

ROCKSTEADY

QC



QUICK CHANGE POWER CHUCK

**HIGH SPEED - CENTRIFUGAL FORCE COMPENSATING - SERRATED BASE JAWS AS STANDARD
LARGE THROUGH HOLE - COLLET PAD MOUNTING - REDUCE SET UP TIMES IMMEDIATELY!**

QC

Time is money. Fact. Downtime when setting on today's CNC Machine tools is costly - so why do we often settle for standard Power Chucks on our Turning Centres? Often, this is down to initial outlay cost for Quick Change Chucks - that combined with the cost of investment in new compatible Jaw systems and the possible upgrade of the actuation system for certain types of Chuck. This can be a minefield. But we at **ROCKSTEADY** Have the answer in our QC Quick Change Product - and here is why.

QUICK JAW CHANGE

Set up times from chip to chip in less than 90 seconds are achievable - a turn of the Chuck Key releases the Base Jaw making way for the new Jaw assembly. Each jaw is poke yoked so that the same jaw is placed in the correct jaw way each time - the single position of the base jaw makes for a simple and fool proof change. Pre setting of the Jaws whilst the machine runs can be carried out with a simple jig

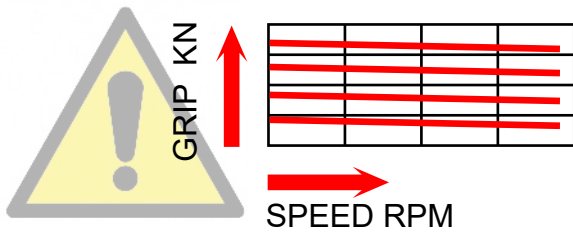


SERRATED BASE JAWS

Each QC Chuck Kit comes with 2 sets of Serrated Base Jaws as Standard. The Base Jaws are compatible with industry standard 1.5mm x 60 degree Top Jaws (1/16" x 90 optional) complete with suitable Tee Nuts and screws. This means that existing Chuck Jaw libraries can be used on the QC Chuck, and new Jaws are readily available and at competitive prices. The Base Jaws feature a precise location for Collet Pads so the Chuck can be used as a Bar/Collet Chuck. Other types of Base Jaws can be supplied on request.

HIGH SPEED WITH CONSTANT GRIP

Our QC Chuck comes with High Speed capability and true Centrifugal Force Compensation. This gives excellent gripping characteristics throughout the pressure range - a nearly flat grip curve from zero to maximum RPM - and sensitive grip for delicate and powerful grip for heavier components. With regular lubrication, this becomes a major factor for improvement in terms of Health and Safety and protection of valuable machine tools.

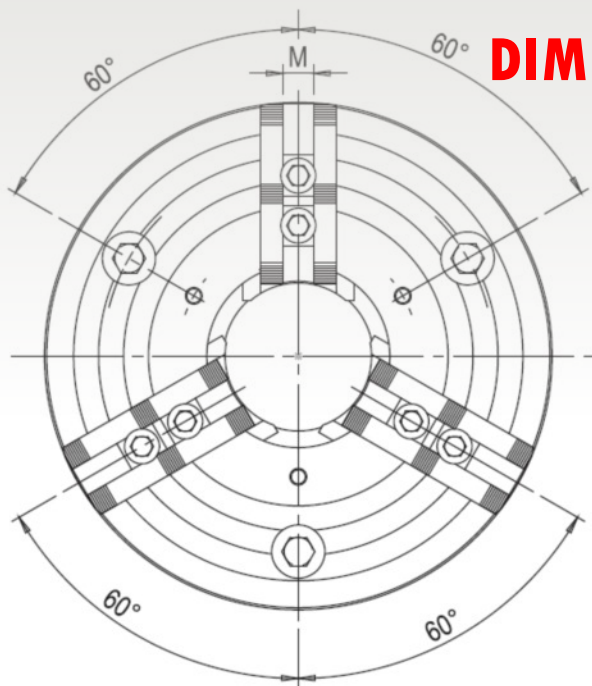


HIGH CONCENTRICITY

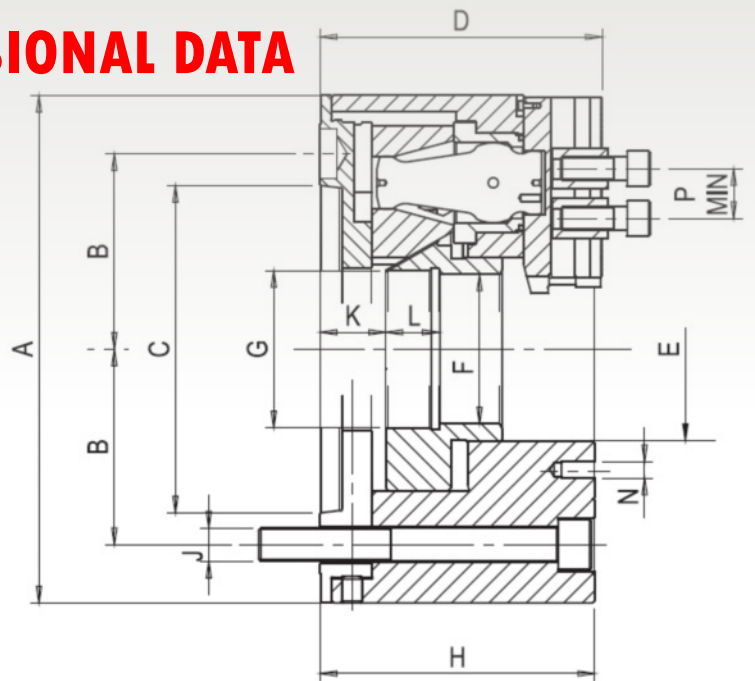
The Chuck Adaptor features Concentricity Adjustment - the body can be set to zero runout by adjusting the peripheral screws. Once set, this can result in better parts produced.



ROCKSTEADY



DIMENSIONAL DATA



MODEL	MOUNT	A	B	C	D	E	F
QC6	A2-5"	165	52.4	82.55	126	56	43
QC8	A2-6"	210	66.7	106.36	140	82	66
QC10	A2-8"	254	85.7	139.7	155	85.73	66.5
QC12	A2-11"	305	117.5	196.87	172	110	90

MODEL	G MAX	H	J	K MAX - MIN	L	M (1.5)	M(1/16)	N	P MIN
QC6	M48 x 1.5	123	M10 x 120	44 - 28	20	12	12	M8	17
QC8	M72 x 1.5	136	M12 x 130	46 - 30	27	14	17	M8	19
QC10	M72 x 1.5	150	M16 x 140	54.5 - 36	27	16	17	M10	19
QC12	M96 x 1.5	168	M20 x 160	51.5 - 33	32	18	21	M10	25

MODEL	UNIT	QC6	QC8	QC10	QC12
PART NO.		QC6A5KIT	QC8A6KIT	QC10A8KIT	QC12A11KIT
MAXIMUM SPEED	RPM	6000	5500	4500	3800
THROUGH HOLE	mm	43	66	66.5	90
JAW STROKE	mm	3.5	3.5	4	4
PISTON STROKE	mm	16	16	18.5	18.5
MAXIMUM PULL	kN	16	24	32	44
TOTAL GRIP	kN	47	66	88	121
WEIGHT	Kg	16	27	42	68

KIT INCLUDES ROCKSTEADY QC CHUCK WITH SPINDLE NOSE ADAPTOR - COMPLETE WITH 2 SETS (OF 3) SERRATED BASE JAWS WITH (6) TEE NUTS & SCREWS, HARD TOP JAWS, SOFT TOP JAWS JAW CHANGE KEY, ALLEN KEYS, MOUNTING BOLTS. DRAWTUBE CONNECTOR NOT INCLUDED AND AVAILABLE ON REQUEST

QUICK CHANGE POWER CHUCK

QC



EXAMPLE JUSTIFICATION FOR QUICK CHANGE

AVERAGE JAW CHANGES/SHIFT	TIME TO CHANGE JAWS	HOURLY RATE £	COST PER SET UP £	NO OF SHIFTS	COST PER DAY £	COST PER MONTH £	COST PER YEAR £
3	20 MINS	65	20.66	2	123.96	3,099.00	37188

AVERAGE JAW CHANGES/SHIFT	TIME TO CHANGE JAWS	HOURLY RATE £	COST PER SET UP £	NO OF SHIFTS	COST PER DAY £	COST PER MONTH £	COST PER YEAR £
3	1 MIN	65	1.08	2	6.5	162.50	1950

This example is based on a factual justification carried out for a UK customer. In this instance the payback time on the investment of £9,866.00 for two chucks was just under 4 months. In the first 12 months the customer saved over £23,000.00!

SAVING PER DAY £	SAVING PER MONTH £	SAVING PER YEAR £
117.46	2,936.50	35238



Contact us now!

www.rocksteadygroup.co.uk

+44(0)1484 500707



ROCKSTEADY

GROUP LIMITED

ATLAS IRON WORKS - ATLAS MILL ROAD - BRIGHOUSE HD6 1ES - WEST YORKSHIRE - UK