



## PARTS LIST

| PART NUMBER         | DESCRIPTION   | NUMBER REQUIRED |
|---------------------|---|-----------------|
| <b>5.5LH-3-A5FS</b> | 5.5 Diameter 3-Jaw Power Chuck, Direct Mount<br>5"-A <sub>2</sub> Spindle | 1               |
| <b>5.5L-01-01</b>   | Body  | 1               |
| <b>5.5L-02-02</b>   | Draw Head   | 1               |
| <b>5.5L-06-01</b>   | Cam Lever   | 3               |
| <b>5.5L-07-01</b>   | Lever Pin   | 3               |
| <b>5.5L-08-01</b>   | Master Jaw Fine Serrated 1/16x90°   | 3               |
| <b>5.5L-09-01</b>   | Top Plate   | 1               |
| <b>5.5L-10-01</b>   | Chip Plate  | 3               |
| <b>5.5L-11-01</b>   | Tee Nut   | 6               |
| <b>5.5L-12-01</b>   | Counterweight   | 3               |

\*When asking for your parts, please substitute your chuck size in place of the '5.5' in the above part numbers (i.e. 4.8, 5.5, 6.5, 7.7, 8.2).

**POWERHOLD****MODEL 5.5LH-3-A5FS  
CHUCK MAINTENANCE**

**LUBRICATION:**  
**Recommended type**  
**Dow Corning**  
**®Molykote BRZ**  
**—Plus Grease**

**Refer**  
**to Back**  
**Cover**

Under normal use, 6 days per week, 10 hours per day, daily lubrication is recommended. Under these conditions, the chuck should be disassembled and cleaned every 200 hours of use. These recommendations can vary widely, depending on the number of shifts and types of material being machined. For example, cast iron will require more frequent disassembly than other types of material. Good indications that a chuck requires disassembly and cleaning are: (A) part slippage, (B) loss of jaw travel, and (C) slow opening and closing. We recommend the use of a jaw force gage to accurately monitor the grip force of a power chuck and to determine the frequency of maintenance.

**DISASSEMBLY:**

*CAUTION: It is advisable to mark all parts with respective relationships to each other and the chuck body at removal to ensure accuracy and balance after reassembly.*

1. Remove the top jaws and tee nuts from the chuck.
2. Loosen and remove the (3) mounting bolts from the face of the chuck.
3. Using the draw tube adjustment collar at the cylinder end of the spindle, turn until the chuck is completely threaded off the tube.
4. Remove the chuck and thoroughly clean the exterior.
5. Place the chuck facedown on a clean bench and remove (6) locking set screws in three locations as shown in the drawing. These screws are provided to secure the cam lever pin.
6. Turn the chuck over with the mounting facedown. Remove the (12) low head cap screws and lift off the top plate exposing the master jaws, number 08-01.
7. Remove the master jaws by lifting straight up and out.
8. Remove the lever pins, number 07-01, by tapping lightly with a soft mallet at the opposite side of the grease fitting.
9. Remove the cam levers by lifting straight out.
10. The draw head, number 02-02, can now be pushed directly out of the chuck body.
11. Clean all parts thoroughly and inspect for wear and damage.

**CAUTION:**

*Any part showing excessive wear and/or damage should not be replaced in the chuck. Consult factory for advice before using any parts that are possibly damaged.*