Code	Table size (LxW)	Magnetic force	Pole pitch	Parallelism of top to bottom
6537-400	400x200mm	12kgf/cm²	1+3mm	0.005mm/100mm
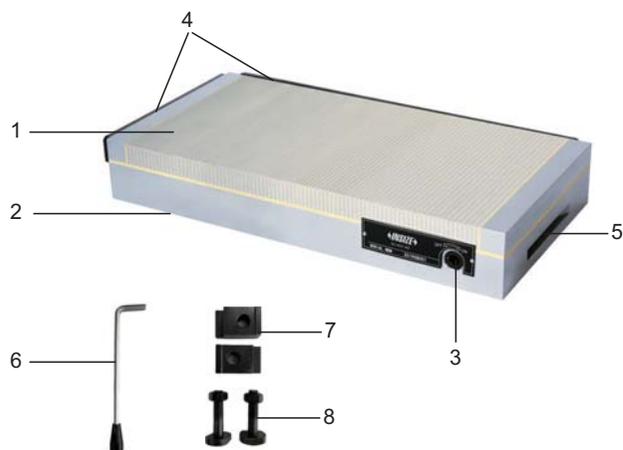
1-Table
2-Bottom
3-Magnetic switch
4-Baffle
5-Mounting slot
6-L-wrench
7-Fixed block
8-Screws and nuts

1. Used on for surface grinding machine to hold workpiece.

2. Installation:
   --- Clean the bottom of the chuck, and the machine table, place the chuck in the appropriate position on the machine table, and fix the chuck with the pressure plate, screws and nuts.
   --- Use a dial gage to measure the parallelism of the chuck table to the machine table, correct the chuck according to requirements, and can process the chuck table with the machine to reach the required parallelism.

3. Operation:
   --- Place the workpiece in the proper position on the chuck table, then use hex wrench to turn the magnetic switch from OFF counterclockwise to ON.

   --- If the workpiece is too small, you can add auxiliary stoppers around the workpiece according to the cutting direction and tooling direction of the tool. The auxiliary stoppers should be placed together with the workpiece before the workpiece is held, and should be against the side of the workpiece.
   --- After processing, use hex wrench to turn the magnetic switch from ON clockwise to OFF to disconnect the magnetic circuit and remove the workpiece from the chuck.

Unit: mm

L

W

1+3

steel copper

top

60

20

bottom
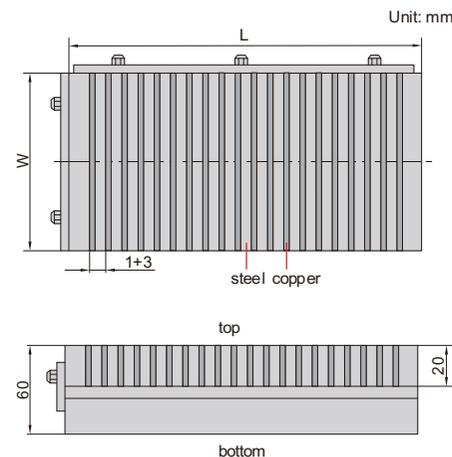
4. Notice:
   --- The chuck table is not hardened and has no hardness. Pay attention to protection when using.
   --- Keep chuck table clean, disconnect the magnetic circuit after use, and apply antirust oil.
   --- It is forbidden to stack sundries on the table to avoid affecting flatness.
   --- During long-term use, if the roughness, flatness of the table or the parallelism is out of tolerance after workpiece is placed, the processing conditions of the machine tool can be used to repair.
   --- Repair in time, if the operating force of the handle is too large or the holding force is obviously insufficient when using hex wrench to turn the switch.

MN-6537-C/E
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