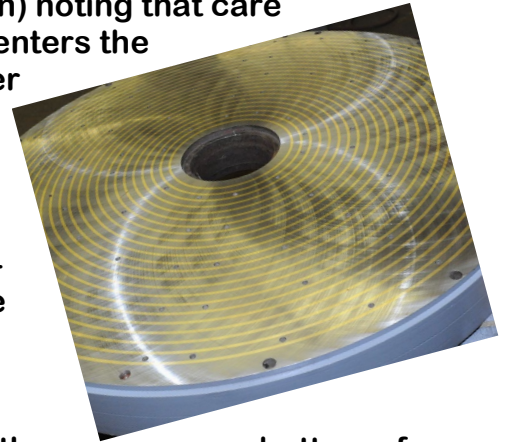




5015 28<sup>th</sup> Avenue  
Rockford, IL 61109  
ph. (815)962-8700  
fax (815)398-0285  
info@magnalock.com  
www.magnalock.com

### *Rotary Chuck Installation*

1. Grind top of table (surface that chuck mounts on) noting that care must be taken to assure that no contamination enters the gear case for the table drive. A temporary cover must be fabricated and installed.
2. Install 3 equally spaced set-screws in the table (outer chuck mounting holes). These should extend about 1" above the table top. These set-screws are to position and hold the chuck in the next procedure which is grinding the chuck bottom.
3. Remove the collector assembly retainer ring in the bottom of the chuck and the brass cover plate on the top side of the chuck. Place the chuck face (top) side down on to the table using the 3 set-screws installed in the previous step as a guide. Grind the bottom of the chuck. Note that care must be taken to assure that no contamination enters the gear case for the table drive. Grind tolerance 0.0" to 0.0005" high in center. When this is achieved, remove chuck and set-screws.
4. Re-install bottom collector assembly retainer ring. Clean and coat table with light coat of oil. Clean chuck bottom and coat with oil. Install chuck on table and tighten all bolts. Next, install brushholder assembly. Now, install brass top cover plate as described in next step.
5. The brass center plate of the chuck only has to be tightened 15-17 foot pounds. Make sure all the bolts are the same foot pounds. When replacing the brass center plate always replace the rubber gasket to ensure a good seal to prevent contaminants from entering into the chuck and possibly doing damage.
6. Grind chuck top plate, coolant should be used.



*If you should have any questions regarding these procedures, please contact us immediately.*