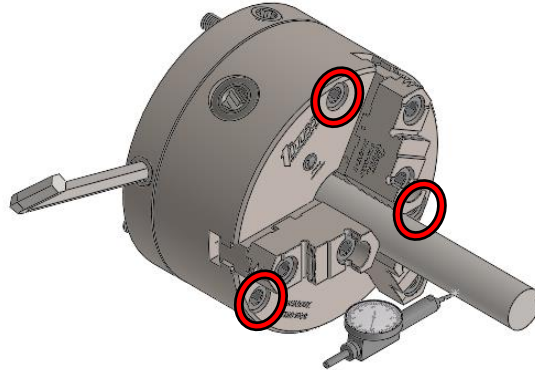


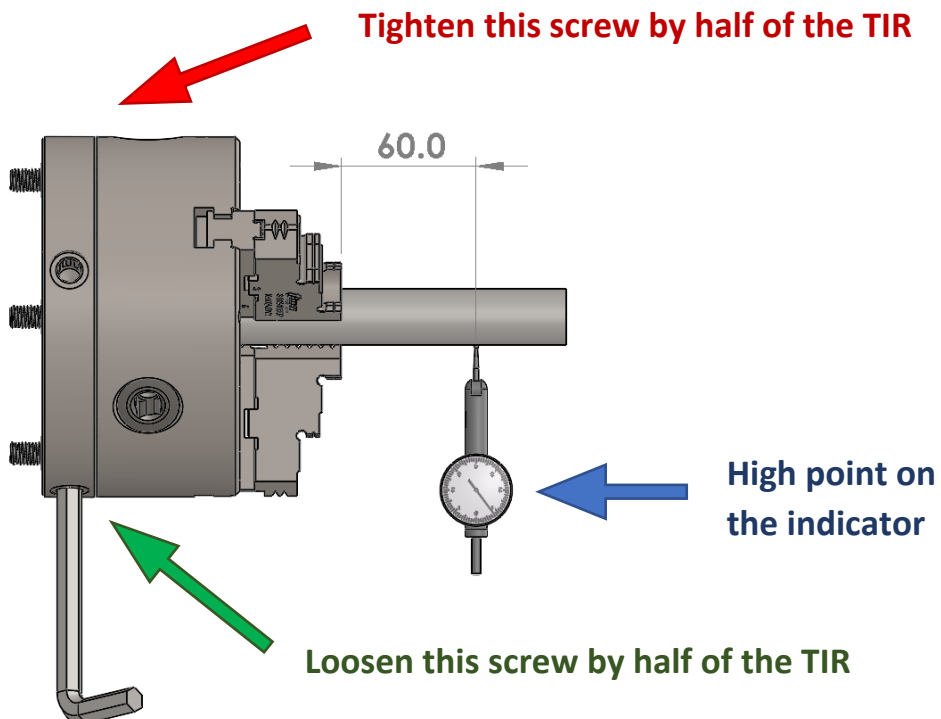
Truing up a TMX SET-TRU™ Chuck

The following guidelines are intended for adjusting the runout of a SET-TRU chuck after it is mounted on the spindle nose using an appropriate adapter plate.

- After Mounting the chuck on the spindle, make sure that the bolts mounting the chuck to the adapter plate are only moderately tight. They should hold the chuck snug on the adapter plate, but still allow for movement when the adjusting screws are turned.



- clamp a round bar in the chuck jaws. **For high accuracy, ground bar stock is preferable.**
- Place a test indicator on your workpiece approximately 60mm from the top surfaces of the chuck jaws and manually rotate the chuck with the workpiece to find high and low points and locations of closest adjusting screws.
- Loosen the the screw **CLOSEST TO THE INDICATOR** by half of the total indicator reading (TIR) error.



- Tighten the screw **OPPOSITE THE INDICATOR** high read-out by half the total TIR
- Repeat the above steps until the desired accuracy is achieved and all four fine adjusting screws are evenly tightened.
- Tighten the bolts mounting the chuck to the adapter plate. The bolts should be tightened evenly.