

# Operating instructions for the Tru-Valve Collet Spindle

## CAUTION:

READ and FOLLOW the instructions below for repeatable and long service life of your Tru-Valve Collet Spindle.

Once the Tru-Valve Collet Spindle is correctly installed in your valve grinder you ready to start grinding valves.

First remove the Spindle Nut

Clean the collet and Insert the correct collet into the nut (the collet must be snapped into the Nut before being placed into the spindle). The correct collet will be the one that your valve just fits through in its relaxed position. For example; you should use a 6-7mm collet for a 7mm valve stem or a 4-5mm collet for a 5mm valve stem. This gives the most surface contact

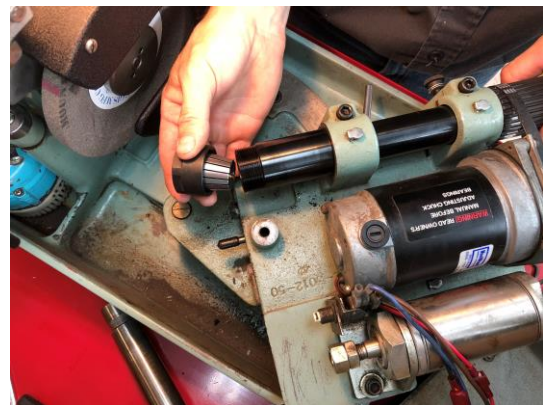


between the collet and valve stem. The more the collet is collapsed the less the surface contact area you will have between the collet and valve stem.

Use a clean rag and wipe out the inside surface where the collet will seat in the spindle (failure to do this will result in inconstant concentricity and diminished spindle life)



Insert collet and thread the nut onto the spindle.



Insert your valve into the collet to your desired depth and tighten the nut. (The nut only needs to be snug or hand tight in most cases. In other words, use the wrench to just hold the nut with

one hand and the other hand to turn and tighten the spindle.



with grinding stone debris, metal chips, or any other such debris will irreversibly damage the spindle). Also, refrain from using excessive or blunt force on any part of the Tru-Valve spindle assembly. When dressing the valve facing stone with the diamond dresser it is best to cover the collet so that no stone dust gets into the collet.



When removing do the reverse but you will need to turn the nut back far enough to pop the collet out of its seat to release the valve.

Be sure to fill the spindle oilers daily and keep the spindle housing adjustment and endplay correct for your machine.



The Tru-Valve Spindle assemblies and the collets are precision pieces and should be treated as such by being kept clean and free from any debris (tightening a collet in the spindle housing

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