



ROYAL 5C, 3J & 16C PULLBACK STYLE COLLET CHUCK INSTRUCTIONS

1. COLLET CHUCK INSTALLATION INSTRUCTIONS

(Note: See attached collet chuck assembly drawing for numbers referenced below.)

- 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.
- 1.6. Thread supplied drawtube adapter(#5) fully onto drawtube.
- 1.7. Make sure drawtube is in retracted position.
- 1.8. Clean inside taper and back mounting surface of collet chuck(#1) thoroughly.
- 1.9. Slip collet chuck onto spindle nose, aligning drive button on spindle nose with drive button hole in rear of collet chuck.
- 1.10. Attach collet chuck securely to spindle nose with the six supplied cap screws(#2). Cross tighten screws and torque per chart below.

2. COLLET INSTALLATION INSTRUCTIONS

(Note: See attached collet chuck assembly drawing for numbers referenced below.)

- 2.1. Move drawtube to the extended (open) position.
- 2.2. Remove drive key(#3) and M5 socket head cap screw(#4) from collet chuck(#1).
- 2.3. Take note of where keyway is located on collet.
- 2.4. Thread collet into drawtube adapter(#5) until collet angle contacts angle in collet chuck.
- 2.5. Continue to thread collet into drawtube adapter until keyway in collet lines up with one of the tapped holes in the collet chuck.
- 2.6. Install drive key into tapped hole in collet chuck that lines up with the keyway in the collet.
- 2.7. Install M5 socket head cap screw into opposite tapped hole in collet chuck.

WARNING: actuating collet without a workpiece installed could result in damage to the collet or collet chuck.

WARNING: for threaded nose collet chucks, do not exceed manufacture's rpm and drawbar force recommendations for any threaded accessories.

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.)
5C	4,490
16C	5,390
3J	5,390

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

Any questions, call a Royal Products application engineer at 1-800-645-4174.