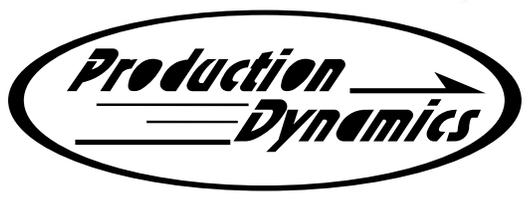


Full Bore Collet Chuck's *When Speed and Accuracy Count*



Lexair, Inc.

Problem Solved.™

FULL BORE *Fixed Length Collet Chucks*

The Lexair Full Bore Chuck is a self-contained, mechanical grip, air release front actuated collet chuck. The chuck does not require an external actuator. Air is used only to open the chuck. Spring force holds the workpiece while it is being machined. Thus, the part remains clamped, even if air pressure is lost. Higher spindle speeds are available since a collet chuck does not have heavy jaws that lose grip force as the spindle speed of the machine increases. Clamping force is adjustable by tightening or loosening the collet using the spanner holes in the front of the collet. The clamp force can also be reduced by removing pairs of springs inside the chuck. The chuck does not require a draw tube, allowing the full inner diameter of the spindle to be utilized.

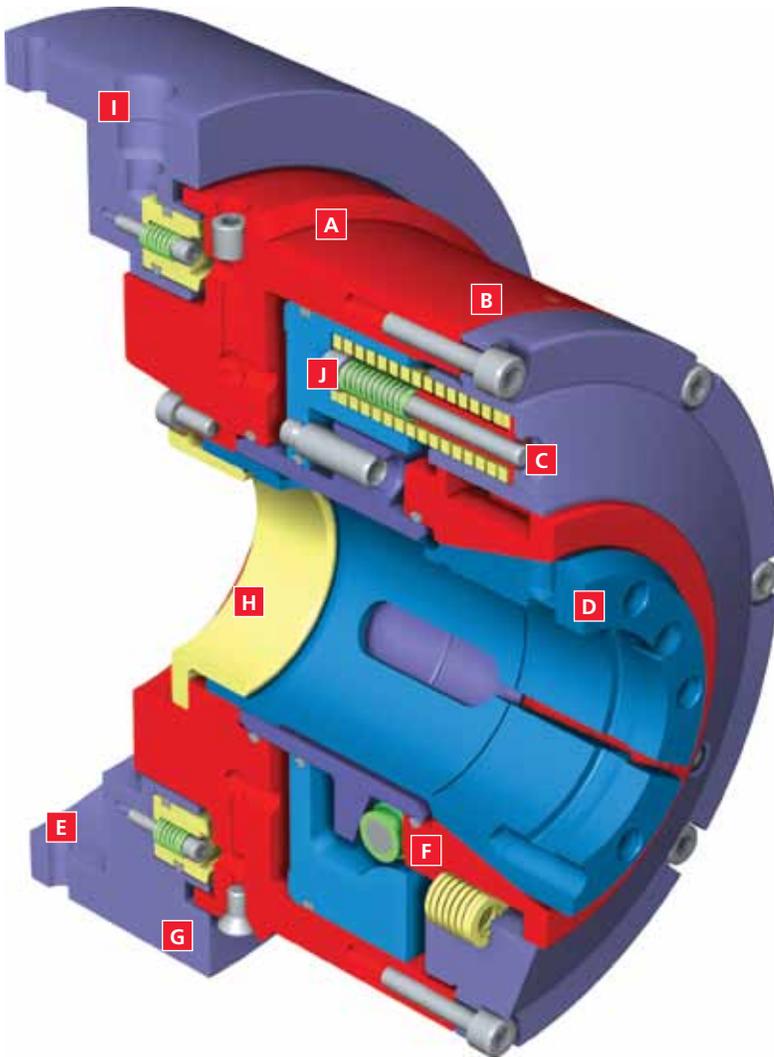


MODEL NUMBER	MASTER COLLET PAD STYLE	CAPACITY USING PADS	SOLID COLLET STYLE	CAPACITY USING SOLID COLLETS	SPINDLE NOSE	WEIGHT LBS.	MAX RPM
FB6-17	S-16	.25-1.625	SPECIAL	.25-1.750	DIN-115	35	6000
FB6-20-B60	S-20	.25-2.00	B60	.25-2.38	A2-5	35	6000
FB6-20	S-20	.25-2.00	SPECIAL	.25-2.00	A2-5	35	6000
FB8-27	S-26	.25-2.63	SPECIAL	.25-2.75	A2-6	55	6000
FB10-32A	S-30	.25-3.00	SPECIAL	.25-3.25	A2-6	85	5000
FB10-32B	S-30	.25-3.00	SPECIAL	.25-3.25	A2-8	90	5000
FB11-40	S-35	.25-3.50	SPECIAL	.25-4.00	A2-8	130	3500
FB14-55	S-50	1.00-5.00	SPECIAL	1.00-5.50	A2-11	235	2500

ALL MEASUREMENTS ARE IN INCHES

COLLET CHUCKS

FULL BORE *Fixed Length Collet Chucks*



A Collet chuck body is shorter than an equal diameter 3 jaw chuck, improving tool clearance.

B Concentricity adjustment for increased accuracy.

C Visual force indicators for clamping force adjustment.

D Master collet utilizing standard "S" style pads.

E Reduced cycle time due to fast chuck actuation

F Constant grip force regardless of speed. As RPM increases, grip force does not change. Allows higher speeds to be used safely.

G *"Open on the fly" feature allows the chuck to be opened while rotating. Reduces cycle times and saves machine wear.

H Full spindle bore available, increasing capacity through the spindle 25-30%.

I Shop air pressure unclamps chuck. Loss of air pressure does not release work.

J Strong dependable die springs provide gripping force.

* For no more than 5 seconds and no more than 500 RPM

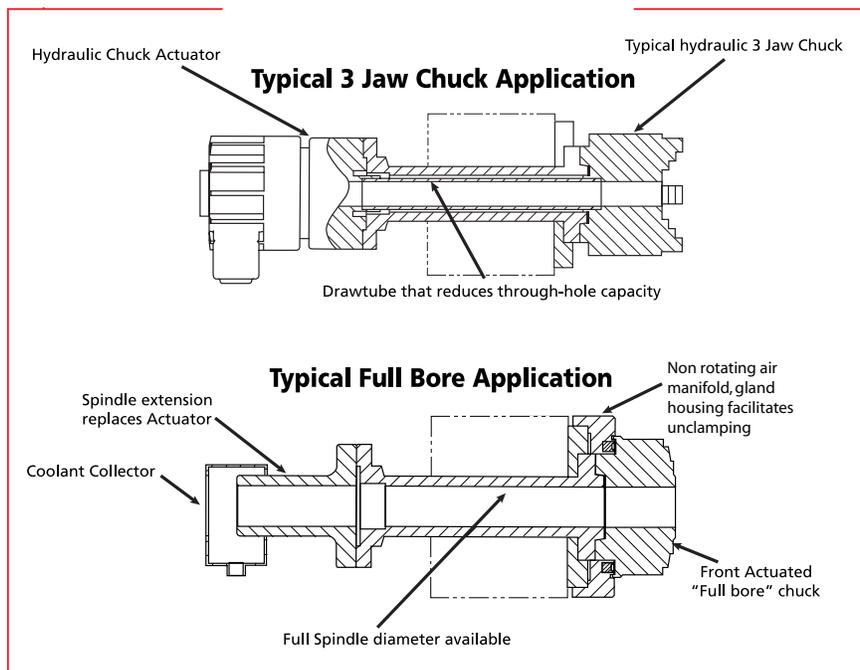
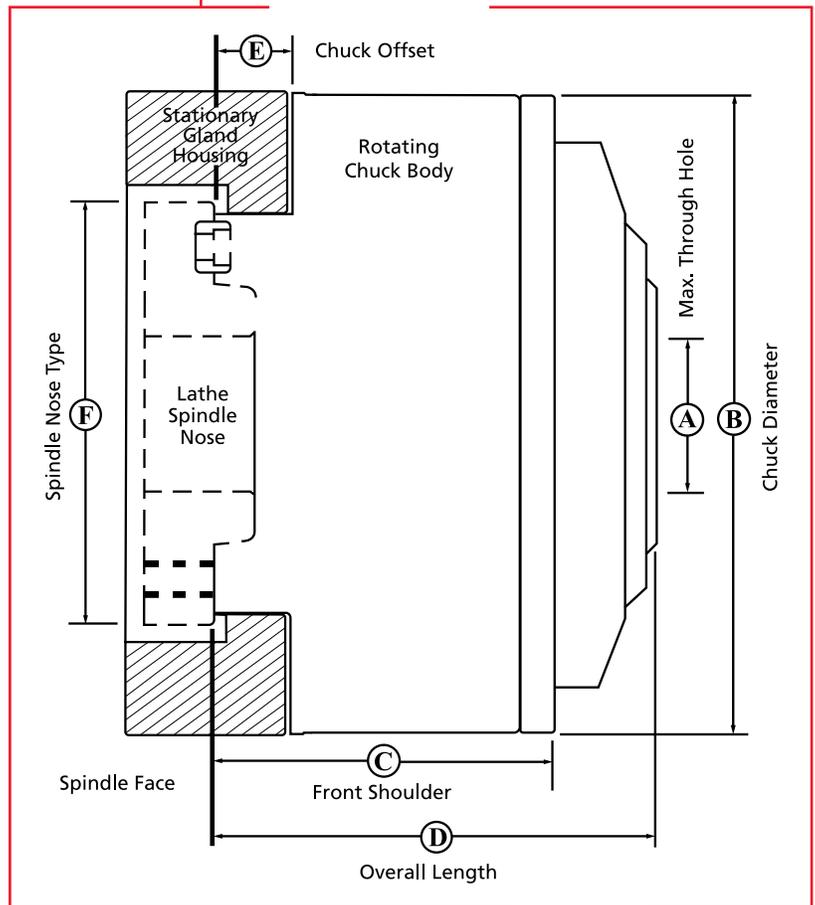
MODEL NUMBER	A	B	C	D	E	F
FB6-17	1.75	6.00	4.21	5.14	.380	DIN-115
FB6-20	2.00	6.75	4.21	5.31	1.0	A2-5
FB6-20-B60	2.00	6.75	4.21	5.31	1.0	A2-5
FB8-27	2.75	8	4.76	5.85	1.5	A2-6
FB10-32A	3.25	10	6.12	6.56	1.5	A2-6
FB10-32B	3.25	10	6.12	6.56	1.5	A2-8
FB11-40	4.00	11	6.90	8.00	1.6	A2-8
FB14-55	5.50	14	8.10	9.25	2.0	A2-11

ALL MEASUREMENTS ARE IN INCHES

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FULL BORE *Fixed Length Collet Chucks*

The gland and gland housing are used to transmit the air to the chuck. When the spindle is stopped and the chuck is opened, a valve admits air into the gland housing, pushing the gland forward against the back of the chuck. The face of the gland seals against the chuck body and allows air pressure to build inside the chuck, forcing the piston forward. The rollers drop back, allowing the pusher to move back and release the collet. When the chuck is closed, the air in the gland housing is vented to the atmosphere. The gland then retracts from the chuck body, and the springs and wedging action of the piston, ramp, rollers, and pusher close the collet on the part.



COLLET CHUCKS