

Hardinge Sjogren Speed Collet Chucks

Quick to mount on all spindle configurations:

- Cam-Lock Spindle
- Threaded Spindle
- Taper-Key Spindle
- American Standard Spindle (ANSI)
- Regular Plain-Back Spindle

3 Nose Styles... Plain-Nose for use with collets,
Threaded and Taper-Nose for use with collets and step chucks with closers.

Sjogren Speed Chucks Parts Lists B-123

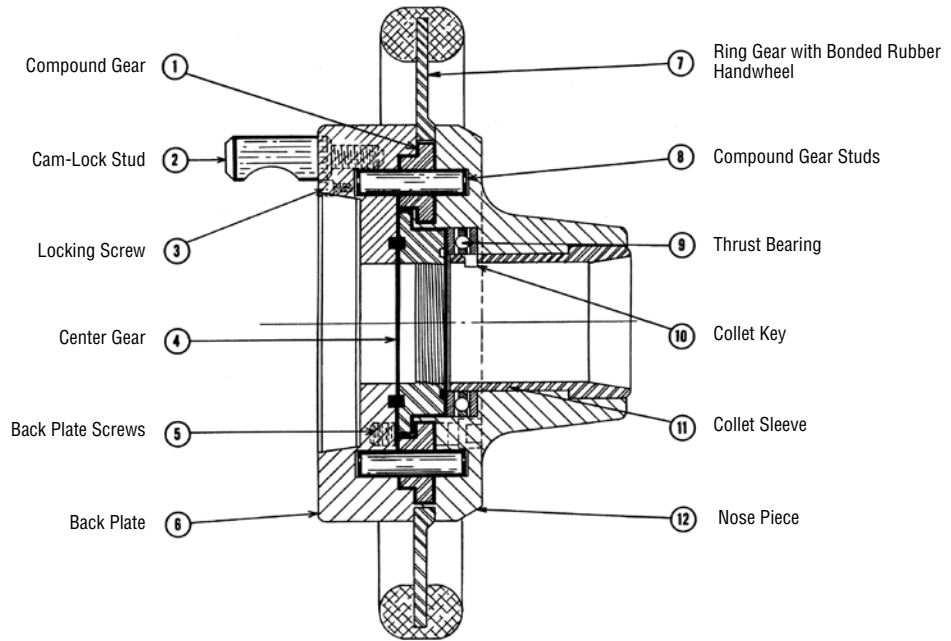
Plain-Nose style for use on Cam-Lock Spindles:



Cam-Lock Spindle



Sjogren 5C Plain-Nose Speed Chuck



Cam-Lock Spindle Nose Chucks – Plain Nose

Chuck Number*	IA	5CA	I	5C	2	2A	I	5C	2	3	I	5C	2	3	I	5C	2	3	22	35	2	3	22	35
Spindle Nose	DI-3"	DI-3"	DI-3"	DI-3"	DI-3"	DI-3"	DI-4"	DI-4"	DI-4"	DI-4"	DI-5"	DI-5"	DI-5"	DI-5"	DI-6"	DI-6"	DI-6"	DI-6"	DI-6"	DI-6"	DI-8"	DI-8"	DI-8"	DI-8"
Key	Part Number in Blue												Model Number in Black											
1 Compound Gear	0306 122	0306 122	0306 122	0306 122	0306 122	0305 120	0306 122	0306 122	0306 122	0306 122	0306 122	0306 122	0306 122	0306 122	0306 122	0306 122	0306 122	0306 122	0306 122	0306 122	0306 122	0306 122	0306 122	0306 122
2 Cam Lock Stud (3 Required)	0460 600	0460 600	0460 600	0460 600	0460 600	0460 600	0462 602	0462 602	0462 602	0462 602	0463 603	0463 603	0463 603	0463 603	0464 604	0464 604	0464 604	0464 604	0464 604	0464 604	0466 606	0466 606	0466 606	0466 606
3 Locking Screw (3 Required)	0461 601	0461 601	0461 601	0461 601	0461 601	0461 601	0461 601	0461 601	0461 601	0461 601	0461 601	0461 601	0461 601	0461 601	0465 605	0465 605	0465 605	0465 605	0465 605	0465 605	0465 605	0465 605	0465 605	0465 605
4 Center Gear***	0302 117	0302 117	0302 117	0302 117	0302 216	0302 217	0302 117	0302 117	0302 216	0302 309	0302 117	0302 117	0302 216	0302 309	0302 117	0302 216	0302 309	0302 509	0302 906	0302 477	0302 309	0302 309	0302 509	0302 906
5 Back Plate Screws (4 Required)	0371 311	0371 311	0371 311	0371 311	0371 311	0346 229	0371 311	0371 311	0371 311	0371 311	0371 311	0371 311	0371 311	0371 311	0371 311	0371 311	0371 311	0371 311	0431 516	0431 916	0477 311	0431 311	0431 516	0477 916
6 Back Plate	0295 106	0295 106	0295 106	0295 106	0318 203	0321 205	0297 108	0297 108	0322 206	0357 303	0298 109	0298 109	0323 207	0359 304	0299 110	0299 110	0325 208	0361 305	0409 502	0469 902	0327 209	0363 306	0413 504	0470 903
7 Ring Gear with Bonded Rubber*** Handwheel	0301 114	0301 114	0300 113	0300 113	0329 210	0331 211	0300 113	0300 113	0329 210	0364 307	0300 113	0300 113	0329 210	0364 307	0300 113	0300 113	0329 210	0364 307	0417 507	0472 905	0329 210	0364 307	0417 507	0472 905
8 Compound Gear Studs (2 Required)	0373 313	0373 313	0373 313	0373 313	0373 313	0348 230	0373 313	0373 313	0373 313	0373 313	0373 313	0373 313	0373 313	0373 313	0373 313	0373 313	0373 313	0373 313	0373 313	0373 313	0373 313	0373 313	0373 313	0373 313
9 Thrust Bearing	0311 127	0311 127	0311 127	0311 127	0343 227	0344 227A	0311 127	0311 127	0343 327	0382 127	0311 127	0311 127	0343 327	0382 127	0311 127	0311 127	0343 327	0382 512	0426 909	0476 227	0343 327	0382 512	0426 909	
10 Collet Key	0308 124	0308 124	0308 124	0308 124	0335 219	0335 219	0308 124	0308 124	0335 219	0376 315	0308 124	0308 124	0335 219	0376 315	0308 124	0308 124	0335 219	0376 315	0424 511	0475 908	0335 219	0376 315	0424 511	0475 908
11 Collet Sleeve**	N/A 123	0403 402	N/A 123	0403 402	0334 218	0334 218	N/A 123	0403 402	0334 218	0334 310	N/A 123	0403 402	0334 218	0334 310	N/A 123	0403 402	0334 218	0334 310	0422 510	0474 907	0334 218	0334 310	0422 510	0474 907
12 Nose Piece (complete with collet sleeve and key)	N/A 101	0400 401	N/A 100	0397 400	0316 200	0317 201	N/A 100	0397 400	0316 200	0353 300	N/A 100	0397 400	0316 200	0353 300	N/A 100	0397 400	0316 200	0353 300	0405 500	0467 900	0316 200	0353 300	0405 500	0467 900

* Chuck number is stamped on front of nose piece
 ** To ensure accuracy, finish grind inside diameter and angles of collet sleeve after inserting in nose piece require the use of special gages. Return the chuck to the factory for installation and grinding of the collet sleeve.
 *** When ordering #0367(309) Center Gear and 0364(307) Ring Gear, specify number of teeth on gear to be replaced.
 N/A Not Available – Obsolete
 NOTE: Aluminum Handwheel supplied with 0472(905) Ring Gear.

Part No. B-0009500-0123

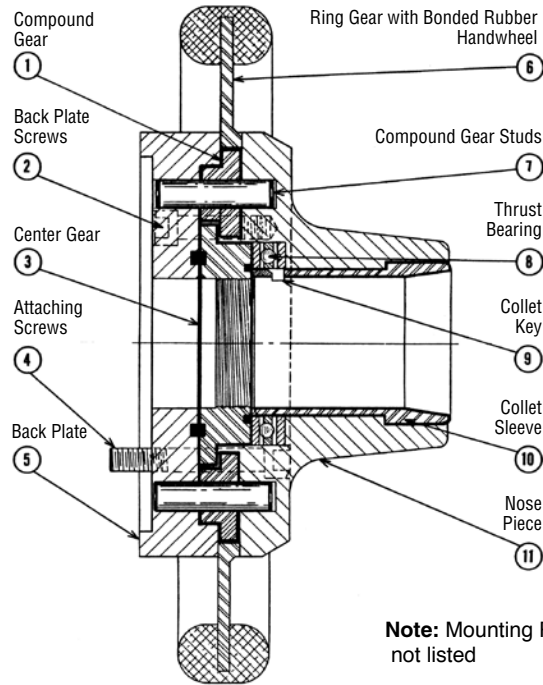
Plain-Nose style for use on Plain-Back, Threaded & Taper Key Spindles:



Taper-Key Spindle



Sjogren 5C Plain-Nose Speed Chuck



Note: Mounting Plate not listed

Plain-Back, Threaded & Taper-Key Chucks – Plain Nose										
Chuck Number*	I	IA	5C	5CA	2	2A	3	22	35	
Key	Part Description									
	Part Number in Blue					Model Number in Black				
1	Compound Gear									
	0306	0306	0306	0306	0306	0305	0306	0306	0306	0306
	122	122	122	122	122	120	122	122	122	122
2	Back Plate Screws (4 Required)									
	0314	0314	0314	0314	0314	0314	0314	0314	0314	0371
	128	128	128	128	128	128	128	128	128	311
3	Center Gear*** (felt kit included #030201)									
	0302	0302	0302	0302	0332	0333	0367	0420	0473	
	117	117	117	117	216	217	309	509	906	
4	Attaching Screw (4 Required)									
	0315	0315	0315	0315	0345	0315	0383	0435	0478	
	129	129	129	129	228	129	328	518	917	
5	Back Plate									
	0293	0294	0293	0294	0319	0342	0354	0407	0468	
	104	105	104	105	204	225	301	501	901	
6	Ring Gear with Bonded Rubber Handwheel***									
	0300	0301	0300	0301	0329	0331	0364	0417	0472	
	113	114	113	114	210	211	307	507	905	
7	Compound Gear Studs(2 Required)									
	0373	0373	0373	0373	0373	0348	0373	0373	0373	
	313	313	313	313	313	230	313	313	313	
8	Thrust Bearing									
	0311	0311	0311	0311	0343	0344	0382	0426	0476	
	127	127	127	127	227	227A	327	512	909	
9	Collet Key									
	0308	0308	0308	0308	0335	0335	0376	0424	0475	
	124	124	124	124	219	219	315	511	908	
10	Collet Sleeve**									
	N/A	N/A	0403	0403	0334	0334	0369	0422	0474	
	123	123	402	402	218	218	310	510	907	
11	Nose Piece (complete with collet sleeve and key)									
	N/A	N/A	0397	0400	0316	0317	0353	0405	0467	
	100	101	400	401	200	201	300	500	900	

* Chuck number is stamped on front of nose piece

** To ensure accuracy, finish grind inside diameter and angles of collet sleeve after inserting in nose piece require the use of special gages. Return the chuck to the factory for installation and grinding of the collet sleeve.

*** When ordering #0367(309) Center Gear and 0364(307) Ring Gear; specify number of teeth on gear to be replaced.

N/A Not Available – Obsolete

NOTE: Aluminum Handwheel supplied with 0472(905) Ring Gear.

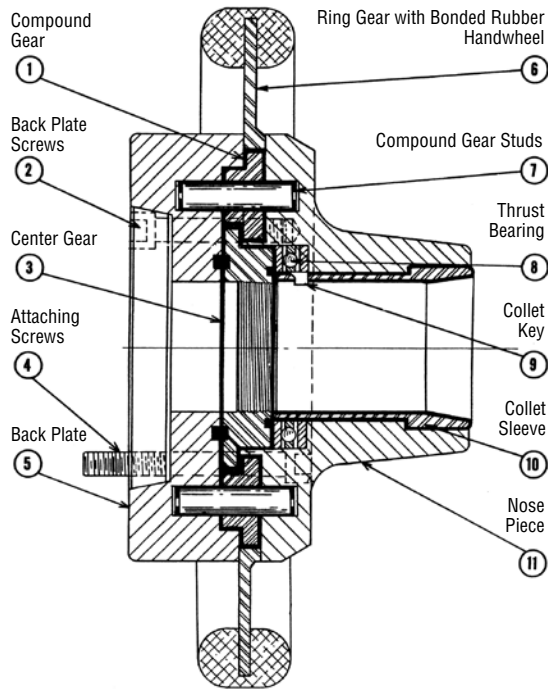
Plain-Nose style for use on American Standard Spindles:



American Standard Spindle



Sjogren 5C Plain-Nose Speed Chuck



American Standard (ANSI) – Plain Nose								
Chuck Number*		1	5C	2	2A	3	22	35
Spindle Nose		A2-5	A2-5	A2-5	A2-5	A2-6	A2-6	A2-8
Key	Part Description	Part Number in Blue				Model Number in Black		
1	Compound Gear	0306	0306	0306	0305	0306	0306	0306
		122	122	122	120	122	122	122
2	Back Plate Screws (4 Required)	0384	0384	0384	0384	0384	0384	0384
		329	329	329	329	329	329	329
3	Center Gear***	0302	0302	0332	0333	0367	0420	0473
		117	117	216	217	309	509	906
4	Attaching Screw (4 Required)	0386	0386	0386	0386	0433	0433	0479
		330	330	330	330	517	517	918
5	Back Plate	0296	0296	0340	0337	0380	0411	0471
		107	107	224	222	317	503	904
6	Ring Gear with Bonded Rubber Handwheel ***	0300	0300	0329	0331	0364	0417	0472
		113	113	210	211	307	507	905
7	Compound Gear Studs(2 Required)	0373	0373	0373	0348	0373	0373	0373
		313	313	313	230	313	313	313
8	Thrust Bearing	0311	0311	0343	0344	0382	0426	0476
		127	127	227	227A	327	512	909
9	Collet Key	0308	0308	0335	0335	0376	0424	0475
		124	124	219	219	315	511	908
10	Collet Sleeve**	N/A	0403	0334	0334	0369	0422	0474
		123	402	218	218	310	510	907
11	Nose Piece (com- plete with collet sleeve and key)	N/A	0404	0338	0336	0378	0405	0467
		102	403	223	221	316	500	900

* Chuck number is stamped on front of nose piece
 ** To ensure accuracy, finish grind inside diameter and angles of collet sleeve after inserting in nose piece require the use of special gages. Return the chuck to the factory for installation and grinding of the collet sleeve.
 *** When ordering #0367(309) Center Gear and 0364(307) Ring Gear, specify number of teeth on gear to be replaced.
 N/A Not Available – Obsolete
 NOTE: Aluminum Handwheel supplied with 0472(905) Ring Gear.

Part No. B-0009500-0123

Threaded & Taper-Nose style for use on Cam-Lock Spindles:



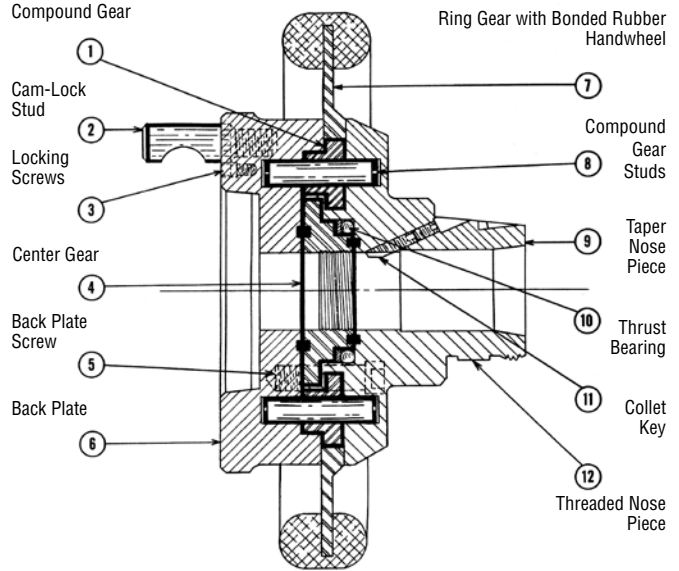
Cam-Lock Spindle



Sjogren 5CT Threaded Nose Speed Chuck



Sjogren 5CX Tapered Nose Speed Chuck



Cam-Lock Spindle Chucks – 5C Spindle Nose														
Chuck Numbers*	5CX	5CAX	5CT	5CAT	5CX	5CAX	5CT	5CAT	5CX	5CAX	5CT	5CAT	5CX	5CT
Spindle Nose	D1-3"	D1-3"	D1-3"	D1-3"	D1-4"	D1-4"	D1-4"	D1-4"	D1-5"	D1-5"	D1-5"	D1-5"	D1-6"	D1-6"
Key	Part Number in Blue												Model Number in Black	
Part Description														
1 Compound Gear	0306	0306	0306	0306	0306	0306	0306	0306	0306	0306	0306	0306	0306	0306
	122	122	122	122	122	122	122	122	122	122	122	122	122	122
2 Cam Lock Stud (3 Required)	0460	0460	0460	0460	0462	0462	0462	0462	0463	0463	0463	0463	0464	0464
	600	600	600	600	602	602	602	602	603	603	603	603	604	604
3 Locking Screw (3 Required)	0461	0461	0461	0461	0461	0461	0461	0461	0461	0461	0461	0461	0465	0465
	601	601	601	601	601	601	601	601	601	601	601	601	605	605
4 Center Gear***	0304	0304	0303	0303	0304	0304	0303	0303	0304	0304	0303	0303	0304	0303
	117X	117X	117T	117T	117X	117X	117T	117T	117X	117X	117T	117T	117X	117T
5 Back Plate Screws (4 Required)	0371	0371	0371	0371	0371	0371	0371	0371	0371	0371	0371	0371	0371	0371
	311	311	311	311	311	311	311	311	311	311	311	311	311	311
6 Back Plate	0295	0295	0295	0295	0297	0297	0297	0297	0298	0298	0298	0298	0299	0299
	106	106	106	106	108	108	108	108	109	109	109	109	110	110
7 Ring Gear with Bonded Rubber Handwheel	0300	0301	0300	0301	0300	0301	0300	0301	0300	0301	0300	0301	0300	0300
	113	114	113	114	113	114	113	114	113	114	113	114	113	113
8 Compound Gear Studs (2 Required)	0373	0373	0373	0373	0373	0373	0373	0373	0373	0373	0373	0373	0373	0373
	313	313	313	313	313	313	313	313	313	313	313	313	313	313
11 Taper Nose Piece	0399	0402	—	—	0399	0402	—	—	0399	0402	—	—	0399	—
	400X	401X	—	—	400X	401X	—	—	400X	401X	—	—	400X	—
9 Thrust Bearing	0313	0313	0312	0312	0313	0313	0312	0312	0313	0313	0312	0312	0313	0312
	127X	127X	127T	127T	127X	127X	127T	127T	127X	127X	127T	127T	127X	127T
10 Collet Key	0310	0310	0309	0309	0310	0310	0309	0309	0310	0310	0309	0309	0310	0309
	124X	124X	124T	124T	124X	124X	124T	124T	124X	124X	124T	124T	124X	124T
12 Threaded Nose Piece	—	—	0398	0401	—	—	0398	0401	—	—	0398	0401	—	0398
	—	—	400T	401T	—	—	400T	401T	—	—	400T	401T	—	400T

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 *** When ordering #0367(309) Center Gear and 0364(307) Ring Gear, specify number of teeth on gear to be replaced.
 N/A Not Available – Obsolete
 NOTE: Aluminum Handwheel supplied with 0472(905) Ring Gear.

Threaded & Taper-Nose style for use on Plain-Back, Threaded & Taper-Key Spindles:



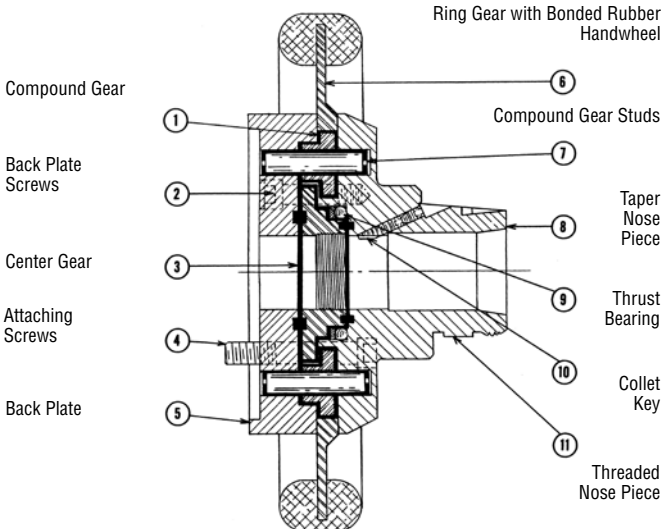
Taper-Key Spindle



Sjogren 5CT Threaded Nose Speed Chuck



Sjogren 5CX Tapered Nose Speed Chuck



Plain-Back, Threaded & Taper-Key Chucks—5C Spindle Nose					
Chuck Numbers*		5CX	5CAX	5CT	5CAT
Key	Part Name				
1	Compound Gear	0306	0306	0306	0306
		122	122	122	122
2	Back Plate Screws (4 Required)	0314	0314	0314	0314
		128	128	128	128
3	Center Gear***	0304	0304	0303	0303
		117X	117X	117T	117T
4	Attaching Screws (4 Required)	0315	0315	0315	0315
		129	129	129	129
5	Back Plate	0293	0294	0293	0294
		104	105	104	105
6	Ring Gear with Bonded Rubber Handwheel	0300	0301	0300	0301
		113	114	113	114
7	Compound Gear Studs (2 Required)	0373	0373	0373	0373
		313	313	313	313
8	Taper Nose Piece	0399	0402	—	—
		400X	401X	—	—
9	Thrust Bearing	0313	0313	0312	0312
		127X	127X	127T	127T
10	Collet Key	0310	0310	0309	0309
		124X	124X	124T	124T
11	Threaded Nose Piece	—	—	0398	0401
		—	—	400T	401T

Part Number in Blue Model Number in Black
*Chuck number is stamped on front of nose piece

Threaded & Taper-Nose style for use on American Standard Spindles:



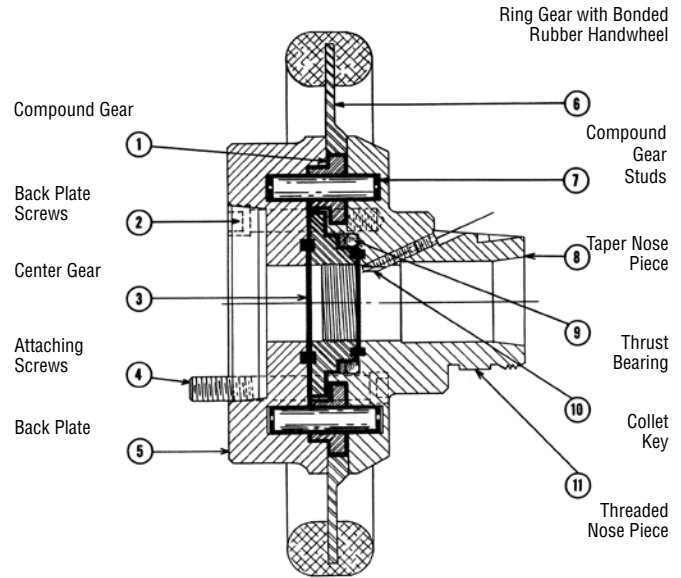
American Standard Spindle



Sjogren 5CT Threaded Nose Speed Chuck



Sjogren 5CX Tapered Nose Speed Chuck



American Standard (ANSI) – 5C Spindle Nose				
Chuck Numbers*	5CX	5CAX	5CT	5CAT
Spindle Nose	A2-5	A2-5	A2-5	A2-5
Key	Part Name			
1	Compound Gear	0306 122	0306 122	0306 122
2	Back Plate Screws (4 Required)	0384 329	0384 329	0384 329
3	Center Gear***	0304 117X	0304 117X	0303 117T
4	Attaching Screws (4 Required)	0386 330	0386 330	0386 330
5	Back Plate	0296 107	0296 107	0296 107
6	Ring Gear with Bonded Rubber Handwheel	0300 113	0301 114	0300 113
7	Compound Gear Studs (2 Required)	0373 313	0373 313	0373 313
8	Taper Nose Piece	0399 400X	0402 401X	— —
9	Thrust Bearing	0313 127X	0313 127X	0312 127T
10	Collet Key	0310 124X	0310 124X	0309 124T
11	Threaded Nose Piece	— —	— —	0398 401T

Part Number in Blue Model Number in Black
 *Chuck number is stamped on front of nose piece