

Operating Instructions

Four-jaw Chuck for

- DB 450
- DB 510 VARIO
- DB 900
- DB 1100
- DB 1202



Four-jaw Chuck Ø 100 mm M33 x 3,5, Set 2

Four-jaw Chuck

Imprit

Produktidentifikation

Four-jaw Chuck	Item number
Ø 100 mm M33 x 3,5, Set 2	5931023

Manufacturer

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Indications regarding the operating instructions

Original operating instructions

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Indications regarding the Copyright

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Subject to technical modifications and error.

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1 Introduction

You have made a good choice by purchasing a HOLZSTAR Four-jaw Chucks Ø 100 mm M33 x 3,5, Set 2.

Carefully read the operating instructions prior to commissioning.

They describe correct commissioning, intended use and safe as well as efficient operation and maintenance of your Four-jaw Chuck.

The operating instructions form part of the Four-jaw Chuck. Keep these operating instructions at the installation location of your Four-jaw Chuck. Also observe the local accident prevention regulations and general safety regulations for the use of the Four-jaw Chuck.

1.1 Copyright

The contents of these operating instructions are protected by copyright. Their application is permitted within the context of the use of the Four-jaw Chuck. Any further use shall not be permitted without written consent by the manufacturer.

For the protection of our products, we shall register trademark, patent and design rights, as this is possible in individual cases. We strongly oppose any infringement of our intellectual property.

1.2 Customer service

Please contact your specialist retailer if you have any questions regarding your Four-jaw Chuck or require any technical information. Your specialist retailer will be happy to support you with specialist advice and information.

Germany:
Stürmer Maschinen GmbH
Dr.-Robert-Pfleger-Str. 26
D-96103 Hallstadt

Repair service:

Fax: 0049 (0) 951 96555-111
E-Mail: service@stuermer-maschinen.de
Internet: www.holzstar.de

Spare parts orders:

Fax: 0049 (0) 951 96555-119
E-Mail: ersatzteile@stuermer-maschinen.de

We are always interested in valuable experience and knowledge gained from using the application, which-then could be shared and be valuable to develop our-products even further.

1.3 Limitation of liability

All data in these operating instructions has been compiled on the basis of the state-of-the-art, valid standards and guidelines as well as our many years of expertise and experience.

The manufacturer shall not be liable for damage in the following cases:

- Non-observance of these operating instructions
- Unintended use
- Deployment of untrained staff
- Conversions at one's own responsibility
- Technical modifications
- Use of unauthorised spare parts

The actual scope of delivery may deviate from the descriptions and illustrations in this document as a result of special variants, optional extras or recent, technical modifications.

The obligations defined in the supply contract shall apply in addition to the general terms and conditions and the manufacturer's general terms and conditions as well as the statutory regulations valid at the time of the conclusion of the contract.

2 Safety

This section provides an overview of all important safety packages for personal protection as well as safe and reliable operation. The sections on individual service life phases contain additional, specifically applicable safety information.

The following safety instructions must be observed:

- Read and understand the operating instructions. Learn about their applications and limitations as well as their specific potential hazards.
- Never work under the influence of concentration disturbing illnesses, fatigue, drugs, alcohol or medication.
- Wear tight-fitting work clothes, safety goggles, respiratory protection, safety shoes and hearing protection. Tie up long hair. Do not wear watches, bracelets, chains, rings or gloves when working (rotating parts!).
- Switch the machine off and disconnect it from the power supply before mounting, dismantling, repairing or cleaning the four-jaw chuck.
- Before each use of the machine, make sure that no parts are damaged. Damaged parts must be replaced immediately to avoid sources of danger.

- The clamped material must not be too unbalanced to prevent it from being thrown out.
- Remove all locking levers and Allen keys from the lathe and chuck to avoid accidental injury. Before turning on the lathe, make sure that the chuck has sufficient clearance by turning it manually.
- Protect the machine from moisture (danger of short circuits!).
- Make sure that the chuck and live center are correctly aligned before you start working.
- Make sure that the four-jaw chuck is securely installed. Use the two locking levers to lock the chuck to the spindle of the woodworking machine.
- Do not make any turning operations with a damaged workpiece that is split or cracked. Risk of injury!



ATTENTION!

For reasons of operator safety, the clamping jaws must not protrude beyond the machine when chisels are used.

3 Intended Use

The Four-jaw Chuck Ø 100 mm M33 x 3.5, Set 2 is intended exclusively for mounting on a compatible HOLZSTAR brand lathe.

Intended use also includes compliance with all the information in these instructions.

4 Technical Data

Model	Four-jaw Chuck Ø 100 mm M33 x 3,5, Set 2
Mounting clamping area outside	48 – 80 mm
Mounting clamping area inside	38 – 73 mm
Outside clamping range for interchangeable jaws	22 – 74 mm
Mounting clamping area inside for interchangeable jaws	7 – 32 mm

5 Transport, packaging, storage

5.1 Delivery and Transport

Check the Four-jaw Chuck after delivery for visible transport damage. If you discover any damage to the Four-jaw Chuck, report it immediately to the transport company or the dealer.

5.2 Packaging

All packaging materials and packaging aids of the device are suitable for recycling and must always be disposed of using material-based recycling systems.

Packaging materials made of cardboard must be shredded and disposed of as part of waste paper recycling.

The foils are made of polyethylene (PE), padding is made of polystyrene (PS). Dispose of these substances at a recycling centre or hand them over to the relevant waste disposal company.

5.3 Storage

The Four-jaw Chuck must be thoroughly cleaned before it is stored in a dry, clean and frost-free environment.

Ambient temperature range: -25 ° C to +55 ° C.

6 Description of device

Illustrations in this manual may differ from the original.



Fig. 1: Four-jaw Chuck

- 1 Screw set
- 2 Thread mount, external clamping range 50-90 mm
- 3 Thread mount, internal clamping range 38-73 mm
- 4 Replaceable jaws

7 Assembly and Operation



ATTENTION!

Before starting cleaning and assembly work, switch off the machine and disconnect the mains plug.

7.1 Mounting and securing the chuck to the wood lathe spindle

To mount the four-jaw chuck on the spindle of the wood-working machine, carefully screw the adapter and the chuck onto the spindle until it stops. Place the lever (A, Fig. 2) in the hole of the jaw chuck and the second lever in the spindle flange hole as shown in Fig. 2. To secure the chuck, turn the two levers clockwise until the adapter face (B, Fig. 2) contacts the spindle flange (C, Fig. 2). To release the chuck, turn the levers counterclockwise.

Opening and closing the clamping jaws (D, Fig. 2) also requires both levers (A, Fig. 2). Place one lever in the hole (E, Fig. 2) and the second lever in the chuck hole. To open the jaws, turn the two levers counterclockwise. To close the jaws, turn the levers clockwise.

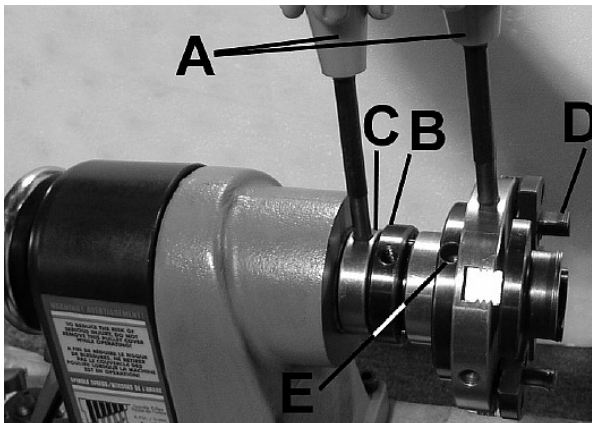


Fig. 2: Assembly of the jaw chuck

7.2 Changing the chuck jaws

To change the standard chuck jaws already mounted to the outer jaws, loosen the 2 cap screws (A, Fig. 3) which fix each jaw to its jaw base. Take the outer jaw with the limiting pin (B, Fig. 3) and position it either on jaw base 2 or 4 (C, Fig. 3). The limit pin (D, Fig. 3) engages in the slot (E, Fig. 3) in the chuck body.

This prevents the positioning of the outer jaw on jaw base 2, so that the jaws do not protrude from the chuck.

Check the jaw numbers against the jaw base numbers and secure the outer jaws with only 1 cap screw per jaw.

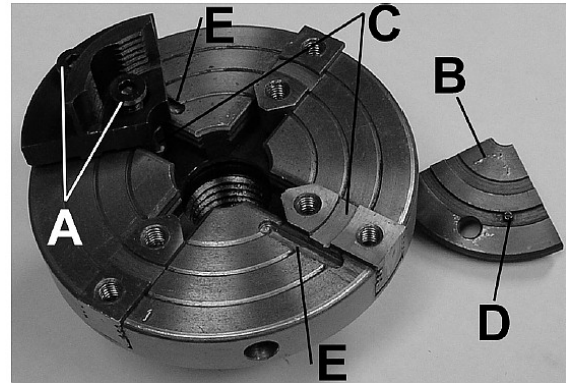


Fig. 3: Changing the chuck jaws

7.3 Clamping a workpiece in the chuck

To clamp a workpiece in the chuck, open the clamping jaws. Position the workpiece in the center so that the jaws are evenly distributed on the workpiece. Tighten the jaws enough to prevent the workpiece from slipping or twisting.

7.4 Removing the adapter

If necessary to remove the adapter, loosen and remove the 3 cap screws that secure it. Screw 2 of the cap screws into the 2 previously unused threaded holes in the adapter. These two cap screws lift the adapter by tightening the two screws one by one until the adapter slowly loosens.

8 Disposal, recycling of old equipment

In your own interests and in the interests of the environment, please ensure that all components of the machine are disposed of in the proper and approved way.

8.1 Decommissioning

Disused machines must be decommissioned immediately to prevent misuse at a later point and putting the environment or persons at risk.

Step 1: Remove all environmentally hazardous fluids from the old machine.

Step 2: If necessary, dismantle the machine into manageable and usable assemblies and components.

Step 3: Guide the machine components and operating materials to the appropriate disposal routes

8.2 Disposal of lubricants

The disposal instructions for the lubricants used are provided by the lubricant manufacturer. If necessary, ask for the product-specific data sheets.

9 Spare parts



DANGER!

Risk of injury caused by the use of incorrect spare parts!

The use of incorrect or faulty spare parts may cause risks for operating staff and damage as well as malfunctions.

- Exclusively genuine spare parts made by the manufacturer or spare parts authorised by the manufacturer shall be used.
- Always contact the manufacturer if you are unsure.



Tips and recommendations

Using non-approved spare parts voids the manufacturer's warranty.

9.1 Spare parts order

Spare parts are available from authorised retailers.

The following key data is required for queries or spare parts orders:

- Device type
- Item number
- Position number
- Year of construction
- Quantity
- Desired shipping type (post, freight, sea, air, express)
- Shipping address

Spare parts orders without the aforementioned data cannot be taken into account. The supplier shall determine the shipping type if no relevant data was provided.

Data on the machine type, item number and year of manufacture is listed on the type plate attached to the device.

Example

The handle for the Four-jaw Chuck Ø 100 mm M33 x 3,5, Set 2 must be ordered. The handle is identified in the spare parts drawing with the number 14.

When ordering spare parts, send a copy of the spare parts drawing with marked component (handle) and marked position number (14) to the authorised dealer or to the spare parts department and provide the following information:

- Type of device: **Four-jaw Chuck Ø 100 mm
M33 x 3,5, Set 2**
- Item number: **5931023**
- Position number: **14**

9.2 Spare parts drawing

The following drawings should help in case of service to identify necessary spare parts. To order, send a copy of the parts drawing with the parts marked to your authorized dealer.

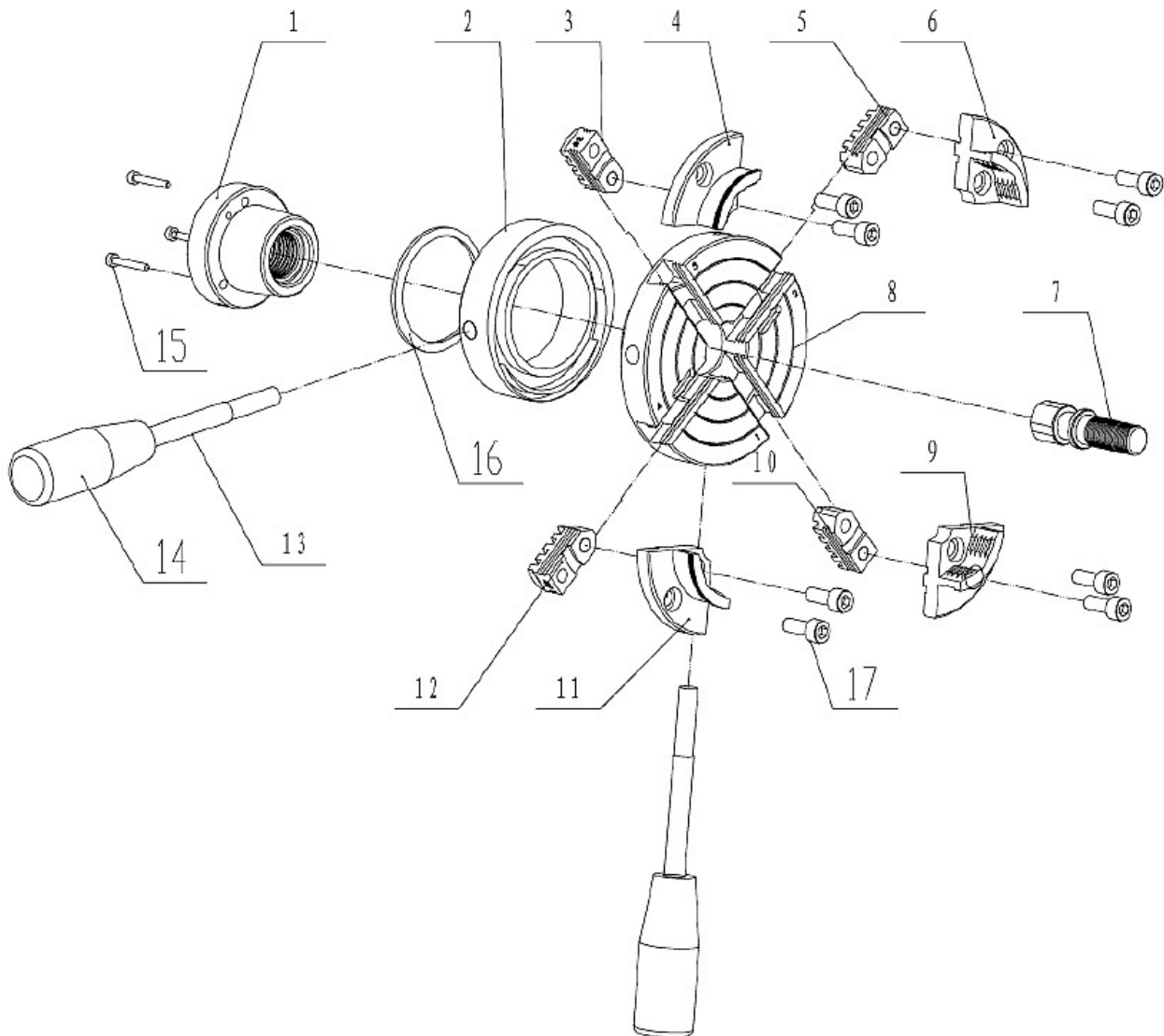


Fig. 4: Spare parts drawing of Four-jaw Chuck

