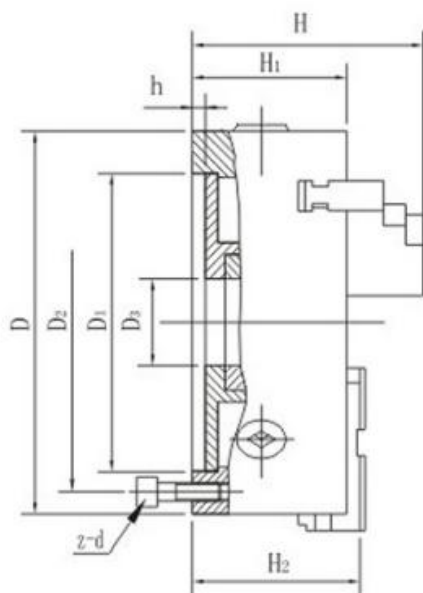
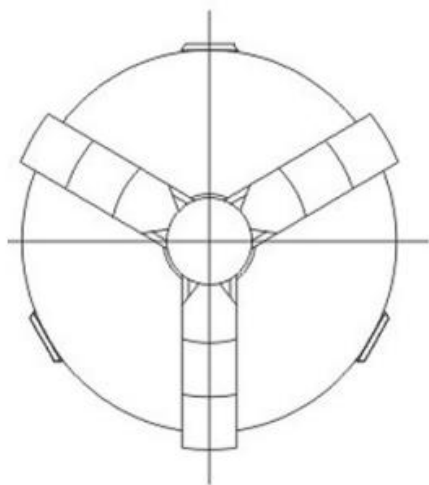
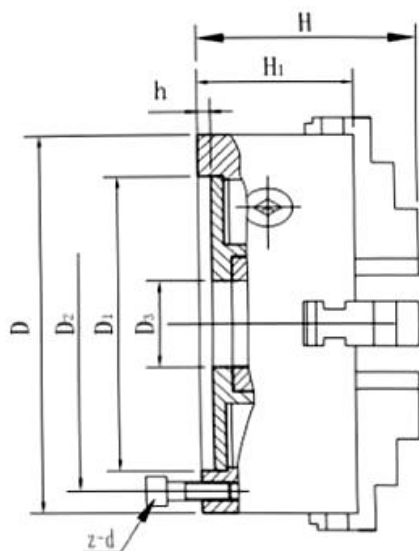
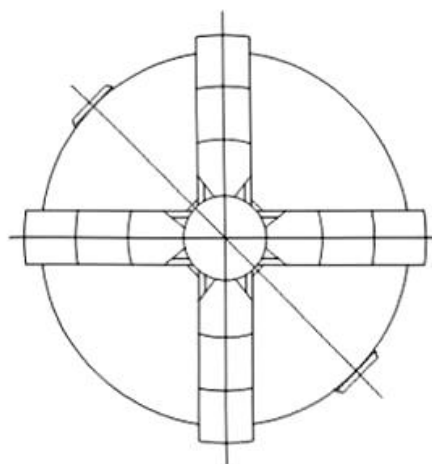
(tableau) mm

Diagramme de test	Article de test m	Chuck Diameter				
		≤165	20 0~250	315 à 400	00~630	800 à 1 000
	a. Radial s'épuiser	a:0,005 b:0,005				
	b. axial s'épuiser					
	Radial s'épuiser mandrin	0,040	0,050	0,060	0,080	0,100
	Axial s'épuiser mandrin	0,050	0,050	0,060	0,080	0,100
	Radial s'épuiser de la barre d'essai	$\alpha = 0,08 L = 50$	$\alpha = 0,080 L = 50(75)$	$\alpha = 0,100 L = 75$	$\alpha = 0,125 = 100$	$\alpha = 0,160 L = 100$
	Radial s'épuiser de l'anneau d'essai	0,060	0,060	0,080	0,100	0,120
	Axial s'épuiser de l'anneau d'essai	0,032	0,040	0,048	0,064	0,080
	Radial s'épuiser de l'anneau d'essai	0,060	0,060	0,080	0,100	0,120

	A x i a l s'épuiser de l'anneau d'essai	0,032	0,040	0,048	0,064	0,080
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SPECIFICATIONS





Caractéristiques

规格/型式 SEPC. /MODEL	D1	D2	D3	H	H1	H2	h	z-d
K1180	55	66	16	66	50	-	3.5	3-M6
K11100	72	84	22	74.5	55	-	3.5	3-M8
K11125	95	108	30	85	58	-	4	3-M8
K11130	100	115	30	85	58	-	4	3-M8
K11160	130	142	40	95	65	-	5	3-M8
K11160A	130	142	40	109	65	71	5	3-M8
K11165	130	145	40	95	65	-	5	3-M8
K11165A	130	145	40	109	65	71	5	3-M8
K11190	155	172	55	109	75	-	5	3-M10
K11190A	155	172	55	122	75	80	5	3-M10
K11200	165	180	65	109	75	-	5	3-M10
K11200A	165	180	65	122	75	80	5	3-M10
K11240	195	215	70	120	80	-	8	3-M12
K11240A	195	215	70	133	80	85	8	3-M12
K11250	206	226	80	120	80	-	5	3-M12
K11250A	206	226	80	133	80	85	5	3-M12

OPERATION INSTRUCTIONS

Le les mâchoires des mandrins de la série ont deux types :

- ① Les modèles K 11 , K12, K13 sont des mâchoires solides. Un mandrin possède chaque jeu de mâchoires internes et externes qui peuvent être utilisées séparément.
- ② Le modèle K11A (ou K11C) 、 K12、 K13 est composé de mâchoires en deux parties, qui est composé d'une mâchoire de base et d'une mâchoire supérieure réversible. Les mâchoires en deux parties peuvent être performantes. En tant que mâchoires internes ou externes par réglage. Selon les diamètres de serrage, Les mors supérieurs souples peuvent être réusinés afin d'obtenir une précision de serrage idéale. Dimensions de raccordement pour les mâchoires à deux pics du modèle K11A conforme à GB4346 (IS03442) Normes.



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

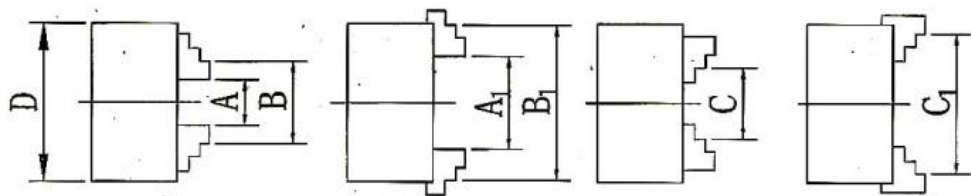
- 1 Les mandrins doivent être entretenus pendant que la machine outils d'entretien.
- 2 Lubrifiez (au niveau du godet à graisse) et nettoyez (utilisez l'air

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)

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 nonting	Adaptateur correspondant conforme exiger
	kapiar plats nith zhkn orsetion tolsrae trop grand e	Adaptateur correspondant 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 I ne fonctionne pas	Impureté chose dans les mandrins	Nettoyer et lubrifier
	La lubrification est mauvaise	Lubrifier



CLAMPING RANGE

D MODEL D Size	Internal Jaws		External Jaws
	Clamping range	Clamping range	Clamping range
	A-A1	B-B1	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

K11-80, K11-100, K11-125, K11-160, K11-200, K11-250

PIÈCE N°	DESCRIPTION	Qté
1	Mandrin à clé	1
2	Vis	3
3	Mâchoires inversées (3 pièces)	1

K11-200A K11-250A

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

K11-160A (1-1/2-8)

PIÈCE N°	DESCRIPTION	Qté
1	Mandrin à clé	1
2	Vis	3
3	Plaque arrière 1 1/2 8 '	1

K11-200A (2-1/4-8)

PIÈCE N°	DESCRIPTION	Qté
1	Mandrin à clé	1
2	Vis	3
3	Plaque arrière 2 1/4 8 '	1

K12-200 (1-1/2-8)

PIÈCE N°	DESCRIPTION	Qté
1	Mandrin à clé	1
2	Vis	3
3	Mâchoires inversées (4 pièces)	1
4	Plaque arrière 1 1/2 8 '	1

K13-1 60A (D1-4)

PIÈCE N°	DESCRIPTION	Qté
1	Mandrin à clé	1
2	Vis M8	3
3	Vis M 6	3
4	Vis de barre de direction	3
5	Plaque arrière D1-4	1

Fabricant : Shanghaimuxinmuyeyouxiangongsi

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

Importé en Australie : SIHAO PTY LTD, 1 ROKEVA STREET, ASTWOOD NSW 2122 Australie

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

EC	REP
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E-CrossStu GmbH
Mainzer Landstr.69, 60329 Frankfurt am Main.

UK	REP
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YH CONSULTING LIMITED.
C/O YH Consulting Limited Office 147, Centurion House,
London Road, Staines-upon-Thames, Surrey, TW18 4AX



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DREHFUTTER

**MODELL: K11-80, K11-100, K11-125, K11-160, K11-200, K11-250
K 11-160A, K11-200A, K11-250A, K 12-160, K12-200 K12-250, K11-160A
(1-1/2-8), K11-200A (2-1/4-8), K13-160A (D1-4), K13-160A**

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 does 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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LATHE CHUCK

MODELL: K11-80, K11-100, K11-125, K11-160, K11-200, K11-250
K 11-160A, K11-200A, K11-250A, K 12-160, K12-200 K12-250, K11-160A
(1-1/2-8), K11-200A (2-1/4-8), K13-160A (D1-4), K13-160A



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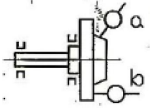
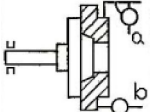
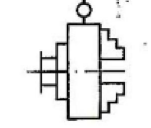
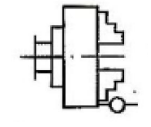
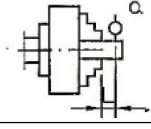
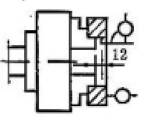
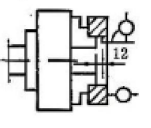
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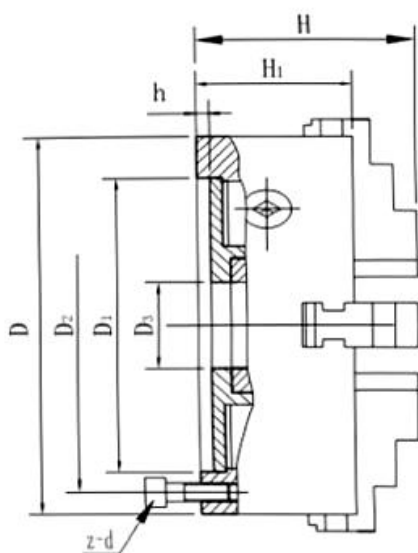
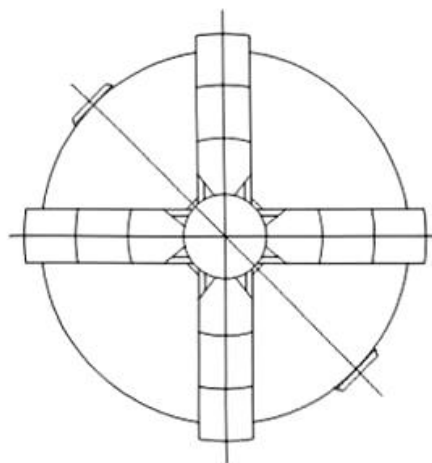
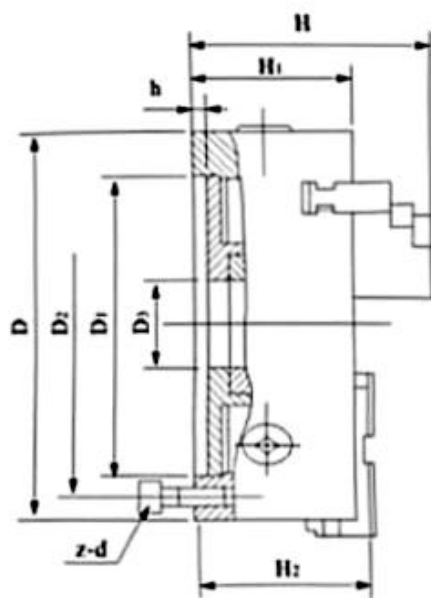
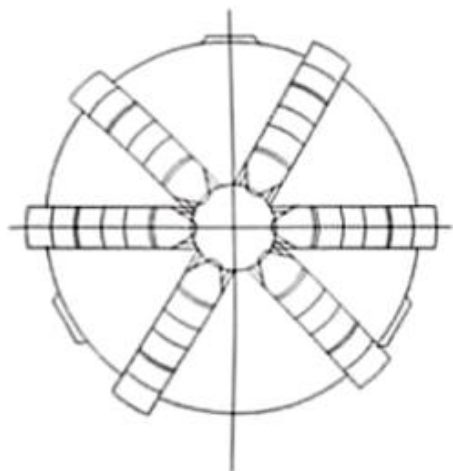
This is the original instruction, please read all manual instructions carefully before operating. VEVOR reserves a clear interpretation of our user manual. The appearance of the product shall be subject to the product you received. Please forgive us that we won't inform you again if there are any technology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

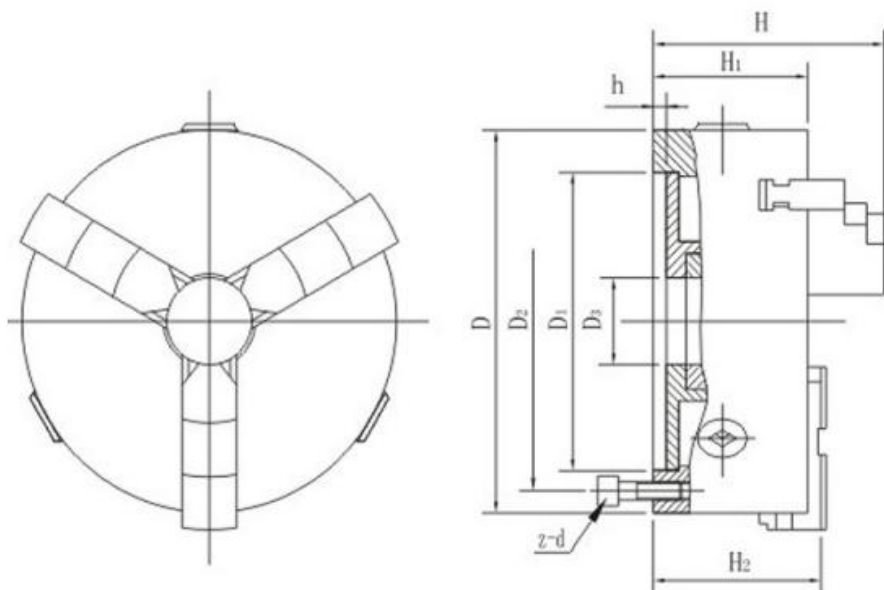
Geometriegenauigkeit (mm)

(Tisch) mm

Diagramm des Tests	Prüfling m	Chuck Diameter				
		≤165	20 0~250	315 bis 400	00~630	800 bis 1.000
	ein. Radial Auslaufen	ein:0,005 b:0,005				
	b . axial Auslaufen					
	Radial Auslaufen Futter	0,0 4 0	0,0 5 0	0,060	0,080	0,100
	Axial Auslaufen Futter	0,0 5 0	0,0 5 0	0,060	0,080	0,100
	Radial Auslaufen des Prüfstabes	$\alpha = 0,08$ L=50	$\alpha = 0,080$ L=50(75)	$\alpha = 0,100$ L=75	$\alpha = 0,125$ =100	$\alpha = 0,160$ L=100
	Radial Auslaufen des Prüfrings	0,060	0,060	0,080	0,100	0,120
	Axial Auslaufen des Prüfrings	0,032	0,040	0,048	0,064	0,080
	Radial Auslaufen des Prüfrings	0,060	0,060	0,080	0,100	0,120
	Axial Auslaufen des Prüfrings	0,032	0,040	0,048	0,064	0,080

SPECIFICATIONS





Technische

Daten

规格/型式 SEPC. /MODEL	D1	D2	D3	H	H1	H2	h	z-d
K1180	55	66	16	66	50	-	3.5	3-M6
K11100	72	84	22	74.5	55	-	3.5	3-M8
K11125	95	108	30	85	58	-	4	3-M8
K11130	100	115	30	85	58	-	4	3-M8
K11160	130	142	40	95	65	-	5	3-M8
K11160A	130	142	40	109	65	71	5	3-M8
K11165	130	145	40	95	65	-	5	3-M8
K11165A	130	145	40	109	65	71	5	3-M8
K11190	155	172	55	109	75	-	5	3-M10
K11190A	155	172	55	122	75	80	5	3-M10
K11200	165	180	65	109	75	-	5	3-M10
K11200A	165	180	65	122	75	80	5	3-M10
K11240	195	215	70	120	80	-	8	3-M12
K11240A	195	215	70	133	80	85	8	3-M12
K11250	206	226	80	120	80	-	5	3-M12
K11250A	206	226	80	133	80	85	5	3-M12

OPERATION INSTRUCTIONS

Der Die Backen der Spannfutter-Serie gibt es in zwei Ausführungen :

① Modell K11 , K12, K13 hat eine solide Backe. Ein Spannfutter verfügt über jeweils einen Satz Innen- und Außenbacken, die verwendet werden können separat.

② Modell K11A (oder K11C) , K12, K13 hat eine zweiteilige Backe.

welches aus Grundbacke und umkehrbarer Aufsatzbacke besteht. Die zweiteiligen Backen können Leistung bringen. Als Innen- oder Außenbacken durch Verstellung. Je nach Spanndurchmesser, Weiche Aufsatzbacken können zum Erreichen einer optimalen Spanngenaugkeit nachbearbeitet werden. Die Anschlussmaße für zweiteilige Backen des Modells K11A entspricht GB4346 (IS03442) Normen.



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.

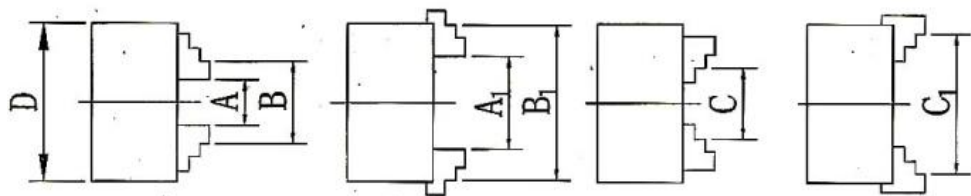
2 Schmieren (an der Fettkammer) und reinigen (mit die Druckluft) die Chucks jeden Tag, In um die Genauigkeit und Haltbarkeit zu erhalten .

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.

(Tisch)

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 Eingangs Drehmoment klein	Erhöhen Sie das Eingangs Drehmoment
	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 Aufnahme futter	Behalten Sie die Kurzkegel sauber
	Mbipiar aco mer 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 Unterkiefer	Halten Sie die Montagefläche der 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

D MODEL D Size	Internal Jaws		External Jaws
	Clamping range	Clamping range	Clamping range
	A-A1	B-B1	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

K11-80, K11-100, K11-125, K11-160, K11-200, K11-250

TEIL NR.	BESCHREIBUNG	Menge
1	Zahnkranzbohrfutter	1
2	Schrauben	3
3	Umkehrbacken (3 Stück)	1

K11-200A K11-250A

TEIL NR.	BESCHREIBUNG	Menge
1	Zahnkranzbohrfutter	1
2	Schrauben	3
3	Sechskantschlüssel	1

K11-160A (1-1/2-8)

TEIL NR.	BESCHREIBUNG	Menge
1	Zahnkranzbohrfutter	1
2	Schrauben	3
3	Rückplatte 1 1/2 8 '	1

K11-200A (2-1/4-8)

TEIL NR.	BESCHREIBUNG	Menge
1	Zahnkranzbohrfutter	1
2	Schrauben	3
3	Rückplatte 2 1/4 8 '	1

K12-200 (1-1/2-8)

TEIL NR.	BESCHREIBUNG	Menge
1	Zahnkranzbohrfutter	1
2	Schrauben	3
3	Umkehrbacken (4 Stück)	1
4	Rückplatte 1 1/2 8 '	1

K13-1 60A (D1-4)

TEIL NR.	BESCHREIBUNG	Menge
1	Zahnkranzbohrfutter	1
2	M8 Schraube	3
3	M 6 Schraube	3
4	Spurstangenschraube	3
5	Rückplatte D1-4	1

Hersteller: Shanghaimuxinmuyeyouxiangongsi

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

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

Importiert in die USA: Sanven Technology Ltd., Suite 250, 9166 Anaheim Place, Rancho Cucamonga, CA 91730

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MANDRINO DEL TORNIO

**MODELLO: K11-80, K11-100, K11-125, K11-160, K11-200, K11-250
K 11-160A, K11-200A, K11-250A, K 12-160, K12-200 K12-250, K11-160A
(1-1/2-8) , K11-200A (2-1/4-8) , K13-160A (D1-4) , K13-160A**

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LATHE CHUCK

MODELLO: K11-80, K11-100, K11-125, K11-160, K11-200, K11-250
K 11-160A, K11-200A, K11-250A, K 12-160, K12-200 K12-250, K11-160A
(1-1/2-8) , K11-200A (2-1/4-8) , K13-160A (D1-4) , K13-160A



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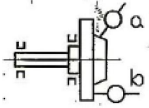
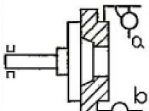
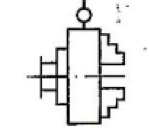
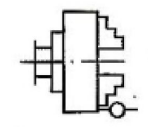
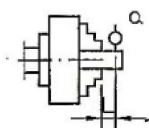
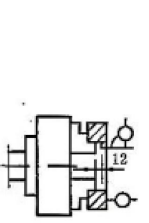
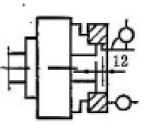
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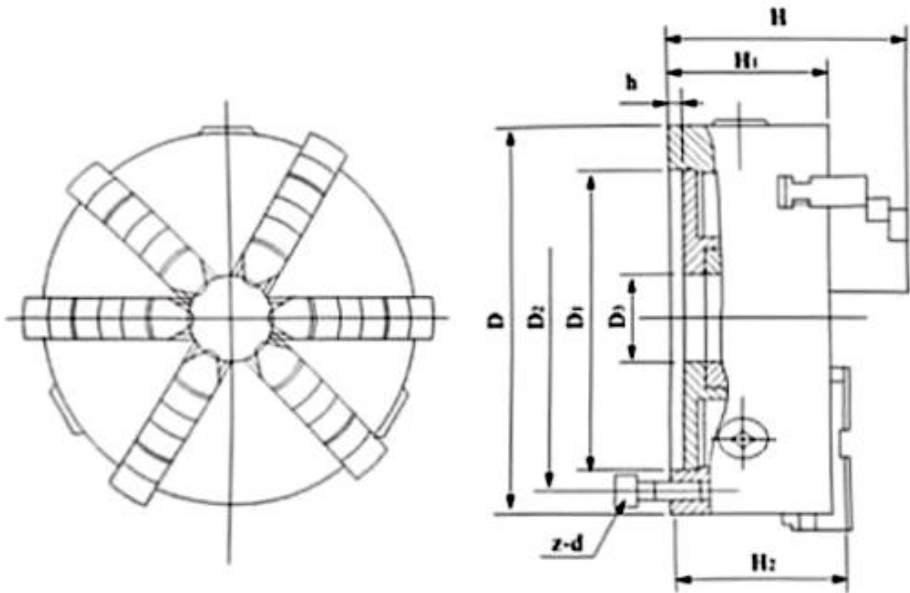
Precisione della geometria (mm)

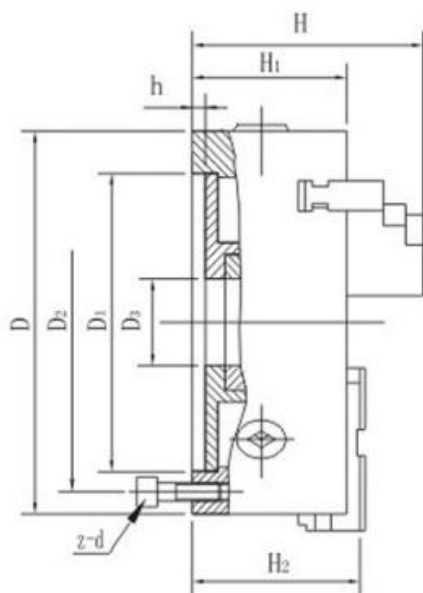
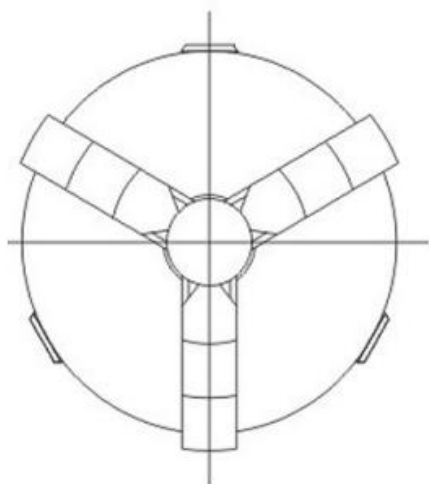
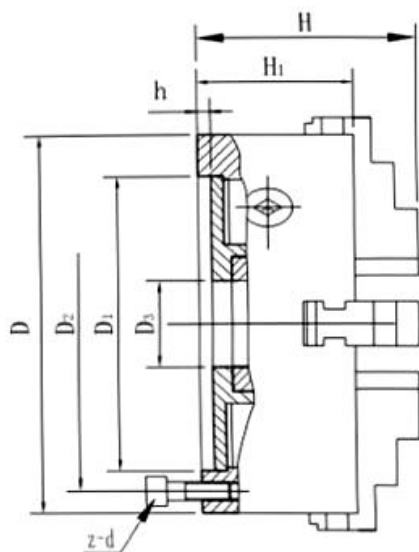
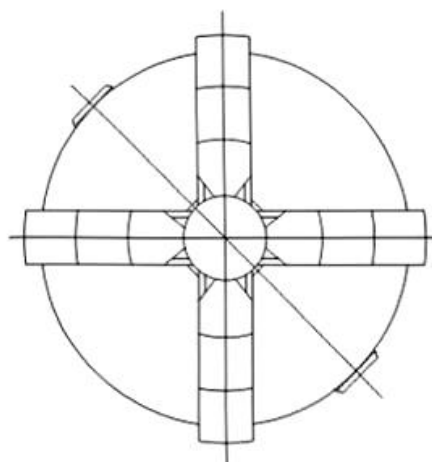
(tavola) mm

Diagramma del test	Elemento di prova m	Chuck Diameter				
		≤165	20 0~250	Da 315 a 400	Da 00 a 630	Da 800 a 1000
	a. Radiale esaurire	un:0,005 b:0,005				
	b. assiale esaurire					
	Radiale esaurire mandrino	0,0 4 0	0,0 5 0	0,060	0,080	0,100
	Assiale esaurire mandrino	0,0 5 0	0,0 5 0	0,060	0,080	0,100
	Radiale esaurire della barra di prova	$\alpha = 0,08$ L=50	$\alpha = 0,080$ L=50(75)	$\alpha = 0,100$ L=75	$\alpha = 0,125$ =100	$\alpha = 0,160$ L=100
	Radiale esaurire di anello di prova	0,060	0,060	0,080	0,100	0,120
	Assiale esaurire di anello di prova	0,032	0,040	0,048	0,064	0,080
	Radiale esaurire di anello di prova	0,060	0,060	0,080	0,100	0,120

Assiale esaurire di anello di prova	0,032	0,040	0,048	0,064	0,080
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SPECIFICATIONS





Specifiche

规格/型式 SEPC. /MODEL	D1	D2	D3	H	H1	H2	h	z-d
K1180	55	66	16	66	50	-	3.5	3-M6
K11100	72	84	22	74.5	55	-	3.5	3-M8
K11125	95	108	30	85	58	-	4	3-M8
K11130	100	115	30	85	58	-	4	3-M8
K11160	130	142	40	95	65	-	5	3-M8
K11160A	130	142	40	109	65	71	5	3-M8
K11165	130	145	40	95	65	-	5	3-M8
K11165A	130	145	40	109	65	71	5	3-M8
K11190	155	172	55	109	75	-	5	3-M10
K11190A	155	172	55	122	75	80	5	3-M10
K11200	165	180	65	109	75	-	5	3-M10
K11200A	165	180	65	122	75	80	5	3-M10
K11240	195	215	70	120	80	-	8	3-M12
K11240A	195	215	70	133	80	85	8	3-M12
K11250	206	226	80	120	80	-	5	3-M12
K11250A	206	226	80	133	80	85	5	3-M12

OPERATION INSTRUCTIONS

IL le ganasce della serie mandrini sono di due tipi :

① I modelli K 11 , K12, K13 sono dotati di ganascia solida. Un mandrino ha un set di ganasce interne ed esterne che possono essere utilizzate separatamente.

② Il modello K11A (o K11C) , K12, K13 è costituito da una ganascia in due pezzi, che è composto da mascella di base e mascella superiore reversibile. Le ganasce in due pezzi possono essere utilizzate. Come ganasce interne o esterne mediante regolazione. In base ai diametri di mandrino, le ganasce superiori morbide possono essere lavorate ulteriormente per ottenere una precisione di serraggio ideale. Le dimensioni di collegamento per le ganasce a due pezzi del modello K11A conforme a GB4346 (IS03442) Standard.



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.

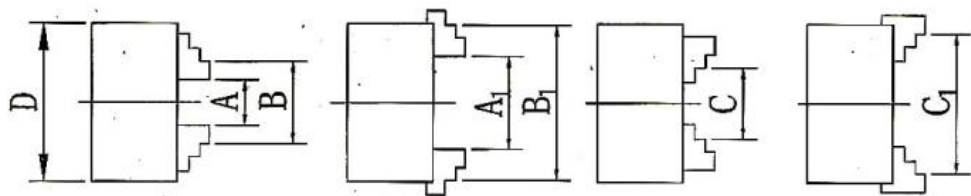
2 Lubrificare (nella coppa del grasso) e pulire (utilizzare l'aria compressa) i mandrini ogni giorno, In per mantenerne la precisione e la durata .

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.

(Tavolo)

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 acomert non conformi the nonting dimension	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

D MODEL D Size	Internal Jaws		External Jaws
	Clamping range	Clamping range	Clamping range
	A-A1	B-B1	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

K11-80, K11-100, K11-125, K11-160, K11-200, K11-250

N. PARTE	DESCRIZIONE	Quantità
1	Mandrino per chiavi	1
2	Vite	3
3	Ganascia inversa s (3 pezzi)	1

Modello K11-200A Modello K11-250A

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

K11-160A (1-1/2-8)

N. PARTE	DESCRIZIONE	Quantità
1	Mandrino per chiavi	1
2	Vite	3
3	Piastra posteriore 1 1/2 8 '	1

K11-200A (2-1/4-8)

N. PARTE	DESCRIZIONE	Quantità
1	Mandrino per chiavi	1
2	Vite	3
3	Piastra posteriore 2 1/4 8 '	1

K12-200 (1-1/2-8)

N. PARTE	DESCRIZIONE	Quantità
1	Mandrino per chiavi	1
2	Vite	3
3	Ganasce invertite (4 pezzi)	1
4	Piastra posteriore 1 1/2 8 '	1

K13-1 60A (D1-4)

N. PARTE	DESCRIZIONE	Quantità
1	Mandrino per chiavi	1
2	Vite M8	3
3	Vite M 6	3
4	Vite del tirante	3
5	Piastra posteriore D1-4	1

Produttore: Shanghaimuxinmuyeyouxiangongsi
Indirizzo: Shuangchenglu 803nong11hao1602A-1609shi, baoshanqu, shanghai 200000 CN.
Importato in AUS: SIHAO PTY LTD, 1 ROKEVA STREETEASTWOOD NSW 2122 Australia
Importato negli USA: Sanven Technology Ltd., Suite 250, 9166 Anaheim Place, Rancho Cucamonga, CA 91730

EC	REP
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E-CrossStu GmbH
Mainzer Landstr.69, 60329 Frankfurt am Main.

UK	REP
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YH CONSULTING LIMITED.
C/O YH Consulting Limited Office 147, Centurion House,
London Road, Staines-upon-Thames, Surrey, TW18 4AX

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MANDRIL DE TORNO

**MODELO: K11-80, K11-100, K11-125, K11-160, K11-200, K11-250
K11-160a , K11-200A, K11-250A, K12-160 , K12-200 K12-250, K11-160A
(1-1/2-8), K11-200A (2-1/4-8), K13-160A (D1-4), K13-160A**

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LATHE CHUCK

**MODELO: K11-80, K11-100, K11-125, K11-160, K11-200, K11-250
K11-160a , K11-200A, K11-250A, K12-160 , K12-200 K12-250, K11-160A
(1-1/2-8), K11-200A (2-1/4-8), K13-160A (D1-4), K13-160A**



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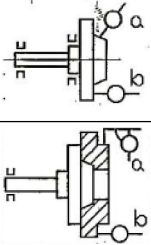
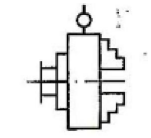
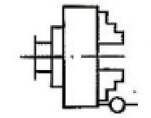
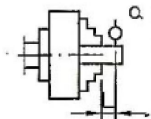
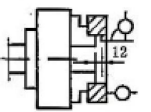
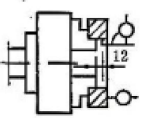
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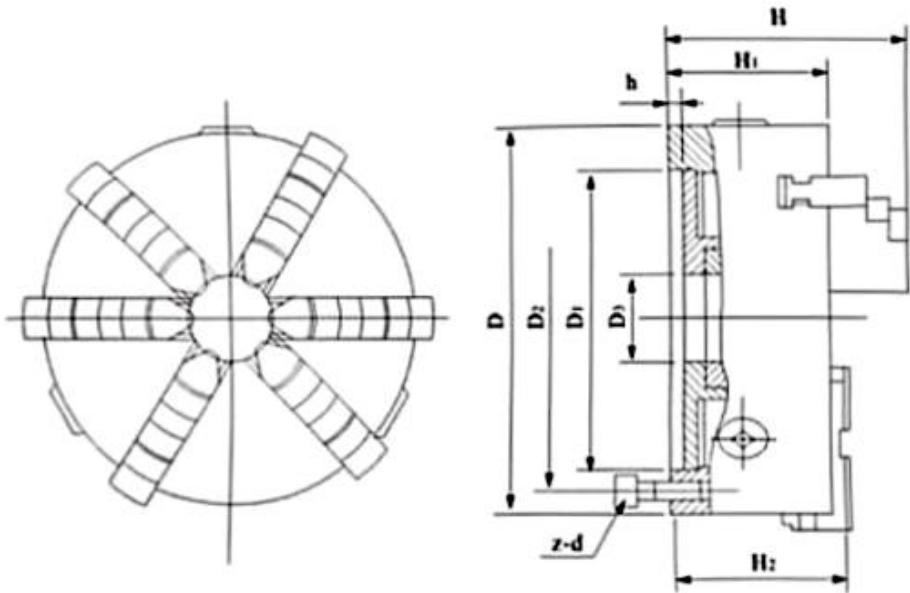
Precisión de geometría (mm)

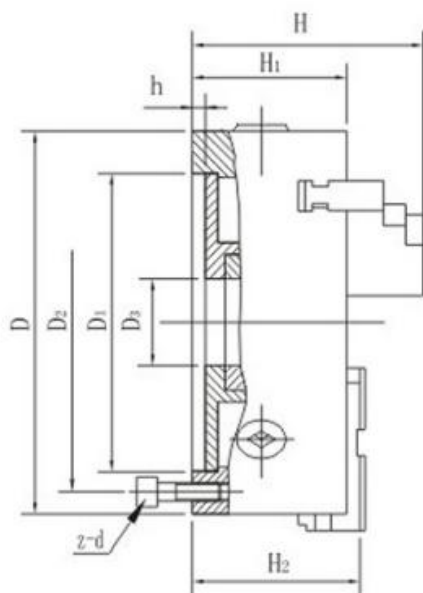
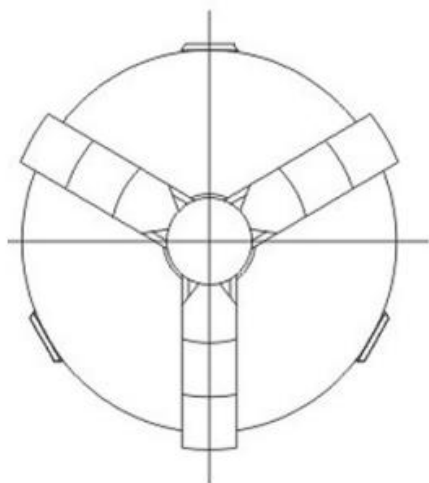
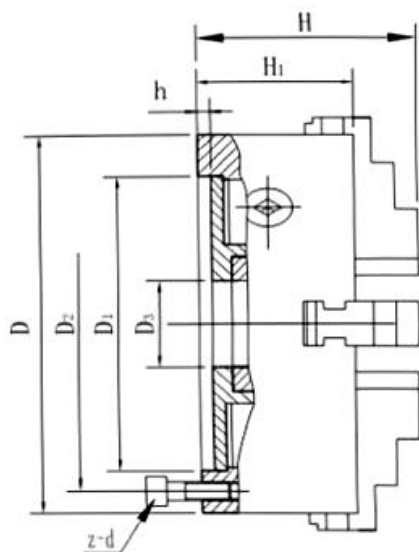
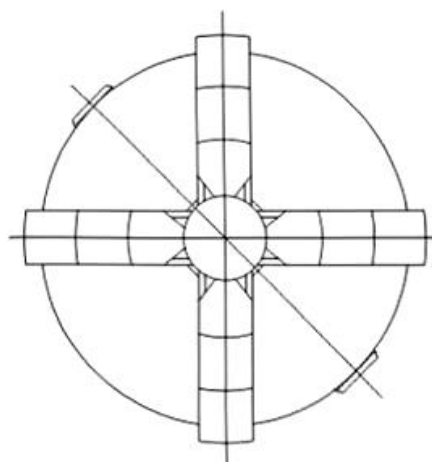
(tabla) mm

Diagrama de prueba	Elemento de prueba m	Chuck Diameter				
		≤165	200 ~ 250	315 ~ 400	500 ~ 630	800 ~ 1000
	a. Radial sin b . axial sin	a:0,005 b:0,005				
	Radial sin arrojar	0.040	0.050	0,060	0.080	0,100
	Axial sin arrojar	0.050	0.050	0,060	0.080	0,100
	Radial sin de barra de prueba	$\alpha = 0,08 L = 50$	$\alpha = 0,080 L = 50(75$	$\alpha = 0,100 L = 75$	$\alpha = 0,125 = 100$	$\alpha = 0,160 L = 100$
	Radial sin de anillo de prueba	0,060	0,060	0.080	0,100	0,120
	Axial sin de anillo de prueba	0,032	0.040	0,048	0,064	0.080
	Radial sin de anillo de prueba	0,060	0,060	0.080	0,100	0,120

Axial sin de anillo de prueba	0,032	0.040	0,048	0,064	0.080
--	-------	-------	-------	-------	-------

SPECIFICATIONS





Presupuesto

规格/型式 SEPC. /MODEL	D1	D2	D3	H	H1	H2	h	z-d
K1180	55	66	16	66	50	-	3.5	3-M6
K11100	72	84	22	74.5	55	-	3.5	3-M8
K11125	95	108	30	85	58	-	4	3-M8
K11130	100	115	30	85	58	-	4	3-M8
K11160	130	142	40	95	65	-	5	3-M8
K11160A	130	142	40	109	65	71	5	3-M8
K11165	130	145	40	95	65	-	5	3-M8
K11165A	130	145	40	109	65	71	5	3-M8
K11190	155	172	55	109	75	-	5	3-M10
K11190A	155	172	55	122	75	80	5	3-M10
K11200	165	180	65	109	75	-	5	3-M10
K11200A	165	180	65	122	75	80	5	3-M10
K11240	195	215	70	120	80	-	8	3-M12
K11240A	195	215	70	133	80	85	8	3-M12
K11250	206	226	80	120	80	-	5	3-M12
K11250A	206	226	80	133	80	85	5	3-M12

OPERATION INSTRUCTIONS

El Las mordazas de la serie chucks son de dos tipos :

- ① Los modelos K 11 , K12 y K13 tienen mandíbula sólida. Un mandril tiene cada juego de mordazas internas y externas que se pueden utilizar por separado.
- ② Los modelos K11A (o K11C) , K12 y K13 tienen mandíbula de dos piezas, que se compone de mandíbula base y mandíbula superior reversible. Las mandíbulas de dos piezas pueden funcionar. Como mandíbulas internas o externas mediante ajuste. Según los diámetros de sujeción, Las mordazas superiores blandas se pueden volver a mecanizar para lograr una precisión de sujeción ideal. Dimensiones de conexión para mordazas de dos piezas del modelo K11A conforme a GB4346 (IS03442) Normas.



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

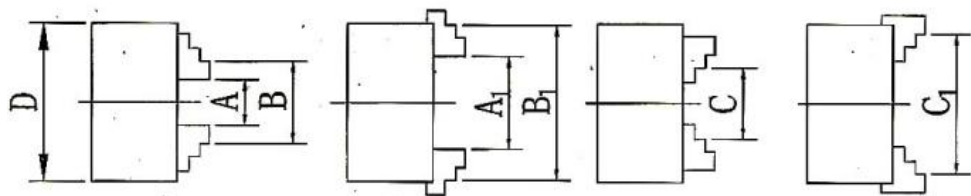
- 1 Los mandriles deben recibir mantenimiento mientras la máquina Herramientas de mantenimiento.
- 2 Lubrique (en el engrasador) y limpie (use el aire comprimido) los chucks

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.

(Mesa)

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
	acomoderar no formar la dimensión no tting	Adaptador compatible exigir
	planos de planta con zhkn La tolsrae 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



CLAMPING RANGE

D MODEL D Size	Internal Jaws		External Jaws
	Clamping range	Clamping range	Clamping range
	A-A1	B-B1	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

K11-80, K11-100, K11-125, K11-160, K11-200, K11-250

NÚMERO DE PIEZA	DESCRIPCIÓN	CANTIDAD
1	Portabrocas de llave	1
2	Tornillo	3
3	Mandíbulas inversas (3 piezas)	1

K11-200A K11-250A

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

K11-160A (1-1/2-8)

NÚMERO DE PIEZA	DESCRIPCIÓN	CANTIDAD
1	Portabrocas de llave	1
2	Tornillo	3
3	Placa trasera 1 1/2 8 '	1

K11-200A (2-1/4-8)

NÚMERO DE PIEZA	DESCRIPCIÓN	CANTIDAD
1	Portabrocas de llave	1
2	Tornillo	3
3	Placa trasera 2 1/4 8 '	1

K12-200 (1-1/2-8)

NÚMERO DE PIEZA	DESCRIPCIÓN	CANTIDAD
1	Portabrocas de llave	1
2	Tornillo	3
3	Mandíbulas inversas (4 piezas)	1
4	Placa trasera 1 1/2 8 '	1

K13-1 60A (D1-4)

NÚMERO DE PIEZA	DESCRIPCIÓN	CANTIDAD
1	Portabrocas de llave	1
2	Tornillo M8	3
3	Tornillo M 6	3
4	Tornillo de la barra de acoplamiento	3
5	Placa posterior D1-4	1

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

EC	REP	E-CrossStu GmbH Mainzer Landstr.69, 60329 Frankfurt am Main.
UK	REP	YH CONSULTING LIMITED. C/O YH Consulting Limited Office 147, Centurion House, London Road, Staines-upon-Thames, Surrey, TW18 4AX



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UCHWYT TOKARSKI

**MODEL: K11-80, K11-100, K11-125, K11-160, K11-200, K11-250
K 11-160A, K11-200A, K11-250A, K 12-160, K12-200 K12-250, K11-160A
(1-1/2-8), K11-200A (2-1/4-8), K13-160A (D1-4), K13-160A**

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LATHE CHUCK

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K 11-160A, K11-200A, K11-250A, K 12-160, K12-200 K12-250, K11-160A
(1-1/2-8), K11-200A (2-1/4-8), K13-160A (D1-4), K13-160A



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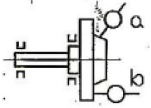
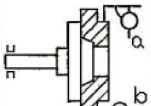
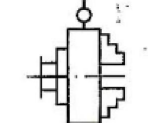
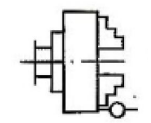
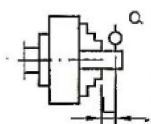
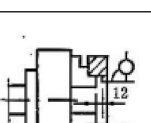
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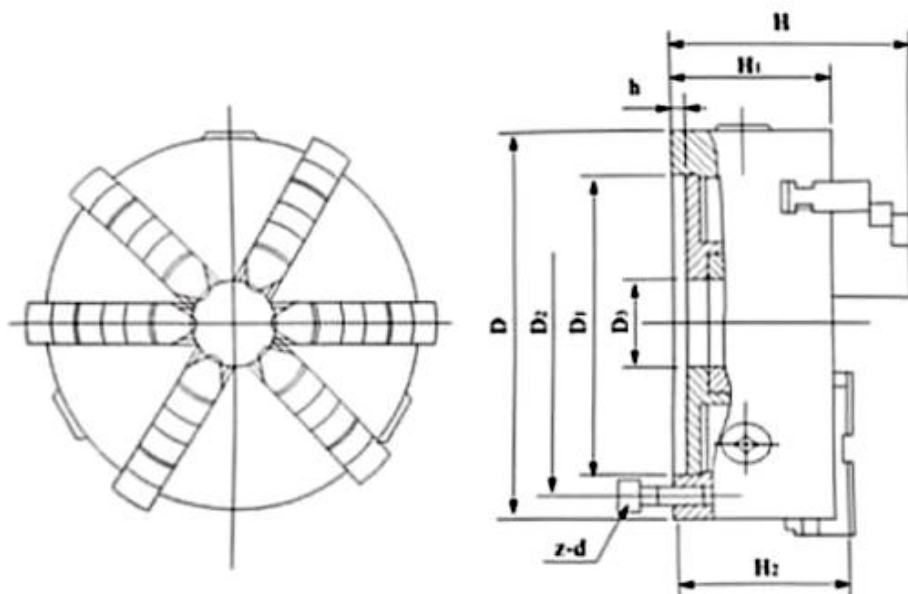
Dokładność geometrii (mm)

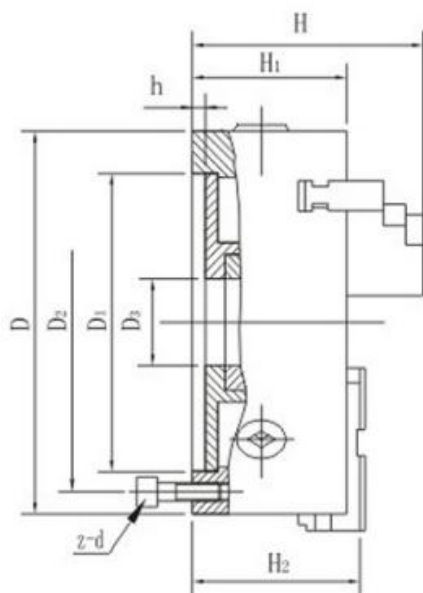
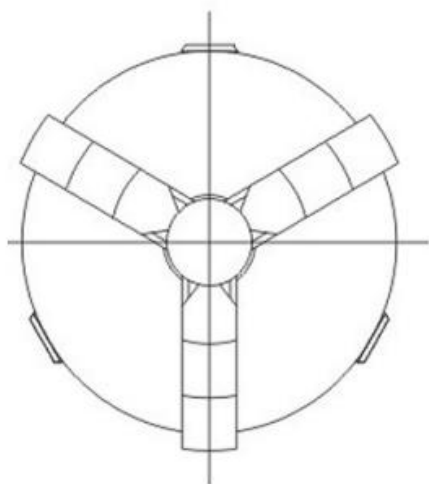
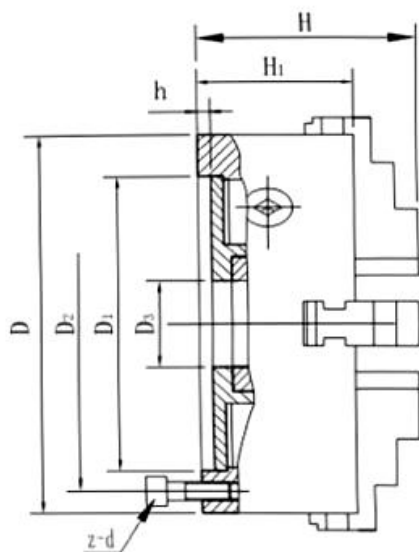
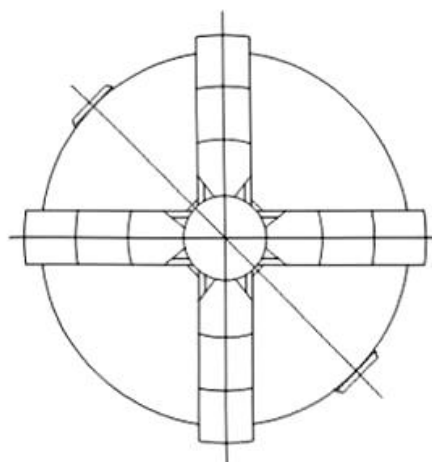
(tabela) mm

Schemat testu	Pozycja testowa m	Chuck Diameter				
		≤165	20 0~250	315~400	00~630	800~1000
	a. Promieniowy nie ma cię	a:0,005 b:0,005				
	b. oś a l wybiec					
	Promieniowy nie ma cię cmokanie	0,0 4 0	0,0 5 0	0,060	0,080	0,100
	A x i a l wybiec cmokanie	0,0 5 0	0,0 5 0	0,060	0,080	0,100
	Promieniowy nie ma cię paska testowego	$\alpha = 0,08 L = 50$	$\alpha = 0,080 L=50(75)$	$\alpha = 0,100 L=75$	$\alpha = 0,125 = 100$	$\alpha = 0,160 L = 100$
	Promieniowy nie ma cię pierścienia testowego	0,060	0,060	0,080	0,100	0,120
	A x i a l nie ma cię pierścienia testowego	0,032	0,040	0,048	0,064	0,080
	Promieniowy nie ma cię pierścienia testowego	0,060	0,060	0,080	0,100	0,120

Axi a l nie ma cię pierścienia testowego	0,032	0,040	0,048	0,064	0,080
---	-------	-------	-------	-------	-------

SPECIFICATIONS





Specyfikacje

规格/型式 SEPC. /MODEL	D1	D2	D3	H	H1	H2	h	z-d
K1180	55	66	16	66	50	-	3.5	3-M6
K11100	72	84	22	74.5	55	-	3.5	3-M8
K11125	95	108	30	85	58	-	4	3-M8
K11130	100	115	30	85	58	-	4	3-M8
K11160	130	142	40	95	65	-	5	3-M8
K11160A	130	142	40	109	65	71	5	3-M8
K11165	130	145	40	95	65	-	5	3-M8
K11165A	130	145	40	109	65	71	5	3-M8
K11190	155	172	55	109	75	-	5	3-M10
K11190A	155	172	55	122	75	80	5	3-M10
K11200	165	180	65	109	75	-	5	3-M10
K11200A	165	180	65	122	75	80	5	3-M10
K11240	195	215	70	120	80	-	8	3-M12
K11240A	195	215	70	133	80	85	8	3-M12
K11250	206	226	80	120	80	-	5	3-M12
K11250A	206	226	80	133	80	85	5	3-M12

OPERATION INSTRUCTIONS

Ten Szczęki uchwytów tokarskich występują w dwóch typach :

- ① Modele K 11 , K12 i K13 posiadają szczęki pełne. Jeden uchwyt ma zestaw szczęk wewnętrznych i zewnętrznych, które można wykorzystać osobno.
- ② Model K11A (lub K11C) 、 K12、 K13 ma szczękę dwuczęściową, który składa się ze szczęki podstawowej i odwracalnej szczęki górnej. Dwuczęściowe szczęki mogą działać. Jako szczęki wewnętrzne lub zewnętrzne poprzez regulację. Według średnic uchwytów, Miękkie szczęki górne można poddać obróbce maszynowej w celu uzyskania idealnej dokładności mocowania. Wymiary przyłączeniowe szczęk dwuostrzowych modelu K11A zgodny z GB4346 (IS03442) Normy.



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 końcu aby zapewnić dokładność.
- e) Nie przekraczać maksymalnej prędkości uchwytu podczas pracy.

Konserwacja i przeglądy

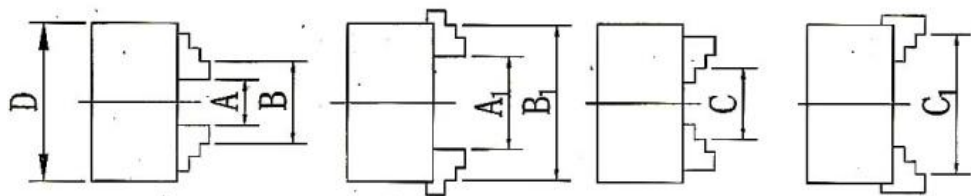
- 1 Uchwyty należy konserwować podczas pracy maszyny narzędzia utrzymują.
- 2 Nasmaruj (w pojemniku na tłuszcz) i wyczyść (używając (sprężone

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 uchwyty. Rozwiązywanie problemów problemów i pomiary patrz tabela 5.

(Tabela)

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 uchwyty
	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 uchwyty stożkowe krótkie	Wyreguluj uchwyty pozycja montażowa
	Powierzchnia stożkowa krótka jest brudna, gdy uchwyty 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 szczęce i dolnej szczęce	Podczas wymiany szczęk utrzymuj 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 uchwyty	Wyczyść i nasmaruj
	Słabe smarowanie	Smarować



CLAMPING RANGE

D MODEL D Size	Internal Jaws		External Jaws
	Clamping range	Clamping range	Clamping range
	A-A1	B-B1	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

K11-80, K11-100, K11-125, K11-160, K11-200, K11-250

NR CZĘŚCI	OPIS	ILOŚĆ
1	Uchwyt na klucze	1
2	Śruba	3
3	Szczęki odwrotne (3 sztuki)	1

K11-200A K11-250A

NR CZĘŚCI	OPIS	ILOŚĆ
1	Uchwyt na klucze	1
2	Śruba	3
3	Klucz sześciokątny	1

K11-160A (1-1/2-8)

NR CZĘŚCI	OPIS	ILOŚĆ
1	Uchwyt na klucze	1
2	Śruba	3
3	Płyta tylna 1 1/2 8 '	1

K11-200A (2-1/4-8)

NR CZĘŚCI	OPIS	ILOŚĆ
1	Uchwyt na klucze	1
2	Śruba	3
3	Płyta tylna 2 1/4 8 '	1

K12-200 (1-1/2-8)

NR CZĘŚCI	OPIS	ILOŚĆ
1	Uchwyt na klucze	1
2	Śruba	3
3	Szczęki odwrotne (4 sztuki)	1
4	Płyta tylna 1 1/2 8 '	1

K13-1 60A (D1-4)

NR CZĘŚCI	OPIS	ILOŚĆ
1	Uchwyt na klucze	1
2	Śruba M8	3
3	Śruba M 6	3
4	Śruba drążka kierowniczego	3
5	Płyta tylna D1-4	1

Producent: Shanghai muxinmuyeyouxiangongsi
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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Mainzer Landstr.69, 60329 Frankfurt am Main.

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C/O YH Consulting Limited Office 147, Centurion House,
London Road, Staines-upon-Thames, Surrey, TW18 4AX

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DRAAIBANKKLAUW

**MODELLEN: K11-80, K11-100, K11-125, K11-160, K11-200, K11-250
K 11-160A, K11-200A, K11-250A, K 12-160, K12-200 K12-250, K11-160A
(1-1/2-8), K11-200A (2-1/4-8), K13-160A (D1-4), K13-160A**

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LATHE CHUCK

MODELLEN: K11-80, K11-100, K11-125, K11-160, K11-200, K11-250
K 11-160A, K11-200A, K11-250A, K 12-160, K12-200 K12-250, K11-160A
(1-1/2-8), K11-200A (2-1/4-8), K13-160A (D1-4), K13-160A



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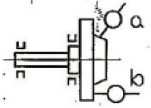
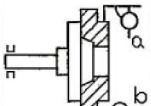
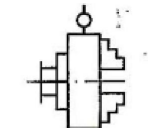
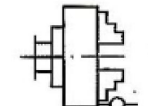
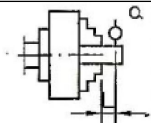
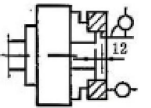
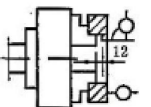
Have product questions? Need technical support? Please feel free to contact us:

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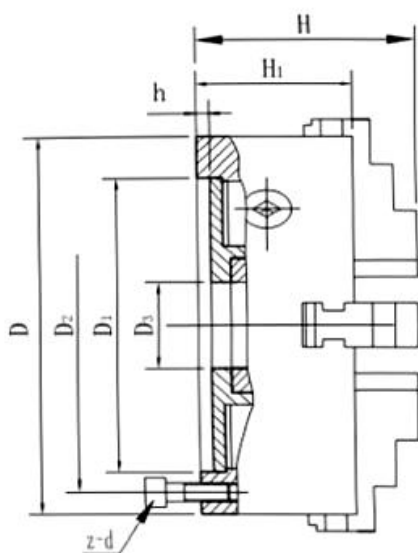
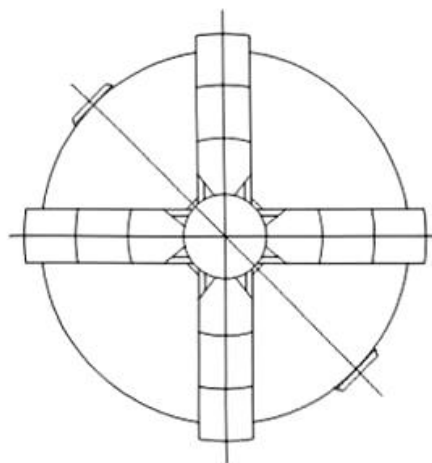
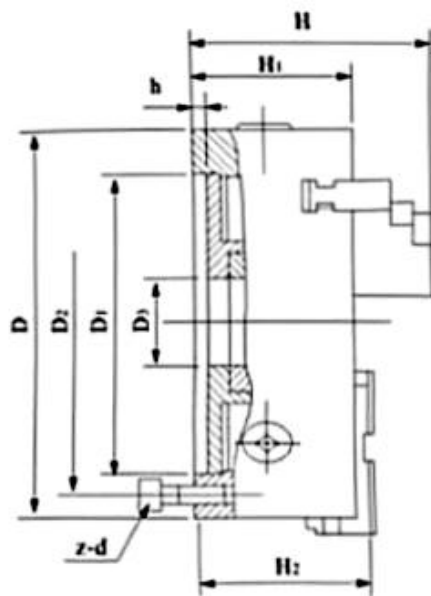
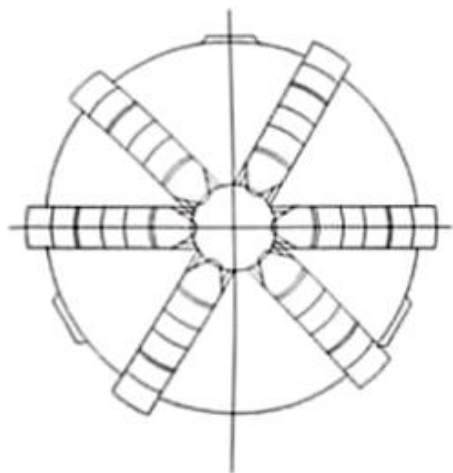
This is the original instruction, please read all manual instructions carefully before operating. VEVOR reserves a clear interpretation of our user manual. The appearance of the product shall be subject to the product you received. Please forgive us that we won't inform you again if there are any technology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

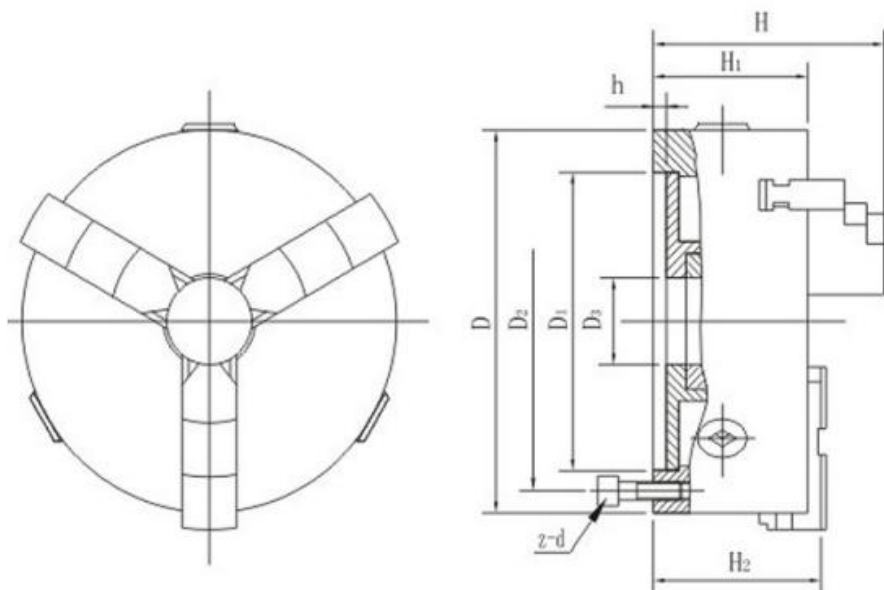
Geometrie nauwkeurigheid (mm)

(tabel) mm

Diagram van de test	Testitem m	Chuck Diameter				
		≤165	20 0~250	315~400	00~630	800~1000
	a. Radiaal ren - uit	een:0.005 b:0.005				
	b. axiaal opraken					
	Radiaal ren - uit klauw	0,0 4 0	0,0 5 0	0,060	0,080	0,100
	Een xiaal opraken klauw	0,0 5 0	0,0 5 0	0,060	0,080	0,100
	Radiaal ren - uit van testbalk	$\alpha = 0,08 L = 50$	$\alpha = 0,080 L = 50(75)$	$\alpha = 0,100 L = 75$	$\alpha = 0,125 = 100$	$\alpha = 0,160 L = 100$
	Radiaal ren - uit van testring	0,060	0,060	0,080	0,100	0,120
	Een xiaal ren - uit van testring	0,032	0,040	0,048	0,064	0,080
	Radiaal ren - uit van testring	0,060	0,060	0,080	0,100	0,120
	Een xiaal ren - uit van testring	0,032	0,040	0,048	0,064	0,080

SPECIFICATIONS





Specificaties

SEPC. /MODEL	D1	D2	D3	H	H1	H2	h	z-d
K1180	55	66	16	66	50	-	3.5	3-M6
K11100	72	84	22	74.5	55	-	3.5	3-M8
K11125	95	108	30	85	58	-	4	3-M8
K11130	100	115	30	85	58	-	4	3-M8
K11160	130	142	40	95	65	-	5	3-M8
K11160A	130	142	40	109	65	71	5	3-M8
K11165	130	145	40	95	65	-	5	3-M8
K11165A	130	145	40	109	65	71	5	3-M8
K11190	155	172	55	109	75	-	5	3-M10
K11190A	155	172	55	122	75	80	5	3-M10
K11200	165	180	65	109	75	-	5	3-M10
K11200A	165	180	65	122	75	80	5	3-M10
K11240	195	215	70	120	80	-	8	3-M12
K11240A	195	215	70	133	80	85	8	3-M12
K11250	206	226	80	120	80	-	5	3-M12
K11250A	206	226	80	133	80	85	5	3-M12

OPERATION INSTRUCTIONS

De De kaken van de serie klauwplaten zijn er in twee typen :

- ① Model K 11 , K12 en K13 hebben een massieve kaak. Eén klauwplaat heeft een set interne en externe kaken die gebruikt kunnen worden afzonderlijk.
- ② Model K11A (of K11C) 、 K12、 K13 heeft een tweedelige kaak, die bestaat uit een basiskaak en een omkeerbare bovenkaak. De tweedelige kaken kunnen presteren. Als inwendige of uitwendige kaken door aanpassing. Afhankelijk van de spandiameters, Zachte bovenbekken kunnen opnieuw worden bewerkt om een ideale klemnauwkeurigheid te bereiken. De aansluitmaten voor tweedelige bekken van model K11A conform GB4346 (IS03442) Normen.



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 chuk 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

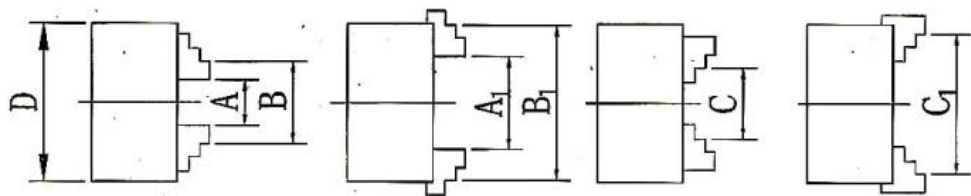
- 1 De klauwplaten moeten worden onderhouden terwijl de machine draait gereedschappen onderhouden.

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.

(Tafel)

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 l niet werken	Onzuiverheid ding in de klauwen	Schoonmaken en smeren
	Smering is slecht	Smeren



CLAMPING RANGE

D MODEL D Size	Internal Jaws		External Jaws
	Clamping range	Clamping range	Clamping range
	A-A1	B-B1	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

K11-80, K11-100, K11-125, K11-160, K11-200, K11-250

ONDERDEELN R.	BESCHRIJVING	Hoeveelheid
1	Sleutelklem	1
2	Schroef	3
3	Omgekeerde kaak (3 stuks)	1

K11-200A K11-250A

ONDERDEELNR.	BESCHRIJVING	Hoeveelheid
1	Sleutelklem	1
2	Schroef	3
3	Inbussleutel	1

K11-160A (1-1/2-8)

ONDERDEELNR.	BESCHRIJVING	Hoeveelheid
1	Sleutelklem	1
2	Schroef	3
3	Achterplaat 1 1/2 8 '	1

K11-200A (2-1/4-8)

ONDERDEELNR.	BESCHRIJVING	Hoeveelheid
1	Sleutelklem	1
2	Schroef	3
3	Achterplaat 2 1/4 8 '	1

K12-200 (1-1/2-8)

ONDERDEELNR.	BESCHRIJVING	Hoeveelheid
1	Sleutelklem	1
2	Schroef	3
3	Omgekeerde kaken (4 stuks)	1
4	Achterplaat 1 1/2 8 '	1

K13-1 60A (D1-4)

ONDERDEELNR.	BESCHRIJVING	Hoeveelheid
1	Sleutelklem	1
2	M8- schroef	3
3	M 6 Schroef	3
4	Stuurstangschroef	3
5	Achterplaat D1-4	1

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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SVARV CHUCK

**MODELL: K11-80, K11-100, K11-125, K11-160, K11-200, K11-250
K 11-160A, K11-200A, K11-250A, K 12-160, K12-200 K12-250, K11-160A
(1-1/2-8) , K11-200A (2-1/4-8) , K13-160A (D1-4) , K13-160A**

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LATHE CHUCK

MODELL: K11-80, K11-100, K11-125, K11-160, K11-200, K11-250
K 11-160A, K11-200A, K11-250A, K 12-160, K12-200 K12-250, K11-160A
(1-1/2-8) , K11-200A (2-1/4-8) , K13-160A (D1-4) , K13-160A



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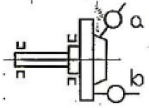
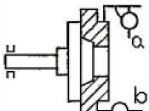
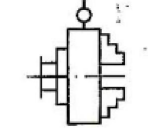
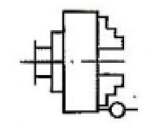
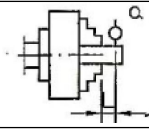
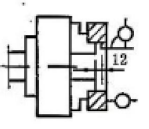
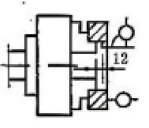
Have product questions? Need technical support? Please feel free to contact us:

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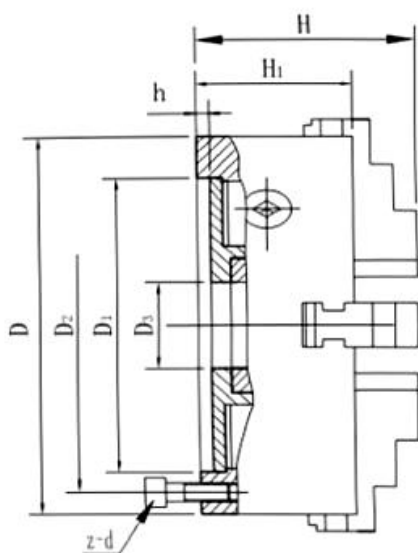
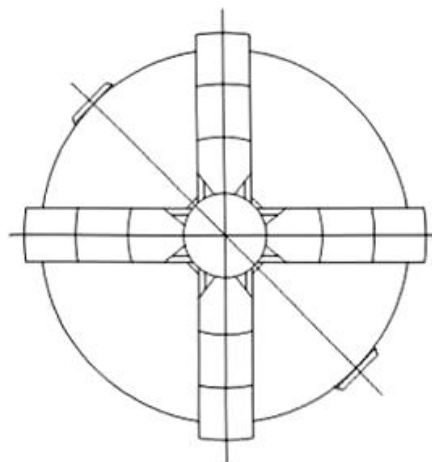
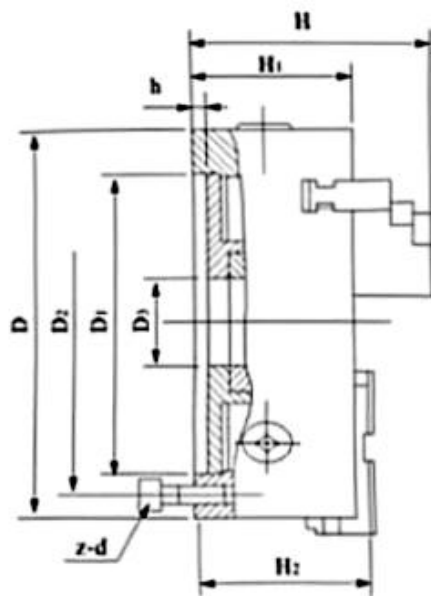
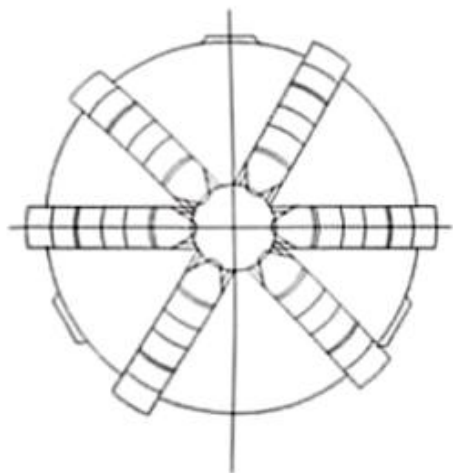
This is the original instruction, please read all manual instructions carefully before operating. VEVOR reserves a clear interpretation of our user manual. The appearance of the product shall be subject to the product you received. Please forgive us that we won't inform you again if there are any technology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

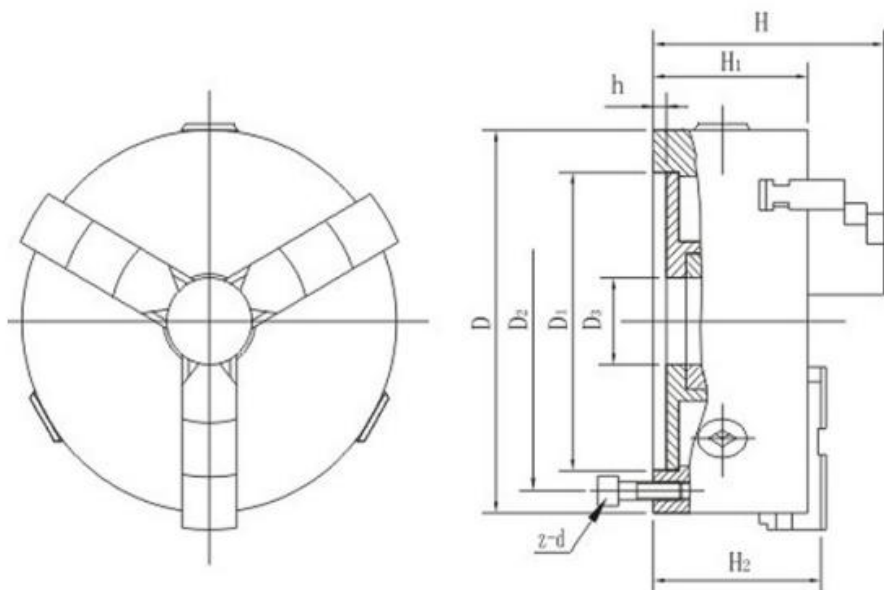
Geometri noggrannhet (mm)

(tabell) mm

Diagram av testet	Testobjekt m	Chuck Diameter				
		≤165	20 0~250	315~400	00~630	800~1000
 	a. Radiell är du n-ut b. axel a l ta slut	a:0,005 b:0,005				
	Radiell är du n-ut chuck	0,0 4 0	0,0 5 0	0,060	0,080	0,100
	A xi a l ta slut chuck	0,0 5 0	0,0 5 0	0,060	0,080	0,100
	Radiell är du n-ut av teststången	a =0,08 L=50	a = 0,080 L=50(75)	a = 0,100 L=75	a = 0,125 =100	$\alpha = 0 \cdot 160$ L=100
	Radiell är du n-ut av testringen	0,060	0,060	0,080	0,100	0,120
	A xi a l är du n-ut av testringen	0,032	0,040	0,048	0,064	0,080
	Radiell är du n-ut av testringen	0,060	0,060	0,080	0,100	0,120
	A xi a l är du n-ut av testringen	0,032	0,040	0,048	0,064	0,080

SPECIFICATIONS





Specifikationer

SEPC. /MODEL	D1	D2	D3	H	H1	H2	h	z-d
K1180	55	66	16	66	50	-	3.5	3-M6
K11100	72	84	22	74.5	55	-	3.5	3-M8
K11125	95	108	30	85	58	-	4	3-M8
K11130	100	115	30	85	58	-	4	3-M8
K11160	130	142	40	95	65	-	5	3-M8
K11160A	130	142	40	109	65	71	5	3-M8
K11165	130	145	40	95	65	-	5	3-M8
K11165A	130	145	40	109	65	71	5	3-M8
K11190	155	172	55	109	75	-	5	3-M10
K11190A	155	172	55	122	75	80	5	3-M10
K11200	165	180	65	109	75	-	5	3-M10
K11200A	165	180	65	122	75	80	5	3-M10
K11240	195	215	70	120	80	-	8	3-M12
K11240A	195	215	70	133	80	85	8	3-M12
K11250	206	226	80	120	80	-	5	3-M12
K11250A	206	226	80	133	80	85	5	3-M12

OPERATION INSTRUCTIONS

De chuckar i serien har två typer :

- ① Modell K 11 、 K12 、 K13 är av solid käke. En chuck har varje uppsättning inre och yttre käftar som kan användas separat.
- ② Modell K11A(eller K11C) 、 K12、 K13 är en tvådelad käke, som består av baskäke och vändbar toppkäke. De tvådelade käftarna kan prestera. Som inre eller yttre käkar genom justering. Enligt chuckdiametrar, käftar med mjuk topp kan bearbetas för att uppnå idealisk spännnoggrannhet. Anslutningsmått för tvådelade käftar av modell K11A överensstämmer med GB4346 (IS03442) Standarder.



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.

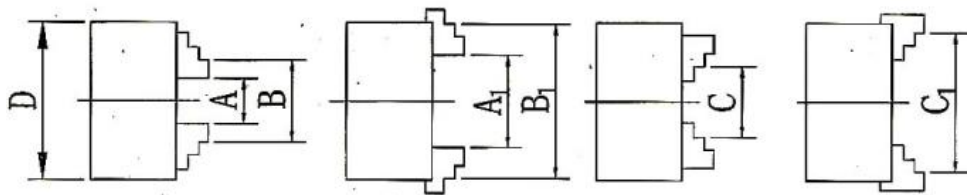
Underhåll och inspektion

- 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)

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 överkåken baskåken	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

D MODEL D Size	Internal Jaws		External Jaws
	Clamping range	Clamping range	Clamping range
	A-A1	B-B1	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

K11-80, K11-100, K11-125, K11-160, K11-200, K11-250

DELNR.	BESKRIVNING	ANTAL
1	Nyckelchuck	1
2	Skruva	3
3	Omvänd käke (3 stycken)	1

K11-200A K11-250A

DELNR.	BESKRIVNING	ANTAL
1	Nyckelchuck	1
2	Skruva	3
3	Sexkantnyckel	1

K11-160A (1-1/2-8)

DELNR.	BESKRIVNING	ANTAL
1	Nyckelchuck	1
2	Skruva	3
3	Bakplatta 1 1/2 8 '	1

K11-200A (2-1/4-8)

DELNR.	BESKRIVNING	ANTAL
1	Nyckelchuck	1
2	Skruva	3
3	Bakplatta 2 1/4 8 '	1

K12-200 (1-1/2-8)

DELNR.	BESKRIVNING	ANTAL
1	Nyckelchuck	1
2	Skruva	3
3	Omvända käftar (4 stycken)	1
4	Bakplatta 1 1/2 8 '	1

K13-1 60A (D1-4)

DELNR.	BESKRIVNING	ANTAL
1	Nyckelchuck	1
2	M8 Skruv	3
3	M 6 Skruv	3
4	Dragstångsskruv	3
5	Bakplatta D1-4	1

Tillverkare: Shanghaimuxinmuyeyouxiangongsi

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

Importerad till AUS: SIHAO PTY LTD, 1 ROKEVA STREETEASTWOOD NSW 2122 Australien

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

EC	REP
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E-CrossStu GmbH
Mainzer Landstr.69, 60329 Frankfurt am Main.

UK	REP
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YH CONSULTING LIMITED.
C/O YH Consulting Limited Office 147, Centurion House,
London Road, Staines-upon-Thames, Surrey, TW18 4AX



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