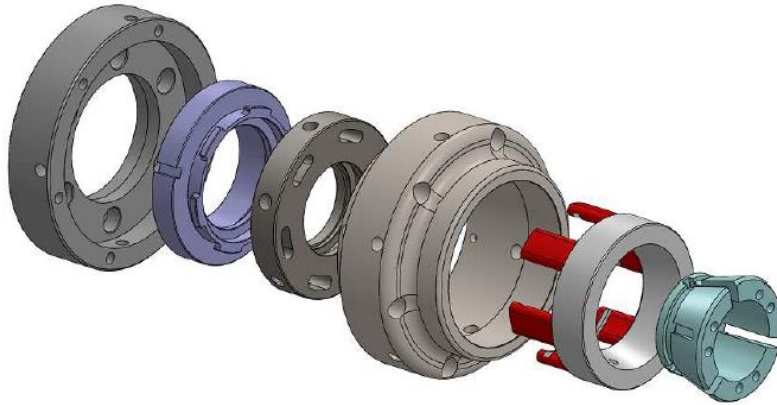


Mounting Instructions:
FOR ATS FQC65TL AND FQC80TL
QUICK CHANGE TRUE LENGTH COLLET CHUCKS
For American Std. and Select Flat-Nose Spindles



- 1) Remove existing chuck, fixtures and any face plate attachments. Thoroughly clean the mounting surface of the spindle free from any chips or debris.
- 2) Clean both the spindle side and the chuck side of mounting plate.
- 3) ***For shipping purposes, the drawtube adapter may already be threaded into the collet actuator. Make sure that the drawtube adapter is completely tightened into the collet actuator.*** If the drawtube adapter is shipped unassembled with the system or packaged separately, place the collet chuck assembly down, mounting flange end up, thread the drawtube adapter into the collet actuator, completely tighten.
- 4) Clean the plate bore of the collet chuck after installing the drawtube adapter.
- 5) **AMERICAN STANDARD SPINDLES:**
Line up the machine's drive pin, located on the machine's spindle, with one of the drive pinholes located on the mounting plate. Place the mounting plate onto the machine's spindle. Secure the mounting plate onto the machine's spindle with the supplied mounting bolts. Install and completely tighten the mounting bolts in an alternating sequence, (crisscross). Verify proper installation of the mounting plate; place a .0001" dial indicator on the face of the mounting plate to ensure a .0001" indicator reading.
SELECT FLAT-NOSE SPINDLES:
Most select flat-nose spindles **WILL NOT** have a drive pin located on the machine's spindle or a drive pinhole located on the collet chuck mounting plate. For select flat-nose spindles, do not completely tighten mounting bolts, this allows the mounting plate to be properly indicated to the spindle. With a .0001" dial indicator, indicate the mounting plate into the machine's spindle to have a zero T.I.R. Once properly adjusted and indicated, completely tighten the mounting bolts.
- 6) Extend the machine's drawtube to a forward/open position.
- 7) Turn the machine's drawtube pressure down just enough to actuate the collet chuck system.

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FQCTL QUICK CHANGE TRUE LENGTHS:

- 8) Place the collet chuck assembly (body and drawtube adapter) onto the machine's drawtube, turning clockwise. Just before the collet chuck assembly is fully threaded onto the machine's drawtube, turn back the collet chuck assembly to the nearest bolt hole location on the mounting plate.
- 9) Retract the machine's drawtube making sure that all the mounting holes are aligned.
- 10) Install all the mounting bolts firmly, (finger tight). **DO NOT** completely tighten. This allows the collet chuck assembly to be properly adjusted and indicated to the machine's spindle.
- 11) **STD. BODY SYSTEMS (A2-6, A2-8, A2-11 & 140MM SPINDLE MNTS):**
To ensure proper installation, place a .0001" dial indicator on the O.D. of the collet chuck nose. Use the four adjusting screws to adjust and indicate the collet chuck to the desired T.I.R.
- 12) Fully tighten all the mounting bolts in an alternating sequence (crisscross). Use a .0001" dial indicator to maintain desired T.I.R. when fully tightening the mounting bolts.

INSTALLING THE QUICK-CHANGE COLLETS:

- 1) Using the Quick-Change Manual Wrench and the Collet chuck on unclamped position.
- 2) Thoroughly clean the Collet Head. Clean out the wrench pin holes on the face of the collet and the closing taper on the collet chuck. Use a lint free cloth to ensure the surfaces are completely free of lint.
- 3) Align the pin holes in the Collet Head with the pins of the changing wrench. Insert the Pins of the Wrench completely into holes of the face of the Collet Head.
- 4) Firmly press the lever of the Quick-Change manual Wrench to compress the collet. Once the collet is compressed, align the collet key (marked on the face of the collet "key") with the keyway located on the SQC collet chuck closing sleeve. Insert the collet into the collet chuck body. Fully seat the Collet head into the chuck body.
- 5) Maintain forward pressure against the chuck and release the collet by pressing on the release trigger. The collet will expand and lock into the collet retainer of the collet chuck body holding it stationary. Remove the wrench.
- 6) Set the machine for I.D. chucking. Insert a workpiece into the collet then actuate the drawtube. Adjust the machine's drawtube pressure to the desired pressure needed to hold the workpiece.

***NEVER ACTUATE THE SYSTEM WITHOUT A
WORKPIECE IN THE COLLET***