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GREX AR368, MR368

Grex 1/8" Collet Instruction Manual for AR368 and MR368 Die Grinders

1. INTRODUCTION

This instruction manual provides essential information for the proper use, installation, and maintenance of your Grex 1/8" Collet. This collet is specifically designed for use with Grex AR368 and MR368 die grinders, ensuring secure gripping of various rotary tool accessories with a 1/8" shank. Adhering to these instructions will help ensure safe operation and extend the lifespan of your collet and tools.

2. PRODUCT OVERVIEW



Figure 1: The Grex 1/8" Collet. This image displays the metal collet, which is a precision-machined cylindrical component. One end features a solid base, while the other end is split into four segments, designed to flex and securely grip a tool shank when tightened within a collet nut. The collet has a dark, textured body with polished metal ends.

The Grex 1/8" Collet is a critical component for securing rotary tool accessories. It is constructed from durable metal, designed for precision and longevity. Its primary function is to hold bits, burrs, and other accessories firmly in place during operation, preventing slippage and ensuring accurate work.

3. SETUP AND INSTALLATION

Before installing the collet, ensure your die grinder is disconnected from its power source to prevent accidental activation.

- 1. Remove Existing Collet (if applicable):** If a collet is already installed, use the appropriate wrenches to loosen and remove the collet nut, then carefully extract the old collet.
- 2. Insert New Collet:** Place the Grex 1/8" Collet into the collet nut. Ensure it seats properly within the nut's recess.
- 3. Attach Collet Nut:** Thread the collet nut, with the collet inside, onto the spindle of your Grex AR368 or MR368 die grinder. Hand-tighten initially.
- 4. Insert Accessory:** Insert the shank of your desired 1/8" accessory (e.g., grinding bit, burr) into the collet. Ensure the shank is inserted as far as possible without bottoming out, leaving enough length for the collet to grip securely.
- 5. Tighten Securely:** Using the two wrenches provided with your die grinder (one to hold the spindle, one to tighten the collet nut), firmly tighten the collet nut. Do not overtighten, as this can damage the collet or the tool. The accessory should be held securely without any wobble.

Always verify that the accessory is firmly secured before connecting power and operating the tool.

4. OPERATING GUIDELINES

Proper operation of the collet involves ensuring the correct accessory is used and securely fastened.

- **Accessory Compatibility:** Only use accessories with a 1/8" (3.175 mm) shank diameter with this collet. Using incorrect shank sizes can lead to poor gripping, accessory slippage, damage to the collet, or injury.
- **Secure Insertion:** Always insert the accessory shank fully into the collet, ensuring it is not bottomed out against the tool's spindle. This provides maximum gripping surface.
- **Regular Inspection:** Before each use, inspect the collet and collet nut for any signs of wear, cracks, or deformation. Replace damaged components immediately.
- **Avoid Side Loads:** While operating, minimize excessive side loads on the accessory, as this can stress the collet and lead to premature wear or breakage.

5. MAINTENANCE

Regular maintenance ensures optimal performance and extends the life of your Grex 1/8" Collet.

- **Cleaning:** Periodically remove the collet from the die grinder and clean it thoroughly. Use a soft brush or compressed air to remove any dust, debris, or metal particles that may accumulate within the slits or on the gripping surfaces.
- **Inspection for Wear:** Regularly inspect the collet for signs of wear, such as:
 - Deformation or rounding of the gripping edges.
 - Cracks, especially around the slits.

- Corrosion or pitting.

If any significant wear or damage is observed, replace the collet immediately. A worn collet can lead to poor gripping, accessory run-out, and potential safety hazards.

- **Lubrication (Optional):** A very light application of dry lubricant (e.g., graphite spray) can be applied to the threads of the collet nut and the tapered surface of the collet to ensure smooth tightening and loosening. Avoid excessive lubrication, which can attract debris.
- **Storage:** Store the collet in a clean, dry environment when not in use to prevent corrosion and damage.

6. TROUBLESHOOTING

This section addresses common issues you might encounter with your Grex 1/8" Collet.

Problem	Possible Cause	Solution
Accessory slips or wobbles	<ul style="list-style-type: none"> • Collet nut not tightened sufficiently. • Incorrect accessory shank size (not 1/8"). • Worn or damaged collet. • Debris in collet or collet nut. 	<ul style="list-style-type: none"> • Ensure collet nut is tightened firmly with wrenches. • Verify accessory shank is exactly 1/8". • Inspect collet for wear; replace if necessary. • Clean collet and collet nut thoroughly.
Difficulty inserting/removing accessory	<ul style="list-style-type: none"> • Collet nut overtightened without an accessory. • Debris or corrosion. • Accessory shank is slightly oversized. 	<ul style="list-style-type: none"> • Loosen collet nut completely before inserting/removing. • Clean collet and collet nut. • Ensure accessory shank is within tolerance.

7. SPECIFICATIONS

- **Brand:** GREX
- **Model Compatibility:** Grex AR368, Grex MR368 Die Grinders
- **Accessory Shank Diameter:** 1/8 inch (3.175 mm)
- **Material:** Metal
- **Thread Size:** 1/8-20 UNC (for collet nut, not the collet itself, but relevant for assembly)
- **Included Components:** Bare collet (requires collet nut and wrenches from your die grinder)

8. SUPPORT AND WARRANTY

For technical assistance, replacement parts, or warranty information regarding your Grex 1/8" Collet or compatible Grex tools, please contact Grex customer support directly. Refer to the documentation provided with your Grex AR368 or MR368 die grinder for specific contact details and warranty terms.

Manufacturer: Grex

