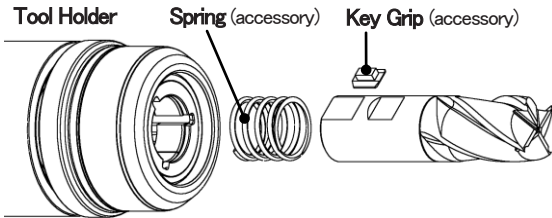


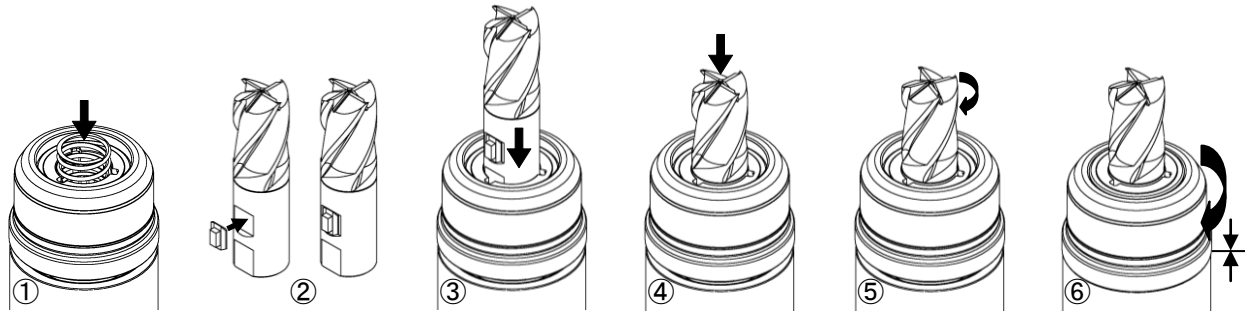
Thank you for purchasing the **BIG** MEGA Perfect GRIP.
Please read these instructions before use and keep them where the operator may refer to them whenever necessary.

SPECIFICATION



- The chuck is for positive rotation. It cannot be used in reverse rotation.
- Please use the cutting tool of straight shanks with drive flat according to JIS B 4005 , ISO 3338-2 , DIN 1835-1 Form B and ASME B94.19.

INSTALLING THE CUTTING TOOL



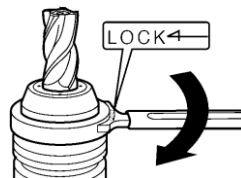
- ① Insert the spring in the chuck.
- ② Insert a Key Grip into the Weldon flat of the cutting tool shank.
- ③ While holding the Key Grip in the Weldon flat, insert the cutting tool into the tool holder bore. The Key Grip must align with one of the three key grooves.
- ④ Push the cutting tool into the tool holder bore until it stops and should be under slight spring tension.
- ⑤ Rotate the cutting tool clockwise until it stops. (Approximately 20 degrees)
- ⑥ Using a MEGA WRENCH, tighten the clamping nut until it rests securely against the end face of tool holder body.(no gap remains when properly tightened)

HOW TO USE MEGA WRENCH

ASSEMBLE

Slide the exclusive MEGA WRENCH over the nut to leave the face marked "LOCK" nearer the cutting tool.

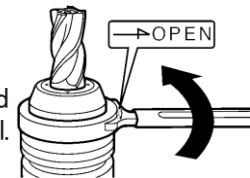
Tighten by rotating the MEGA WRENCH in the direction of the arrow (clockwise) until the nut achieves absolute contact with the body.



DISASSEMBLE

Slide the MEGA WRENCH over the nut to leave the face marked "OPEN" nearer the cutting tool. Rotate the MEGA WRENCH in the direction of the arrow ensuring the nut achieves its free position.

Disassemble the cutting tool by rotating approximately 20 degrees counterclockwise and remove cutting tool with Key Grip.



CAUTION

- Before clamping or unclamping clean the outer diameter of the Nut with a cloth or similar to prevent slipping.
- Be careful not to touch the cutting tool with the MEGA WRENCH when applying to the nut.
- Always release the nut at least a further revolution after removing the cutting tool. Failure to do so could result in reduced gripping force on the subsequent tightening and possible failure during cutting.
- NEVER USE any chuck which has been damaged or has cracks.
- NEVER USE a cutting tool having a shank diameter less than the nominal for the chuck by 0.02mm(.0008") or more.
- Remove any flaws and traces of oil and particles from both the inside of the chuck and cutting tool shank.
- DO NOT USE any cutting tool which shows wear to its second rake of more than 0.4mm(.016").
- The cutting tool should always be held via a cloth or similar to avoid injury on the cutting edges.
- DO NOT continue if vibration / chatter is experienced.
- DO NOT touch the chuck or cutting tool while the spindle is revolving.
- NEVER clamp the nut without a cutting tool being inserted.