

My New CDCO 5C Collet Chuck

By **R. G. Sparber**

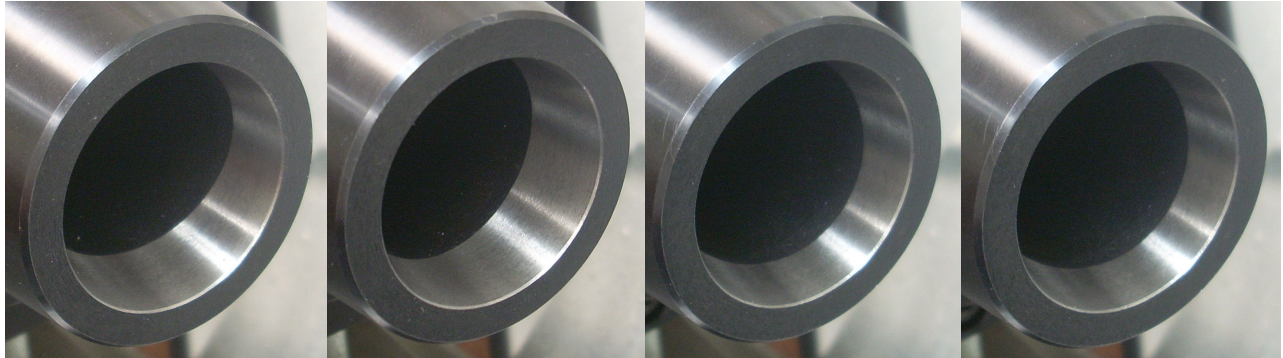
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Here is my CDCO Machinery Corp 5C collet chuck. It has been carefully mounted on a semi-finished back plate that has been machined in place on my lathe. As I measure the face of this chuck and its outside diameter, you would think I did a fairly good job. But take a close look at the tapered bore. When I measure it, I get a TIR of 0.01". That sure is a far cry from the 0.0004" shown in the spec sheet.

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Here is the taper as I turn the spindle 90° at a time. The camera position was not moved between shots:



The minimum width of the land is 0.35” and the maximum width is 0.55”. If the taper was centered, the land would be uniform.

I will be sending this sad puppy back for a new one tomorrow.

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