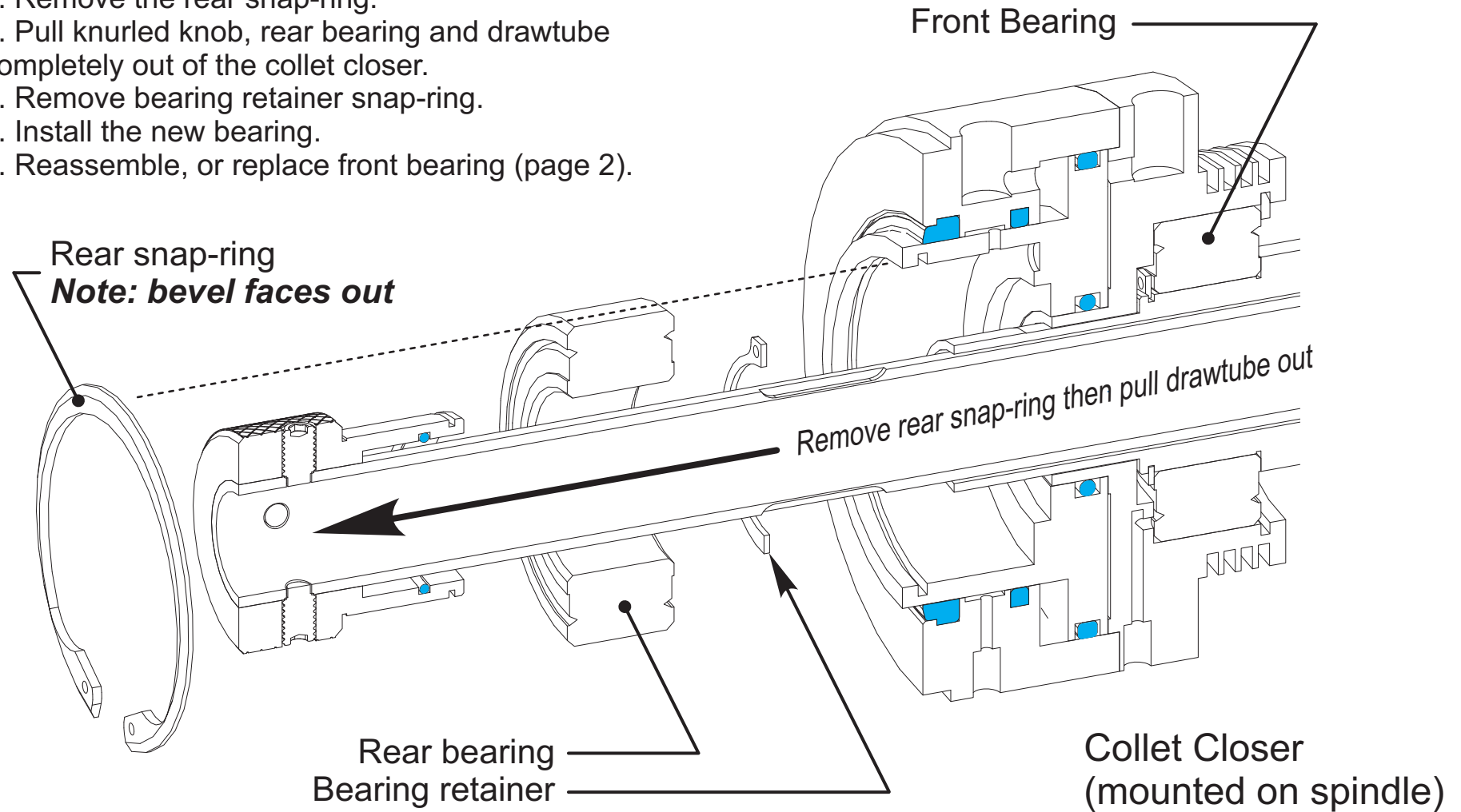


To replace the bearings:  
(Do not remove collet closer from spindle)

**Rear Bearing**

1. Remove the collet.
2. Remove the rear snap-ring.
3. Pull knurled knob, rear bearing and drawtube completely out of the collet closer.
4. Remove bearing retainer snap-ring.
5. Install the new bearing.
6. Reassemble, or replace front bearing (page 2).

Seals & O-rings  
shown in blue

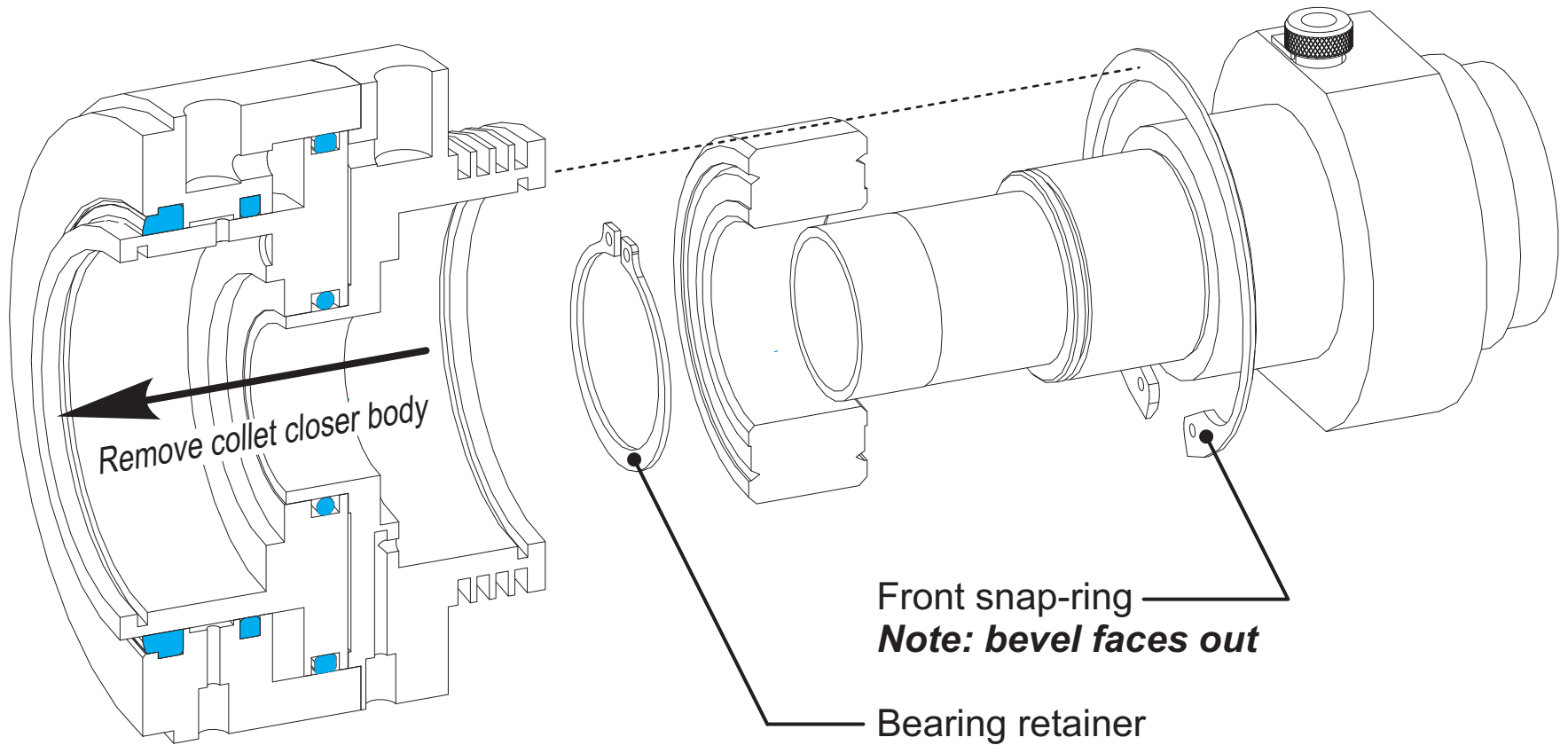


**Front bearing:**

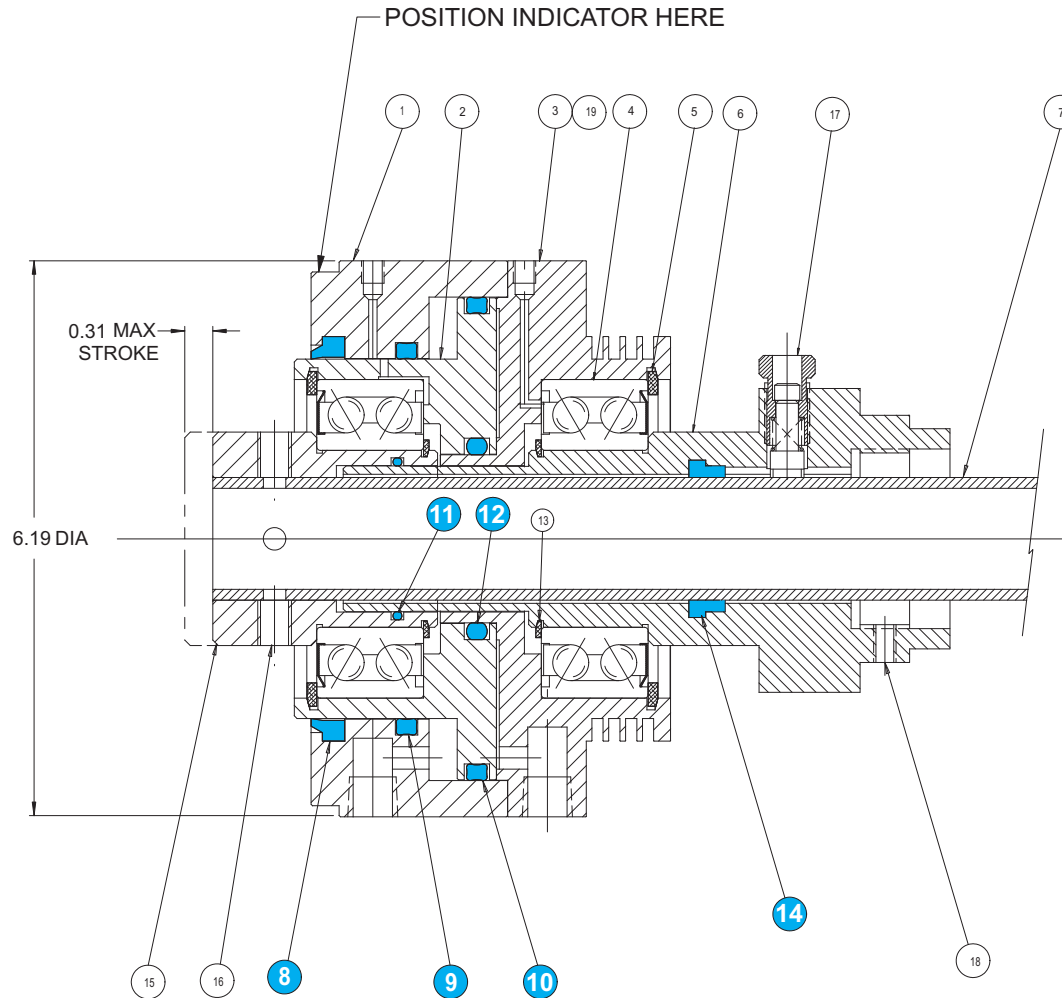
7. Remove anti-rotation bracket
8. Remove four air hoses (push-lock fittings)
9. Remove front snap-ring.
10. Slip collet closer body off main bearing mount.
11. Remove bearing retainer snap-ring.
12. Install the new bearing.
13. Reassemble and verify concentricity.

Seals & O-rings  
shown in blue

Main bearing mount  
(mounted on spindle)



REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
A	ENGINEERING RELEASE	11/97	MG



19	#10-24 X 1" LG.	SOCKET HEAD CAP SCREW	8
18	1/4-20 X 3/8 LG	BRASS POINT SOC SET SCREW	3/6
17	MA299-H	LOCKING KEY ASSEMBLY	1
16	3/8-16 X 5/8 LG	HALF DOG POINT SET SCR	4
15	MC544	KNURLED ADJUSTING KNOB	1
14	00602100A	DISOGRIN SEAL	1
13	5102-196	TRU-ARC SNAP RING	2
12	D-328	"O" - RING	1
11	D-130	"O" - RING	1
10	Q4353	QUAD RING	1
9	Q4345	QUAD RING	1
8	006-044	DISOGRIN SEAL	1
7	MB244-H6	DRAWTUBE	1
6	MC543-A/ MC543-F	MAIN BRG. MOUNT	1
5	5002-354	TRU-ARC SNAP RING	2
4	D-55510ND	DACC BEARING (ONE SHIELD)	2
3	MC542	MAIN BRG. HOUSING	1
2	MC541	PISTON	1
1	MC540	CYLINDER	1

ITEM	PART NO.	DESCRIPTION	QTY.																				
UNLESS OTHERWISE SPECIFIED																							
ANGLES MAY VARY																							
DECIMAL DIM. MAY VARY																							
.xx ±.015 .xxx																							
FRACTIONAL DIM. MAY VARY ±.005																							
ROUND EDGES .005-.015																							
CORNERS TO HAVE FILLETS .005-.020																							
SURFACE FINISH																							
<table border="0"> <tr> <td>THE DUNHAM TOOL COMPANY</td> <td>±.005</td> <td>COLLET ACTUATOR - OIL MIST</td> <td>NO ELECTRONICS</td> </tr> <tr> <td>BETHEL, CONNECTICUT</td> <td>±.1/64</td> <td></td> <td></td> </tr> <tr> <td>CHK.</td> <td>DATE</td> <td>MATL</td> <td>FIN</td> </tr> <tr> <td></td> <td>11/97</td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td>NEXT ASSM.</td> <td></td> </tr> </table>				THE DUNHAM TOOL COMPANY	±.005	COLLET ACTUATOR - OIL MIST	NO ELECTRONICS	BETHEL, CONNECTICUT	±.1/64			CHK.	DATE	MATL	FIN		11/97					NEXT ASSM.	
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