

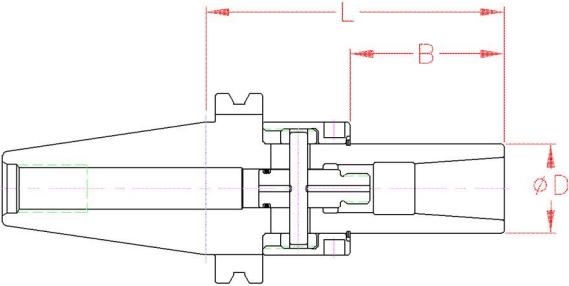


Premium Tool Holding & Work Holding

VX Ultimate Precision Holding System

HPI - PIONEER

- 3 Microns (0.0001") TIR @ 4X Tool Diameter *or better!*
- High Pressure Coolant Thru
- Front Locking System w/ Center Pull Design eliminates collet twisting for higher accuracies
- Uses MX or VX Collets
- Increased Holding Power
- 30% Higher than Standard MX Collet Chucks w/ MX Collets
- Reduced Nose Diameter for Close Center Applications
- Other Shank Styles and Projections Available on Demand



Tool Size	Part Number	Range	L Proj.	B	D	Collet	Wrench
1/2 Max.	CAT40-VX12-100	0.157 - 0.500	3.94	2.00	1.18	MX12	SXW16

MX Collets

- 3 Microns (0.0001") TIR @ 4X Dia. *or better!*
- High Pressure - Up to 1,500 PSI
- Jet Slotting Available for "Around Solid Tool" Coolant



Collet Style	Tool Sizes (h6 Req'd)	
MX12	Inch	3/16, 1/4, 5/16, 3/8, 7/16, 1/2
	Metric	4, 5, 6, 8, 10, 12

Assembly Instructions

The instructions below are a basic procedure. Always use proper safety equipment when working with any machine tool component. Contact your safety officer for your facilities recommended safety equipment and procedures.



Turn locking collar counter-clockwise until it stops.



Insert collet and turn clockwise.



Turn collet until it stops or reaches 1/8" from the face of the chuck. Do not tighten!



Insert cutter, do not allow the cutter to rest on the bottom, while holding the cutter hand tighten the locking collet clockwise until the collet holds the tool.



Tighten locking collar to 80 ft/lbs Maximum. Do not over tighten!



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