



Mounting Instructions: **NOSE CAP STYLE COLLET CHUCKS** **(TL-21, TL-22, TL-42, TL-60, & TL-90)** **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 closing sleeve. Make sure that the drawtube adapter is completely tightened into the closing sleeve.*** 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 closing sleeve, completely tighten.
- 4) Clean the mounting 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.
- 8) Place the collet chuck assembly (body and drawtube adapter) onto the machine's drawtube, turning clockwise. Just before the collet chuck assembly is completely threaded onto the machine's drawtube, turn back the collet chuck assembly to the nearest bolt hole location on the mounting plate.

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NOSE CAP STYLE:

- 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) 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) Make sure that the machine's drawtube is in a retracted position when adjusting for T.I.R.
- 13) Completely 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.
- 14) With the drawtube still in a retracted position, insert the desired collet into the collet chuck assembly. Thread the nose cap (nut) completely onto the collet chuck body.
- 15) Using an ATS nut wrench, proceed to tighten the nose cap (nut), onto the collet chuck body. Thread the 10/32 set screw, located on the face of the nose cap (nut), until secure, locking the nose cap (nut) into place.
- 16) 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.***