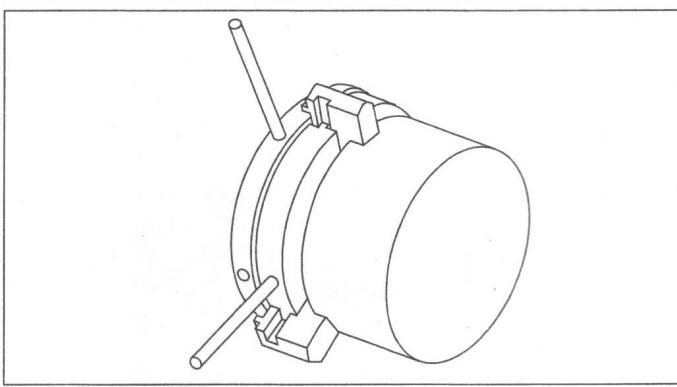
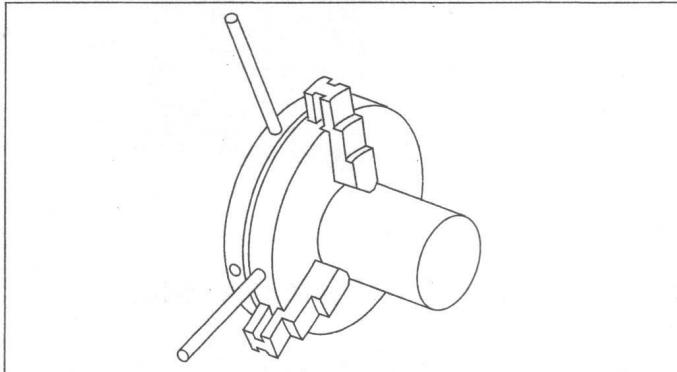


### The 3-Jaw self-centring chuck

The 3-jaw chuck is the most popular clamping device. The workpiece is automatically centred when held in the 3-jaw chuck. The jaws are reversible & can be used as either internal or external jaws.

Workpieces with a diameter of up to 22mm are gripped with the internal jaws. Pins are used for tightening (as illustrated).

Workpieces with a diameter of up to 50mm are gripped with the external jaws, necessitating the reversal of the jaws. Do not exceed clamping capacity!



### Reversing the jaws

The jaws are unscrewed and cleaned. Turn the knurled tension ring until the beginning of the spiral thread comes into the respective groove. The jaws are then inserted in the following order:

1. Jaw no. 3 is inserted in reverse into groove no. 1 and then the tension ring rotated, so that the jaw is held firmly.
2. Follow the same procedure with jaw no. 2 in groove no. 2
3. And jaw no. 1 in groove no. 3

### Remounting the jaws as internal jaws

Mount in the following order:

1. Jaw no. 1 in groove no. 1
2. Jaw no. 2 in groove no. 2
3. Jaw no. 3 in groove no. 3

