

# NORTHFIELD

## ***PRECISION INSTRUMENT CORP.***

POST OFFICE BOX 550, 4400 AUSTIN BOULEVARD, ISLAND PARK, NEW YORK 11558

PHONE (516) 431-1112

FAX # 516-431-1928

www.northfield.com • e-mail: sales@northfield.com

RE: **TOP JAW MOUNTING.**

- **Here is the procedure for mounting / re-mounting TOP JAWS:**

1) Ensure that all critical surfaces are clean !

2) Apply a small amount of moly oil to mounting surfaces of top jaws.

3) Mount each top jaw stamped "1", "2" & "3" onto its corresponding master jaw (also stamped "1", "2" & "3") with socket head screws supplied.

4) Tighten screws fully to seat each jaw and "squish" out moly oil leaving a fine film between top jaw and master jaw. Wipe away excess oil.

5) Back off the top jaw mounting screws and retighten to hand snug such that they have freedom to move, but not lift, upon clamping.

6) With the top jaws in the unclamped position, load a plug into the top jaws. Apply clamping line pressure to allow the jaws to come to a fully clamped position - this will eliminate any minute gaps between the master jaw pins and their corresponding pinholes in the top jaws. Open and close the jaws 6-10 times - leave the jaws clamped.

7) Fully tighten the top jaw mounting screws by first tightening the ones closest to the grip diameter. Next, tighten the remaining screws moving outward toward the chuck OD in a circular pattern. Top jaws are now properly loaded.