

Tnut-Plus Instruction Manual

Refer to the chuck instruction manual.

Tnut-Plus is T-nut for mounting soft jaw of the power chuck. It can be used only with the chuck of Table 1. Soft jaws formed using the Tnut-Plus can maintain the gripping accuracy equivalent to just-formed soft jaws even after they are removed from the chuck once, because they can be reinstalled in the same positions.

- To maintain the installation repeatability of the Tnut-Plus for a long period of time, always tighten the jaw mounting bolts from the chuck outside diameter side with the specified torque. (See Figure 2 and Table 2)
- The Tnut-Plus is elastically deformed when the bolts are tightened. Therefore, although the resistance you feel when tightening the bolts is different from ordinary T-nuts, it is normal.
- If the Tnut-Plus is used for a long period of time, the soft jaws may be fixed and become hard to be removed. In this case, remove them by tapping with a plastic hammer. If you apply CHUCK GREASE PRO to the side of the T-nut, it becomes hard to fix.
- The gripping accuracy may be deteriorated due to aging such as fatigue of the workpiece gripping surface. In such a case, re-form the soft jaws.

Table 1 Correct chuck type

Tnut-Plus type	Chuck type
TN06PLUS	BR06
TN08PLUS	BR08
TN10PLUS	BR10
TN12PLUS	BR12

Table 2 Specified torque

Thread size	Tightening torque [N·m]
M8	33
M10	73
M12	107
M14	171
M16	250
M20	402

*Strength classification : 12.9

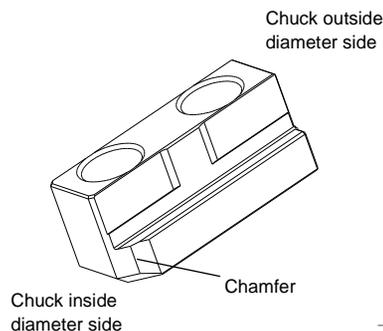


Figure 1 Tnut-Plus

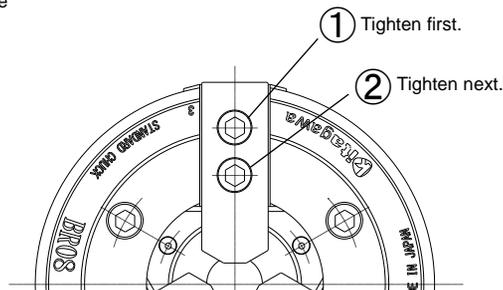


Figure 2 Tightening order of the jaw mounting bolts

Warning Failure to follow the safety precautions below could result in death or serious injuries.

Mount the Tnut-Plus with the chamfer side facing the chuck inside diameter side. (See Figure 1)
If it is mounted in the opposite direction, seizure may occur due to significant deformation of the master jaws. As a result, the gripping force will be reduced, causing the workpiece to fly out.

Do not use the Tnut-Plus on a chuck that does not correspond to it. (The T-slot shapes of such chucks do not match the Tnut-Plus, so the Tnut-Plus cannot be mounted physically. Do not use the Tnut-Plus forcibly on such chucks by additionally machining them.)
If the Tnut-Plus is used on such chucks, seizure may occur due to significant deformation of the master jaws. As a result, the gripping force will be reduced, causing the workpiece to fly out. Additional machining of the T-nut and master jaws may damage them, causing the workpiece to fly out.

Do not use soft jaws manufactured by other companies.
If soft jaws manufactured by other companies are used, seizure may occur due to significant deformation of the master jaws. As a result, the gripping force will be reduced, causing the workpiece to fly out. Using soft jaws manufactured by other companies may damage the T-nut, causing the workpiece to fly out.

Notice Indicates instructions which, if you do not heed given instructions, could result in damage to the product or shortened service life, or damage to peripheral equipment.

Do not use soft jaws manufactured by other companies. When mounting already-formed soft jaws again, use the same T-nut used when the soft jaws were formed, match the jaw No. of the soft jaws and master jaws, and mount the soft jaws in the same serration position. Also, carefully clean fitting parts of the serration and the T-nuts.
Failure to follow the above precautions may lead to poor accuracy.

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