

# Mounting Instructions for ER Collets

**Warning:** Incorrect assembly will cause poor tool clamping which is dangerous and can cause damage to the collet chuck, collet, nut, cutter and user.

**Note** – Ensure all parts are clean and free of debris before assembling and collect chuck is secured in the machine spindle or tool setting stand.

1. Looking down the barrel of the nut you can see the eccentric extractor ring. It will appear elliptical or off centre.
2. Insert the collet at an angle inside the nut and rotate the collet down to lock it into position onto the eccentric extractor ring groove.
3. Fix the nut and collet to the collet chuck and start thread by hand.
4. Insert the cutter into the collet front and tighten nut with a wrench.

