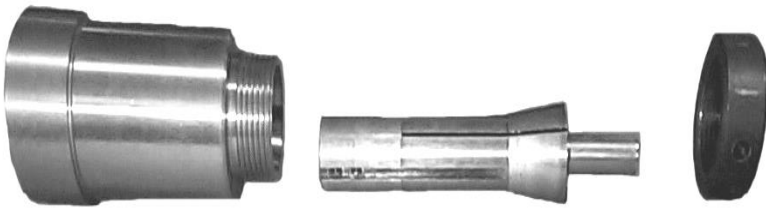


“Spring Collets Only” ... does not work for solid tool holders!

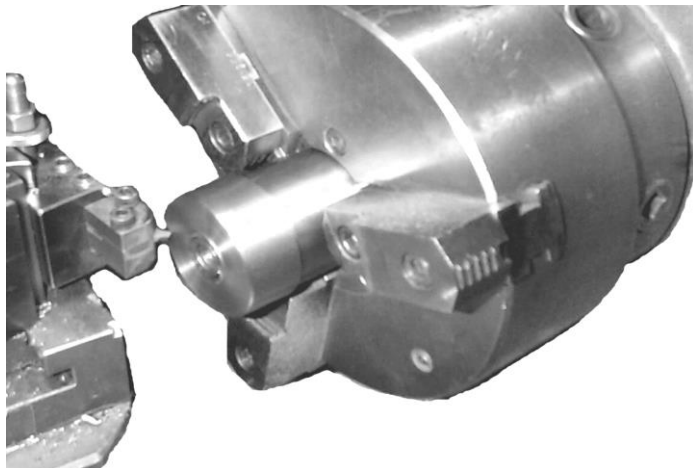
The gage is set for spring collets that use collet closers and will not work on solid holders because Collet Closers add about $\frac{1}{2}$ " to the length figured into gage & solid tool holders don't use Collet Closers so there's about a $\frac{1}{2}$ " to be machined off and that can't be done with this facing fixture... only collets because there's not much coming off. Solid tool holders need to be sent to Mach-1 System to be modified because there is about $\frac{1}{2}$ " to be removed



To convert standard R-8 collets to be used with the MACH-1 Tooling System, the length of the collet must be qualified to $\pm .005$ to the front of the facing fixture. Slide a gage pin that corresponds with the collet size into the collet. Then slide the collet into the facing fixture. Use the cover of a collet closer that came with the tooling system to secure the collet in the fixture.



Example: if you are facing a $\frac{1}{2}$ " collet you should have a $\frac{1}{2}$ " pin in the collet. You need to have the corresponding pin with the collet or the collet will not qualify correctly. Once you have secured the collet in place with the correct pin size in the collet you are ready to face the collet to length.



Place the collet facing fixture in the chuck of a lathe so that the threads of the R-8 collet can be faced. This is the end of the collet that will get qualified. Before starting the lathe, touch the facing tool to the front of the fixture and move away $.002$ so the fixture does not get cut. Now you are ready to cut away any material that may extend beyond the facing fixture.

If the collet does not extend beyond the fixture, then you will need to measure the drop from the face of the fixture to the top of the collet and record your reading. Write your reading on the collet with a marker.



Once you have faced all your collets to length, you're ready to install the pull stud. Clean the collet and pull stud threads so they are free of oil. Next apply loctite thread locker to the pull stud and screw it into the collet. Tighten with pliers and let set.

If your collet was shorter than the fixture, set a feeler gage to that dimension, apply thread lock (Loctite 271 RED) to the pull stud threads and screw pull stud down until it bottoms out on feeler gage. Remove feeler gage and let set.

MACH-1 Systems does not guarantee concentricity for collets retrofit with pull stud.