

## Troubleshooting

If a failure is suspected, check the contents in the Table below and take necessary measures.

Problem	Cause	Countermeasure
Jaws do not move	Parts are damaged	Disassemble and clean the chuck. Replace damaged parts.
	Slideways get seized	Disassemble and clean the chuck. Correct the seized part with an oilstone or replace the part.
	Cylinder does not operate	Check the piping and electric system, and if normal, repair or replace the cylinder.
Stroke is insufficient	Chips accumulate inside	Disassemble and clean the chuck.
	Draw pipe loosened	Remove the draw pipe from the cylinder and retighten it.
Workpiece slips	Jaw stroke insufficient	Confirm that the master jaw base line is within the appropriate stroke range when a workpiece is gripped.
	Lack of gripping force	Confirm that the hydraulic pressure is appropriate.
	The formed diameter of the top jaw does not match the workpiece diameter	Re-form the jaw according to the correct forming method.
	Excessive cutting force	Calculate cutting force and check that it is appropriate for the chuck and machine specifications.
	Lack of grease	Supply grease.
	Excessive rotational speed	Slow down the rotational speed to obtain required gripping force.
	Swing due to misalignment of the bar feeder, steady rest, tailstock, etc.	Thoroughly conduct alignment to eliminate swing.
Accuracy failure	Run-out of chuck circumference is large	Adjust the run-out to 0.020 mm T.I.R. or less.
	Dust accumulates in serration parts of master jaw and top jaw	Remove the top jaws and thoroughly clean the serration parts.
	Jaw mounting bolts are not sufficiently tightened	Tighten the jaw mounting bolts with the specified torque.
	Top jaw forming method is improper	Confirm that the disc for finish turning of top jaw is parallel to the chuck end face and it is not deformed by the gripping force.
	Due to excessive top jaw height, top jaws are deformed and jaw mounting bolts are extended	Lower the top jaw height. Adjust the top jaws so that the gripping surfaces contact the workpiece evenly.
	Excessive gripping force deforms workpiece.	Reduce the gripping force to the extent that machining can be executed to prevent deformation.