



101 Perinton Parkway, Fairport, New York 14450  
Phone: 585-425-4400 Fax: 585-425-7542

*Operating Instructions*  
*Parlec Power Milling Chuck*  
*(3/4", 1-1/4", and 1-1/2")*



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***Important: Please read, and understand, all instructions carefully before attempting to use the Parlec power Milling Chuck. Failure to do so can result in reduced tool life, damage to the chuck or spindle, or bodily harm.***

## **Operation**

1. Clean the tool shank of excess oil and grease. Failure to do so can result in tool slippage.
2. Clean the bore of the milling chuck to ensure that there are no particles present that would contribute to undesirable run-out.
3. Inspect tool shank for proper shank size and tolerance. All shanks must be ANSI Specification in order to operate properly. Failure to do so can result in loss of gripping power.
4. Insert tool shank into the Power Milling chuck. If a Reduction Sleeve is required, insert it into the Power Milling chuck first, then the tool shank into the sleeve.
5. Be sure that the tool shank is fully engaged in the bore. Do not allow excessive tool overhang, as this will reduce the stiffness of the assembly.  
***Minimum shank engagement is 2 times its diameter. Failure to do so will result in loss of gripping power.***
6. Hand tighten the compression sleeve (turn clockwise). This will ensure that the tool shank maintains its correct engagement length while the compression sleeve is fully tightened.
7. Using a pin spanner wrench, fully tighten the compression sleeve (turn clockwise). The sleeve will be fully tightened when the back face of the compression sleeve contacts the front face of the tool holder. This is a “positive” stop. **Any more tightening can cause damage to the chuck.** After the compression sleeve has been fully tightened, loosen the sleeve approximately 1/8 (turn counter-clockwise). This ensures that the bearings have been fully seated.
8. The milling chuck is now ready for use

## **Maintenance**

Because of the many parts involved in the function of the Parlec Power Milling Chuck, it is not recommended that the unit be serviced by the customer. If you feel that the unit needs to be inspected, serviced, or lubricated, please contact your Parlec Representative.