



SAFETY CHUCK

PHASE A : INSTALLATION

1. Ensure correct Shaft and Journal size
2. Align Chucks
3. Loaded Roll Support

PHASE B : OPERATION

1. Before Each Operation
2. To Operate the Chuck

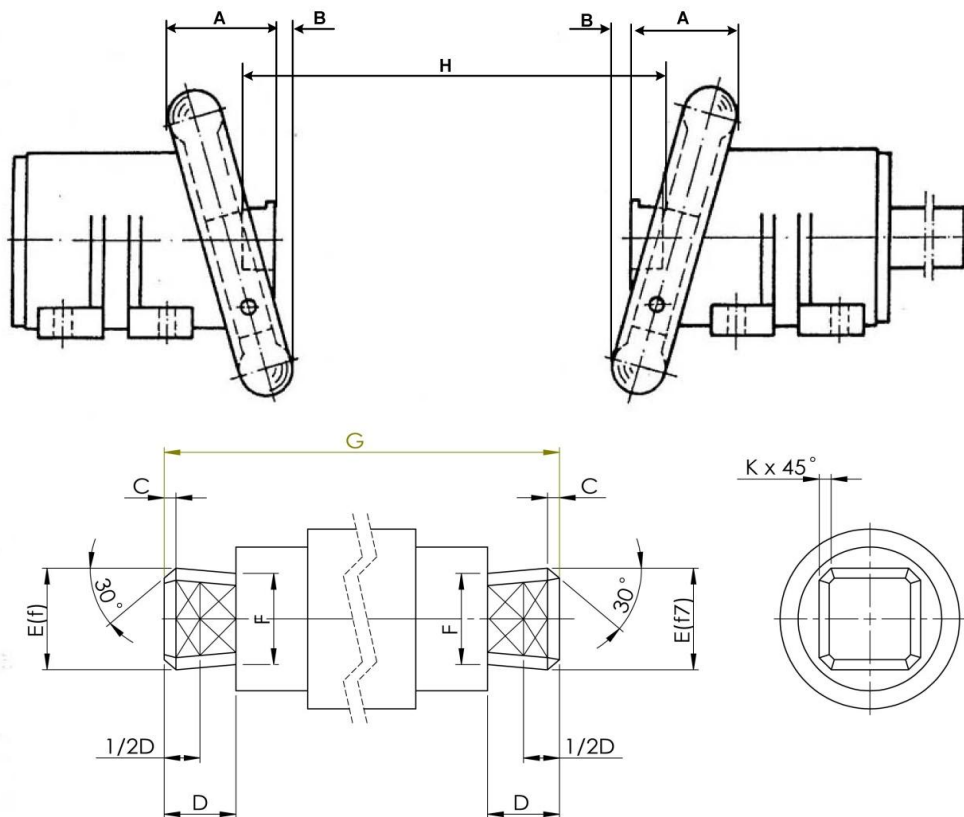
PHASE C : MAINTENANCE

1. Preventive Maintenance
2. Troubleshooting
3. Spare Parts

1. Ensure correct Shaft and Journal size

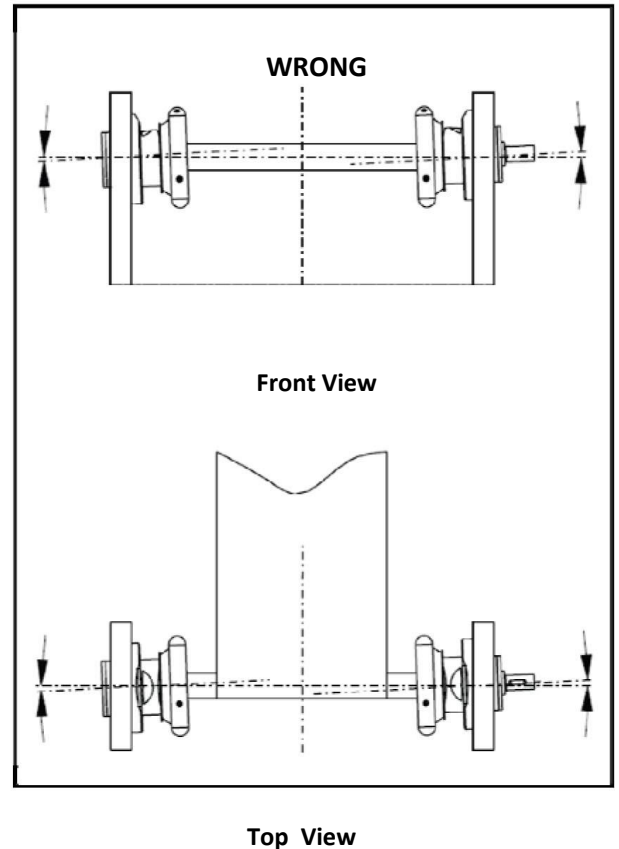
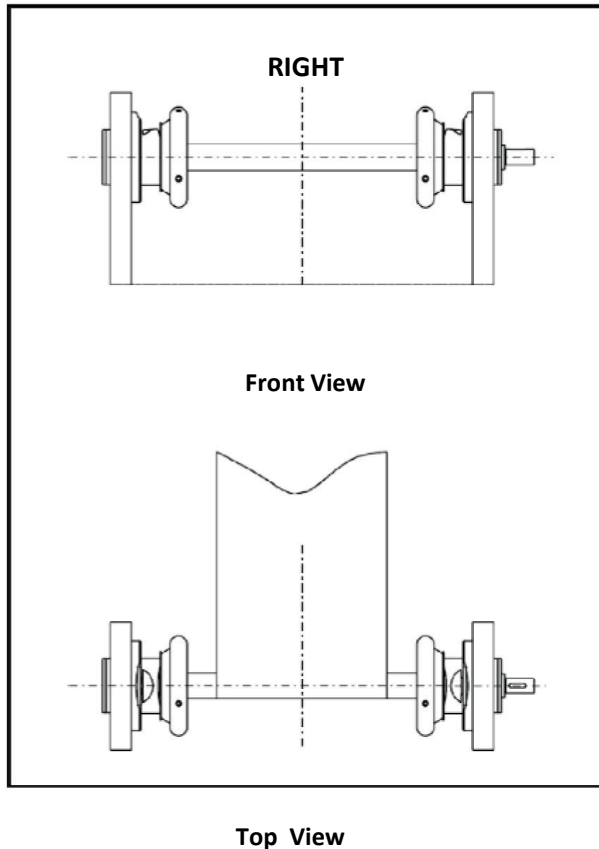
- * Due to close tolerances and the exact manufacture of these chucks, it is important to machine the shafts and journals to the dimensions below.
- * The recommended clearance between the back of the chuck socket and the end of the shaft journal is 0.5mm (0.25mm each side).

METRIC									
Size	A	B	C	D	E (f7)	E-F	½ D	H-G	K
19	54	9	3	24	19-25	0.1	12	0.5	1
28	61	8	4	28	22-30	0.15	14	0.5	1
35	73	13	5	30	30-40	0.2	15	0.5	1.5
50	81	13	5	32	40-50	0.3	16	0.5	2
75	106	16	6	40	50-80	0.4	20	0.5	3



2. Align Chucks

- * Misalignment of chucks can substantially reduce the usable life of this products.
- * Ensure the two chucks are aligned – in both axes – within 0.3°.
- * See illustration below.



3. Loaded Roll Support

- * Deflection of the mounting frame or the shaft under load can substantially reduce the usable life of this products.
- * Make sure that the machine frame is sturdy enough to maintain a true horizontal centerline for rotation.
- * Ensure that the shaft is designed to support all wound roll configurations with minimum deflection.

1. Before Each Operation

- * The Safety Chuck is designed to operate at optimal levels when all fasteners are installed and tightened to recommended torque values. Before operation, check for damaged or missing fasteners. If any fasteners are damaged or missing, please contact us or our agent :
- * We recommends closing the hand-wheel manually before operating to ensure positive locking during operation. The automatic closing feature is a safety backup if chucks are mistakenly left open. Always close chucks manually to avoid premature wear on chuck parts.
- * Before operating the chucks for the first time , make sure that the hand-wheels close easily.
- * After closing the hand-wheels, it must be easy to turn the winding bar in any position.
- * We requires hand-wheel locks for chucks operating in a turret winder.

2. To Operate the Chuck

- * Manually tilt back the hand-wheel to open the chuck.
- * Load the shaft. When installing the shaft, it is important to place the shaft straight into the chucks. The shaft should be level and the journals should enter chucks at the same time.
- * Manually return the hand-wheel to the upright position to close. Always close chucks manually to avoid premature wear on chuck parts.
- * Open chucks by rotating chuck until the socket is at the 12 o'clock position, and then push the closing ring open with an open hand.
- * When removing the shaft, it is important to lift the shaft straight out of the chucks. The shaft should be level and the journals are lifted out of both chucks at the same time.

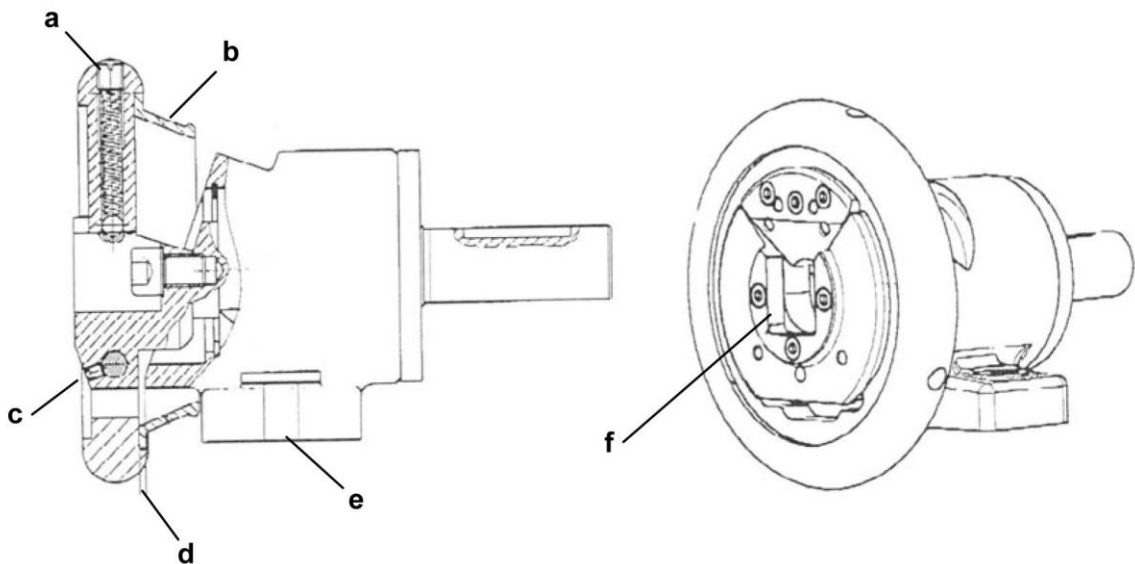
CAUTION

Pinch hazard

Do not contact the chucks while in operation
Do not place your hands behind the finger guard.

Safety Check Inspection

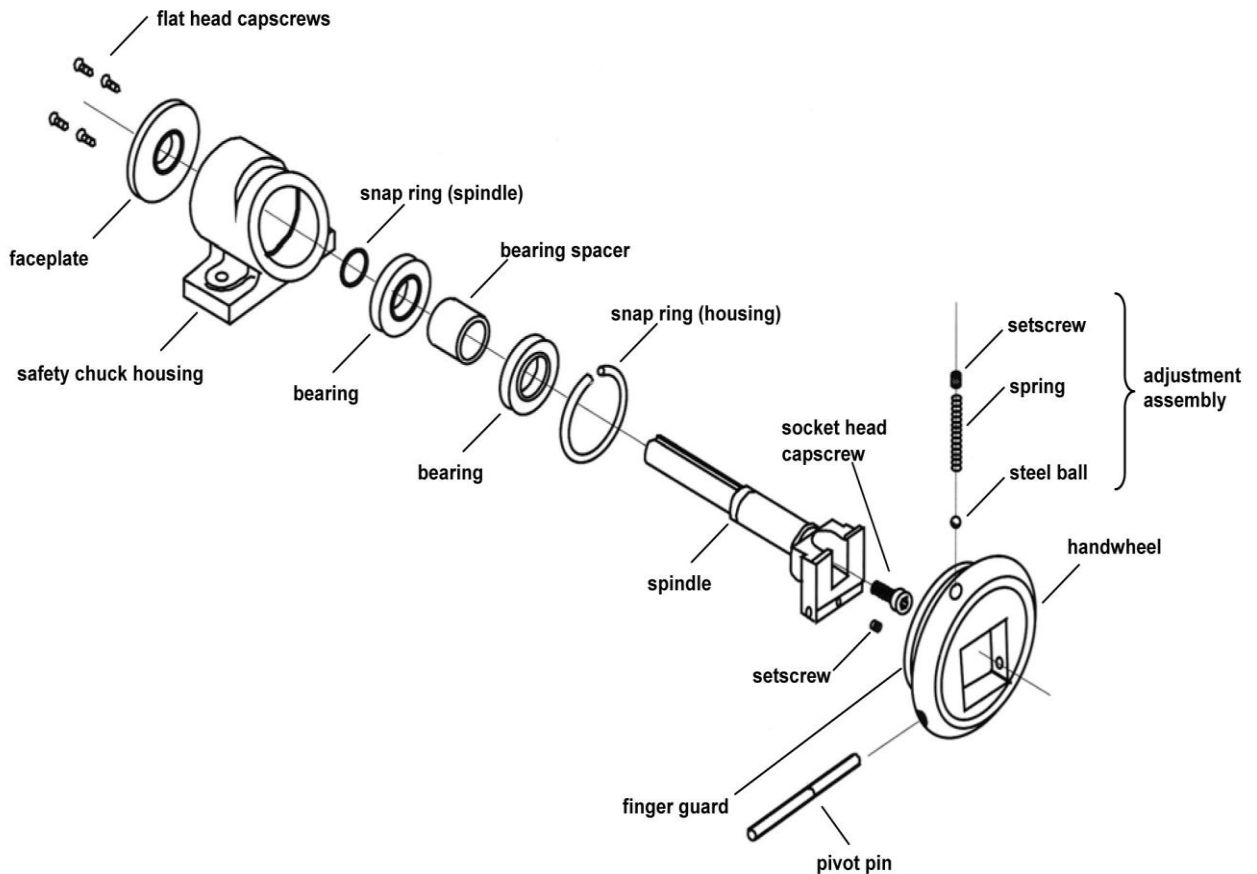
- * Is the adjustment assembly functioning correctly ?.....(a)
- * Is the finger guard in place ?(b)
- * Is the pivot pin centered and tight ?.....(c)
- * Is the safety chuck housing without wear ?
If the chuck will not stay closed , or there is evidence of metal shavings under the chuck, the housing is worn. Don not operate if the chuck will not stay closed.
- * Is the chuck mounting tight ? (e)
- * Is the square pocket worn ?(f)



Problem	Possible Causes	Recommended Solution
Chuck opens during operation	<ol style="list-style-type: none"> 1. The hand-wheel was not closed manually or was not closed correctly. 2. The shaft is bending more than 0.4° at the end of the journals. 3. Chucks are misaligned. 4. Shaft is too short.. 	<ol style="list-style-type: none"> 1. Manually close the hand-wheel completely before each operation. 2. Contact us 3. Align chucks 4. Properly size shaft to chuck spacing.
Worn Chuck body and hand-wheel	<ol style="list-style-type: none"> 1. Excessive shaft deflection. 2. Shaft overall length is too short. 3. The chuck is misaligned 	<ol style="list-style-type: none"> 1. Contact us 2. Replace shaft 3. Ensure correct chuck installation and correct shaft length
Hand-wheel is not closing or is not closing easily	<ol style="list-style-type: none"> 1. Metal shavings and other debris trapped under the chuck. 2. The shaft is not installed correctly. 3. The hand-wheel pivot pin is bent. 	<ol style="list-style-type: none"> 1. Remove all debris before each operation 2. When installing shaft, make sure to place the shaft straight into the chucks and enter both at the same time 3. Replace hand-wheel pivot pin
Excessive journal wear	<ol style="list-style-type: none"> 1. Wear part is too soft. 2. Chuck are misaligned. 3. Shaft is too short or too long. 4. Journal dimensions are undersized or worn. 	<ol style="list-style-type: none"> 1. Contact us 2. Align chucks 3. Properly size shaft to chuck spacing 4. Replace journal
Excessive socket wear	<ol style="list-style-type: none"> 1. Wear part is too soft. 2. Journal dimensions are undersized or worn. 	<ol style="list-style-type: none"> 1. Contact us 2. Replace journal
Clanking noise when running	<ol style="list-style-type: none"> 1. Socket is worn. 2. Journal dimensions are undersized or worn. 	<ol style="list-style-type: none"> 1. Replace socket 2. Replace journal

Please refer to the size and type of safety chuck when ordering spare parts

- * **Hand-wheel & Pivot Pin**
the spindle must also be replaced with the hand-wheel.
- * **Finger Guard**
- * **steel ball, spring, setscrew- adjustment assembly**
- * **Optional replacement inserts to accommodate a spindle with a different journal configuration or size**





SAFETY CHUCK