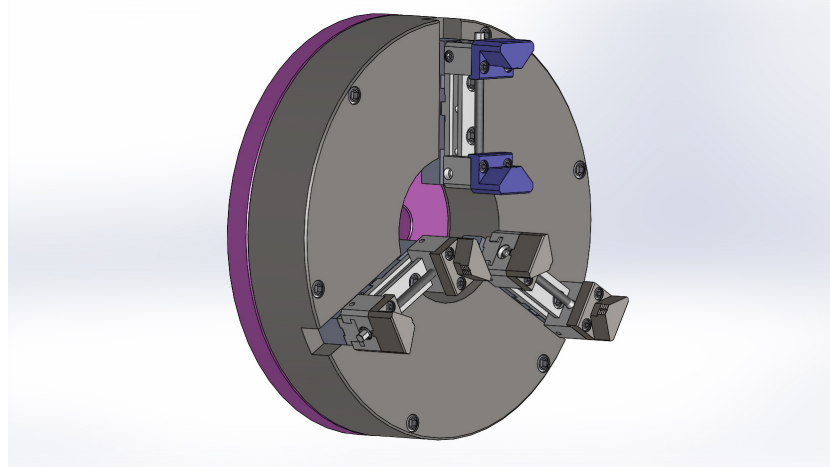


Dimac Pinch Jaws User Instructions

Part Number: DMWR-0215-00 (suit Ø600 Manual Chuck)



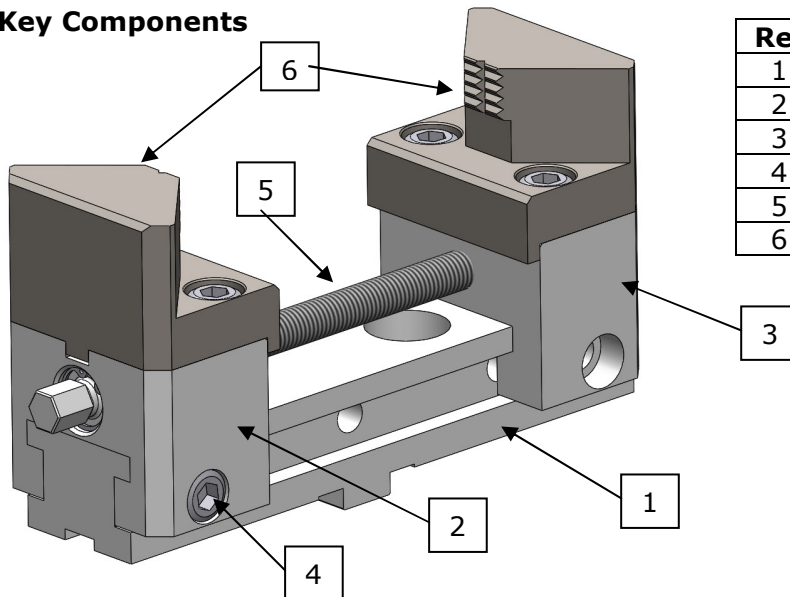
Description of Pinch Jaws

Dimac have developed the Pinch Jaw system as an effective way to grip thin walled or easily distorted products in a manual chuck for turning operations.

Our Pinch Jaw design offers great flexibility for centering, either externally or internally, and gripping of suitable components in a wide range of sizes. The chuck mounting face of the Pinch Jaw is an industry standard American cross tenon suited to a particular size of manual chuck.

The gripper side of the Pinch Jaws accepts Dimac Top Jaws (6) and these can be standard grip jaws or configured to suit a particular application

Key Components



Ref	Description
1	Base
2	Slide Jaw - Anchored
3	Slide Jaw - Nut
4	Slide Jaw Lock Bolt
5	Leadscrew
6	Top Jaw

How to use the Pinch Jaw System

Mount the Pinch Jaws to the cross tenon on the chuck. The Pinch Jaws can be mounted in one of two orientations 180° apart. Choose the orientation that allows best access to the drive hex on the end of the leadscrew, either outward facing for external access or inward facing internal access.

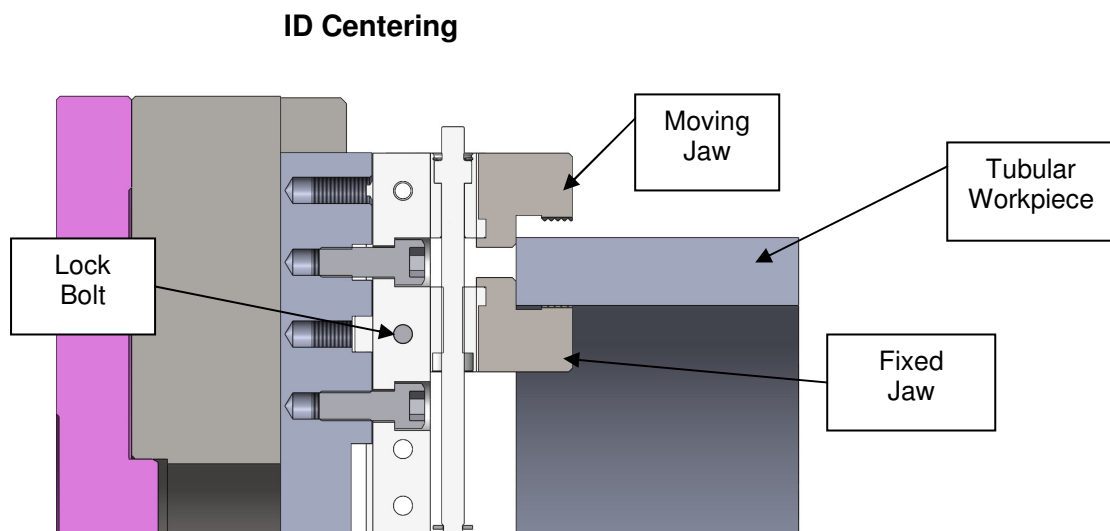
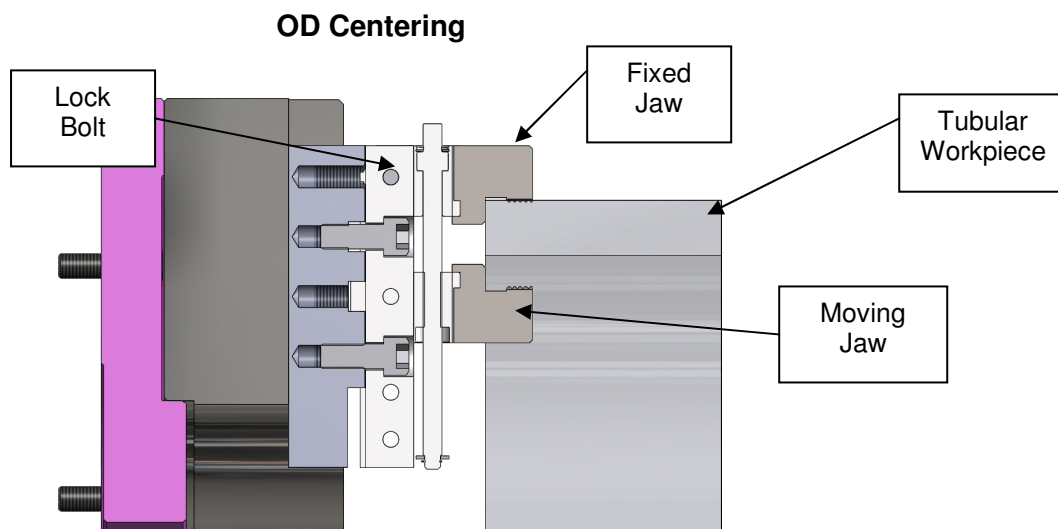
Move the Slide Jaw Lock Bolt (4) to fix the Pinch Jaw (2) or (3) that will be doing the centering, either internal workpiece centering or external workpiece centering, see diagram below of each method noting location of Slide Jaw Lock Bolt (4).

Operate the Leadscrew (5) to open the Movable Jaw sufficiently to allow loading of the workpiece

Operate the manual chuck to lightly engage the Fixed Jaw to the workpiece. It is vitally important the no excessive force is applied from the chuck to the Fixed Pinch Jaw. This is a centering operation only, not a gripping operation. The Pinch Jaw System is not designed or expected to take the gripping force of the chuck, the chuck is for centering or positioning of the workpiece, all the gripping force on the workpiece comes from the closing of the Pinch Jaws onto the workpiece.

While still supporting the workpiece, to ensure it is square or on centreline, then operate each Pinch Jaw Leadscrew (5) to grip the workpiece.

Check for run-out prior to machining. The Pinch Jaws are designed for machining difficult thin walled components and are not intended for heavy duty material removing.



Please contact Dimac Tooling on 03 9561 6155 if you have questions or require further application information.

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