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**Hitachi 331969**

# Hitachi 331969 Collet D3 Replacement Part Instruction Manual

**Model:** 331969

**Brand:** Hitachi (now Metabo HPT)

## Product Overview

The Hitachi 331969 Collet D3 is a genuine replacement part designed to ensure the proper functioning of your Hitachi power tools. This component is crucial for securely holding various bits and accessories during operation, maintaining precision and safety. Hitachi Power Tools has transitioned its brand name to Metabo HPT, but the commitment to quality and compatibility remains consistent.

### Key Features:

- Genuine Hitachi power tool replacement part.
- Designed for use on Hitachi power tool products.
- Ensures secure gripping of bits and accessories.
- Constructed from durable alloy steel and chromium vanadium steel.

## Product Visual



This image displays the Hitachi 331969 Collet D3, a precision-engineered brass component designed for securing bits in power tools. It features a tapered end with multiple slits for flexible gripping and a cylindrical body for insertion into the tool's chuck mechanism.

## Installation Guide

Proper installation of the collet is essential for safe and effective tool operation. Follow these steps carefully.

### 1. Preparation

Before beginning installation, ensure the power tool is disconnected from its power source to prevent accidental activation. Wear appropriate safety gear, including eye protection and gloves.

### 2. Removing the Old Collet (if applicable)

1. Locate the existing collet on your power tool.
2. Depending on your tool model, you may need a wrench or a specific tool to loosen and remove the collet nut.
3. Carefully extract the old collet from the tool's spindle.

### 3. Installing the New Collet

1. Insert the Hitachi 331969 Collet D3 into the tool's spindle. Ensure it seats properly.
2. If your tool uses a collet nut, thread it onto the spindle and tighten it by hand until snug.
3. Use the appropriate wrench to fully tighten the collet nut. Do not overtighten, as this can damage the collet or the tool.
4. Verify that the collet is securely fastened and does not wobble.

## Operating Instructions

The Hitachi 331969 Collet D3 is designed to securely hold various bits and accessories in compatible power tools. Proper operation ensures safety and optimal performance.

### 1. Inserting a Bit

1. Ensure the power tool is off and unplugged.
2. Loosen the collet nut slightly, just enough to allow the bit to slide in.
3. Insert the shank of the desired bit into the collet. Ensure the bit is inserted as far as possible without bottoming out, leaving enough shank for proper gripping.
4. Tighten the collet nut firmly using the appropriate wrench. A properly tightened collet prevents the bit from slipping during operation.

### 2. Removing a Bit

1. Ensure the power tool is off and unplugged.
2. Loosen the collet nut using the wrench.
3. Carefully pull the bit out of the collet.

## Maintenance and Care

Regular maintenance of your Hitachi 331969 Collet D3 will extend its lifespan and ensure consistent performance.

- **Cleaning:** Periodically remove the collet from the tool and clean it. Use a soft brush or compressed air to remove dust, debris, and metal shavings that may accumulate inside the collet slots.
- **Lubrication:** A very light application of machine oil to the threads of the collet nut and the exterior of the collet can help prevent seizing and ensure smooth operation. Avoid excessive lubrication, which can attract dust.

- **Inspection:** Regularly inspect the collet for signs of wear, cracks, or deformation. If the collet appears damaged or no longer grips bits securely, it should be replaced immediately.
- **Storage:** Store the collet in a clean, dry place when not in use, preferably within the tool or in a protective container.

## Troubleshooting

This section addresses common issues you might encounter with your collet.

| Problem | Possible Cause | Solution |
|---|---|---|
| Bit slips during operation | Collet nut not tightened sufficiently; Collet is worn or damaged; Incorrect bit shank size. | Ensure collet nut is fully tightened. Inspect collet for wear and replace if necessary. Use bits with the correct shank diameter for the collet. |
| Difficulty inserting/removing bit | Collet or collet nut threads are dirty or damaged; Bit shank is dirty or burred. | Clean collet and collet nut threads. Apply a small amount of lubricant to threads. Clean bit shank. Inspect for damage and replace if necessary. |
| Excessive vibration or runout | Collet is damaged or bent; Bit is bent or unbalanced; Collet not seated properly. | Inspect collet and bit for damage and replace if needed. Ensure collet is fully seated in the tool's spindle. |
| Collet nut seizes | Over-tightening; Lack of lubrication; Dirt/debris in threads. | Do not overtighten. Clean and lightly lubricate threads regularly. |

## Product Specifications

| Attribute | Detail |
|---|---|
| Part Number | 331969 |
| Item Model Number | 331969 |
| Brand | Hitachi (now Metabo HPT) |
| Manufacturer | Koki Holdings America, Ltd |
| Material | Alloy Steel, Chromium Vanadium Steel |
| Item Weight | 0.353 ounces |
| Product Dimensions | 1 x 1 x 1 inches |
| Country of Origin | China |
| Date First Available | October 7, 2014 |
| UPC | 754005319697 |

## Warranty Information

For detailed warranty information regarding your Hitachi (now Metabo HPT) power tool products and replacement parts, please visit the official manufacturer's website:

hitachipowertools.com

*Note: Hitachi Power Tools has rebranded to Metabo HPT. Warranty terms and conditions remain consistent with the manufacturer's policies.*

## Customer Support

For further assistance, technical support, or inquiries regarding the Hitachi 331969 Collet D3 Replacement Part, please contact Koki Holdings America, Ltd. (formerly Hitachi Koki USA, Ltd.).
You can also visit the official brand store for more information and product resources:
Visit the Hitachi Store on Amazon

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