



2075HP PARTS LIST SUPPLEMENT

Use of the 2075HP Collet Chuck

1. Select the smallest collet that will slide over the valve stem.
2. Place the grooved end of the collet into the nut at an angle. Engage the groove of the collet into the large part of the eccentric ring in the nut. Straighten the collet until it snaps into the nut. Reverse to remove collet.
3. Screw the nut onto the shaft lightly, making sure the collet and shaft bore are clean.
4. Insert the valve to the desired depth and tighten collet by hand. Be sure to keep hands clear of the grinding wheel. Always use the rubber valve shield to keep oil and grit out of the collet.
5. If required the supplied wrench may be used to snug the nut down. The large end of the aligner wrench may be used in the cross hole of the shaft to hold it in place while tightening the nut.
6. A moveable stop may be moved ahead to set a stop point for valve loading by using the long end of the aligner wrench to push with.
7. To remove the valve, unscrew the nut about 1 turn. This will pull the collet from the shaft.

Be sure to keep collets and shaft taper clean to maintain accuracy.

Available Service Parts

Part No.	Description
66792	Chuck Assembly
66793	Nut
66794	Stop
66789	Wrench

Available Collets

Catalog No.	Size
607-4	3-4mm
607-5	4-5mm
607-6	5-6mm
607-7	6-7mm
607-8	7-8mm
607-9	8-9mm
607-10	9-10mm
607-11	10-11mm
607-12	11-12mm
607-13	12-13mm
607-14	13-14mm
607-15	14-15mm
607-65	5.5-6.5mm
607-75	6.5-7.5mm

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