



TO INFORM YOU

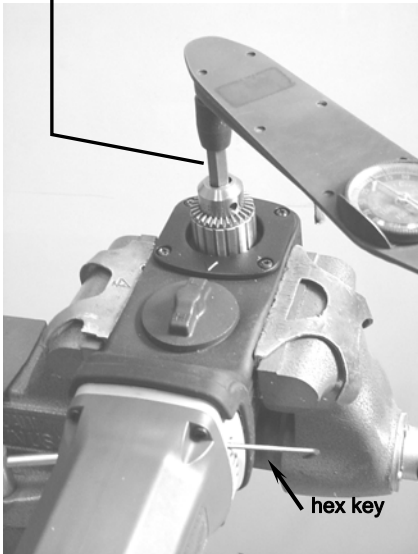
PRODUCT SUPPORT BULLETIN # 438

TO: AUTHORIZED *Portable Electric Tool* SERVICE STATIONS
factory SERVICE CENTERS
SALES COMPANIES

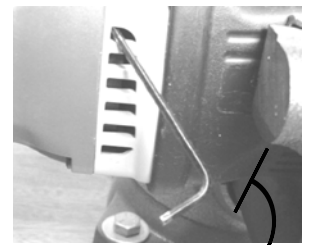
TOOL(S) \ PRODUCT(S) AFFECTED : 1680-20 Super Hole-Hawg®

SUBJECT: 3-Jaw Drill Chuck torque specification
61-40-1015 Spindle Wrench
61-30-0156 1/2" X 2-1/4" Hex Shank Service Fixture

61-30-0156 Service Fixture
1/2" hex shank

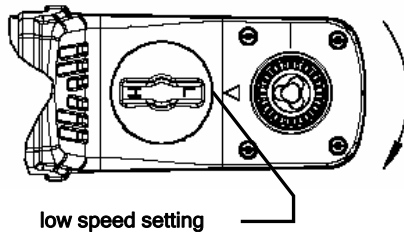


90 - 50 ft-lbs is the acceptable 'static' torque range of the 32-10-1058 Clutch Assembly. To check the Clutch Assembly static torque, place the tool in a vise. Place a small [1/8"] hex key in the upper most right side air vent (as viewed looking down at the 3-jaw chuck) as shown, locking the motor / fan from turning. The hex key must be inserted at a 45° compound angle. With a 1/2" hex shank [61-30-0156 Service Fixture], 1/2" socket & torque wrench and the **Shifting Knob in the 'low speed' position**, turn the torque wrench clockwise noting the torque at which the Clutch Assembly slips. 90 - 50 ft-lbs is the acceptable 'static' torque range.



small [1/8"] hex key in air vent

hex key catches the edge of the fan blade at it's hub



low speed setting

61-40-1015 Spindle Wrench

61-40-1015 Spindle Wrench can be used to **remove** or **install** the 3-Jaw Drill Chuck, see illustration. Pins of fixture mate with two [2] 5/16" counter bores in Spiral Bevel Gear. Specifications call for the 3-Jaw Chuck to be tightened / **seated to the spindle at 80-90 ft-lbs of torque**. With the 61-40-1015 Spindle Wrench securely clamped in a vise to prevent the spindle from turning (*see note*), use a 1/2" hex shank & 1/2" socket and torque wrench to install the 3-jaw chuck. When installing a 3-jaw chuck it **must be seated to the spindle at 80-90 ft-lbs of torque**. Remember to re-install LH Socket Hd Chuck retaining screw.



Note, apply a strong downward pressure to torque or socket wrench when either installing or removing 3-jaw chuck to insure pins of service fixture remain in contact with two [2] 5/16" Spiral Bevel Gear counter bores.

5/16" counter bores



This bulletin supersedes and replaces Product Support Bulletin #384

This bulletin is for informational purposes. PLEASE NOTE ON SERVICE PARTS LIST: 54-10-0250, 54-10-0251