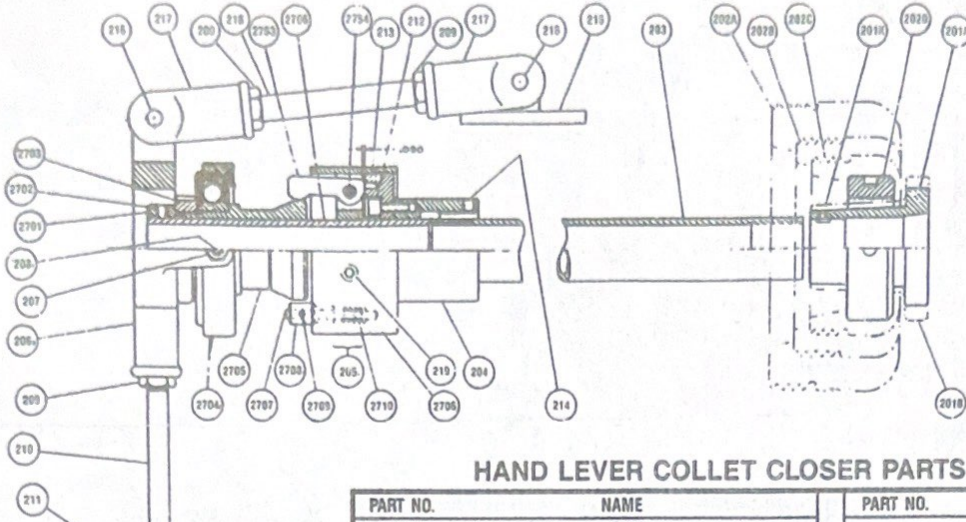




# Production Collet Closers

Hand Lever -



HAND LEVER COLLET CLOSER PARTS LIST

PART NO.	NAME	PART NO.	NAME
201-A	Adapter, Collet 2 1/2"	2707	Pin, Index
201-B	Adapter, Collet 3"	2708	Knob
201-K	Key	2709	Screw
202-A	Ring, Nose L1	2710	Spring
202-B	Ring, Nose L0	206	Handle Casting
202-C	Ring, Nose L00	207	Nut
202-D	Ring, Nose Threaded	208	Screw
202-E	Ring, Nose L2	209	Nut
203	Tube, Draw	210	Rod, Handle
204	Hub Adapter	211	Handle
205	Actuator Assembly	212	Screw
	2701 Collar	213	Ring, Index
	2702 Screw	214	Screw
	2703 Nut	215	Bracket
	2704 Bearing & Retainer Assembly	216	Pin
	2705 Cam	217	Connector, Rod
	2706 Collar (Knurled)	218	Rod
	2753 Finger	219	82° Flat Head Allen
	2754 Pin, Pivot		

**SPECIAL INSTRUCTIONS MUST INDICATE INDEX RING ON LATHE TO HAVE COLLET CLOSER OPERATE CORRECTLY. SEE NOTE #2**

**To install HAND LEVER CLOSER**

1. Mount hub (204) on back end of spindle. Hubs for plain spindles should be pressed on completely so that the end of the spindle will seat against the bottom of the bore in the hub. Lock with the two set screws (214). Threaded hubs should be screwed onto the spindle so that the end will abut the collar or locknut on the spindle. In some cases it may be necessary to remove the thrust collar or locknut on the spindle to allow complete adaption of the hub.
2. Mount the index ring (213) on the hub (204) by means of the three screws (212). It is very important that the periphery of this ring be concentric with the axis of the spindle. It is suggested that the mounting screws be loosened slightly and the ring positioned accurately with an indicator. After determining that it is running true the screws should be tightened securely.
3. Where applicable install nose ring (202) to spindle nose.
4. Check the taper in the front of the lathe spindle to ascertain that there are no nicks or bumps on the surface. By the use of an indicator determine that the spindle turns without runout in the taper.

5. Install the closer unit thru the back end of the spindle, slipping the actuator collar (2706) over the index ring (213). Pull out the index pin (2708) and turn so that the set screw (2709) is resting on the edge of the collar (2706).
6. Mount bracket (215) on case of lathe in such a position that the linkage will be at the same elevation as the spindle. Connect linkage to closer unit.
7. Insert collet adapter (201) in nose of spindle.
8. Insert desired collet into adapter and turn collar (2706) so that draw tube (203) will engage collet. Insert piece of material of the required size into the collet and with the unit in the released position turn the collar (2706) until the material is lightly held. Move the hand lever back and forth until the desired tension is obtained by turning the collar. Release the index pin (2708) allowing it to enter the closest hole in the index plate (213). The collar may require turning slightly to allow the index pin to seat completely. Caution: Avoid excessive tension on collet.
9. Adjust linkage so that the operating handle will travel angularly equal from open to middle position and closed to middle position.

**Special Instructions:** You MUST indicate Index Ring on lathe to have Collet Closer operate correctly.

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