

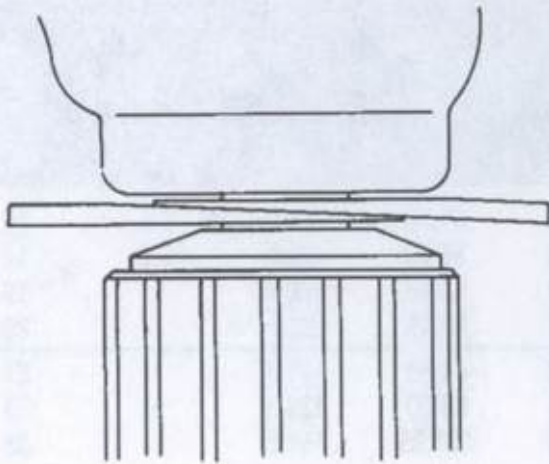
## **On Tapered Spindles**

### **To mount chuck:**

Clean both tapers of all grease and grit. With the chuck jaws completely retracted into the chuck and using a thin piece of wood to protect the chuck nose, tap the chuck into place on the spindle.

### **To Remove chuck:**

If a power tool has a tapered spindle, the chuck may be removed from the spindle by inserting chuck removal wedges between the chuck back and the spindle housing (Illus. B).



*Illus. B*

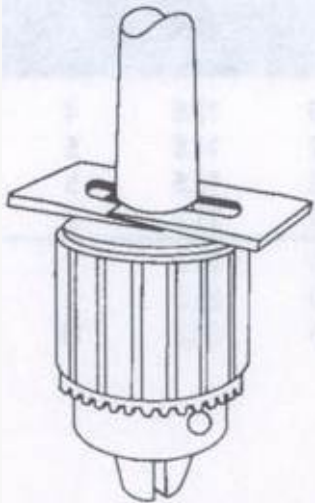
### **On Tapered Shank Arbors**

#### **To mount chucks:**

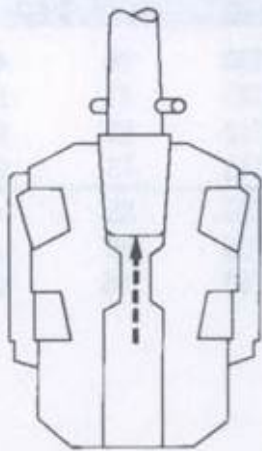
Clean both tapers as above. With the jaws retracted into the chuck and with the chuck nose resting on a wooden bench, strike the tang of the arbor lightly to seal it into the chuck. Do NOT assemble on an arbor press as excessive pressure will expand the chuck body and distort the chuck jaw holes.

#### **To remove chucks:**

Insert wedges between the back of the chuck and the shoulder of the arbor (Illus. C). In case the mounting taper of the arbor does not provide a shoulder, a cross hole should be drilled through the neck of the arbor (illus. D.) and a cross pin inserted. Then the wedges can be used between the chuck back and the cross pin. If desired, a hole may be drilled through the soft center portion of the chuck body (Illus. D.), and a pin may then be used with an arbor press to force the arbor out of the chuck.



*Illus. C*



*Illus. D*