



## 2075HPA PARTS LIST SUPPLEMENT

Use of the 2075HPA Air Collet Chuck

### WARNING

*TO PREVENT CONTACT WITH THE GRINDING WHEEL, BE SURE TO TURN OFF THE MACHINE BEFORE MAKING ANY ADJUSTMENTS TO THE VALVE SPINDLE.*

*FAILURE TO DO SO MAY CAUSE PERSONAL INJURY.*

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. Depress the collet control button to open position. The collet may be locked in the open position by turning the button when depressed.
4. Make sure that the spindle taper and threads are clean.
5. Thread the "T" handle into the internal stop inside the spindle nose. This will allow you to move the adjustable stop to the desired position.
6. Screw the nut onto the spindle until it is bottomed on the large black cylinder. Do not over-tighten as this will make the nut hard to remove.
7. Depress the collet button and insert the valve to the desired depth. Release the button to close the collet. The internal stop may be moved back by pushing in with the valve. 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. The accuracy of your machine depends on keeping the collet and spindle taper clean.*
8. Adjust the air pressure starting at 15 PSI and raising it slowly, until it is high enough to hold the valve securely. Excessive air pressure will cause the collet to stick. A stuck collet may be removed by unscrewing the nut about 4-5 turns. This will pull the collet free. ***DONOT*** hammer on the valve or spindle to free a stuck collet. *Always make any of these adjustments with the machine off to prevent contact with the grinding wheel. FAILURE TO DO SO MAY CAUSE PERSONAL INJURY.* If collet sticking persists reduce the air pressure slightly and add a small amount of light oil to outside of the collet.
9. To remove the valve, depress the collet button to the open position. If the collet does not release the valve, turn off the machine and unscrew the collet nut about 4-5 turns. This will pull the collet and valve free from the spindle.
10. Be sure to keep collets and shaft taper clean to maintain accuracy.
11. Once a month add 6 drops of 30W oil or clean SIOUX #250A to the oil cup in front of the collet release button. This will renew the oil supply for the chuck spindle bearings.

# SIOUX TOOLS INC.

250 SNAP-ON DRIVE ■ PO BOX 1596 ■ MURPHY, NC 28906 ■ USA ■

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## Available Service Parts

Part No.	Description
67955	Regulator Bracket
67956	Filter - Regulator
67957	Check Valve
67958	Control Valve
67959	Shim
67960	Wick
67971	Switch Plate
67972	Pipe Nipple 1/8" NPT
67973	Air Fitting (3)*
67974	Tube
67979	Spindle Assembly
67980	Bearing Sleeve
67991	Dust Sleeve
67992	Pulley
67993	Cover Plate
67995	Muffler
67996	Label
68384	Nut Assembly

## 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
607-16	15-16mm
607-17	16-17mm
607-65	5.5-6.5mm
607-75	6.5-7.5mm

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