

## COLLET CHUCK

# Fixtures

Standard & Short series

\* only inch type

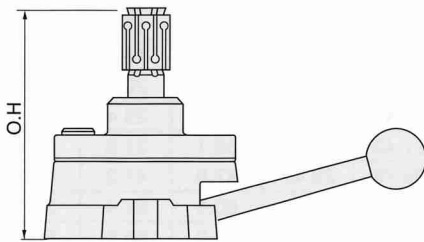


The Tork-Lok Fixture is used with the drawbar models of the Tork-Lok Arbors. This series allows to provide strong work-holding force to the arbors by easy and simple lever operation and suitable for milling, drilling, gear-cutting and other operations.

※ When you fix drawbar type ARBOR to fixture type, refer to below table and instruction.

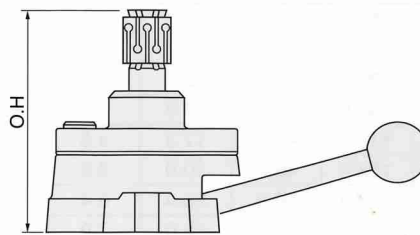
### Dimension diagram

#### Standard [ 5000 type ]



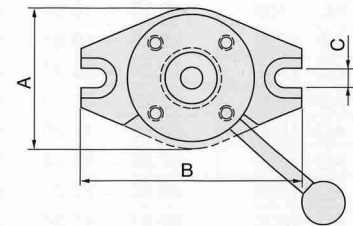
Body No.	O.H.	Arbor ass'y	"C" connector
AC-5110	109.3	AC-2110	AC-172-A
AC-5210	114.3	AC-2210	AC-172-A
AC-5310	121.2	AC-2310	AC-174-A
AC-5410	136.9	AC-2410	AC-472-A
AC-5510	144.8	AC-2510	AC-473-A
AC-5610	151.2	AC-2610	AC-672-A
AC-5710	159.3	AC-2710	AC-672-A

#### Short [ 12000 type ]



Body No.	O.H.	Arbor ass'y	"D" connector
AC-12100	91.9	AC-8100	AC-12272
AC-12200	96.0	AC-8200	AC-12272
AC-12300	100.6	AC-8300	AC-12372
AC-12400	105.7	AC-8400	AC-12472
AC-12500	111.8	AC-8500	AC-12572
AC-12600	120.4	AC-8600	AC-12672
AC-12700	121.7	AC-8700	AC-12672

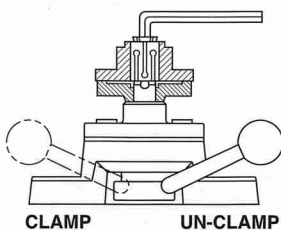
#### Fixture base



Body No.	A	B	C
AC-6100	95.3	162.1	14.3
AC-6400	114.3	174.8	14.3
AC-6600	133.4	196.9	14.3

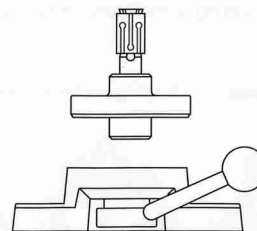
\* Each body model in the above table consists of an arbor, C-type connector, and fixture base.

### How to operate



- 1 Fit FIXTURE on machine.
- 2 Locate lever to an unfastening position and adjust clearance between collet and work-piece after fastening expander by hexagon socket screw key. Confirm that collet is contacting with the flat surface of arbor.
- 3 When clamping work-piece, move handle clock wisely and when unclamping work-piece, move handle anti-clock wisely.

### How to exchange



When exchanging ARBOR after fixing connector suitable for another size of arbor to fixing base on the same fixing position.

- 1 Unfasten fixing screw and clock wisely until arbor separate from position.
- 2 Handle is to be used under unfastening position.
- 3 Turn anti-clock wisely until the arbor to be exchanged contact with upper surface of base. Set the fixing hole and fix with fixing screw.