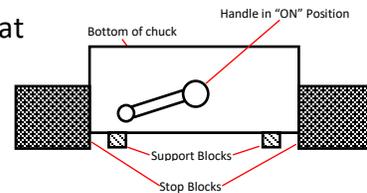




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Uni-Mesh and Micro-Mesh Permanent Magnetic Chuck Preparation and Mounting Procedures

1. Clean and dress the mounting surface of the machine table.
2. With the chuck handle in the "ON" position, place the chuck on the table bottom side up, supported at each end by parallels (at least ½" thick) as shown to the right. Block at each end to prevent movement.
3. Dress the bottom of the chuck as follows:
 - a. Use a general purpose grinding wheel, freshly trued.
 - b. Wet grind using any non-nitrite or inhibited-nitrite coolant.
 - c. Depth of cut - .0001"
 - d. Cross feed – half wheel width per pass.
 - e. Table speed – about 75feet/min.
 - f. Grind to clean bottom of chuck.
4. Remove the chuck, clean and dry the mounting area of the table.
5. Apply a light coat of corrosion inhibitor.
6. Place a sheet of Mylar on the table. The sheet should be about 1" longer and wider than the chuck.
7. Clean and dry the bottom of the chuck. Apply an additional thin coating of corrosion inhibitor to the bottom (including recessed pockets) and place it on the Mylar so that about ½" of Mylar extends on all sides.
8. Align the chuck with the table and clamp it in the following sequence:
 - a. Right clamp to 10-15 ft.-lb.
 - b. Left clamp to 10-15 ft.-lb.
 - c. Right clamp to 30-40 ft.-lb.
9. Turn the handle to "ON" and grind the top to clean using the same steps as in #3 listed above.



Note: For additional protection against pitting or corrosion between the chuck case and the table, it is recommended that one of the many non-nitrite or inhibited-nitrite coolants be used for all grinding applications.