

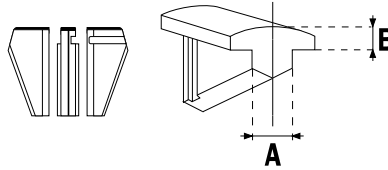
HOW TO REPLACE THE JAWS OF A NIKKEN NPU DRILL CHUCK

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Tools Needed



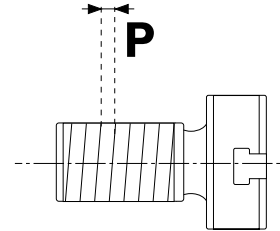
Jaw Set



Jaw Set

SP08061	A = 4.4 mm	B = 1.5 mm
SP08062	A = 4.4 mm	B = 2.5 mm
SP13061	A = 5.0 mm	B = 1.5 mm
SP13062	A = 5.0 mm	B = 2.5 mm

Lead Screw



Lead Screw

NPU-0805	All NPU-S
NPU-1305	P = 3.00 mm (Before 2001)
NPU-13051	P = 2.25 mm (After 2001)



STEP 1: Remove the Pull Stud.



STEP 2: Loosen the Draw Screw halfway.



STEP 3: Insert Spacer and replace the Solid Pull Stud.



STEP 4: Tighten Pull Stud until Chuck is pressed on Taper.



STEP 5: Remove the Pull Stud, Spacer, Draw Bolt and Chuck from the Taper portion.



STEP 6: Remove O-Ring from Chuck and move Jaws to the forward position.



STEP 7: Place Chuck in Vise Grip on the lower portion, NOT the Taper.



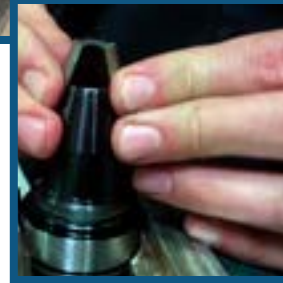
STEP 8: Heat the Nose Cone to burn off Loctite.

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STEP 9: Use Spanner Wrench to remove the Nose Cone and expose the Jaws.



STEP 10: Once cooled, remove old Jaws and replace with new Jaws.



STEP 11: Apply Loctite (Semi-Perm) to threads and tighten down the Nose Cone.



STEP 12: Reverse the above procedure for Assembly.