

Assembly and Operating Manual

Jaw turning fixture

BAV / BSA

Translation of Original Operating
Manual

Imprint

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Technical changes:

We reserve the right to make alterations for the purpose of technical improvement.

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Dear Customer,

Thank you for trusting our products and our family-owned company, the leading technology supplier of robots and production machines.

Our team is always available to answer any questions on this product and other solutions. Ask us questions and challenge us. We will find a solution!

Best regards,

Your SCHUNK team

Customer Management

Tel. +49-7133-103-2555

Fax +49-7133-103-2239

sonderdehnspanntechnik@de.schunk.com



Please read the operating manual in full and keep it close to the product.

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1 General

1.1 About this manual

This manual contains important information for a safe and appropriate use of the product.

This manual is an integral part of the product and must be kept accessible for the personnel at all times.

Before starting work, the personnel must have read and understood this operating manual. Prerequisite for safe working is the observance of all safety instructions in this manual.

In addition to these instructions, the documents listed under Link Mitgeltende Unterlagen are applicable.

NOTE: The illustrations in this manual are intended to provide a basic understanding and may deviate from the actual version.

1.1.1 Presentation of Warning Labels

To make risks clear, the following signal words and symbols are used for safety notes.



⚠ DANGER

Dangers for persons!

Non-observance will inevitably cause irreversible injury or death.



⚠ WARNING

Dangers for persons!

Non-observance can lead to irreversible injury and even death.



⚠ CAUTION

Dangers for persons!

Non-observance can cause minor injuries.

NOTICE

Material damage!

Information about avoiding material damage.

1.1.2 Definition of Terms

The term "product" replaces the product name on the title page in this manual.

1.1.3 Applicable documents

- General terms and conditions*
- Contractual agreements
- Assembly and operating manual of the lathe chuck used

The documents labeled with an asterisk (*) can be downloaded from [schunk.com](https://www.schunk.com).

1.2 Warranty

If the product is used as intended, the warranty is valid for 12 months from the date of delivery from the production facility.

1.3 Scope of delivery

BAV

The scope of delivery includes

- 1 BAV jaw turning fixture
(ID 119100; 119101; 119102; 119103; 119104)
- 1 Assembly and operating manual
(ID 1540578)

BSA

The scope of delivery includes

- 1 BSA jaw turning fixture
(ID 119110; 119111; 119112)
- 1 Ball handle
(ID 9150050)
- 1 Assembly and operating manual
(ID 1540578)

2 Basic safety notes

2.1 Intended use

- The product is used for turning and grinding out chuck jaws.
- The product may only be used and applied within the scope of the information in the technical data, ▶ 3 [12].
- The product may only be used and operated with suitable, prescribed or approved attachment parts.
- The product is intended for industrial use.
- Appropriate use of the product includes compliance with all instructions in this manual.

2.2 Inappropriate use

The product is not being used as intended if, for example:

- The product is not clamped correctly.
- The information in the technical data is not observed when using and operating the product ▶ 3 [12].
- The product is used and operated with non-approved attachment parts.
- The product is used in corrosive media.
- The maintenance and storage instructions are not observed ▶ 6 [30].

2.3 Constructional changes

Implementation of structural changes

By conversions, changes, and reworking, e.g. additional threads, holes, or safety devices can impair the functioning or safety of the product or damage it.

- Structural changes should only be made with the written approval of SCHUNK.

2.4 Spare parts

Use of unauthorized spare parts

Using unauthorized spare parts can endanger personnel and damage the product or cause it to malfunction.

- Use only original spare parts or spares authorized by SCHUNK.

2.5 Environmental and operating conditions

Required ambient conditions and operating conditions

Incorrect ambient and operating conditions can make the product unsafe, leading to the risk of serious injuries, considerable material damage and/or a significant reduction to the product's life span. See also ▶ 3.1 [12].

2.6 Personnel qualification

Inadequate qualifications of the personnel

If the personnel working with the product is not sufficiently qualified, the result may be serious injuries and significant property damage.

- All work may only be performed by qualified personnel.
- Before working with the product, the personnel must have read and understood the complete assembly and operating manual.
- Observe the national safety regulations and rules and general safety instructions.

The following personal qualifications are necessary for the various activities related to the product:

Qualified personnel

Due to its technical training, knowledge and experience, qualified personnel is able to perform the delegated tasks, recognize and avoid possible dangers and knows the relevant standards and regulations.

Instructed person

Instructed persons were instructed by the operator about the delegated tasks and possible dangers due to improper behaviour.

Service personnel of the manufacturer

Due to its technical training, knowledge and experience, service personnel of the manufacturer is able to perform the delegated tasks and to recognize and avoid possible dangers.

2.7 Personal protective equipment

Use of personal protective equipment

Personal protective equipment serves to protect staff against danger which may interfere with their health or safety at work.

- When working on and with the product, observe the occupational health and safety regulations and wear the required personal protective equipment.
- Observe the valid safety and accident prevention regulations.
- Wear protective gloves to guard against sharp edges and corners or rough surfaces.
- Wear heat-resistant protective gloves when handling hot surfaces.
- Wear protective gloves and safety goggles when handling hazardous substances.
- Wear close-fitting protective clothing and also wear long hair in a hairnet when dealing with moving components.

2.8 Notes on safe operation

- Install and clamp the product according to the specifications in this manual.

Incorrect handling of the personnel

Incorrect handling and assembly may impair the product's safety and cause serious injuries and considerable material damage.

- Avoid any manner of working that may interfere with the function and operational safety of the product.
- Use the product as intended.
- Observe the safety notes and assembly instructions.
- Do not expose the product to any corrosive media. This does not apply to products that are designed for special environments.
- Eliminate any malfunction immediately.
- Observe the care and maintenance instructions.
- Observe the current safety, accident prevention and environmental protection regulations regarding the product's application field.

2.9 Transport

Handling during transport

Incorrect handling during transport may impair the product's safety and cause serious injuries and considerable material damage.

- When handling heavy weights, use lifting equipment to lift the product and transport it by appropriate means.
- Secure the product against falling during transportation and handling.
- Stand clear of suspended loads.

2.10 Malfunctions

Behavior in case of malfunctions

- Immediately remove the product from operation and report the malfunction to the responsible departments/persons.
- Order appropriately trained personnel to rectify the malfunction.
- Do not recommission the product until the malfunction has been rectified.
- Test the product after a malfunction to establish whether it still functions properly and no increased risks have arisen.

2.11 Disposal

Handling of disposal

The incorrect handling of disposal may impair the product's safety and cause serious injuries as well as considerable material and environmental harm.

- Follow local regulations on dispatching product components for recycling or proper disposal.

2.12 Fundamental dangers

General

- Observe safety distances.
- Never deactivate safety devices.
- Before commissioning the product, take appropriate protective measures to secure the danger zone.
- Disconnect power sources before installation, modification, maintenance, or calibration. Ensure that no residual energy remains in the system.
- If the energy supply is connected, do not move any parts by hand.
- Do not reach into the open mechanism or movement area of the product during operation.

2.12.1 Protection during handling and assembly

Incorrect handling and assembly

Incorrect handling and assembly may impair the product's safety and cause serious injuries and considerable material damage.

- Have all work carried out by appropriately qualified personnel.
- For all work, secure the product against accidental operation.
- Observe the relevant accident prevention rules.
- Use suitable assembly and transport equipment and take precautions to prevent jamming and crushing.

Incorrect lifting of loads

Falling loads may cause serious injuries and even death.

- Stand clear of suspended loads and do not step into their swiveling range.
- Never move loads without supervision.
- Do not leave suspended loads unattended.

2.12.2 Protection during commissioning and operation

Falling or violently ejected components

Falling and violently ejected components can cause serious injuries and even death.

- Take appropriate protective measures to secure the danger zone.
- Never step into the danger zone during operation.

3 Technical data

3.1 Ambient conditions and operating conditions

Operating temperature range	+18°C to +25°C
Maximum product temperature	+35°C
Storage temperature range	+20°C ±10°C

NOTE: The temperatures refer to the product.

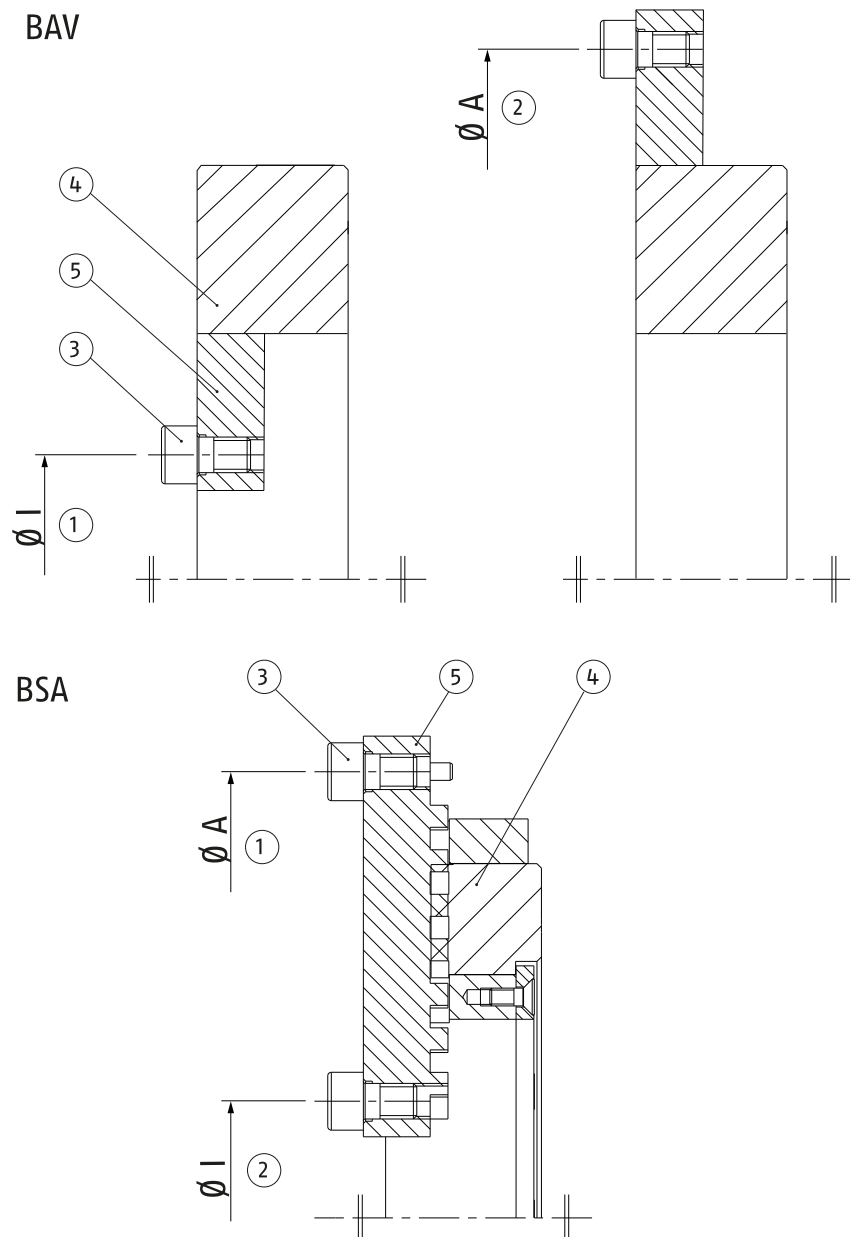
3.2 BAV/BSA

Description	BAV 0	BAV 1	BAV 2	BAV 3	BAV 4
ID	119100	119101	119102	119103	119104
for chuck size	125	200	250	250	315
Outer Ø [mm]	Ø 153	Ø 176	Ø 215	Ø 244	Ø 290
Inner Ø [mm]	Ø 110	Ø 110	Ø 135	Ø 162	Ø 208
Weight [kg]	1.5	3.3	5.2	5.6	6.8
Clamping mounting range Ø A [mm]	Ø 150 to Ø 215	Ø 170 to Ø 260	Ø 215 to Ø 285	Ø 240 to Ø 315	Ø 290 to Ø 360
Clamping mounting range Ø I [mm]	Ø 50 to Ø 115	Ø 35 to Ø 125	Ø 70 to Ø 140	Ø 100 to Ø 175	Ø 145 to Ø 215
Permissible clamping force [kN]	15	30	30	30	30

Description	BSA 10	BSA 20	BSA 30
ID	119110	119111	119112
for chuck size	250	315	400
Outer Ø [mm]	Ø 225	Ø 288	Ø 384
Inner Ø [mm]	Ø 135	Ø 184	Ø 256
Weight [kg]	7.0	11.5	21.0
Clamping mounting range Ø A [mm]	Ø 229 to Ø 305	Ø 292 to Ø 368	Ø 388 to Ø 464
Clamping mounting range Ø I [mm]	Ø 81 to Ø 157	Ø 128 to Ø 204	Ø 208 to Ø 284
Permissible clamping force [kN]	45	60	75

4 Design and description

4.1 Design



NOTE: The illustration may differ from the actual design.

- | | |
|---|----------------------|
| 1 | Inner mounting range |
| 2 | Outer mounting range |
| 3 | Mounting screw |
| 4 | Housing |
| 5 | Adjusting jaw |

4.2 Description of function

The product is used for turning and grinding out chuck jaws.

NOTE: With regard to the max. permissible total clamping force with which the fixture may be clamped, the cutting and machining parameters must be adjusted accordingly.

BAV:

The light BAV design is suitable for low clamping forces up to 30 kN.

The knurled spiral ring is turned by hand. This causes 3 adjustment jaws to move, each of which has a mounting screw attached. The adjusting jaws of the jaw turning fixture are reversible and infinitely adjustable. The mounting range is adjusted by the knurled spiral ring or by turning the adjustment jaws.

1. Turn clockwise: the mounting diameter decreases.
2. Turn counterclockwise: the mounting diameter increases.

ATTENTION: The mounting ranges must not be exceeded, otherwise damage to the turning fixture may occur!

BSA:

Heavy-duty BSA design for high clamping forces up to 75 kN.

The spiral ring is turned by hand via the ball handle supplied. This causes 3 adjustment jaws to move, each of which has a mounting screw attached. The mounting screw can be screwed in internally or externally. The adjusting jaws are **not** reversible. The adjustment range is limited inwards by a clamping sleeve in the adjusting jaw.

1. Turn clockwise: the mounting diameter increases.
2. Turn counterclockwise: the mounting diameter decreases.

ATTENTION: The mounting ranges must not be exceeded, otherwise damage to the turning fixture may occur!

5 Assembly and operation

5.1 Basic information



⚠ WARNING

Risk of injury if the product falls during transport, assembly or disassembly.

Due to the oily surface required to preserve it, the product can slip through your hands, resulting in injury.

- Take appropriate safety measures to prevent the product from falling.
- Wear suitable protective equipment, especially protective gloves and safety boots.



⚠ WARNING

Risk of injury when the product is rotating, due to the possibility of parts flying off!

- Do not exceed the maximum permissible clamping force.
- Make sure that the product is mounted correctly.
- Take suitable protective measures to secure the danger zones.
- Wear suitable protective equipment.



⚠ WARNING

Danger of crushing, impact and cutting when clamping and unclamping the product!

- When clamping and unclamping the product, do not reach between the product and the chuck jaws.
- Prevent unintentional actuation of the lathe chuck.
- Remove sharp edges on the chuck jaws after turning.
- Wear suitable protective equipment, especially gloves.



⚠ CAUTION

Risk of crushing and impact when assembling and disassembling the product.

- Do not reach between the product and the chuck jaws.
- Wear suitable protective equipment.



⚠ CAUTION

Risk of injury from sharp edges and corners!

Sharp edges and corners on the machined chuck jaws can cause cuts.

- Wear suitable protective equipment, especially gloves.

NOTICE

Risk of damage to the product

If the permissible clamping force is exceeded, the product may be damaged.

- Do not exceed the permissible clamping force.


5.2 Application of the product

- Turning or skimming chuck jaws:
If the turning fixture is used for turning or skimming monoblock jaws, it is recommended (for the user) to drill a hole in the flat surface at the front of each jaw. The position of the holes depends on the desired turning area (it is possible to drill to the crack).
- Grinding out clamping jaws:
If the turning device is used for regrinding jaw steps, excessive contamination of the adjusting jaw serration should be avoided (brush off dust from time to time).

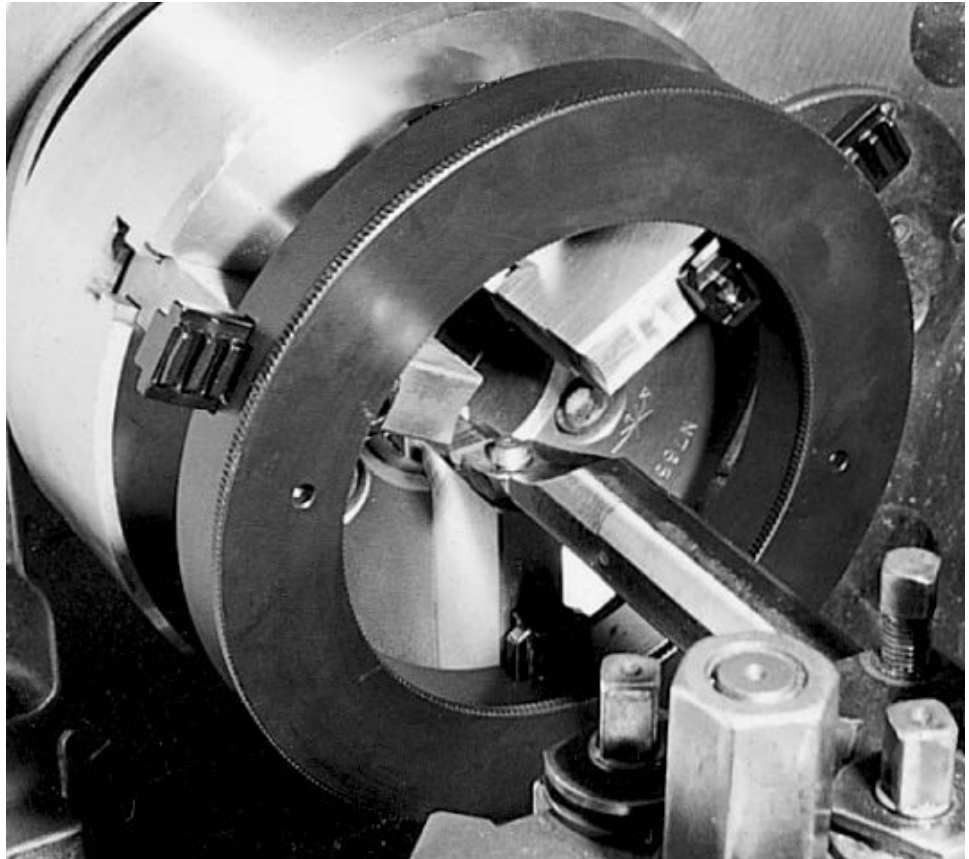
NOTE: With regard to the max. permissible total clamping force with which the fixture may be clamped, the cutting and machining parameters must be adjusted accordingly.

ATTENTION: The mounting ranges must not be exceeded, otherwise damage to the turning fixture may occur!

Grinding chuck jaws

Proceed in the same way as for turning. Avoid excessive contamination of the adjusting jaw serration. Clean serration if a lot of dirt accumulates ▶ 6 [ 30].

5.2.1 BAV – internal turning (for O.D. clamping)



NOTE: The illustration may differ from the actual design.

To clamp the product, proceed as follows:

1. Mount the chuck jaws to be turned according to the specifications in the operating manual of the lathe chuck used.
2. Ensure that the lathe chuck is in an unclamped state. Observe the specifications in the operating manual of the lathe chuck used.
3. Move the jaws of the lathe chuck to be turned to the desired clamping diameter (consider how much material will be removed during turning).
4. Place the turning fixture in the correct position.
5. Insert the adjusting jaws of the jaw turning fixture into the counterbores of the jaws using the adjustment screws until they come into contact.

ATTENTION: The screw heads of the adjustment screws must be inserted into the counterbores of the chuck jaws as far as the stop!

6. Turn the knurled spiral ring counterclockwise until the turning fixture is firmly seated.

7. Clamp the lathe chuck inward according to the specifications in the operating manual of the lathe chuck used (without workpiece). Observe the specifications for the permissible clamping force according to the technical data ▶ 3 [12].
⇒ The product is reliably clamped.

For turning, proceed as follows:

1. Ensure that the product is securely clamped.
2. Pre-turn chuck jaws to the preliminary size.
3. If the results are OK, remove the jaw turning fixture ▶ 7 [32] and make sure that the jaw turning fixture is not misaligned.
4. Remove the pre-turned jaws and deburr them.
NOTE: Select large enough chamfers so that the pre-turned jaws are not sharp-edged even after finish turning.
5. Mount the pre-turned jaws according to the specifications in the operating manual of the lathe chuck used.
6. Clamp the chuck jaws again via the jaw turning fixture according to this assembly and operating manual.
7. Turn the chuck jaws to the finished size.
8. If the results are OK, remove the jaw turning fixture ▶ 7 [32].

5.2.2 BAV - external turning (for I.D. clamping)



NOTE: The illustration may differ from the actual design.

To clamp the product, proceed as follows:

1. Mount the chuck jaws to be turned according to the specifications in the operating manual of the lathe chuck used.
2. Ensure that the lathe chuck is in an unclamped state. Observe the specifications in the operating manual of the lathe chuck used.
3. Move the jaws of the lathe chuck to be turned to the desired clamping diameter (consider how much material will be removed during turning).
4. Place the turning fixture in the correct position.
5. Insert the adjusting jaws of the jaw turning fixture into the counterbores of the jaws using the adjustment screws until they come into contact.

ATTENTION: The screw heads of the adjustment screws must be inserted into the counterbores of the chuck jaws as far as the stop!

6. Turn the knurled spiral ring clockwise until the turning fixture is firmly seated.

7. Clamp the lathe chuck inward according to the specifications in the operating manual of the lathe chuck used (without workpiece). Observe the specifications for the permissible clamping force according to the technical data ▶ 3 [12].
⇒ The product is reliably clamped.

For turning, proceed as follows:

1. Ensure that the product is securely clamped.
2. Pre-turn chuck jaws to the preliminary size.
3. If the results are OK, remove the jaw turning fixture ▶ 7 [32] and make sure that the jaw turning fixture is not misaligned.
4. Remove the pre-turned jaws and deburr them.
NOTE: Select large enough chamfers so that the pre-turned jaws are not sharp-edged even after finish turning.
5. Mount the pre-turned jaws according to the specifications in the operating manual of the lathe chuck used.
6. Clamp the chuck jaws again via the jaw turning fixture according to this assembly and operating manual.
7. Turn the chuck jaws to the finished size.
8. If the results are OK, remove the jaw turning fixture ▶ 7 [32].

5.2.3 BAV – Reversing the adjusting jaws

BAV – Reversing the adjusting jaws

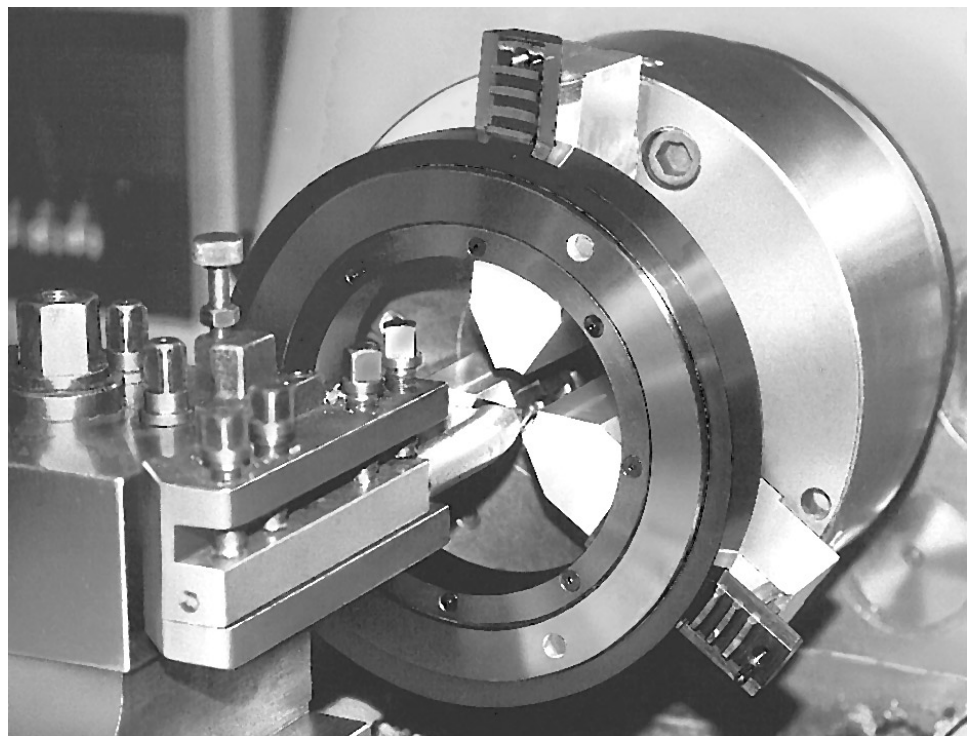
1. Turn knurl to the left and remove adjusting jaws.
2. Turn the adjusting jaws over (screw heads outward) and reinsert them in the following sequence:
Adjusting jaw 3 in guide 1
Adjusting jaw 2 in guide 2
Adjusting jaw 1 in guide 3, making sure to
3. turn the knurl to the right again.

TIP:

For a quick rotary movement of the knurled ring, insert a 6 mm round rod or a punch into the bore hole provided for this purpose on the face side of the knurled ring. The knurled ring can now be turned like a crank.

ATTENTION: Remove round rod or punch after jaw change!

5.2.4 BSA – internal turning (for O.D. clamping)



NOTE: The illustration may differ from the actual design.

To clamp the product, proceed as follows:

1. Mount the chuck jaws to be turned according to the specifications in the operating manual of the lathe chuck used.
2. Ensure that the lathe chuck is in an unclamped state. Observe the specifications in the operating manual of the lathe chuck used.

3. Move the jaws of the lathe chuck to be turned to the desired clamping diameter (consider how much material will be removed during turning).
4. Place the turning fixture in the correct position.
5. Insert the adjusting jaws of the jaw turning fixture into the counterbores of the jaws using the adjustment screws until they come into contact.
ATTENTION: The screw heads of the adjustment screws must be inserted into the counterbores of the chuck jaws as far as the stop!
6. Turn the spiral ring with the supplied ball handle clockwise until the turning fixture is firmly seated.
7. Clamp the lathe chuck inward according to the specifications in the operating manual of the lathe chuck used (without workpiece). Observe the specifications for the permissible clamping force according to the technical data ▶ 3 [12].
 ⇒ The product is reliably clamped.

For turning, proceed as follows:

1. Ensure that the product is securely clamped.
2. Pre-turn chuck jaws to the preliminary size.
3. If the results are OK, remove the jaw turning fixture ▶ 7 [32] and make sure that the jaw turning fixture is not misaligned.
4. Remove the pre-turned jaws and deburr them.
NOTE: Select large enough chamfers so that the pre-turned jaws are not sharp-edged even after finish turning.
5. Mount the pre-turned jaws according to the specifications in the operating manual of the lathe chuck used.
6. Clamp the chuck jaws again via the jaw turning fixture according to this assembly and operating manual.
7. Turn the chuck jaws to the finished size.
8. If the results are OK, remove the jaw turning fixture ▶ 7 [32].

5.2.5 BSA – internal turning (for O.D. clamping) in power lathe chucks

For clamping, proceed as follows:

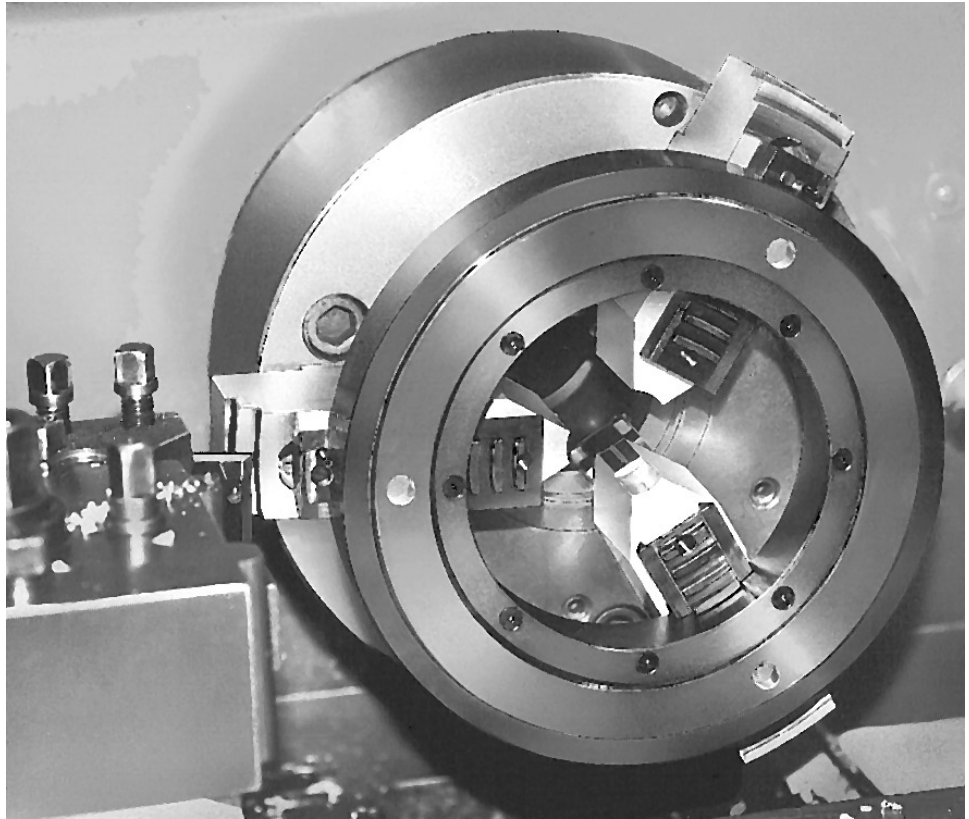
1. Mount the chuck jaws to be turned according to the specifications in the operating manual of the lathe chuck used.
2. Ensure that the lathe chuck is in an unclamped state. Observe the specifications in the operating manual of the lathe chuck used.
3. Move the jaws of the lathe chuck to be turned to the desired clamping diameter (consider how much material will be removed during turning).
4. Place the turning fixture in the correct position.
5. Insert the adjusting jaws of the jaw turning fixture into the counterbores of the jaws using the adjustment screws until they come into contact.
ATTENTION: The screw heads of the adjustment screws must be inserted into the counterbores of the chuck jaws as far as the stop!
6. Turn the spiral ring with the supplied ball handle clockwise until the turning fixture is firmly seated.
7. Now turn the spiral ring counterclockwise again until the adjusting jaw has moved inwards by approx. half of the max. chuck stroke (for opening stroke and sufficient clamping reserve).
8. Clamp the power lathe chuck according to the specifications in the operating manual of the lathe chuck used (without workpiece) ▶ 3 [12].
⇒ The product is reliably clamped.

For turning, proceed as follows:

1. Ensure that the product is securely clamped.
2. Pre-turn chuck jaws to the preliminary size.
3. If the results are OK, remove the jaw turning fixture ▶ 7 [32] and make sure that the jaw turning fixture is not misaligned.
4. Remove the pre-turned jaws and deburr them.
NOTE: Select large enough chamfers so that the pre-turned jaws are not sharp-edged even after finish turning.
5. Mount the pre-turned jaws according to the specifications in the operating manual of the lathe chuck used.

6. Clamp the chuck jaws again via the jaw turning fixture according to this assembly and operating manual.
7. Turn the chuck jaws to the finished size.
8. If the results are OK, remove the jaw turning fixture
▶ 7 [📄 32].

5.2.6 BSA - external turning (for I.D. clamping)



NOTE: The illustration may differ from the actual design.

To clamp the product, proceed as follows:

1. Mount the chuck jaws to be turned according to the specifications in the operating manual of the lathe chuck used.
2. Ensure that the lathe chuck is in an unclamped state. Observe the specifications in the operating manual of the lathe chuck used.
3. Move the jaws of the lathe chuck to be turned to the desired clamping diameter (consider how much material will be removed during turning).
4. Place the turning fixture in the correct position.
5. Insert the adjusting jaws of the jaw turning fixture into the counterbores of the jaws using the adjustment screws until they come into contact.

ATTENTION: The screw heads of the adjustment screws must be inserted into the counterbores of the chuck jaws as far as the stop!

6. Turn the spiral ring with the supplied ball handle counterclockwise until the turning fixture is firmly seated.

7. Clamp the lathe chuck inward according to the specifications in the operating manual of the lathe chuck used (without workpiece). Observe the specifications for the permissible clamping force according to the technical data ▶ 3 [12].
⇒ The product is reliably clamped.

For turning, proceed as follows:

1. Ensure that the product is securely clamped.
2. Pre-turn chuck jaws to the preliminary size.
3. If the results are OK, remove the jaw turning fixture ▶ 7 [32] and make sure that the jaw turning fixture is not misaligned.
4. Remove the pre-turned jaws and deburr them.
NOTE: Select large enough chamfers so that the pre-turned jaws are not sharp-edged even after finish turning.
5. Mount the pre-turned jaws according to the specifications in the operating manual of the lathe chuck used.
6. Clamp the chuck jaws again via the jaw turning fixture according to this assembly and operating manual.
7. Turn the chuck jaws to the finished size.
8. If the results are OK, remove the jaw turning fixture ▶ 7 [32].

5.2.7 BSA – external turning (for I.D. clamping) in power lathe chucks

To clamp the product, proceed as follows:

1. Mount the chuck jaws to be turned according to the specifications in the operating manual of the lathe chuck used.
2. Ensure that the lathe chuck is in an unclamped state. Observe the specifications in the operating manual of the lathe chuck used.
3. Move the jaws of the lathe chuck to be turned to the desired clamping diameter (consider how much material will be removed during turning).
4. Place the turning fixture in the correct position.
5. Insert the adjusting jaws of the jaw turning fixture into the counterbores of the jaws using the adjustment screws until they come into contact.

ATTENTION: The screw heads of the adjustment screws must be inserted into the counterbores of the chuck jaws as far as the stop!

6. Turn the spiral ring with the supplied ball handle counterclockwise until the turning fixture is firmly seated.
7. Now turn the spiral ring clockwise again until the adjusting jaw has moved inwards by approx. half of the max. chuck stroke (for opening stroke and sufficient clamping reserve).
8. Clamp the power lathe chuck according to the specifications in the operating manual of the lathe chuck used (without workpiece) ▶ 3 [12].

⇒ The product is reliably clamped.

For turning, proceed as follows:

1. Ensure that the product is securely clamped.
2. Pre-turn chuck jaws to the preliminary size.
3. If the results are OK, remove the jaw turning fixture ▶ 7 [32] and make sure that the jaw turning fixture is not misaligned.
4. Remove the pre-turned jaws and deburr them.
NOTE: Select large enough chamfers so that the pre-turned jaws are not sharp-edged even after finish turning.

5. Mount the pre-turned jaws according to the specifications in the operating manual of the lathe chuck used.
6. Clamp the chuck jaws again via the jaw turning fixture according to this assembly and operating manual.
7. Turn the chuck jaws to the finished size.
8. If the results are OK, remove the jaw turning fixture
▶ 7 [📄 32].

5.3 Unclamping the product

1. Secure the product against falling.
2. Unclamp the lathe chuck according to the specifications in the operating manual of the lathe chuck used.

6 Maintenance

6.1 Basic information



⚠ CAUTION

Injury of the eyes by dirt particles

When cleaning with compressed air, the eyes may be injured by flying dirt particles.

- Wear suitable protective equipment, particularly protective goggles.

For trouble-free, long-lasting use, clean, maintain and check the functionality of the product regularly.

Repair work may only be carried out by SCHUNK!

If you have any questions regarding maintenance and servicing, our technical

customer service is available during our business hours:

Service telephone: +49-7133-103-2956

service.toolholder@de.schunk.com

6.2 Intervals and tasks

Operation	Interval period
Cleaning and testing the product	after every clamping procedure
Lubricate plane thread	weekly or after 1,000 clamping operations

The specified maintenance intervals are based on practical experience gathered by SCHUNK and are recommended. Depending on the ambient and operating conditions, as well as the clamping frequency of the product, the maintenance intervals must be adapted and noted accordingly. For maintenance intervals with two or more specifications, the valid specification is the one that applies first.

6.2.1 Cleaning and testing the product

1. Unclamp the product ▶ 5.3 [29].
2. Remove the product ▶ 7 [32].
3. Clean the entire product and attachments with compressed air.
4. Wipe all surfaces dry with a clean cloth.
5. Check the product and attachments, in particular the contact surfaces, for deformation, damage or wear. Replace if necessary.

NOTE: Damage or wear can compromise the functioning of the product. If non-replaceable parts of the product are worn or damaged, return the product to SCHUNK for inspection.

6.2.2 Lubricate plane thread



⚠ CAUTION

Allergic reactions if oil comes into contact with the skin.

Skin contact with oil may cause allergic reactions.

- Wear suitable protective equipment, especially protective gloves.

1. Unclamp the product ▶ 5.3 [29].
2. Remove the product ▶ 7 [32].
3. Remove adjusting jaws ▶ 7 [32].
4. Put a little oil on the plane thread.
5. Replace the adjusting jaws.

7 Disassembly

7.1 Basic information



⚠ WARNING

Risk of injury if the product falls during transport, assembly or disassembly.

Due to the oily surface required to preserve it, the product can slip through your hands, resulting in injury.

- Take appropriate safety measures to prevent the product from falling.
- Wear suitable protective equipment, especially protective gloves and safety boots.



⚠ CAUTION

Risk of crushing and impact when assembling and disassembling the product.

- Do not reach between the product and the chuck jaws.
- Wear suitable protective equipment.

7.2 Disassembling the product

1. Ensure that the product is unclamped ▶ 5.3 [29].
2. Remove the product.

NOTE: To avoid scratches, only place the product on a clean and soft surface.

7.3 Disassembling the adjusting jaws

1. Remove the product ▶ 7 [32].
2. Turn the spiral ring until the adjusting jaws can be removed.
3. Check the adjusting jaws, in particular the contact surfaces, for deformation, damage or wear. Replace if necessary.

NOTE: To avoid scratches, only place the product on a clean and soft surface.

8 Storage

When storing the product for a longer period of time, observe the following points:

- Clean the product and attachments and lubricate lightly.
- Store the product and attachments in a suitable transport container.
- Only store the product and attachments in dry rooms.
- Protect the product and attachments from major temperature fluctuations.
- Comply with the storage temperature specified in the technical data.

NOTE: Before reassembling, clean the product and all attachments ▶ [6.2.1 \[31\]](#), and check for damage and functionality.

9 Disposal

- Follow local regulations on dispatching product components for recycling or proper disposal.
- Alternatively, you can return the product to SCHUNK for correct disposal.





SCHUNK GmbH & Co. KG
Clamping and gripping technology

Bahnhofstr. 106 -134
D-74348 Lauffen/Neckar
Tel. +49-7133-103-0
Fax +49-7133-103-2399
info@de.schunk.com
schunk.com

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