



Collet Torque Test Procedure

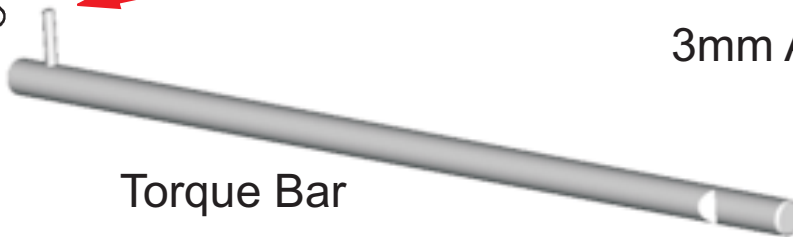


Collet Torque Test Procedure

Tools required



Must be clean



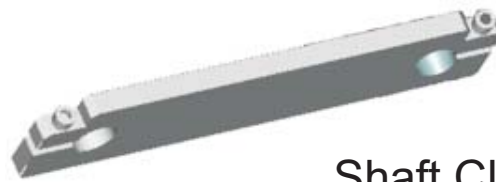
Torque Bar



3mm A/F Allen Key

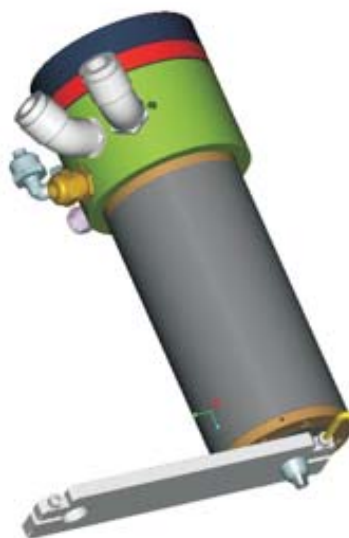


Spring Balance



Shaft Clamp

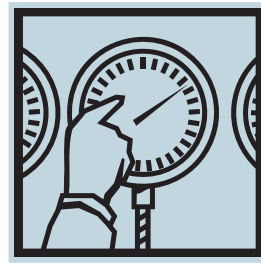
1.



Attach shaft clamp
and tighten screw

5 inch. lb

2.



80 psi



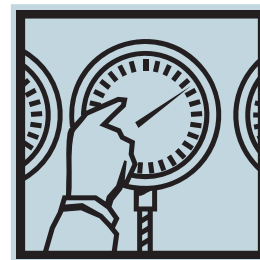
Apply air pressure to collet actuation port

3.



Insert Torque bar

4.

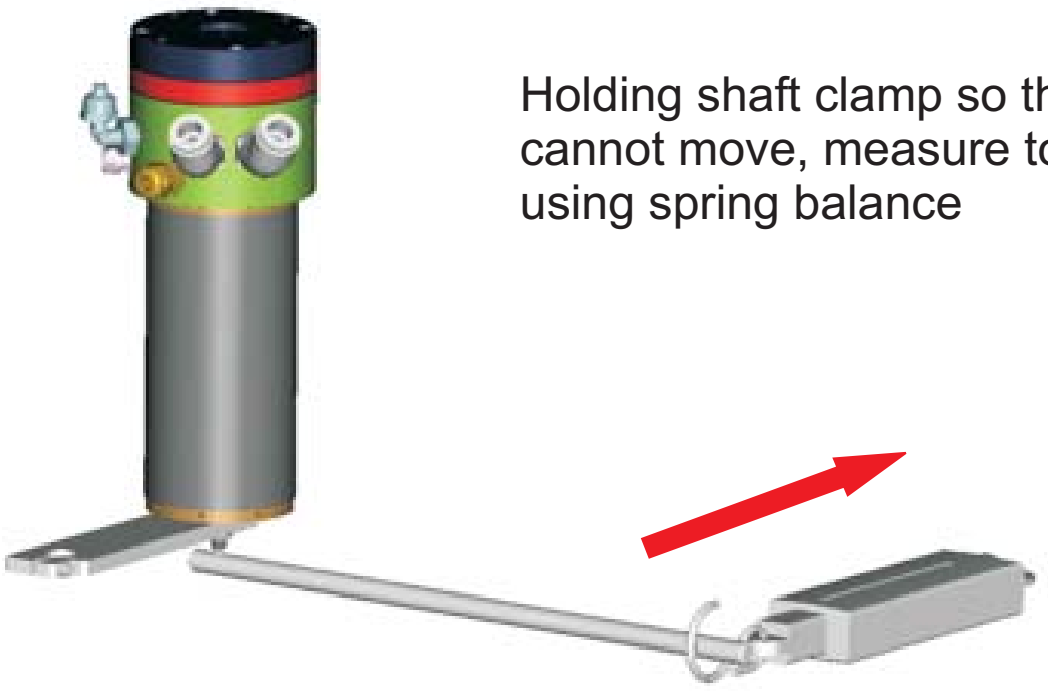


0 psi



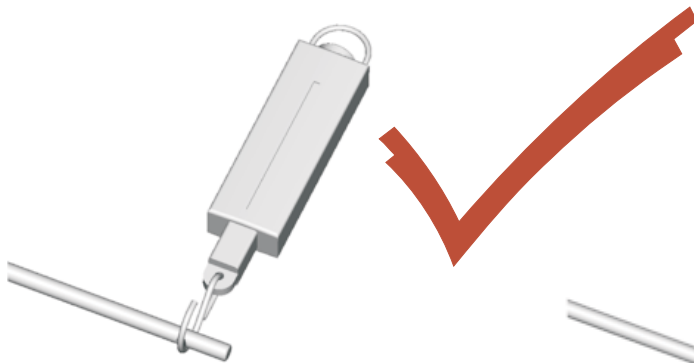
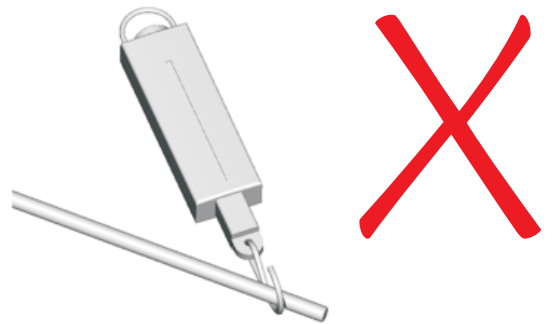
Release air pressure from collet actuation port

5.



Holding shaft clamp so that shaft cannot move, measure torque using spring balance

Minimum Torque for Drilling = 300g
Minimum Torque for Routing = 425g
Minimum Torque for Drilling holes >3mm = 425g



For further information please email: wwinfo@gsig.com