

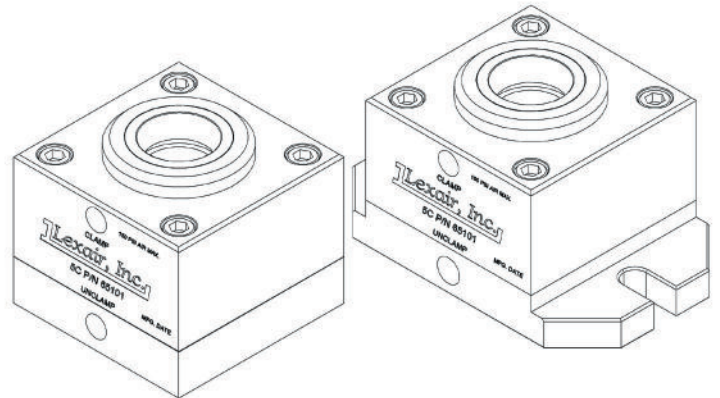
5C Collet Closer

Air Actuated, Double Acting, Pull Down Style

(P/N: 65101 & 65102)

Specifications

- Maximum operating pressure – 150 psi
- Draw tube force – 7.5 x line pressure
- Collet capacity – 5C (1/64" to 1 1/16" round)
- Thru-hole in base
- 65101 has four 3/8-24 mounting holes in bottom of base.
- 65102 is flanged with two slots for 1/2" mounting screws.
- Two 3/8" dowel holes in bottom of base
- Two 1/4" NPT ports
- 2 position 4 way control valve recommended (not included)



Safety

- Do not over tighten the mounting hardware or the plumbing fittings.
- When installing a collet in the closer, do not over tighten the collet.
- Do not exceed maximum operating pressure.
- Make sure that the collet retains your material when the closer is closed.

Application

This 5C collet closer is a stationary unit with a double acting cylinder. It is effective on machine and assembly operations that require reliable clamping and unclamping. Use the closer as a single unit or mount multiple closers on rotary tables, pallets, or tombstones for increased productivity.

Installation

1. Mount the collet closer to a rigid flat surface.
2. Plumb your first supply line to the clamp port of the closer and the normally open port of your control valve.
3. Plumb your second supply line to the unclamp port of the closer and the normally closed port of your control valve.
4. Plumb your control supply to the pressure port of the valve.
5. This configuration maintains a closed collet until the valve is actuated.

Operation

1. Remove the supply from the valve.
2. Loosen the collet locking screw until the tip does not protrude into the piston guide threads.
3. Put a witness mark on the face of your collet in-line with the collet groove and then insert the collet in the top of the collet closer.
4. Using the collet wrench, turn the collet clockwise until it contacts the piston taper.
5. Turn the collet counter clockwise until the collet witness mark lines up with the locking screw.
6. Tighten the collet locking screw. Do not overtighten.
7. To close the collet closer, insert a piece of material in the collet, and connect the supply to the valve. Do not close the collet closer without a piece of material in the collet.
8. Adjust your supply pressure to a level that assures effective workholding only. Continuously operating the closer at maximum pressure will decrease the service life of the seals and collet.
9. To open the collet, actuate the valve.

Maintenance

If, over a period of time, you experience a decrease in clamping force even though hydraulic pressure remains unchanged, remove the closer from service, disassemble, and replace any damaged or worn o-rings.

Warranty

The products furnished hereunder are guaranteed by Lexair, Inc. against any defect in material or workmanship for a period of one (1) year from date of shipment when owned by original buyer or first user, and maintained and operated under normal conditions. Any products hereunder not manufactured by Lexair, Inc. are warranted only to the extent of the original manufacturer's warranty. Parts found to be defective in material or workmanship under this guaranty shall be repaired or replaced without charge, F.O.B., original point of shipment provided prompt notice of the defect is given and compliance with the terms of this guaranty are established. LEXAIR, INC. SHALL BE LIMITED STRICTLY AND WHOLLY TO THE FOREGOING.

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