



Assembly Instructions and Parts Manual

5C Collet Closer

for E-1340VS/1440VS ELITE Lathes



JET
427 New Sanford Road
LaVergne, Tennessee 37086
Ph.: 800-274-6848
www.jettools.com

Part No. M-892036
Edition 1 03/2017
Copyright © 2017 JET



1.0 IMPORTANT SAFETY INSTRUCTIONS

WARNING – To reduce risk of injury:

1. Read and understand the entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace warning labels if they become obscured or removed.
4. Familiarize yourself thoroughly with the operation and safety instructions in your lathe manual before using this collet closer.
5. This lathe accessory is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a lathe, do not use until proper training and knowledge have been obtained.
6. Do not use this product for other than its intended use. If used for other purposes, JET disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
7. Always wear ANSI Z87.1 approved safety glasses or face shield while using a lathe. (Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.)
8. Before operating the lathe, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Do not wear loose clothing. Confine long hair. Non-slip footwear or anti-skid floor strips are recommended. Do not wear gloves.
9. Wear ear protectors (plugs or muffs) if noise exceeds safe levels.
10. CALIFORNIA PROPOSITION 65 WARNING: This product contains chemicals known to the State of California to cause cancer, or birth defects or other reproductive harm.
11. This product, when used for welding, cutting, or working with metal, produces fumes, gases, or dusts which contain chemicals known to the State of California to cause birth defects and, in some cases, cancer. (California Health and Safety Code Section 25249.5 et seq.)
12. Make certain the switch is in the OFF position before connecting the machine to the power supply.
13. Make certain the machine is properly grounded.
14. Make all machine adjustments or maintenance with the machine unplugged from the power source.
15. Remove adjusting keys and wrenches. Form a habit of checking to see that keys and adjusting wrenches are removed from the machine before turning it on.
16. Keep safety guards in place at all times when the machine is in use. If removed for maintenance purposes, use extreme caution and replace the guards immediately after completion of maintenance.
17. Check damaged parts. Before further use of the machine, 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.
18. Provide for adequate space surrounding work area and non-glare, overhead lighting.
19. Keep the floor around the machine clean and free of scrap material, oil and grease.
20. Keep visitors a safe distance from the work area. Keep children away.
21. Make your workshop child proof with padlocks, master switches or by removing starter keys.
22. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
23. Maintain a balanced stance at all times so that you do not fall or lean against the cutter or other moving parts. Do not overreach or use excessive force to perform any machine operation.
24. Use the right tool at the correct speed and feed rate. Do not force a tool or attachment to do a job for which it was not designed. The right tool will do the job better and more safely.
25. Use recommended accessories; improper accessories may be hazardous.
26. Maintain tools with care. Keep cutting tools sharp and clean for the best and safest performance. Follow instructions for lubricating and changing accessories.

27. Turn off the machine before cleaning. Use a brush or vacuum to remove chips or debris — do not use bare hands.
28. Do not stand on the machine. Serious injury could occur if the machine tips over.
29. Never leave the machine running unattended. Turn the power off and do not leave the machine until it comes to a complete stop.
30. Remove loose items and unnecessary work pieces from the area before starting the machine.
31. Do not attempt to adjust or remove tools during operation.
32. Never stop a rotating chuck or workpiece with your hands.
33. Choose a low spindle speed when working unbalanced workpieces, and for threading and tapping operations.
34. Do not exceed the maximum speed of the workholding device.
35. Do not exceed the clamping capacity of the chuck or collet.
36. Workpieces longer than 3 times the chucking diameter must be supported by the tailstock or a steady rest.
37. Avoid small chuck diameters with large turning diameters.
38. Avoid short chucking lengths and small chucking contact.
39. Do not operate the lathe in flammable or explosive environments. Do not use in a damp environment or expose to rain.

2.0 Assembly

Note: The following illustrations may or may not show your specific lathe model.

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, as these items will damage painted surfaces.
3. Turn cam locks (A, Figure 1) to release chuck. Remove chuck and place it on a piece of wood.

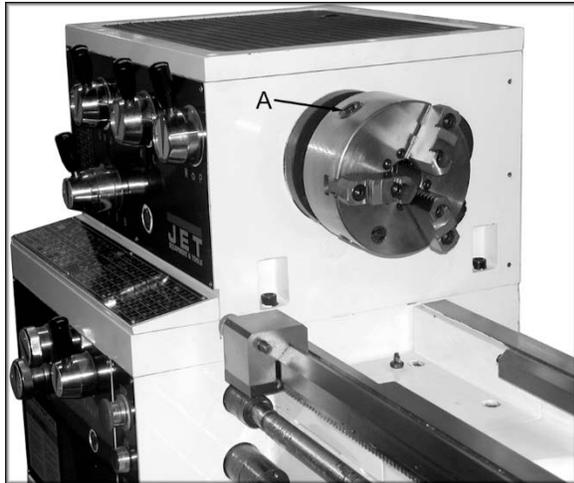


Figure 1

4. Clean spindle nose and internal taper thoroughly.
5. Screw coupling assembly (A, Figure 2) onto spindle threads located at rear of spindle.

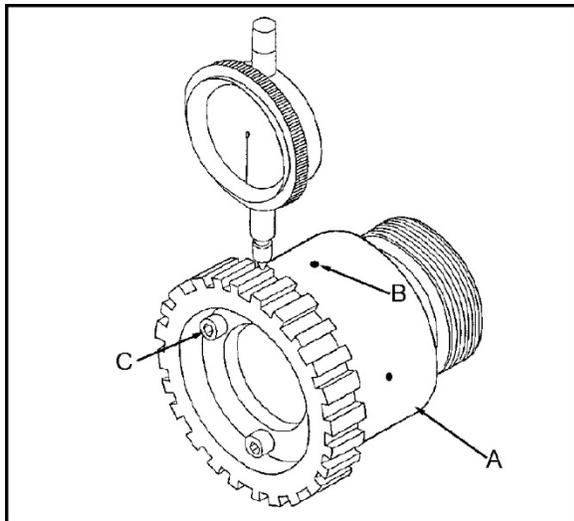


Figure 2

6. Tighten coupling in place using three hex socket screws (B, Figure 2).
7. Measure runout on coupling using a dial indicator. Runout should be 0.005" or less.

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

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

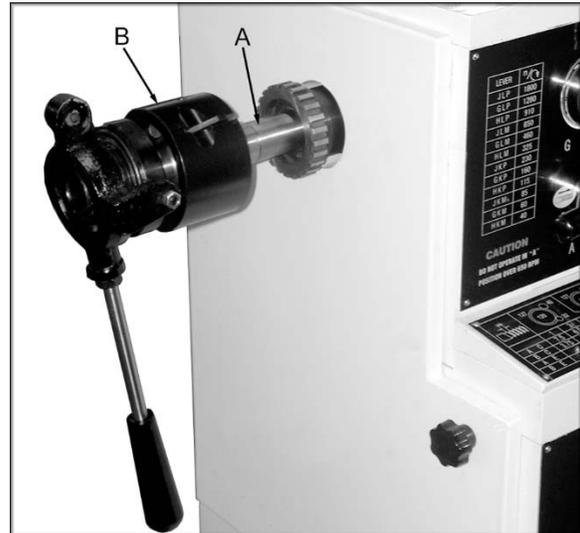


Figure 3

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

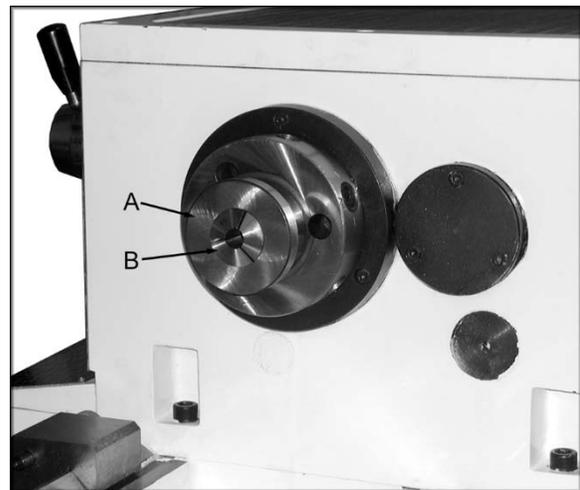


Figure 4

12. Screw 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 in collet while turning closer body to engage draw bar with collet. Continue turning until collet taper is seated, but not tensioned in the taper.
13. Assemble all linkage and attach to collet closer body (Figure 5).

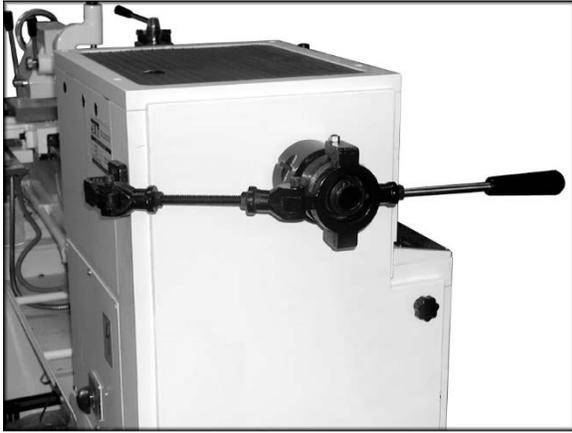


Figure 5

14. With the help of another person, hold the collet closer in position with the fixed seat against the headstock. Note: The bearing shaft should be centered in bearing body (Figure 5).
15. 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 the four mounting holes.



Figure 6

(measurements shown for reference only; your lathe model measurements may vary slightly.)

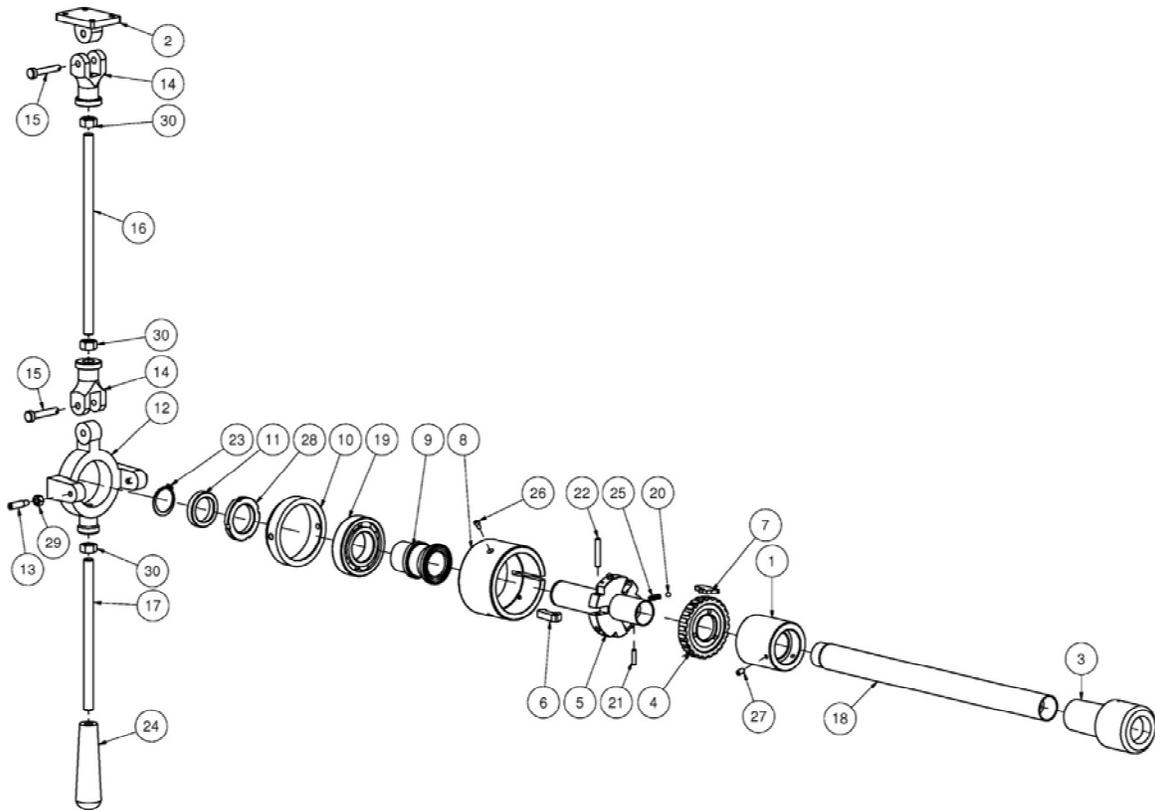
16. Drill four appropriate sized holes with a 0.203 drill bit. **Note: Do not drill through headstock panel.**
17. Tap drilled holes with a 1/4"-20 tap.
18. Install fixed seat to headstock with four 1/4"-20 x 3/4" hex socket cap screws, and four 1/4" lock washers.
19. Connect and adjust all linkage so that bearing shaft is centered in bearing body (Figure 5).
20. Place a cutter or material into collet so you can adjust the outward flange (B, Figure 3). Turn outward flange until you can move the lever and it "pops" into place, locking the cutter or material into the collet.

3.0 Replacement Parts

Replacement parts are listed on the following pages. 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.

Non-proprietary parts, such as fasteners, can be found at local hardware stores, or may be ordered from JET. Some parts are shown for reference only, and may not be available individually.

3.1.1 Collet Closer for E-1340VS/1440VS Lathes – Exploded View



Index No	Part No	Description	Size	Qty
	892036	5C Collet Closer Kit (#1 thru 30)		1
1	C51064006	Sleeve Coupling		1
2	C52302004	Fixed Seat (Length)		1
3	C53004118	Sleeve	#5	1
4	C54002038	Coupling		1
5	C54004047	Arbor		1
6	C54006001	Buckle		3
7	C54008007	Buckling Plate		1
8	C54012019	Outward Flange		1
9	C54014002	Bearing Shaft		1
10	C54016011	Bearing Stand		1
11	C54018020	Collar		1
12	C54020023	Bearing Body		1
13	C54021000	Set Screw		2
14	C54025015	Coupling		2
15	C54026005	Special Pin		2
16	C54027202	Stud	273L mm	1
17	C54029208	Lever Shaft	205L mm	1
18	C554920	Draw Bar	492L mm	1
19	BB-6208ZZ	Ball Bearing	6208ZZ	1
20	SB-6MM	Steel Ball	Ø6.0	1
21	5510484	Spring Pin	5 x 20L mm	1
22	F012000	Spring Pin	1/4" x 1-1/2"L	3
23	GC020101	Retaining Ring (external)	32 mm	1
24	GD020596	Grip	1/2"	1
25	GE040176	Spring		1
26	TS-1501021	Hex Socket Cap Screw	M4 x 8L	3
27	TS-1523031	Set Screw	M6 x 10L	3
28	GF030823	Locking Nut	AN08	1
29	TS-0561021	Hex Nut	5/16"-18	2
30	TS-0561051	Hex Nut	1/2"-13	3

4.0 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. JET woodworking machinery is designed to be used with Wood. Use of these machines in the processing of metal, plastics, or other materials outside recommended guidelines may void the warranty. The exceptions are acrylics and other natural items that are made specifically for wood turning.

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
1 Year – Motors; Machine Accessories
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; Air 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.



427 New Sanford Road
LaVergne, Tennessee 37086
Phone: 800-274-6848
www.jettools.com