

How to Replace Collets and Tools

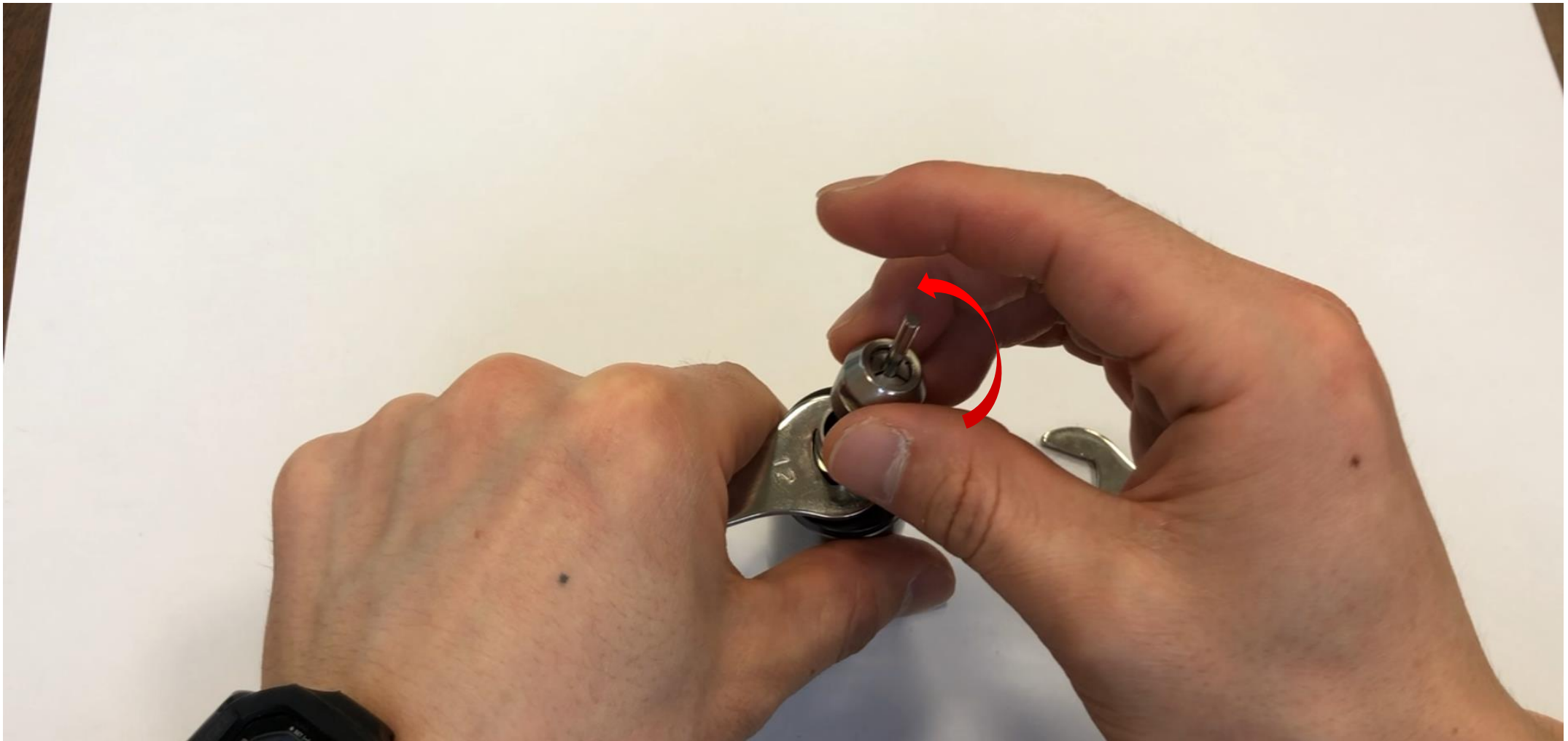
*NR-3060S with CHK collet is used on this document.



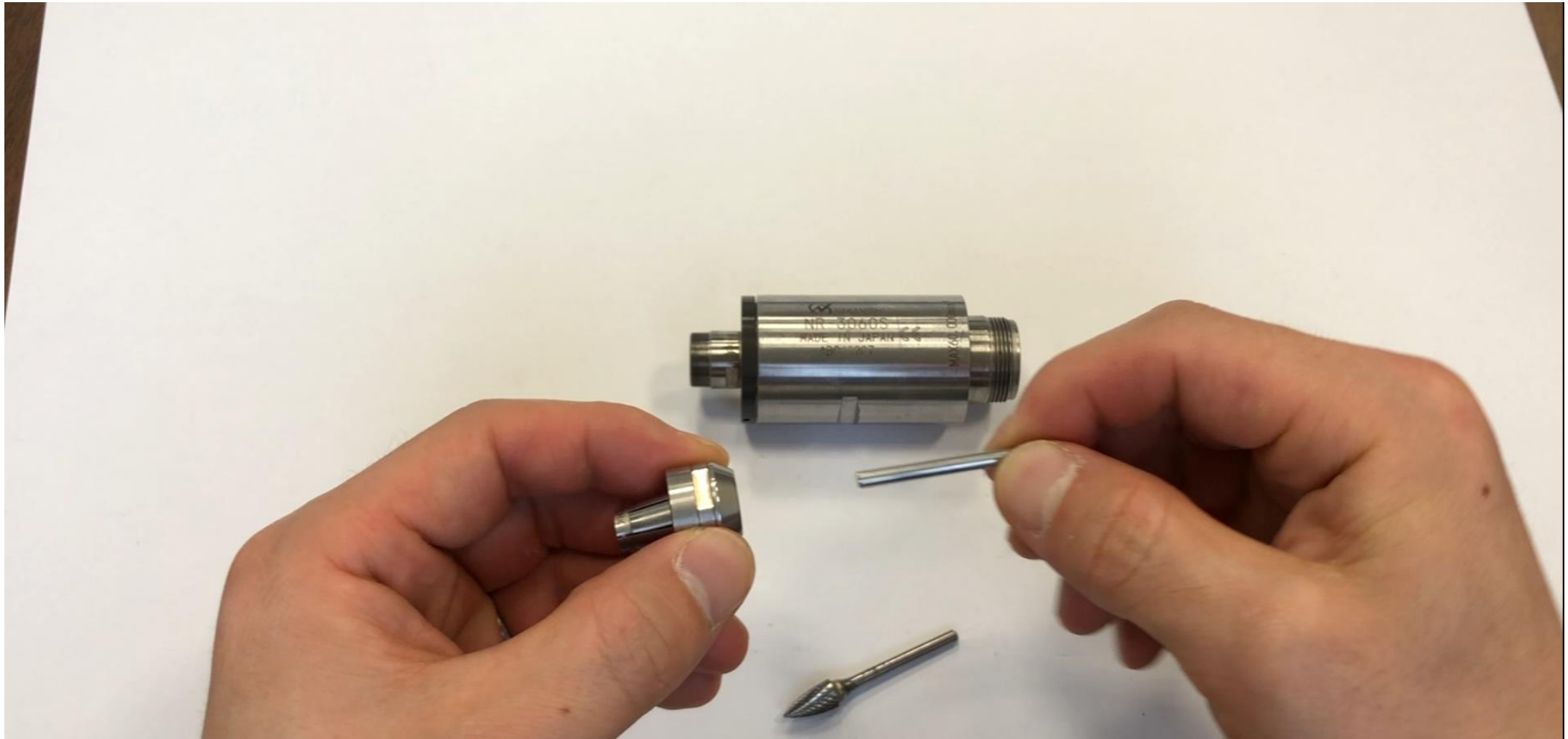
Hang the provided 12 mm wrench on the groove of the spindle shaft to fix the shaft.



Hang the provided 14 mm wrench on the groove of the collet nut and turn it counterclockwise.



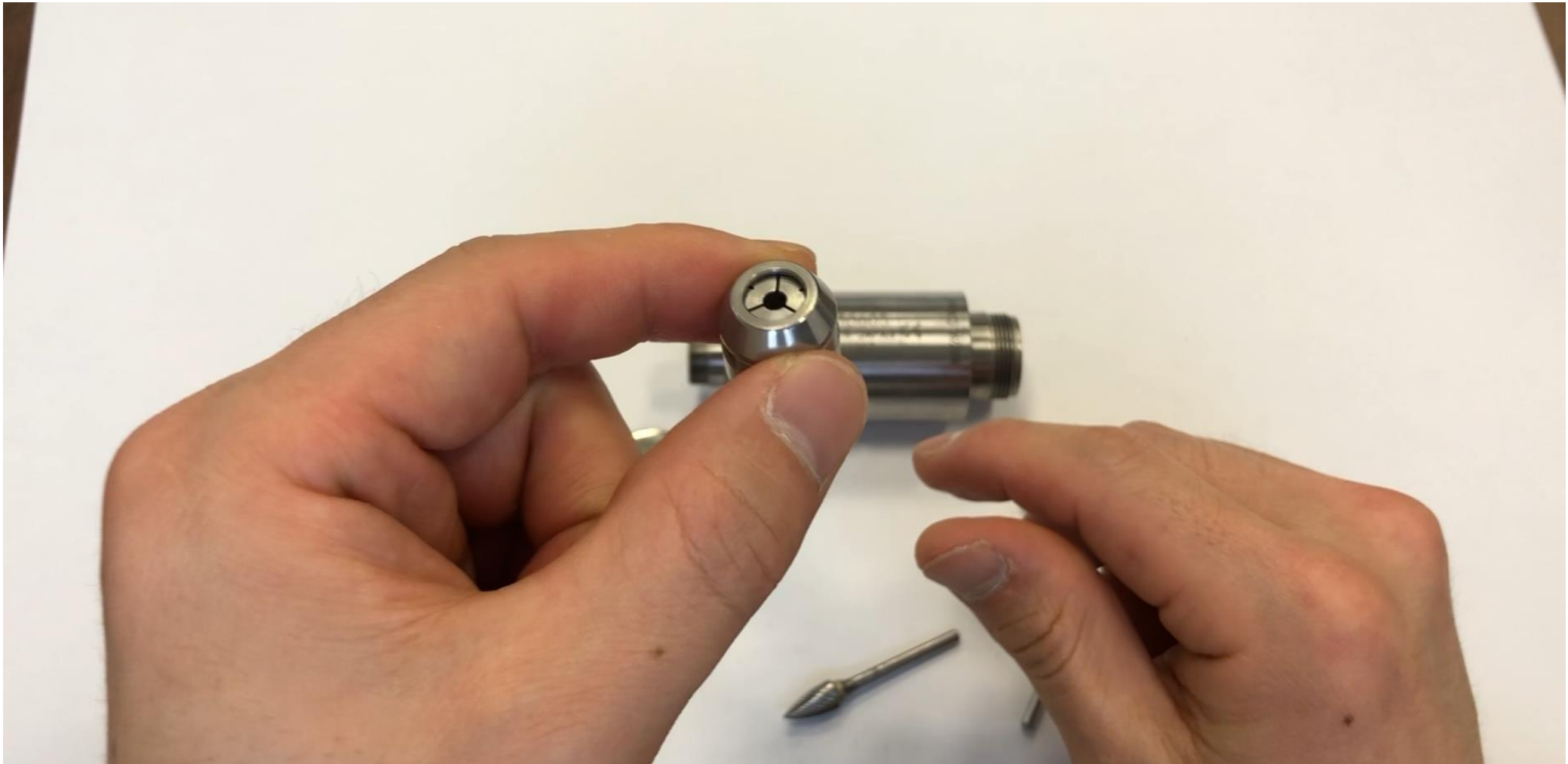
Loosen the collet nut.



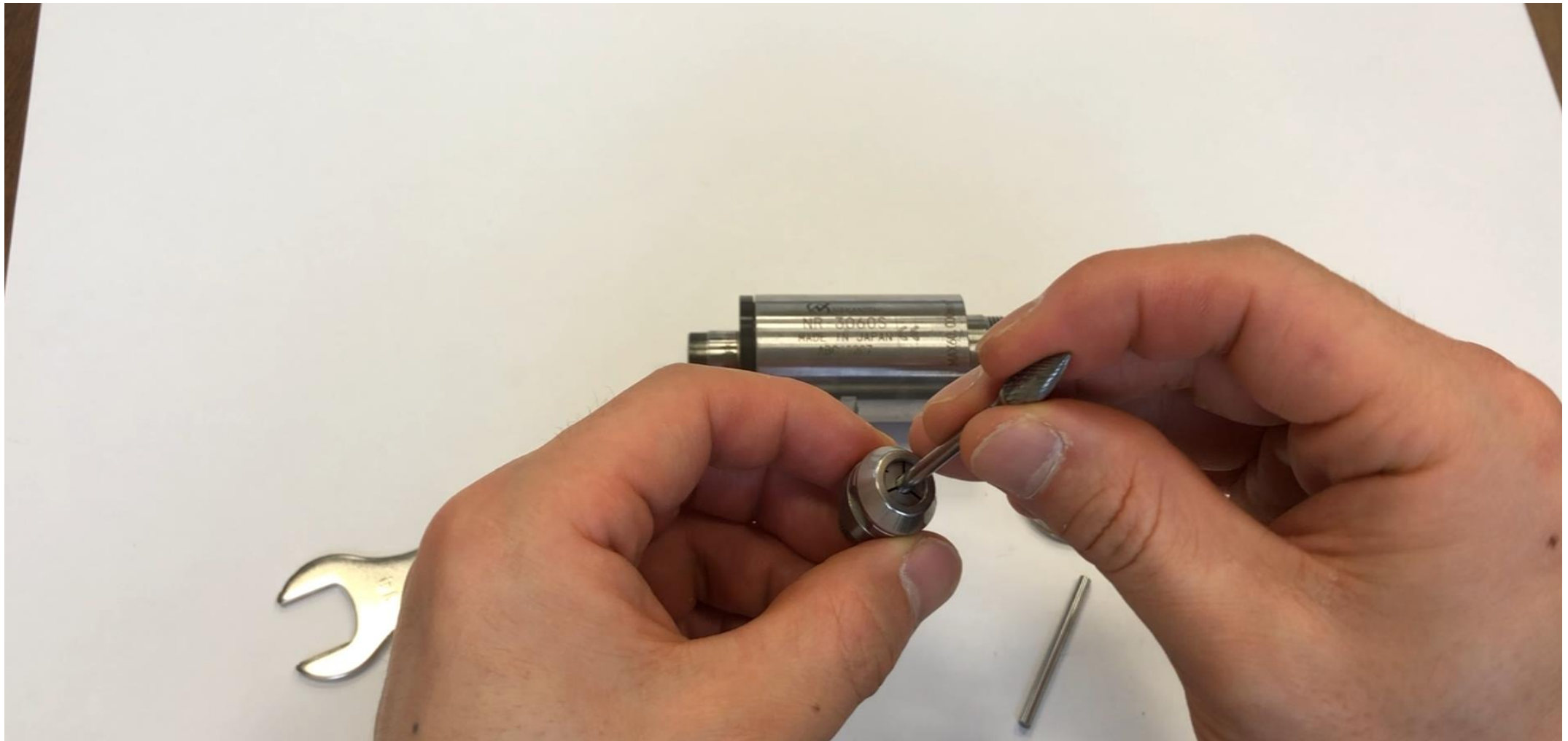
Pull out the tool.



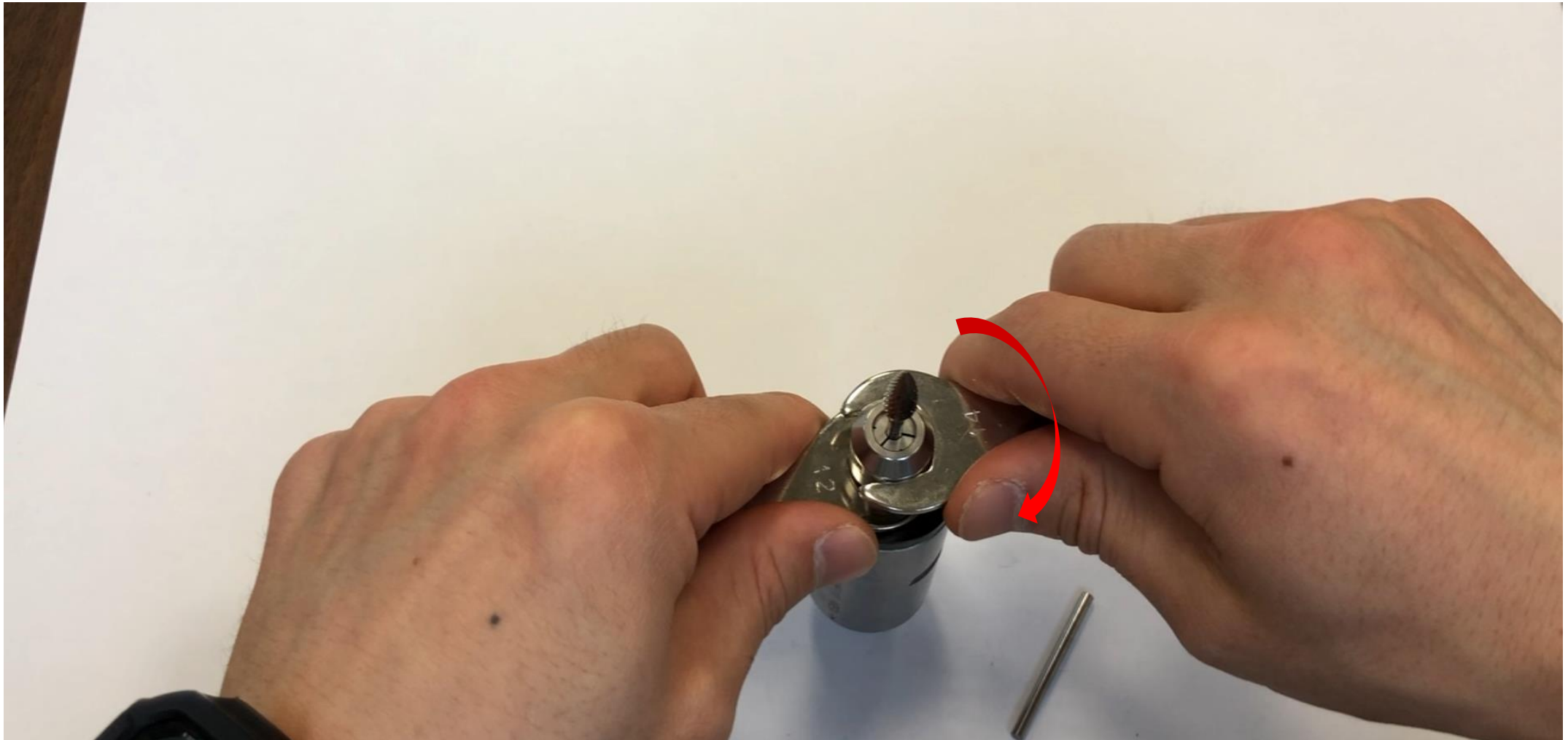
Remove the collet from the collet nut.



Insert the replacement collet with the collet surface is parallel to the collet nut. Confirm that it remains in place when shaken.
*Note that inserting the collet with a tilt may result in a malfunction.



Insert the replacement tool.



Fix the spindle shaft again with the wrench and turn the collet nut clockwise to secure the tool with proper tightening torque.

*For details of proper tightening torque, see the next page.

Proper tightening torque

Proper tightening torque depends on the type and size of collet.

for CHK collet (ϕ 3.0–6.0): 7.0 N·m

for CHA collet (ϕ 3.0–4.0): 6.0 N·m

for CH16 collet (all sizes): 8.0 N·m

[Other sizes]

for CHK collet

Diameter (mm)	Tightening torque(N·m)
0.5–1.0	2
1.1	3
1.2–2.0	3.5
2.1–2.5	4
2.6–2.7	5.5
2.8–2.9	6

for CHA collet

Diameter (mm)	Tightening torque (N·m)
0.5–0.8	1.5
0.9–1.5	2
1.6–1.8	2.5
1.9–2.2	3
2.3–2.4	3.5
2.5	4
2.6	4.5
2.7–2.8	5
2.9	5.5



Confirm that the tool cannot be removed when pulled.



Complete.

