

KWIK-WAY HIGH PRECISION SMALL COLLET CHUCK KIT INSTRUCTIONS



012-1575-60

Reference	Description	Part Number
1	Collet Chuck Extension	012-1575-61
2	Hex Drive Cup Point (Valve Stop) (not pictured)	012-1575-64
3	Valve Stop Key	012-1575-69
4	3 mm (2.5mm to 3.0mm / .098 to .118")	012-1575-62
5	4 mm (3.5mm to 4.0mm / .138 to .157")	012-1575-63
6	5 mm (4.5mm to 5.0mm / .177 to .197")	012-1575-65
7	6 mm (5.5mm to 6.0mm / .217 to .236")	012-1575-66
	Storage Container (not pictured)	012-1575-78
	These Instructions (not pictured)	009-1400-09

(Additional collet sizes available, see page 3)

READ THESE INSTRUCTIONS CAREFULLY
 Damage will occur if improperly used.



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The Small Collet Chuck Kit includes 4 collets in the range of 3mm to 6mm, the collet chuck extension and the valve stop hex key.

1. Select the appropriate collet for the valve you wish to grind. NEVER use a smaller collet for a valve. For example, if your valve stem is 3.1mm in size you MUST NOT use the 3mm collet. You will damage it if you do. In this example you will need the 3.5mm optional collet.
2. Unscrew and remove the extension rod end. Insert the large end of the collet into the extension rod nut. Be aware that the nut has an internal lip that the groove in the collet fits over to seat it properly. (See Images to the right) Once you have the proper collet seated correctly in the extension rod nut, thread the extension rod nut and collet onto the holder without tightening.
3. Slide the valve stem into the collet that is correctly mounted in the extension rod. Using the included hex key, adjust the stop from the opposite end of the extension rod by turning the threaded valve stop until the desired position of the valve is reached.
4. Once the desired depth is set by the valve stop, use a 17mm and an 11mm wrench (not included) to snug the valve into place. Do not use excessive force to tighten, just enough to securely hold the valve from turning or moving in and out of the collet.
5. The extension rod with the valve secured is now ready to be inserted into your Valve Refacer Chuck the same way you would normally insert a larger valve. **NOTE:** Best results are obtained with the least amount of valve sticking out of the extension rod.
6. When grinding is complete, remove the extension rod from your Valve Refacer and then remove the valve from the extension rod using the two wrenches. **WARNING:** Never remove the valve while the extension rod is still in your Valve Refacer chuck. Doing so could cause damage and/or injury to you or your Valve Refacer.



Optional Collets Are Available from Irontite Products at +1-800-553-5953

012-1575-53	3.5 mm Collet (3.0 to 3.5mm / .118 to .138")
012-1575-55	5.5 mm Collet (5.0 to 5.5mm / .197 to .217")

012-1575-54	4.5 mm Collet (4.0 to 4.5mm / .157 to .177")
012-1575-56	6.5 mm Collet (6.0 to 6.5mm / .236 to .256")



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INSTRUCTIONS

From

