



Assembly Instructions and Parts Manual

5C Collet Closer for GHW Lathes

Model CC-GHW



JET
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Warranty and Service

JET warrants every product it sells against manufacturers' defects. If one of our tools needs service or repair, please contact Technical Service by calling 1-800-274-6846, 8AM to 5PM CST, Monday through Friday.

Warranty Period

The general warranty lasts for the time period specified in the literature included with your product or on the official JET branded website.

- JET products carry a limited warranty which varies in duration based upon the product. (See chart below)
- Accessories carry a limited warranty of one year from the date of receipt.
- Consumable items are defined as expendable parts or accessories expected to become inoperable within a reasonable amount of use and are covered by a 90 day limited warranty against manufacturer's defects.

Who is Covered

This warranty covers only the initial purchaser of the product from the date of delivery.

What is Covered

This warranty covers any defects in workmanship or materials subject to the limitations stated below. This warranty does not cover failures due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair, alterations or lack of maintenance.

Warranty Limitations

Woodworking products with a Five Year Warranty that are used for commercial or industrial purposes default to a Two Year Warranty. Please contact Technical Service at 1-800-274-6846 for further clarification.

How to Get Technical Support

Please contact Technical Service by calling 1-800-274-6846. **Please note that you will be asked to provide proof of initial purchase when calling.** If a product requires further inspection, the Technical Service representative will explain and assist with any additional action needed. JET has Authorized Service Centers located throughout the United States. For the name of an Authorized Service Center in your area call 1-800-274-6846 or use the Service Center Locator on the JET website.

More Information

JET is constantly adding new products. For complete, up-to-date product information, check with your local distributor or visit the JET website.

How State Law Applies

This warranty gives you specific legal rights, subject to applicable state law.

Limitations on This Warranty

JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

JET sells through distributors only. The specifications listed in JET printed materials and on official JET website are given as general information and are not binding. JET reserves the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever. JET® branded products are not sold in Canada by JPW Industries, Inc.

Product Listing with Warranty Period

90 Days – Parts; Consumable items; Light-Duty Air Tools
1 Year – Motors; Machine Accessories; Heavy-Duty Air Tools; Pro-Duty Air Tools
2 Year – Metalworking Machinery; Electric Hoists, Electric Hoist Accessories; Woodworking Machinery used for industrial or commercial purposes
5 Year – Woodworking Machinery
Limited Lifetime – JET Parallel clamps; VOLT Series Electric Hoists; Manual Hoists; Manual Hoist Accessories; Shop Tools; Warehouse & Dock products; Hand Tools

NOTE: JET is a division of JPW Industries, Inc. References in this document to JET also apply to JPW Industries, Inc., or any of its successors in interest to the JET brand.



Safety warnings

For your own safety, read this instruction manual before operating the tool.

Wear Eye Protection

- **KEEP GUARDS IN PLACE** and in working order.
- **REMOVE ADJUSTING KEYS AND WRENCHES.** Form the habit of checking to see that keys and adjusting wrenches are removed from the tool before turning it on.
- **KEEP THE WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
- **DO NOT USE IN A DANGEROUS ENVIRONMENT.** Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
- **KEEP CHILDREN AWAY.** All visitors should be kept safe distance from the work area.
- **MAKE THE WORKSHOP KID PROOF** with padlocks, master switches, or by removing starter keys.
- **DON'T FORCE THE TOOL.** It will do the job better and safer at the rate for which it was designed.
- **USE THE RIGHT TOOL.** Don't force a tool or attachment to do a job for which it was not designed.
- **USE THE PROPER EXTENSION CORD.** Make sure you extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in the line voltage resulting in loss of power and overheating. **For runs up to 25 feet, use a 14 AWG or larger gauge cord. For runs up to 50 feet, use a 12 AWG or larger cord. Runs over 50 feet are not recommended.** If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.
- **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.
- **ALWAYS USE SAFETY GLASSES.** Also use face or dust masks if the cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- **SECURE WORK.** Use clamps or a vise to hold the work when its practical. It's safer than using your hand and it frees both hands to operate the tool.
- **DON'T OVERREACH.** Keep proper footing and balance at all times.
- **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
- **DISCONNECT TOOLS** before servicing; when changing accessories, such as blades, bits cutters, and the like.
- **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure the switch is in the off position before plugging in the machine.
- **USE RECOMMENDED ACCESSORIES.** Consult the owner's manual for recommended accessories. The use of improper accessories may cause a risk of injury.
- **NEVER STAND ON A TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
- **CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
- **DIRECTION OF FEED.** Feed work into a blade or cutter against the direction of rotation of the blade or cutter only.
- **NEVER LEAVE THE TOOL RUNNING UNATTENDED. TURN THE POWER OFF.** Don't leave the tool until it comes to a complete stop.

Assembly

1. Disconnect machine from power source.
2. Unpack and clean all rust protected surfaces with a mild solvent or kerosene. Do not use paint thinner, lacquer thinner, or gasoline - these items will damage painted surfaces.
3. Turn cam locks (A, Figure 1) to release the chuck.

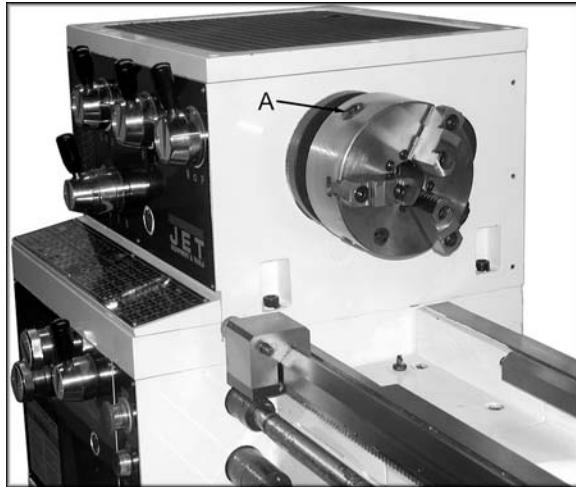


Figure 1

4. Remove the chuck and place it on a piece of wood.
5. Clean the spindle nose and internal taper thoroughly.
6. Screw the coupling assembly (A, Figure 2) onto the spindle threads located at the rear of the spindle.

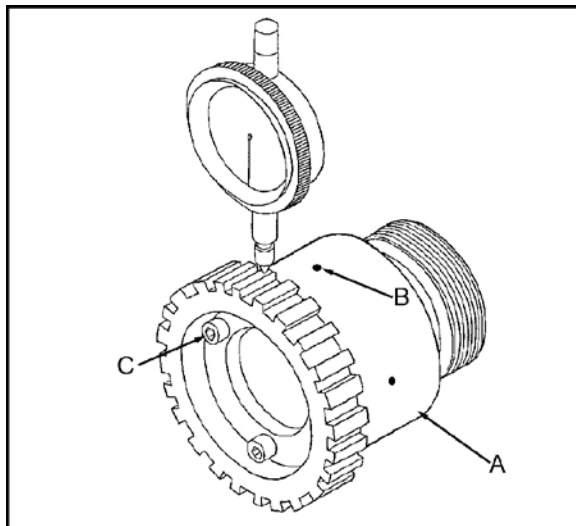


Figure 2

7. Open the end train door slightly to allow access and tighten the coupling in place using three hex socket screws (B, Figure 2).
8. Measure the runout on coupling using a dial indicator. The runout should be 0.005" or less.

Adjustments can be made by loosening three hex socket cap screws (C, Figure 2).

9. Thread the drawbar (A, Figure 3) into the collet closer assembly (B, Figure 3) until it is flush

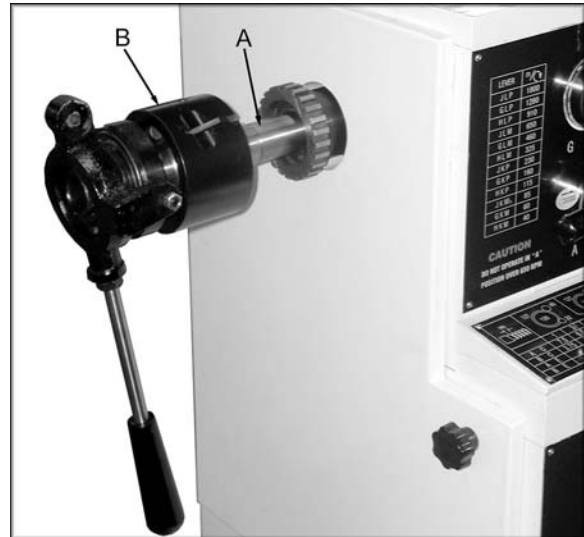


Figure 3

10. Slide collet closer assembly into spindle. Make sure it completely engages castled gear on the coupling.
11. Insert the collet sleeve into the spindle nose (A, Figure 4).
12. Insert a collet (B, Figure 4).

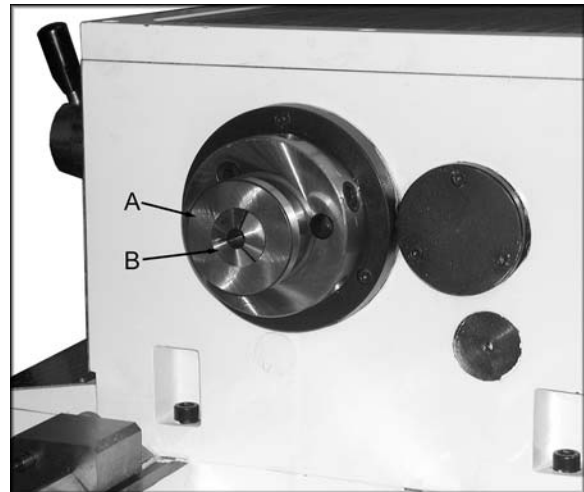


Figure 4

13. Screw the collet closer into collet by releasing collet closer assembly lock and turning collet closer outer flange (B, Figure 3) clockwise. Note: it is necessary to push collet in while turning closer body to engage draw bar with the collet. Continue turning until the collet taper is seated, but not tensioned in the taper.
14. Assemble all linkage and attach to collet closer body (Figure 5).

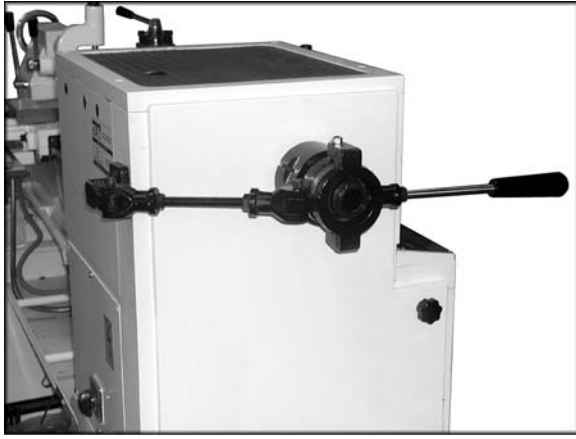


Figure 5

15. With the help of another person, hold the collet closer in position with the mounting foot against the rear of the end train cover. Note: the bearing shaft should be centered in the bearing body, (Figure 5).
16. Once the location of the fixed seat has been determined (should be similar to location shown in Figure 6), use a transfer punch to mark the location of three mounting holes.



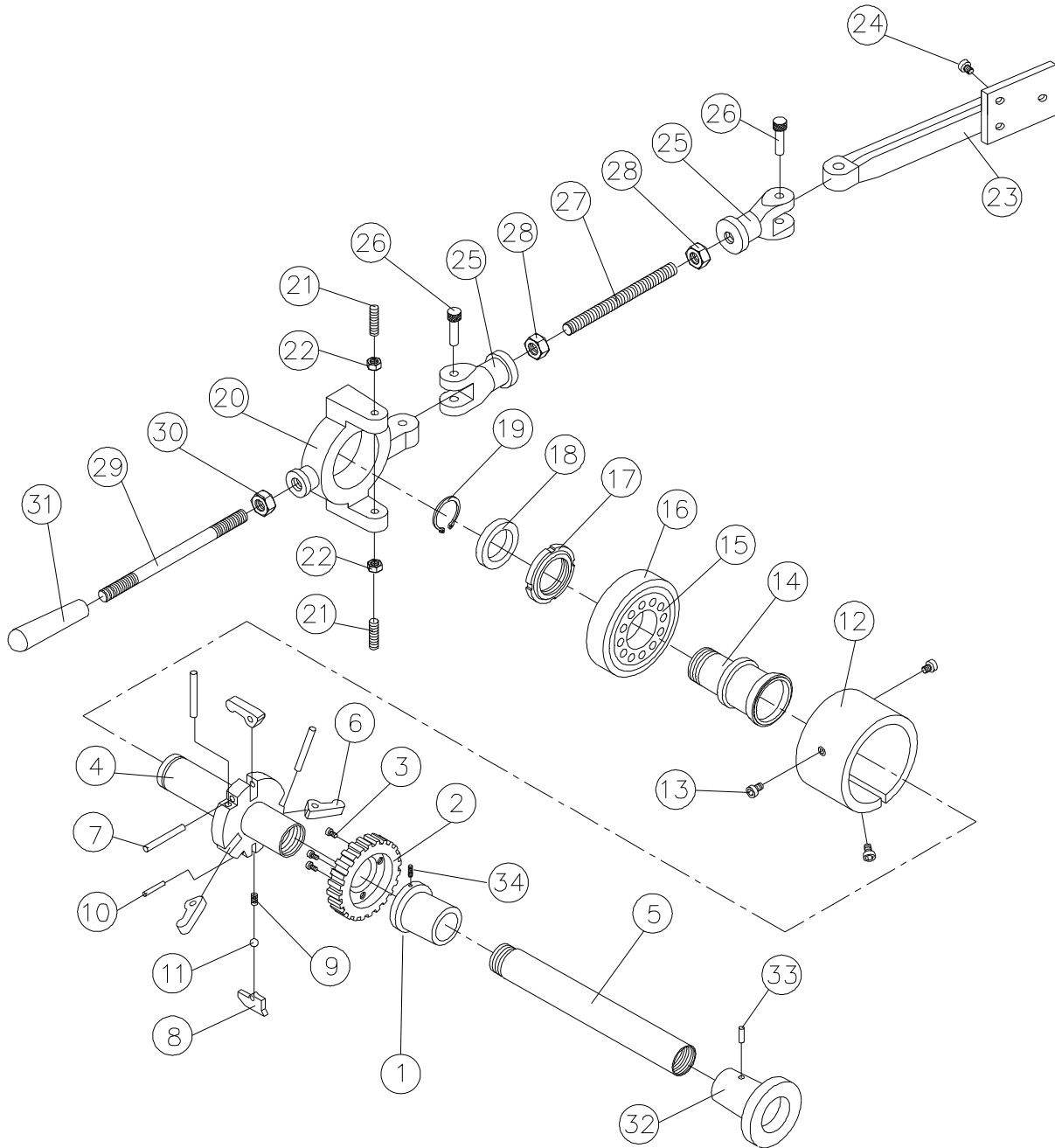
Figure 6

17. Drill three appropriate sized holes with a 0.203 drill bit. Note: do not drill through belts. The belt cover is approximately 0.3" thick so marking the drill bit will assist in drilling the correct depth.
18. Tap drilled holes with a 1/4"-20 tap.
19. Install the fixed seat to belt cover with three 1/4"-20 x 1" hex socket cap screws, and three 1/4" lock washers.
20. Connect and adjust all linkage so that the bearing shaft is centered in the bearing body, (Figure 5).
21. Place a cutter or material into the collet so you can adjust the outward flange (B, Figure 3). Turn the outward flange until you can move the lever and it "pops" into place locking the cutter or material into the collet.

Replacement Parts

To order parts or reach our service department, call 1-800-274-6848 Monday through Friday, 8:00 a.m. to 5:00 p.m. CST. Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

CC-GHW Collet Closer – Exploded View



CC-GHW Collet Closer – Parts List

Index No	Part No	Description	Size	Qty
1	85-0301	Sleeve Coupling		1
2	85-0102	Coupling		1
3	85-0102-00-1	Hex Socket Cap Screw		3
4	85-0103	Arbor		1
5	CC-05G	Draw Bar	495mm	1
6	85-0105	Buckle		3
7	85-0105-00-1	Pin		3
8	85-0106	Buckling Plate		1
9	85-0106-00-1	Spring		1
10	85-0107	Pin		1
11	85-0107-00-1	Steel Ball		1
12	85-0108	Outward Flange		1
13	85-0108-00-1	Hex Socket Cap Screw		3
14	85-0109	Bearing Shaft		1
15	85-0109-00-1	Ball Bearing		1
16	85-0110	Bearing Stand (re: 85-0109-00-1)		1
17	85-0111	Locking Nut		1
18	85-0112	Collar		1
19	85-0112-00-1	Retaining Ring (external)		1
20	85-0113	Bearing Body		1
21	85-0114	Set Screw		2
22	85-0114-00-1	Hex Nut		2
23	CC-23LN	Fixed Seat (length)	200L	1
24	85-0116-00-1	Hex Socket Cap Screw		3
25	85-0117-00	Coupling		2
26	85-0118-00	Special Pin		2
27	85-0119-00	Screw Bolt		1
28	85-0419-00-1	Hex Nut		2
29	85-0120-00	Screw Bolt		1
30	85-0122-00-1	Hex Nut		1
31	85-0121-00	Grip		1
32	85-0122-00	Sleeve		1
33	85-0123-00	Pin		1
34	85-0301-00-1	Set Screw		1



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