

INTEGRAL ER COLLET ASSEMBLY INSTRUCTIONS

✓ **RIGHT WAY** (4 steps below)



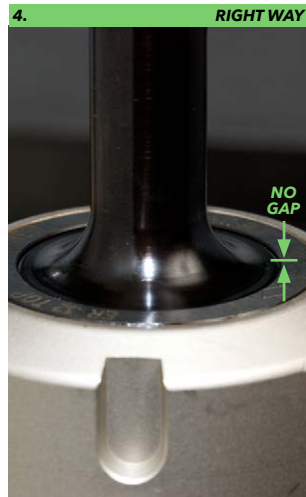
1. Place the nut on the integral ER collet. Assemble the nut with the shank by mating the retention tabs with the ER groove.



2. The nut/shank assembly is shown ready for installation.



3. Place the nut/shank assembly into the holder and secure the nut.



4. No gap.

✗ **WRONG WAY** (4 steps below)



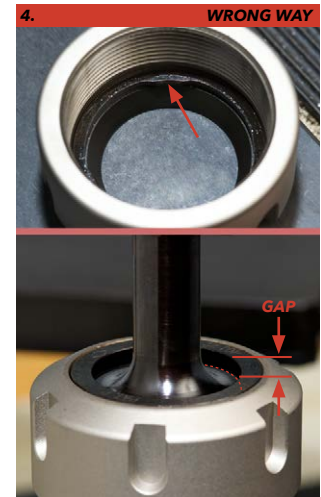
1. Remove nut from ER holder.



2. Place the integral ER collet into the collet chuck.



3. Screw the nut on the holder.



4. The nut will BIND up on the retention tabs prematurely, leaving a GAP. Applying extra force may BREAK THE NUT.