MODEL DACC (REF DWG MB244)
ASSEMBLY AND OPERATING INSTRUCTIONS

ASSEMBLY INSTRUCTIONS

1) **Remove Spindle Adapter (Item 18) if ordered. Chuck hub end in lathe and indicate O.D. and face to .001" TIR.**
   Spindle Adapter is made long to fit through covers of various machines. Face off extra length to keep unit as close to spindle as possible. Bore adapter to length and diameter to fit outboard end of spindle. Thread adapter if outboard end of spindle is threaded. Turn O.D. if necessary to fit through cover of machine . Drill and tap four (4) holes 90 degrees for ¼-20 set screws. Set screws will lock adapter to spindle.
2) **Mount Spindle Adapter to Dunham Air Collet Closer. Attach unit to outboard end of spindle. Secure assembly to spindle by tightening screws in adapter. Hook up valves, regulator and gage to unit. With piston (Item 3) in forward position (under pressure) insert Drawtube (Item 17) with threaded end toward front of spindle. With Locking Key (Item 6) in out position turn drawtube until completely engaged on collet threads; back off 1 ½ revolutions. Cut off excessive length of the drawtube so it is flush with outboard end of Dunham Air Collet Closer (Item 5).**
3) **Again make sure piston is in forward position (under pressure). Then tighten one (1) half dog set screw (Item 15) in knurled knob (Item 5) against drawtube (Item 17). This will secure drawtube for drilling operation. Remove one (1) of the four (4) half dog set screws from knurled adjusting knob (Item 5). Insert tubular drill bushing (supplied) on knurled adjusting knob; using ¼" drill with knurled knob and drill bushing as a drill fixture, drill through drawtube. Deburr I.D. of drawtube, re insert half dog set screwand tighten into hole just drilled. Repeat this procedure for the three (3) remaining set screws to produce a total of four crossholes in the drawtube.**
4) **Adjust four (4) screws (Item 19(to finger tight lockup. Place dial indicator on diameter of cylinder (Item 1) as marked on drawing at outermost point. Rotate spindle slowly. If Air Collet Closer is in dead alignment with spindle, indicator reading will remain constant within a few thousandths. If not, tap Air Collet Closer into alignment position with spindle to within .001"-.002". Then lock four (4) screws (Item 19) tight**.**

****NOTE: Air Collet Closer body does not rotate. It will 'rise and fall' as spindle is rotated if it is not properly aligned.**
Other than flange of adapter and special guard (see page 2 Safety) no other special modifications to equipment are needed. The only accessories required are a hand or foot valve, air regulator and gage and hoses for shop air connection.

MODEL DACC (REF DWG MB244)
OPERATING INSTRUCTIONS

Inserting Collet:

1) **With piston (item 3) in forward or released position, back off locking key (item 6) , enabling drawtube (item 17) to be turned by knurled collet adjusting knob (item 5).**
2) **Place collet in spindle. Turn knurled knob (item 5) clockwise until taper of collet engages with taper of spindle.**
3) **Align locking key (item 6) with adjusting slot (4 slots provided) on draw tube, engage locking key (item 6). This prevents drawtube from turning and becoming loose during operation.**

How to control holding force:

1) **By using the regulator and gage, start with air pressure of 40 lbs.; increase pressure gradually until part is held sufficiently for machining operation.**
2) **The Dunham Air Actuator permits even gripping pressure although workpiece may have diameter variation. Holding force can be adjusted for any type of machining by increasing or decreasing the air pressure.**

Maintenance:

1) **Little or no maintenance is required. Bearings are self lubricating. All components such as bearings, "O" ring seals and retaining rings are standard. (See drawing #MB244 when ordering replacements.)**

   Installing an air cleaner and lubricator in line is advisable, but not essential.

*****SAFETY*****

The purchaser or end user of this retrofit unit is fully responsible for the fabrication and application of special protective guarding to cover this unit's moving parts. Drawtube cutoff must be performed as instructed above. Oil must be available for the oil-mist system.

FAILURE TO COMPLETE THE PROPER INSTALLATION AS INSTRUCTED ABOVE CAN RESULT IN OPERATOR INJURY OR PREMATURE WEAR ON THE UNIT.