

## REPAIR INSTRUCTIONS

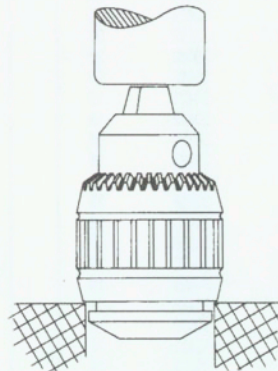
### DISASSEMBLY

#### Plain Bearing Chucks:

Extend the jaws to half capacity, press the sleeve off over front (jaw end) of body, remove the nut halves (illus. E).

#### Ball Bearing Chucks:

Extend the jaws to half capacity, press the sleeve off over front (jaw end) of body, remove the nut halves, jaws, bearing race, and thrust washer (illus. E).



illus. E

### ASSEMBLY

**CAUTION:** Each of the three jaws differ slightly from the other by the location of the threaded portion (illus. G). In order to ensure proper operation, they must be re-installed in the proper sequence.

#### Plain Bearing Chucks:

Refer to illus. C and insert the jaws in the correct sequence when viewing the chuck from the body nose diameter. insert No. 1 jaw (with small step) first, then No. 2 jaw (with largest step) in the clockwise position, then No. 3 jaw (without a step) should be inserted.

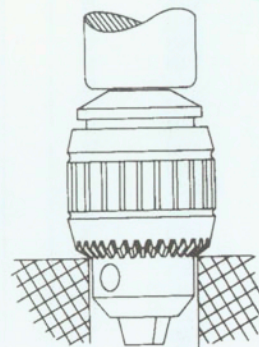
Turn chuck jaws to closed position and check to ensure that all three jaws are properly aligned. The height of all three jaws should be uniform.

A good grade of grease should be applied to the jaw and nut threads, then the nut halves should be closed around the jaws. Extend jaws to half capacity. Press on the sleeve with an arbor press (illus. F).

#### Ball Bearing Chucks:

Slip the thrust race over jaw end of the body until it contacts the rear flange. Slip the caged bearing over jaw end of the body until it contacts the thrust race.

Follow Plain Bearing jaw assembly and nut procedure.



illus. F

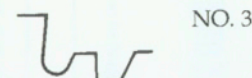
**JAW NUMBER INDICATED BY PROFILES SHOWN BELOW.**



NO. 1



NO. 2



NO. 3

illus. G - Jaw Identification