



ROYAL QUICK-GRIP ACCU-LENGTH STYLE COLLET CHUCK INSTRUCTIONS

1. COLLET CHUCK INSTALLATION INSTRUCTIONS

- 1.1. Remove any existing chuck or tooling from spindle nose.
- 1.2. Remove any existing drawtube adapter.
- 1.3. Make sure drawtube is fully threaded into actuator.
- 1.4. Clean spindle nose and drawtube threads thoroughly.
- 1.5. Make sure drawtube is in extended position.

FOR A CHUCK WITH A BACK PLATE:

- 1.6. Clean inside taper and back mounting surface of back plate thoroughly.
- 1.7. Place back plate onto spindle nose aligning the drive button on the spindle nose with one of the drive button holes on the rear of the back plate.
- 1.8. Attach back plate securely to the spindle nose with the six supplied cap screws. Cross tighten screws and torque per chart below.
- 1.9. Clean inside taper and back mounting surface of chuck body thoroughly.
- 1.10. Thread collet chuck fully onto drawtube then back off to align mounting holes with tapped holes on face of back plate.
- 1.11. Carefully retract drawtube allowing chuck to be drawn tightly against the back plate.
- 1.12. Attach collet chuck securely to back plate with the six supplied cap screws. Cross tighten screws and torque per chart below.

FOR A CHUCK WITHOUT A BACK PLATE:

- 1.13. Clean inside taper and back mounting surface of chuck body thoroughly.
- 1.14. Thread collet chuck fully onto drawtube then back off to align mounting holes with tapped holes on face of spindle.
- 1.15. Carefully retract drawtube allowing chuck to be drawn tightly against the spindle nose.
- 1.16. Attach collet chuck securely to the spindle nose with six supplied cap screws. Cross tighten screws and torque per chart below.

2. COLLET INSTALLATION INSTRUCTIONS

- 2.1. Move drawtube to the retracted (open) position.
- 2.2. Insert pins of collet installation tool into holes on face of collet and compress collet.
- 2.3. Take note of where keyway is located on collet.
- 2.4. Insert collet firmly into chuck aligning key with keyway and release installation tool.

WARNING: do not exceed chuck's max drawbar force. Exceeding the max drawbar force could result in damage to the chuck and / or collet.

COLLET TYPE	MAX DRAWBAR FORCE (LBS.)
QG-32	5,620
QG-42	7,865
QG-52	7,865
QG-65	10,115
QG-80	11,240
QG-100	14,610

THREAD SIZE	RECOMMENDED TIGHTENING TORQUE
M6	9.4 ft-lbs
M8	28.2 ft-lbs
M10	53.5 ft-lbs
M12	78.8 ft-lbs
M16	184.4 ft-lbs
M20	296.6 ft-lbs
7/16-14	70 ft-lbs
1/2-13	110 ft-lbs
5/8-11	210 ft-lbs
3/4-10	380 ft-lbs

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