



# Dead Stop Collet Maintenance Instructions

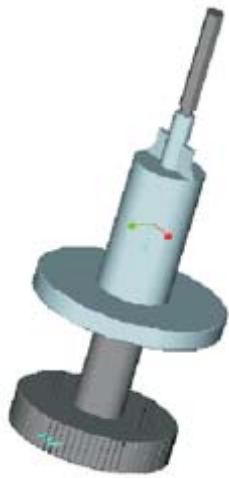
*\*NOTE: NEVER CLOSE COLLET WITHOUT A TOOL  
OR BLANK FITTED.*

*Spindles to be maintained every 100 hours*



# Dead Stop Collet Maintenance

## Main Items



1

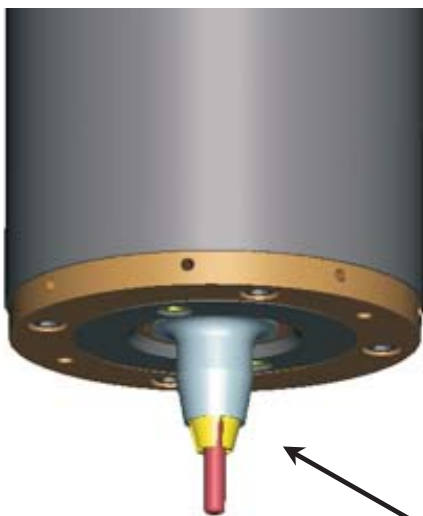


## Collet tool



2

2mm A/F  
Allen Key



Shaft

Dead Stop

lock nut

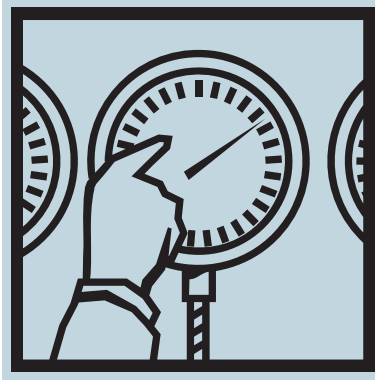
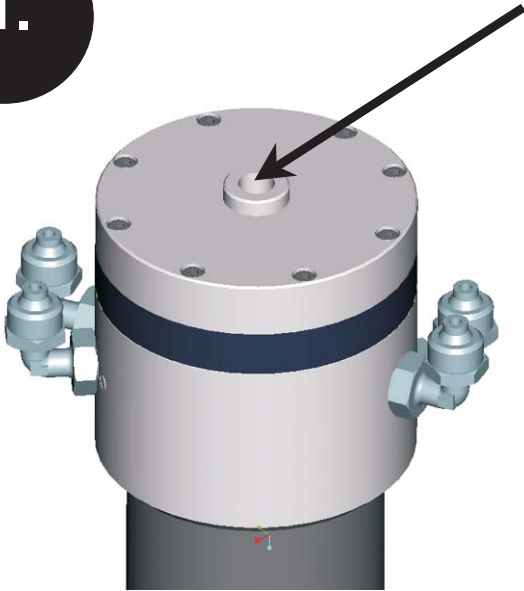
Collet  
stud



Collet



1.

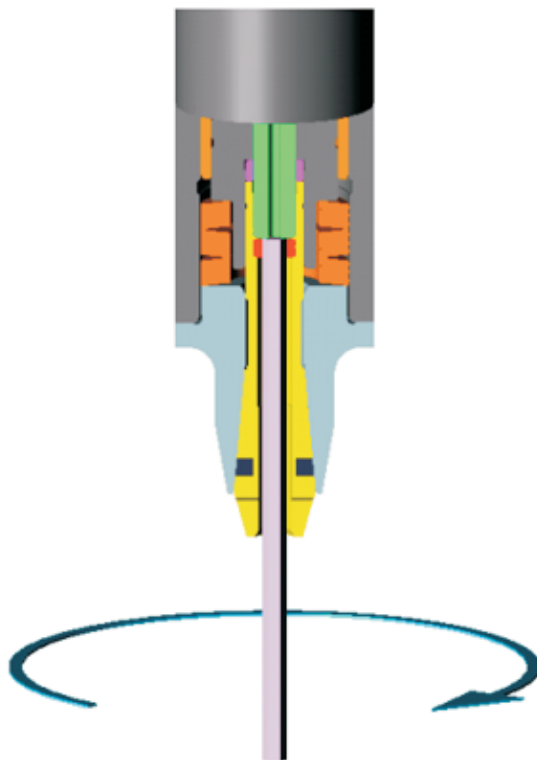


80 psi



Apply air pressure to collet actuation port

2.



2

Unscrew collet lock nut using 2mm A/F Allen key

3.

Unscrew collet



1

4.



Solvent



Use solvent and lint-free cloth to clean inside of shaft

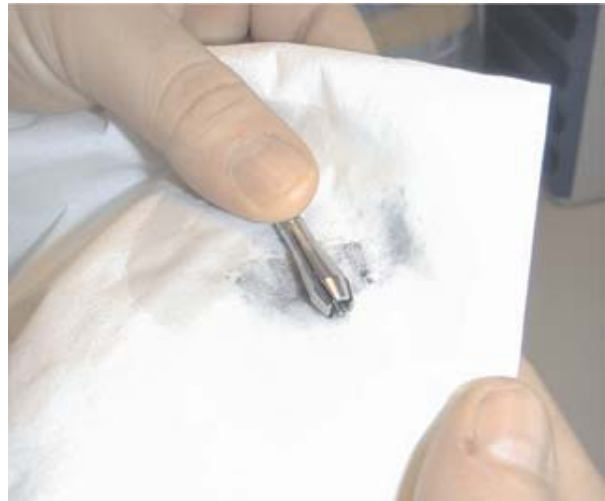


**5.**

## Clean Collet



Use solvent and lint-free cloth



Clean outside of collet



Spray solvent inside collet

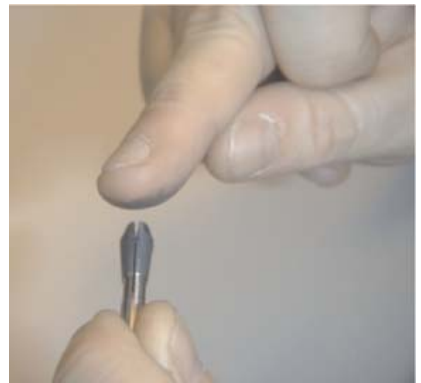


Use a pin to clear debris from inner bore of collet

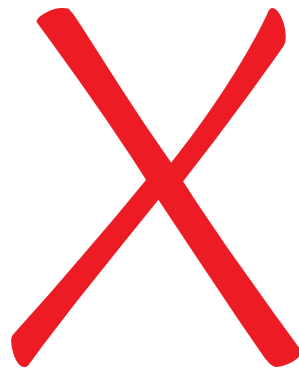


Clean with compressed air

6.

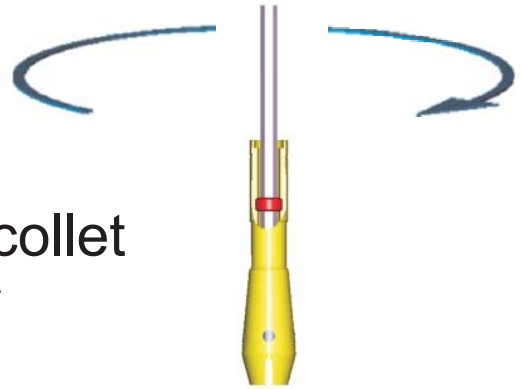


Apply MTLM grease to taper of collet



7.

Screw lock nut fully into collet using 2mm A/F Allen key



8.

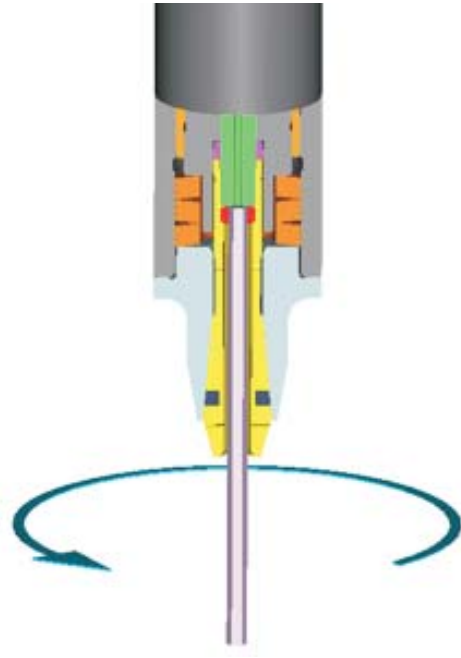
Torque 7 lb.inch



Screw collet into shaft using collet tool

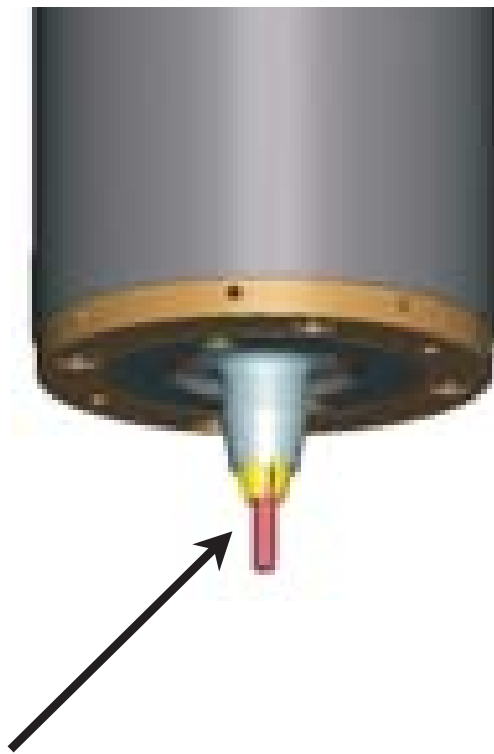
9.

Torque 5 lb.inch



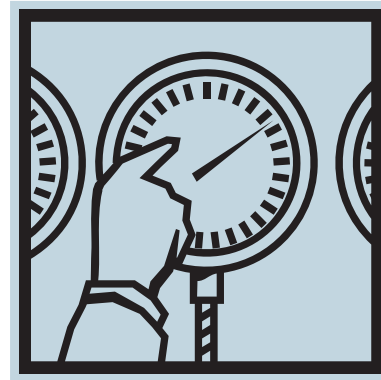
10.

Tighten lock nut



Ensure a pin is fitted in collet

11.



0 psi

Release air pressure from collet actuation port