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Clutch Adjustments

I have found in the past that far too often the High Speed and Hand clutch have been improperly adjusted. This has the potential for causing a number of problems all of which could cost you down time as well as parts and labor repair.

Simply follow these instructions and you can count on all of your people to properly and uniformly adjust the clutches.

1. Back off the adjusting nut on the clutch.
2. Engage the clutch (at this point there should be no pressure on the clutch).
3. By HAND tighten the nut until it will not tighten any further.
4. Disengage the clutch and tighten the nut approximately one 1/16 of a turn further.
5. Tighten the two bolts on the adjusting nut.

You may find that if you are machining very large stock with heavy cuts you may need to tighten the clutches slightly more.

A quick double check: you should be able to engage and disengage your High Speed Clutch with a CHUCKING BAR.

Stand in front of your machine; with your Left hand you should be able to engage the clutch by simply PUSHING it.

You should feel a crisp snap when the clutches are engaged.

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