

# Pratt Burnerd / Atlas Workholding

Model Number PB23-00/PB16-00

Hand Wheel 5C & 16C Collet Chuck



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Workholding prior written permission is prohibited

**Important:** Read this manual before using this product:

Contact us if you have questions prior to using this product:

Pratt Burnerd America/Atlas Workholding Equipment may be set up and

operated by those only who are trained to do so. Persons using

Workholding Equipment who do not possess the necessary training run

the risk of potential injury from clamping motion and forces generated.

Contact Information:

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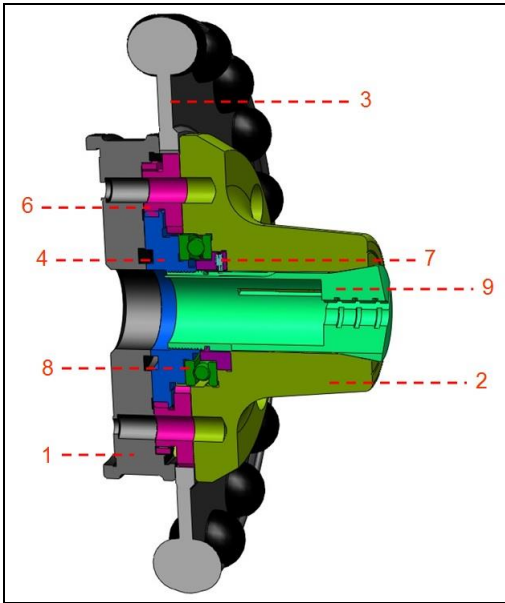
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# PB23-00 & PB16-00 Part List



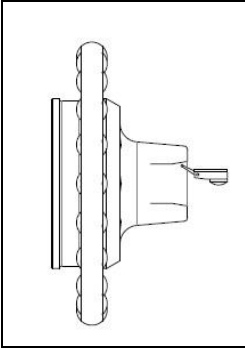
Part No.	PB-23 Part Numbers	PB16 Part Numbers	Description	Qty.
1	NA	NA	Back Body	1
2	NA	NA	Chuck Nose Body	1
3	PB23-RING	PB16-RING	Hand Wheel	1
4	PB23-GEAR	PB16-GEAR	Center Gear	1
6	PB23-C-GEAR	PB16-C-GEAR	Compound Gear	2
7	PB23-COLLAR	PB16-COLLAR	Collar w/ Collet Key	1
8	PB23-BEARING	PB16-BEARING	51108 Thrust Bearing	1
9	5C Collet	16C Collet	1	



# **PB23-00 & PB16-00 Installation**

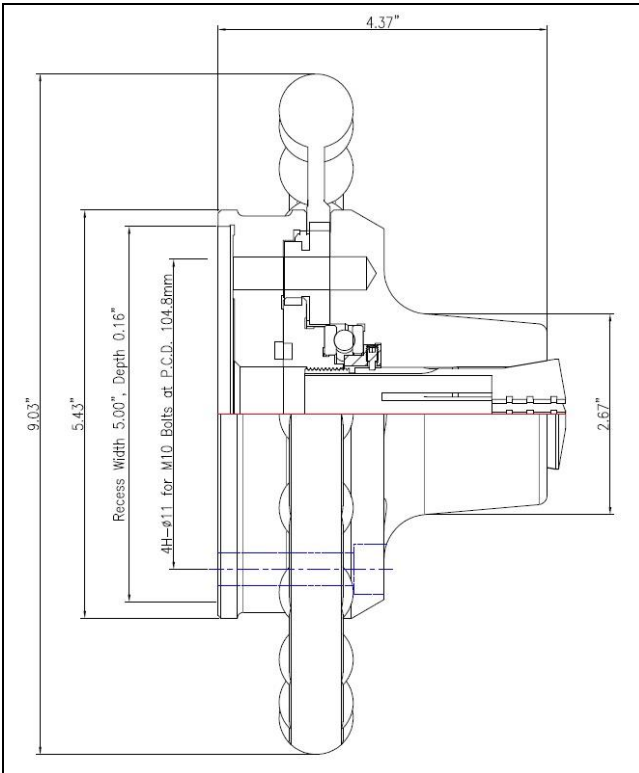
 <b>DANGER</b>	<b>Do not exceed PB23-00 max. 2500 R.P.M - PB16-00 max. 2000 R.P.M.</b>
 <b>DANGER</b>	<b>Do not run the chuck at R.P.M. higher than 150 unless a collet is inserted into the chuck and a work-part is securely clamped by the chuck.</b>

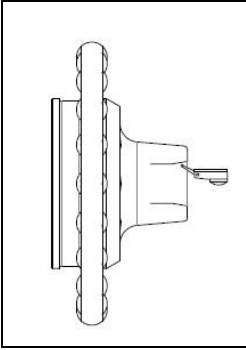
1. Install the chuck adaptor onto the spindle nose. Check with indicator to make sure adapter is flat, if not take a light face cut of .005-.010" should be enough. There are two faces on the mounting plate. Only face the outer face where the threaded holes are that mount the Collet Chuck.
2. Install the Hand Wheel Collet Chuck onto the adaptor. Tighten the four included mounting bolts.
3. Use a dial indicator to check with the concentricity of the chuck taper. Refer to the following figure. The criteria of the T.I.R. should be within 0.0006". If there is run out, loosen the mounting bolts and tap chuck in with plastic hammer. Once the T.I.R is within 0.0006," re-tighten mounting bolts up recheck T.I.R . The pilot on the mounting plate is .005" smaller than the chuck recess to allow for adjustment.
4. Rotate the Hand Wheel manually to see if the gear works smoothly.
5. Align the Collet Key with the Key Slot of the Collet. Insert the Collet into the chuck.
6. Clockwise rotate the Hand Wheel to pull back the collet and close it.
7. Load and chuck a work-part securely. Run the chuck at a low R.P.M. to ensure the part is gripped securely.



Set Dial indicator on Collet Chuck taper for testing TIR.

## **PB23-00 Dimensions**





Set Dial indicator on Collet Chuck taper for testing TIR.

## **PB16-00 Dimensions**

