



ADJUSTING GUIDELINE PRECISION MILLING CHUCK APC

The Albrecht Precision Chuck (APC) is a high precision toolholder with clamping gear. Its unique design provides a very high clamping force, run-out accuracy as well as a positive dampening feature.

The APC uses a special collet to clamp the cutting tool. Operation of the APC is done with a hex key from the side of the unit. For clamping of tools with round shanks according to DIN 1835 B and E with shaft diameter tolerance of h6.

For milling, drilling, reaming, tapping, heavy-duty cutting, finish milling, HSC operations.

1. INSERTING THE COLLET



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Clean the inner taper of the APC (for cleaning the inner cone we recommend our special taper wiper). Manually screw the clean collet with the tool into the chuck until the collet connects with the taper.

2. CLAMPING



FIG. 1



FIG. 2

The chucking procedure starts by engaging the screw on the side of the APC and rotating the hex key clockwise.

CAUTION

Put in the hex key as far as possible. Use only the hex key supplied with the APC or a torque key.

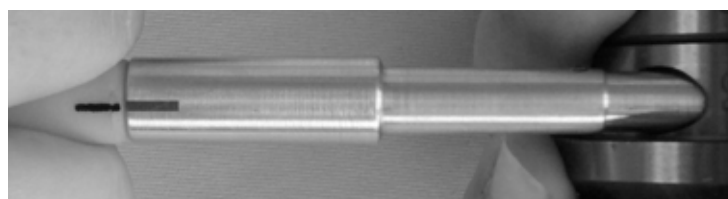
FIG. 1: Correct

FIG. 2: **Not** correct



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For a clamping match the two lines. This corresponds with approx. 10- 12 Nm. The max. clamping torque is 14 Nm. As an alternative we recommend the use of our torque key ref.no. 139 0012 900 0.



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3. OPENING



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Open the APC by turning the hex key counter-clockwise.

Note: when opening the APC you must overcome two resistance points. First, you will overcome the friction torque, then the collet is loosened.

Then open until the tool can be taken out or the collet can be unscrewed manually, resp.

4. LENGTH STOP



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A length stop screw is located in the collet and can be adjusted with the hex key. For operation from the back through the APC chuck with taper shank a bolt with a through hole is necessary.

APC type	Clamping Diameter		min. insertion depth of tool [mm]	Adjusting range [mm]	Max. depth without screw [mm]
	[mm]	[inch]			
APC14/APC20	2 – 5	1/8 – 3/16	17	11	48
APC14/APC20	6	1/4	24	11	48
APC14/APC20	8	5/16	25	11	48
APC14/APC20	9	3/8	29	11	48
APC14/APC20	10		29	11	48
APC14/APC20	12 – 14	7/16 – 9/16	34	11	48
APC20	16 – 18	5/8 – 11/16	37	11	48
APC20	20	3/4	39	11	48
APC32	20 – 22	3/4	39	11	58
APC32	25	1	45	11	58
APC32	32	1 1/4	48	11	58

Technische Daten APC-Typen

5. BALANCING QUALITY

Each Albrecht APC is balanced serially with G 2,5 up to 20.000 Rpm or with G 6,3 up to 15.000 Rpm. For the according balancing quality and rpm please see the marking on the chuck. Higher balancing quality and rpm are possible on request.

6. MAINTANCE

The Precision Chuck APC is maintenance free.
Clean APC (especially the inner cone) and collet after use.
Before storing, apply a thin coat of anticorrosive

7. REPAIRS

In order to guarantee the precision of the tool any APC in need of repair should be sent to the manufacturer or an authorized national agent only.

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