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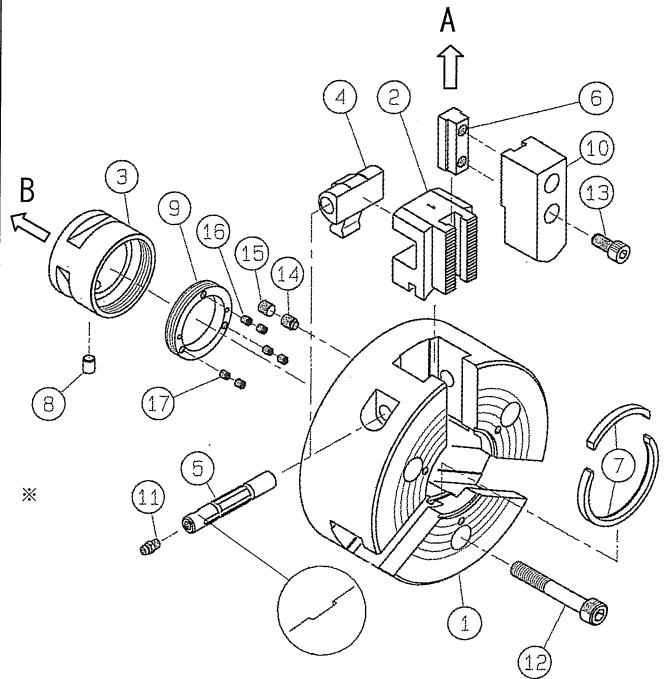
● **Disassembling procedures of HF,MO,HDM type chuck**

- (1) First of all, in advance of the start of disassembling, confirm the position of the number of each master jaw with respect to the chuck body. (Put the fitting marks on the chuck body to attach the jaws correctly in the original position at reassembling).
- (2) Unscrew both of the two screws, flat point screw ⑮ and full top point screw ⑭ (the hexagonal socket head stopper screws to lock the cam lever pin).
- (3) Extract the cam lever pin ⑤ making use of the screw hole for the grease nipple. (Detach the grease nipples.)
- (4) Extract the master jaw ② in direction of →A on the figure. The cam lever will come out together with the jaw.
- (5) Extract the chuck piston ③ in direction of →B on the figure.
- (6) Clean every part in washing fluid and inspect for abnormal wear or other damage.

● **Reassembling**

- (1) Assembling must be performed to return the chuck completely to the initial state, following reversely the disassembling procedures.
- (2) Apply the grease to every part, especially sufficiently to the chuck piston and the part of the master jaw mating with the cam lever.
- (3) Tighten the two hex. socket head stopper screws (to lock the cam lever pin) arranging in order of the full top point screw and next the flat point screw receding from the notch of the pin.
- (4) After completion of assembling, try to move the chuck-piston with hand to see its smooth movement and inspect for any abnormality.
- (5) Finally, apply the grease through the grease nipples.

No	Part name	Qu'ty
1	Chuck body	1
2	Base jaw	3
3	Chuck-piston	1
4	Cam lever	3
5	Cam lever pin	3
6	T-nut	3
7	Spacer	1
8	Stop pin	1
9	Ring screw	1
10	Soft jaw	3
11	Grease nipple	3
12	Hexagon socket head cap screw	3or6
13	Hexagon socket head cap screw	6
14	Hexagon socket head screw, long dog point	3
15	Hexagon socket head screw, flat point	3
16	Hexagon socket head screw, flat point	1



※ Size 4~6 inches ----3pieces
Size more than 8inches ----6pieces