

Arc-Zone PT-051 & PT-052 Positioner Chuck Installation Guide

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Selection Guide

► MIG/GMAW ► TIG/GTAW ► Stick/SMAW ► Plasma ► General/Multiprocess

General

Positioner Hardware List

4" Chuck

- (3) ¼"-20 X 2-1/2" socket head cap screws, black oxide or zinc plated.
- (6) Steel flat washers, zinc plated.
- (3) ¼"-20 thin nylon lock nuts, zinc plated.
- (1) Chuck Centering bushing, part number: JWS-051-4-Bushing

6" Chuck

- (3) ¼"-20 X 3" socket head cap screws, black oxide or zinc plated.
- (9) Steel flat washers, zinc plated.
- (3) ¼"-20 thin nylon lock nuts, zinc plated.
- (1) Chuck Centering bushing, part number: JWS-051-6-Bushing

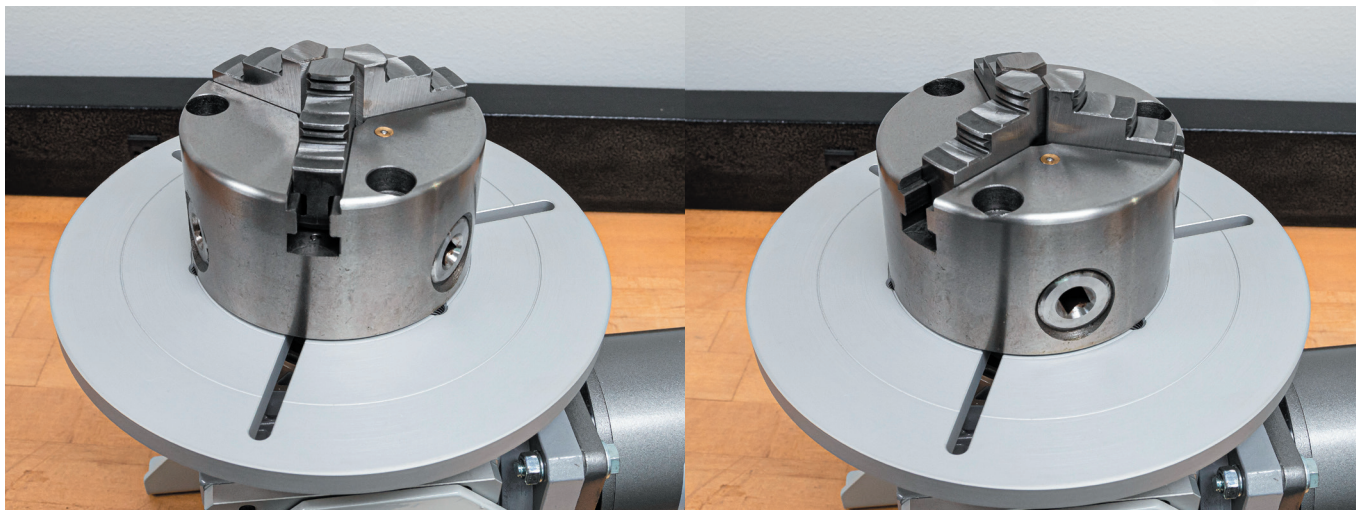
Installation Instructions

1. Insert the chuck centering bushing into the center hole of the positioner faceplate, as shown on right image.

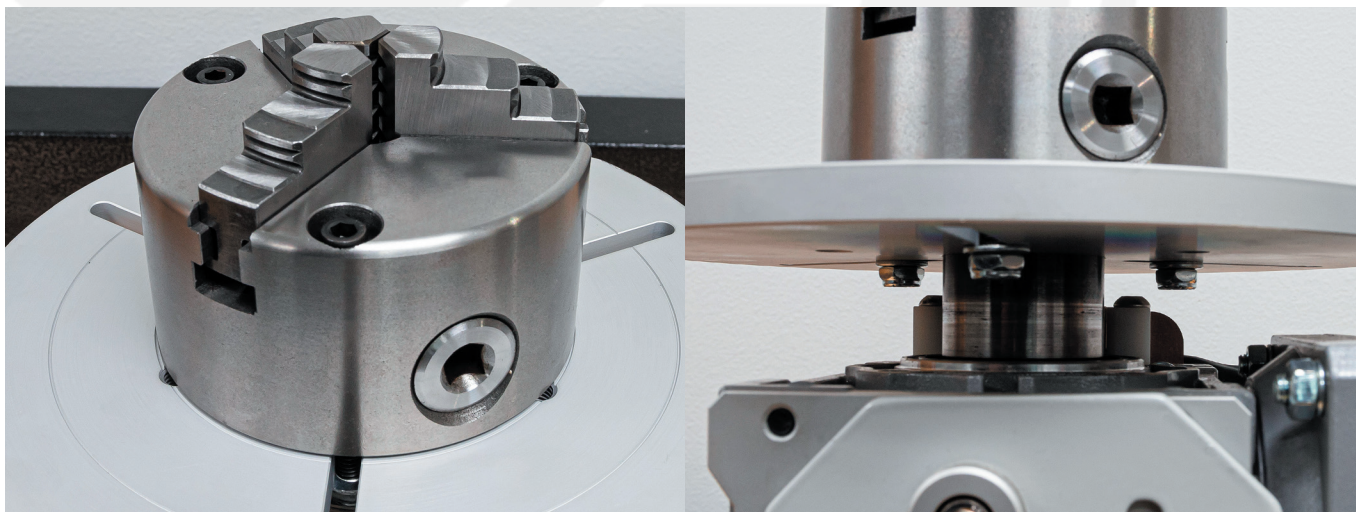


Installation Instructions

2. Position the chuck onto the faceplate centered, so that the centering bushing pilots on the bore of the chuck.
3. Rotate the chuck on the positioner faceplate to align the (3) chuck mounting holes with the (3) mounting slots on the positioner faceplate.



4. Install (3) 1/4"-20 bolts, washers and nylon lock nuts, as shown. Tighten nuts using a 3/16" allen wrench and a 7/16" wrench. Tighten the (3) nuts to 30 inch-pounds.
5. Slowly rotate the positioner turntable while checking to assure that there is free rotation, and that the chuck bolts/nuts do not interfere with the operation of the positioner.



Chuck Maintenance

- Periodically wipe the chuck and its components with light oil to avoid rusting.
- Periodically lube the chuck internally by installing light oil in the spring ball lube point on the face of the chuck.
- Keep chuck free of dirt & debris.

Positioner Chuck Instructions - Changing Jaws

To change from I.D. jaws to O.D. jaws, and, visa versa:

1. Using the chuck key, fully open the chuck jaws by turning the chuck key counter-clockwise.
2. Once the chuck is in the fully open position each of the three chuck jaws can be slid out of their chuck T-slots.
3. Remove the chuck jaws making note that each chuck T-slot is identified by a "1", "2" and "3". Each chuck jaw is marked with these same corresponding numbers.
4. Install the new chuck jaws marked "1", "2" and "3" into the corresponding chuck T-slots. While keeping light inward pressure on all (3) chuck jaws, turn the chuck key clockwise to engage the new jaws.
5. Close the chuck completely to verify that all (3) chuck jaws are concentric and close correctly.

About ARC-ZONE.com

Jim Watson

Jim is CEO and founder of Arc-Zone.com. He is a master fabricator with years of hands-on experience in his own shop and also as a winning motorcycle racer, car builder, and chief mechanic for a top motorsports team. He also has extensive experience in manufacturing, technical sales, and product development. Before launching Arc-Zone.com, he held leadership positions in some of the most respected companies in the welding industry.

Arc-Zone.com

Under Jim's direction, Arc-Zone.com has led the industry in product innovation and online sales and service, becoming the world's leading supplier of high-quality, high-performance welding and metal working tools and accessories.

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