

## VX Assembly & Tightening Instructions

The instructions below are a basic procedure. Always use proper safety equipment when working with any machine tool component.



Turn locking collar counter-clockwise until it stops.



Insert collet and turn clockwise. Use Flat Screw Driver if required.



Turn collet until it stops or reaches 1/8" from the face of the chuck. Assemble loose, ***Do not tighten!*** Thread gap is required for proper function.



Insert cutter, while holding the cutter hand tighten the locking collar clockwise until the collet holds the tool.



Tighten locking collar to 30 ft/lbs Maximum Do not over tighten or tool can jam or cause excessive TIR!