

# Collet Stops

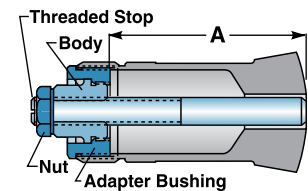
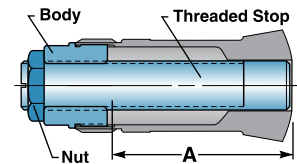
5C, 16C, 20C, 25C and 3J



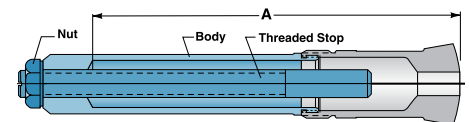
## Threaded Positive Solid Stops

Style	Description	Part Number	Model	"A" Depth
5C	<b>Solid Stop Assembly</b>	<b>1049-00-00-000000</b>	<b>SS-5C</b>	3 1/8" (73.38)
	— Body	1051-00-00-000000		
	— Nut	5A-0001466-C		
	— Threaded Stop <sup>1</sup>	1053-00-00-000000		
16C	<b>Solid Stop Assembly</b>	<b>1805-00-00-000000</b>	<b>SS-16C</b>	3 3/4" (95.25)
	— Body	1807-00-00-000000		
	— Nut	1185-00-00-000000		
	— Threaded Stop <sup>1</sup>	1183-02-00-000000		
16C	<b>Adapter-Style Assembly</b>	<b>1199-00-00-000000</b>		3 3/4" (95.25)
	— Body	1051-00-00-000000		
	— Adapter Bushing	1155-01-00-000000		
	— Nut	5A-0001466-C		
	— Threaded Stop (1/2" diameter) <sup>1</sup>	1071-00-00-000000		
16C	<b>Adapter Bushing</b> Used with the 5C Solid Stop Assembly	<b>1155-01-00-000000</b>		
20C	<b>Solid Stop Assembly</b>	<b>1279-00-00-000000</b>	<b>20C-SS</b>	5 7/8" (149.23)
	— Body	1278-00-00-000000		
	— Nut	1185-00-00-000000		
	— Threaded Stop <sup>1</sup>	1271-00-00-000000		
25C	<b>Solid Stop Assembly</b>	<b>1073-00-00-000000</b>	<b>25C-SS</b>	6 1/8" (155.58)
	— Body	1075-00-00-000000		
	— Nut	1185-00-00-000000		
	— Threaded Stop <sup>1</sup>	1271-00-00-000000		
3J	<b>Solid Stop Assembly</b>	<b>1999-00-00-000000</b>	—	3" (76.2)
	— Body	1051-00-00-000000		
	— Adapter Bushing	1995-00-00-000000		
	— Threaded Stop <sup>1</sup> (1/2" Dia.)	1071-00-00-000000		
	— Nuts [2]	5A-0001466-C		

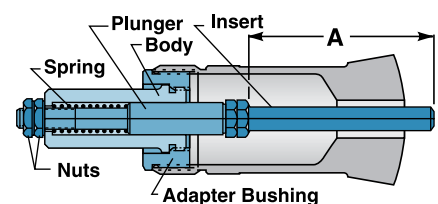
The standard Hardinge® collet comes with a deep precision-threaded section at the rear of the capacity bore to permit the use of Hardinge positive solid and ejector stops. Purchase a standard collet and it is always ready for stop work since the threaded capacity bore is found in all fractional, decimal, hexagon, square, rectangular and emergency Hardinge collets within the ranges listed. The Hardinge solid, ejector and long threaded stops are threaded into and positively locked against the end of the collet. Once locked in place, the stop cannot move even under heavy drilling or other end-working pressures. The three types of stops permit a wide variety of chucking work since all are adjustable and machinable for the desired part length to the maximum workpiece depths indicated.



16C Adapter-style Solid Stop Assembly



Long Stop Assembly



Collets are not included in assemblies.

## Long Stops

Style	5C Part Number	16C Part Number	20C & 25C Part No.	3J Part Number
<b>Long Stop Asm.</b>	<b>1067-00-00-000000</b>	<b>1213-00-00-000000</b>	<b>N/A</b>	<b>2003-00-00-000000</b>
Model	LS-5C	LS-16C	—	—
"A" Depth	7 1/2" (190.50)	7 1/4" (184.15)	—	7 7/8" (200)
— Body	1069-00-00-000000	1181-02-00-000000	—	1997-00-00-000000
— Thrd. Stop <sup>1</sup>	1071-00-00-000000	1183-02-00-000000	—	1183-02-00-000000
— Nut	5A-0001466-C	1185-00-00-000000	—	1185-00-00-000000

<sup>1</sup>- Threaded stops can be altered to different lengths.

NOTE: Millimeters in parentheses.

## Ejector Stops

Style	5C Part Number	16C Part Number	20C & 25C Part No.	3J Part Number
<b>Ejector Stop Asm.</b>	<b>1057-00-00-000000</b>	<b>1155-00-00-000000</b>	<b>N/A</b>	<b>2001-00-00-000000</b>
Model	ES-5C	ES-16C	—	ES-3J
"A" Dimension	2 3/4" (69.85)	3 3/8" (85.73)	—	3 3/8" (85.73)
— Body	1059-00-00	1059-00-00	—	1059-00-00
— Plunger	1061-00-00	1061-00-00	—	1061-00-00
— Insert	1063-00-00	1063-00-00	—	1063-00-00
— Spring	1065-00-00	1065-00-00	—	1065-00-00
— Adpt bushing	—	1155-01-00 <sup>1</sup>	—	1995-00-00 <sup>1</sup>
— Nuts [2]	U-0004141-C	U-0004141-C	—	U-0004141-C

<sup>1</sup>- Use AF7 wrench (7559)

NOTE: Millimeters in parentheses.

# Universal Collet Stops



## 5C Universal Collet Stop Set

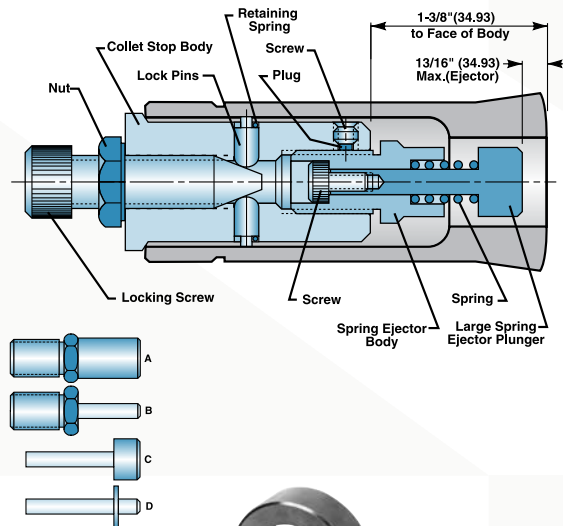
The Hardinge® Universal Collet Stop Set will convert Hardinge 5C collets without internal threads into Solid Stop or Spring Ejector Stop Collets. The two solid inserts and the two inserts for the spring ejector housing can be machined to suit varying requirements. The front end of the collet stop body has a standard 1/2-20 thread for convenient application of other sizes and special-shaped stops. The solid inserts of the spring ejector are adjustable in or out in the stop body to arrive at the desired chucking depth. The locking screw and brass plug hold the insert or spring ejector in the predetermined position. Once that is done, merely place the collet stop in the back of the collet and tighten the lock screw—see illustration. This causes the locking plugs to securely anchor the collet stop inside the collet. Application does not require machining of the collet—the stop is merely placed in the collet.

## 5C Universal Collet Stop Set

Description	Part Number	Fig.	Model
<b>Universal Stop Set - including:</b>	<b>1019-00-00-000000</b>		<b>G10</b>
— Collet Stop Body	1029-00-00-000000		RX-107-F
— Locking Screw	1031-00-00-000000		RX-107-G
— Nut	U-0004141-C		
— Lock Pins [6]	1021-00-00-000000		RX-107-A
— Retaining Spring	1025-00-00-000000		RX-107-C
— Plug	N37-0000483		
— Screw	0550303		
— Solid Insert, 9/16" Diameter <sup>1</sup>	1023-00-00-000000	A	RX-107-B
— Solid Insert, 1/4" Diameter <sup>1</sup>	1027-00-00-000000	B	RX-107-E
— Plunger, 9/16" Diameter <sup>1</sup>	1035-00-00-000000	C	RX-107-L
— Plunger, 1/4" Diameter <sup>1</sup>	1037-00-00-000000	D	RX-107-N
— Spring for Plunger	1039-00-00-000000		RX-107-R
— Spring Ejector Body	1033-00-00-000000		RX-107-H
— Screw	0100306		

1 - Can be altered to different lengths.

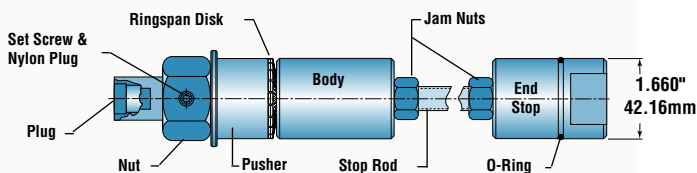
NOTE: Millimeters in parentheses.



## 16C Universal Stop – Draw-Tube Style

Description	Part Number
<b>Universal Stop Assembly - including:</b>	<b>1717-66-00-000000</b>
— Plug	1717-66-01-000000
— Body	1717-66-02-000000
— Nut	1717-66-03-000000
— 10 - 32" x 3/16" Set Screws [3]	0570303
— 5/32" x 1/16" Nylon Plugs [3]	N370000483
— Pusher	1717-66-04-000000
— Ringspan Disks	1717-66-08-000000
— 1/2" - 13 Jam Nut	MD 0003182
— Short Stop Rod	1717-66-05-000000
— Long Stop Rod	1717-66-06-000000
— End Stop	1717-66-07-000000
— O-Ring	OR 0002427

NOTE: Unit is mounted in the draw tube of the collet closer.



## Stop Wrench for Collet Body

Description	Part Number	Part Number
	5C	16C
<b>Collet Stop Wrench</b>	<b>ST-0011759</b>	<b>CC-0011759</b>
— Body	ST-0004025-02	CC-0004025
— Handle	ST-0006239	CC-0006239
— Key	ST-0011006	ST-0011006
Model Number	G-15	16C-15
	<b>20C</b>	<b>25C</b>
<b>Collet Stop Wrench</b>	<b>CL-0011759-A</b>	<b>7605-00-00</b>
— Body	CL-0004025-01	7609-00-00
— Handle	CC-0006239	CC-0006239
— Key	CL-0011006	CL-0011006
Model Number	20C-15	25C-15
	<b>3J</b>	
<b>Collet Stop Wrench</b>	<b>ST-0011759-01</b>	
— Body	ST-0004025	
— Handle	CC-0006239	
— Key	ST-0011006-01	
Model Number	3J-15	