

# Soft Jaw Forming Ring



The size can be adjusted against the helical slot.

Bias pin can be rotated 180 degree for different size to extend a clamping range.

Don't need to drill new hole. The hole on the soft jaws can be used directly for bias pin.

The material is hardened and ground, can last for a long time.

## FAETURES

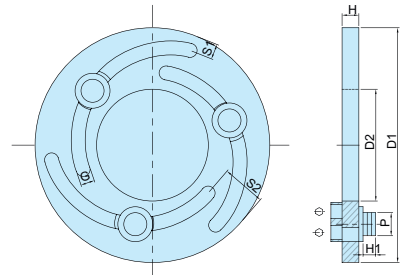
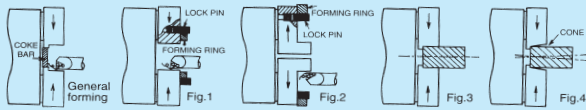
## CHUCK NOT INCLUDED

- Forming ring is available for 5", 6", 8", 10" & 12" power chuck.
- The clamping force is increasing. the roundness and vibration caused by eccentricity can be improved. The cutting accuracy is much better because of no taper hole(as fig.3) and less vibration.
- Both Clamping(as fig.1) and extension (as fig. 2) are available. Meanwhile ,the size adjusting is at will, the operation is easy and enduring.
- More improvement for used chuck to have better accuracy & strong clamping force .
- For CNC Lathe.

## INSTRUCTION

Because the forming ring is used for cutting soft jaws by clamping and with extending through-hole could increase the accuracy of clamping work piece. (please refer to fig.1.2&3)

As fig.4 the soft jaw is created without forming ring. Cause bad accuracy. The clamping force is not stable & vibration will occur.

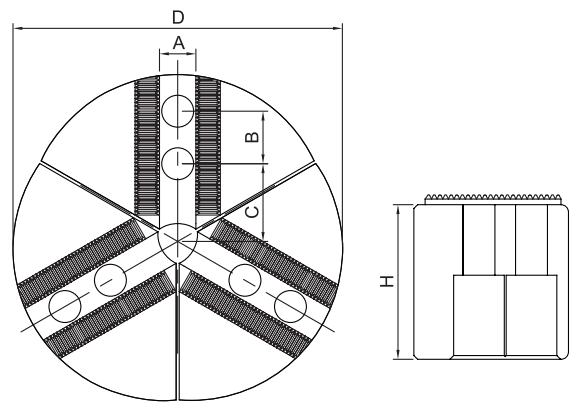


ORDER NO.	SUIT TO SK-CHUCK SIZE	H	D1	D2	S1	S2	G	H1	O	KGS	CODE NO.
VFR-05	5"	12	140	60	12	28	10	9	13.5	1	5002-360
VFR-06	6"	12	168	80	12	32	10	9	16.5	1.5	5002-361
VFR-08	8"	12	218	115	17	36	10	9	18.5	2.4	5002-362
VFR-10	10"	12	258	150	15	40	10	9	18.5	3	5002-363
VFR-12	12"	15	316	188	21	50	10	9	21.5	5	5002-364
VFR-15	15"	20	380	230	23	52	12	16	31	10.1	5002-365

# Round Disc Soft Jaw

MATERIAL : STEEL S45C

NEW



## FAETURES

- This type of soft jaw can cover the outerdie of workpiece to decrease deformation and increase the accuracy.
- For example : VFRD-8 can hold parts with outer dia. of 200 mm.
- Pie Jaw are suitable for extra bigger outer dia. (thin wall)
- To suit kitagawa and other famous chucks.
- Pie shpspe soft jaw

Unit:mm

ORDER NO.	D	A	B	C	H	THREAD	THRU HOLE	SERRATION PITCH	WEIGHT (kg)	CODE NO.
VFRD-6	169	12	20	49.5	36	M10	25	1.5x60°	6.12	5002-381
VFRD-8	200	14	25	51	40	M12			9.64	5002-382
VFRD-9	200	14	25	51	50	M12			13.2	5002-383
VFRD-10	250	16	30	65	50	M12			18.1	5002-384
VFRD-12	300	21	30	81	50	M16			25.8	5002-385