



Rotating Products Team

Parlec Inc. 101 Perinton Pkwy. Fairport, NY 14450

1-800-TOOL USA

Maintenance Instructions for the Parlec Power Milling Chuck

The Power Milling Chuck is designed to provide years of quality service. The bearing cage assembly, located between the compression nut and the shank, will require greasing on a regular basis. It is recommended that it be greased at 6 month to 1 year intervals, depending on severity of conditions.

Service procedure:

- 1) Secure the Power Milling Chuck in a tightening device.
- 2) Rotate the compression nut clockwise (tighten) until it bottoms against the face of the shank.
- 3) Remove and discard the retaining ring (#7).
- 4) Remove and discard spacing washers (#8) and record the quantity (1-3).
- 5) Loosen the compression nut until it is free rotating. Do not remove.
- 6) Place the tool on a clean cloth or on a clean tray. **Caution:** Do not lift or hold the tool by the compression nut. The nut is loose and may cause the tool to drop.
- 7) Carefully remove the nut and bearing assembly from the shank.
- 8) Remove the retaining rings, spacer and rear seal (#4, #5 and #6). If they are removed carefully they should be re-usable. The bearing cage can be removed through the bottom of the nut. The bearing will be free to fall out of the cage.
- 9) If the bearings are in serviceable condition (do not show any heavy pitting or flat spots), clean the bearings, cage and interior of the nut of all old grease and any dirt. Inspect the body taper and the nut id for pitting, gouges, deep scratches, etc. If any of these conditions exist, it is recommended to replace the tool. Slight wear or witness marks are normal.
- 10) Reassemble the cage, spacer, seal and retaining rings in the reverse order removed. Care should be taken to ensure that the retaining rings are fully engaged in the groove. Lightly line the inside of the bearing cage with grease (we recommend Mobil HTS or any water proof molly or marine grease), insert cleaned or new bearings, making sure that each of the cutouts have 5 bearings. Pack bearing with additional grease.
- 11) Slide cage to the bottom of the nut and reassemble on to shank.
- 12) Retighten the nut until it bottoms out. Clean excess grease from the opening between the nut and the bearing cage assemble. Install the same number of new spacer washers that were originally removed into the nut.
- 13) Install the retaining ring. Loosen the nut and make sure that it is free rotating.

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Parts list for 1 _" Power Milling Chuck (12MC's)

Detail	Quantity	Part Number	Description
1	1	12MC-BC	BEARING CAGE
3	1	12MC-001K	ROLLER NEEDLES (165 PIECES)
4	1	12MC-002	SEAL – REAR
5	2	12MC-003	WASHER .015 X 1.8" X 2.0" DIAMETER
6	2	12MC-005	RETAINING RING
7	1	12MC-006-2	RETAINING RING
8	1-3	12MC-007	SPACER WASHER .015 X 1.7 X 1.84 DIA.
9	1	SHANK	VARIES BY THE TAPER AND LENGTH
2	1	12MC-NT	COMPRESSION NUT ASSEMBLY INCLUDES #1, #3, #4, #5 AND #6
N/A	1	12MC-KIT	INCLUDES #3, #4, #7 AND #8.

Parts list for 3/4" Power Milling Chuck (75MC's)

Detail	Quantity	Part Number	Description
1	1	75MC-BC	BEARING CAGE
3	1	75MC-001K	ROLLER NEEDLES (132 PIECES)
4	1	75MC-002	SEAL – REAR
5	2	75MC-003	WASHER .015 X 1.8" X 2.0" DIAMETER
6	2	75MC-005	RETAINING RING
7	1	75MC-006-2	RETAINING RING
8	1-3	75MC-007	SPACER WASHER .015 X 1.7 X 1.84 DIA.
9	1	SHANK	VARIES BY THE TAPER AND LENGTH
2	1	75MC-NT	COMPRESSION NUT ASSEMBLY INCLUDES #1, #3, #4, #5 AND #6
N/A	1	75MC-KIT	INCLUDES #3, #4, #7 AND #8.

NOTE: Units built before November of 2000 may require a different retaining ring. Part number 75MC-006.

