

## **Procedure for removing Blanchard Chuck from machine table and installing Magna-Lock Chuck**

- A. Remove Blanchard chuck and machine table.
  1. Install (3) eye-belts in tapped holes of magnetic face or (1) eye-belt in tapped hole at center of table
  2. Lift chuck and machine table straight up, high enough to clear drive gear projecting down bottom of table.
  3. Invert chuck/table assembly on timbers on the floor.
- B. Remove the chuck assembly from the machine table.
  1. Remove all socket head cap screws that hold the gear and way assembly to the bottom of the table, remove the gear & way.
  2. Remove all socket head cap screws holding the machine table to the magnetic chuck and remove the collector ring from the center area.
  3. Lift the machine table away from the magnetic chuck, there is a 2" dia. alignment plug in the center that may have to be pressed or driven into the chuck to permit removal of the table.
  4. Clean the top side of the machine table; remove all burrs.
- C. Mount the Magna-Lock chuck to the machine table.
  1. With the magnetic chuck, bottom-side up, place the machine table on the chuck, be sure to center the chuck and table. Transfer the location of the socket head cap screw holes to the base of the chuck. Use (12) holes near the outside diameter and (4) holes near the center.
  2. Remove the table and drill and tap the holes, drill no deeper than 1".
  3. Remove the protective seal from the center hole in the bottom of the chuck. Pull the lead wires up through the center hole.
  4. Clean both the bottom of the chuck and machine table, apply a light coat of rust preventative to both surfaces.
  5. Place chuck on machine table, feed lead wires through the center hole of the table. Install cap screws and torque according to cap screw standards.
  6. Install collector ring and connect lead wires. Check for continuity and ground.
  7. Reinstall the gear and way assembly.
- D. Install chuck and table on machine.
  1. Check the brush holder for freedom of brush travel, spring pressure, etc.
  2. Invert chuck and table assembly. Clean and oil all ways.
  3. Lower assembly into place; be careful with drive gear alignment.
  4. Check operation of table drive and chuck energization.
- E. Grind-in chuck.