

*How to “grind-in” your rectangular chuck:*

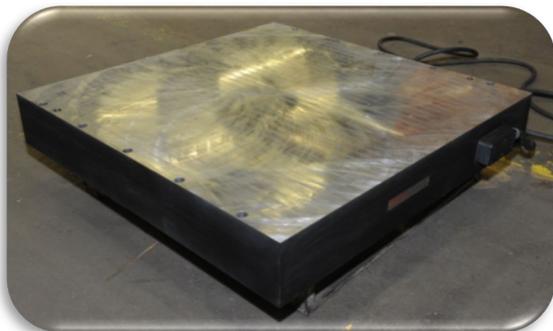
*The surfaces of this chuck have been ground at the factory, but to insure accuracy, it is necessary to “grind-in” the chuck on the grinder with which it is to be used. The following procedure is recommended for a new chuck. Each time the chuck is removed from the machine, the top surface should again be ground, to insure parallelism between this surface and the saddle and table ways:*

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The procedure below is necessary to assure that the chuck surface also will be flat and parallel:

1. Grind table flat.
2. Take .0002” to .0005” deep cuts, using .010” cross-feed and 35 fpm table speed. **BE SURE TO USE COOLANT**
3. Grind bottom surface of chuck. Do not turn power on and do not clamp chuck down - merely block the ends to keep chuck from moving on table.
4. Put a fine layer of oil on the table to prevent rusting and assist the chuck with movement in the horizontal plane.
5. Turn chuck over and grind top surface using same procedures. Except this time with chuck clamped to table, pulling bolts on left side fairly tight, but leaving bolts on right side merely “snug”. This allows the chuck to expand in the horizontal plane without “buckling” if heating occurs. The chuck should be turned on and the machine and chuck should be running at operating temperature. Be sure the chuck is flooded with coolant.



*If you have any questions regarding these instructions, please do not hesitate to contact us.*