



Pull Back HRG Collet Chuck

Setup manual

IMPORTANT NOTE:

Before you use the product,
please read instructions carefully.
Keep the instructions on file.



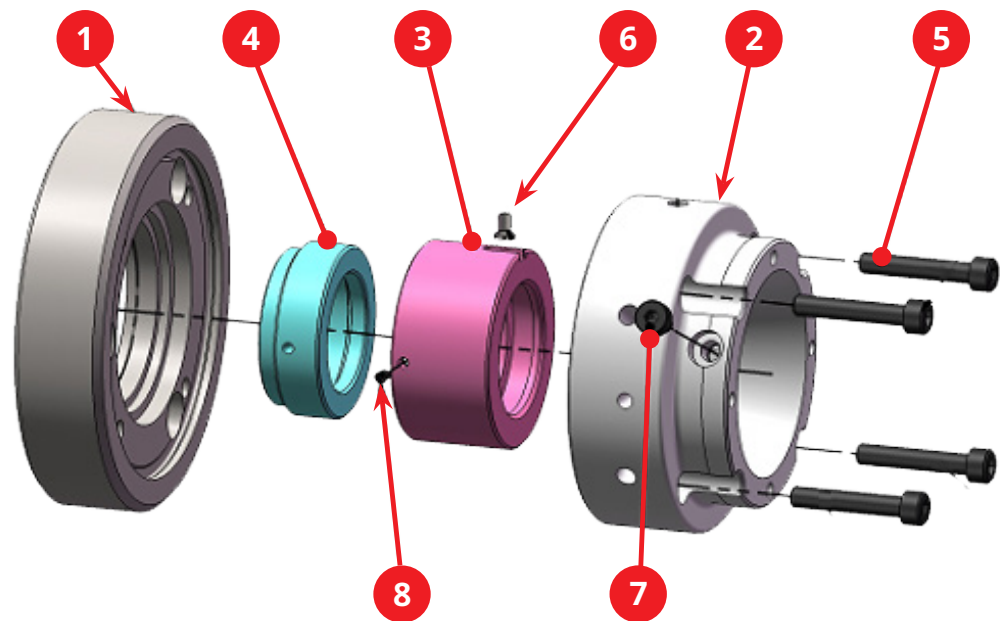
Scan to view
Pull Back Collet Chuck
Installation



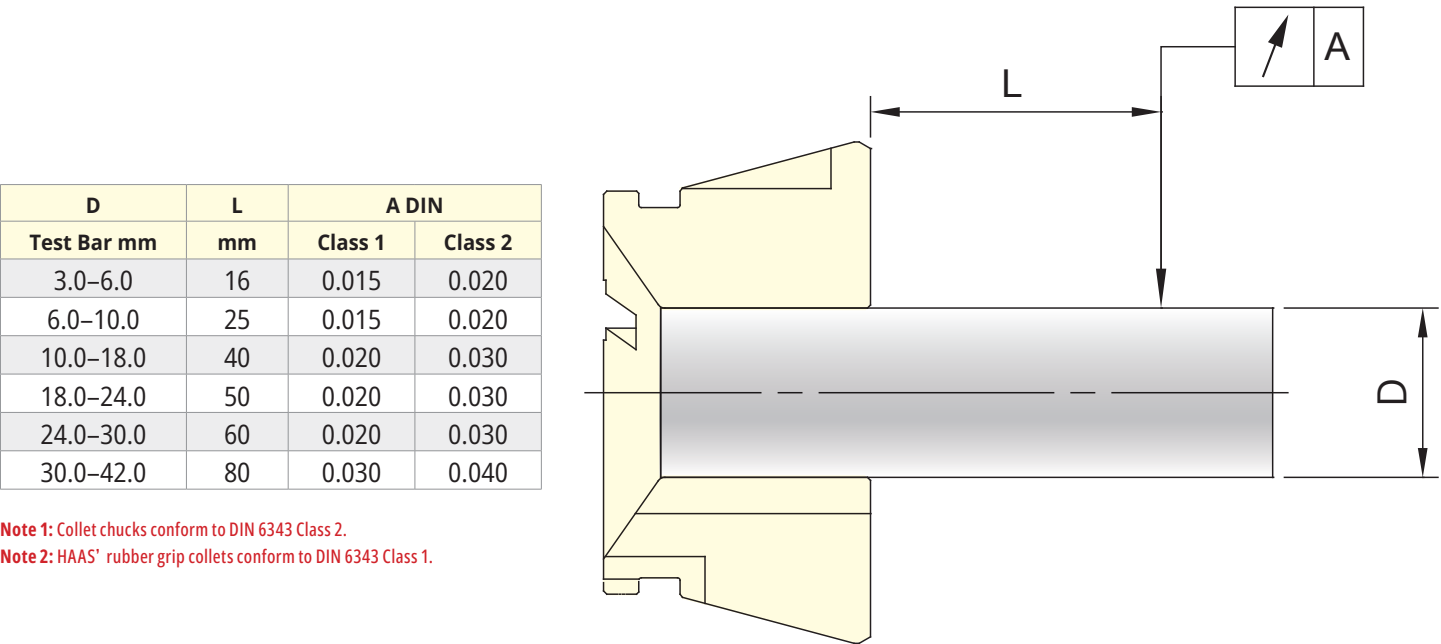
PULL BACK COLLET CHUCK

			MAX. CHUCKING CAPACITY								
Model		Plunger stroke	Round	Hex	Square	Max. D.B. pull	Max. clamping force	Max. speed	Weight	Matching steel collet	Max. pressure
			mm	mm	mm	mm	kN (kgf)	kN (kgf)	min ⁻¹ (r.p.m.)		(kg)
HRG-42	A5	4.5	4–42	7–36	7–30	34.3 (3500)	78.4 (8000)	7000	6.2	HRG-42	2.8 (28)

PARTS LIST OF PULL BACK COLLET CHUCK



No.	Name of parts	Qty
1	Adapter plate	1
2	Body	1
3	Wedge plunger	1
4	Draw nut	1
5	Hex. Socket cap bolt	4
6	Pin	1
7	Set bolt	1
8	Hex. socket set screw	1



Note 1: Collet chucks conform to DIN 6343 Class 2.
Note 2: HAAS' rubber grip collets conform to DIN 6343 Class 1.

PULL BACK COLLET CHUCK SETUP STEPS:

TIPS:

*Setting 282 allows users to switch between OD and ID clamping

OD clamping tells the controller the workpiece is clamped when the drawtube is **retracted**

ID clamping tells the controller the workpiece is clamped in the **extended** position

*M14 activates the spindle brake

*M19 orients and holds the spindle in position. It can be used on machines not equipped with a spindle brake

STEP 1.

Lower chuck pressure to around **80 PSI**.
It should be as low as possible but still be able to extend and retract the draw bar.

STEP 2.

Clean **spindle nose** and apply a thin layer of **rust preventative**.
(Check runout within 0.0001 in / 0.003 mm)

STEP 3.

Ensure the **adapter plate is clean** and apply a thin layer of **rust preventative** to the mating surface.

STEP 4.

Align the **spindle nose drive pin** with the recessed holes on the adapter plate and bolt adapter plate down tightening in a cross pattern. (Runout within 0.0002 in / 0.005 mm)
(Use M19 to help tighten bolts)

STEP 5.

Ensure the **draw tube is extended out** and that the pin (item 6) is aligned with the key way in the wedge plunger (item 3).

STEP 6.

Screw the **draw nut and collet chuck body assembly** all the way down until it bottoms out then back off 2-3 full rotations. Verify the pin and key way are still align.

STEP 7.

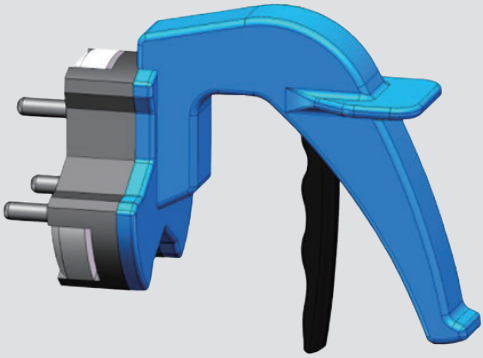
Line up bolts with adapter plate and tighten.
(It may be necessary to use the foot pedal to retract the drawtube) (Measure the T.I.R. within 0.0004 in / 0.01mm)

STEP 8.

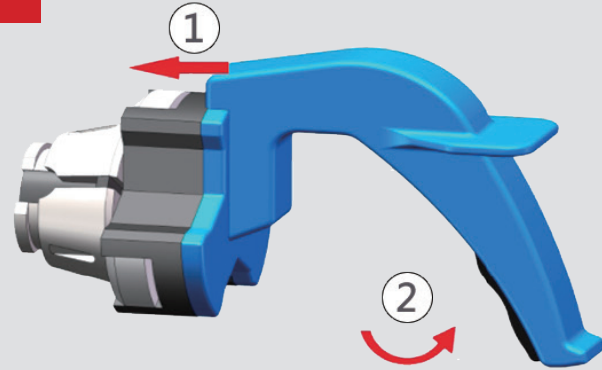
Raise the pressure to your desired **clamping pressure** and Change setting 282 to OD Clamping

USE COLLET CHANGING TOOL TO INSTALL / REMOVE THE COLLET

1.

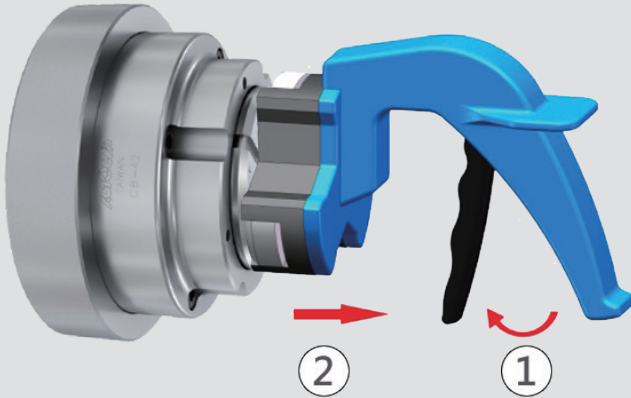


2.



The collet chuck must be unclamped before proceeding to step 3

3.



- **Tighten the mounting bolts** according to the specified torque.
- **Use included bolts only.**

Bolt size	Tightening torque
M6	12.7 N m (9.4 lb-ft)
M8	38.2 N m (28.2 lb-ft)
M10	72.6 N m (53.5 lb-ft)
M12	106.8 N m (78.8 lb-ft)
M14	170.6 N m (125.8 lb-ft)
M16	250.0 N m (184.4 lb-ft)
7/16"-14	108.5 N m (80.0 lb-ft)

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