



BC Holder Operation



Remove the lock nut from the BC holder assembly, wipe off any dirt or existing grease from taper and inside the lock nut.



Apply grease to taper.



The Grease we use, any similar brand will work.



Re-Assemble lock nut.

Body protruding
1mm out from the
lock nut



Tighten lock nut until it stops or 1mm (0.040") of the chuck body protrudes out from the face of the lock nut.

Tightening

BC Mill Chucks do require additional torque to fully tighten. Please use the chart below for tightening Torque. Torque wrench heads available upon request. The holder should lock before you reach max torque if greased properly and everything is in good condition.

Note: BC Holders need to be worked in. The first 2 uses will require more pressure to tighten. The holder will loosen up and require less pressure to tighten as the nut works in.

Chuck Size	Torque Required
037-050	100 ft/lbs
062-075	120 ft/lbs
100-125	140 ft/lbs