

Attachment of locator and jig

- In the case of attaching the locator and the jig on the chuck body surface, tap or drill a hole in the additional process range specified in Fig. 14.

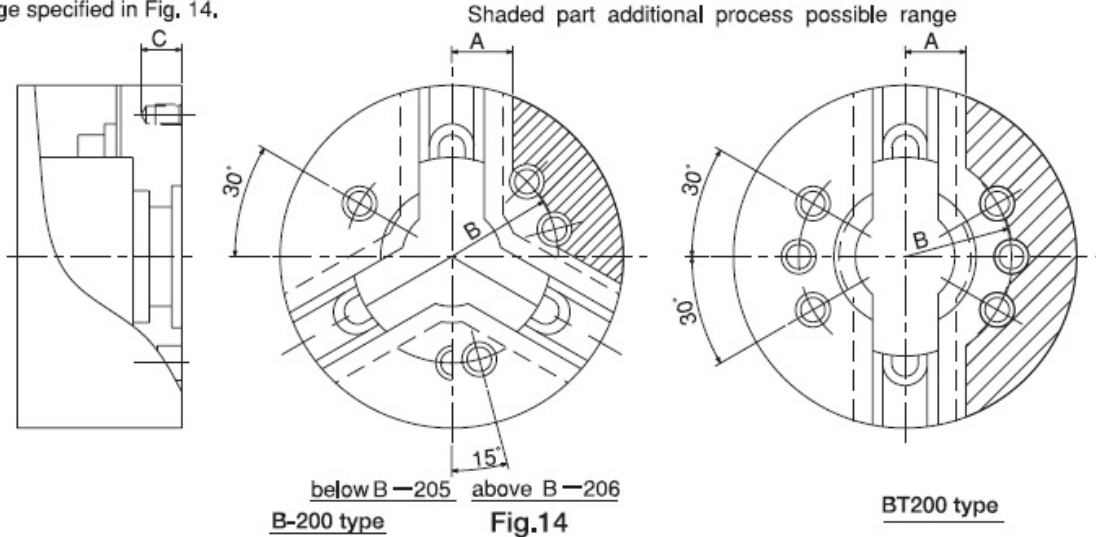


Fig.14

Table 6

Type	A (mm)	B (mm)	C (mm)
B-204,BT204	23	39	Less than 15
B-205,BT205	23	45	Less than 15
B-206,BT206	30	53	Less than 20
B-208,BT208	33	63	Less than 20

Type	A (mm)	B (mm)	C (mm)
B-210,BT210	36	79	Less than 20
B-212,BT212	42	90	Less than 30
B-215	60	120	Less than 40

A, B: Additional process impossible dimension.
C: Processible depth of tapping or drilling a hole.

DANGER

- The chuck can be modified only in the manufacturer permissible range. This will not only break the chuck but the chuck and work may fly out, which is dangerous.
- Provide a countermeasure against flying out (dwell pin, etc.) due to centrifugal force to the locator or the jig, and attach with bolts which have sufficient strength. The locator or the jig may fly out, and this is dangerous.