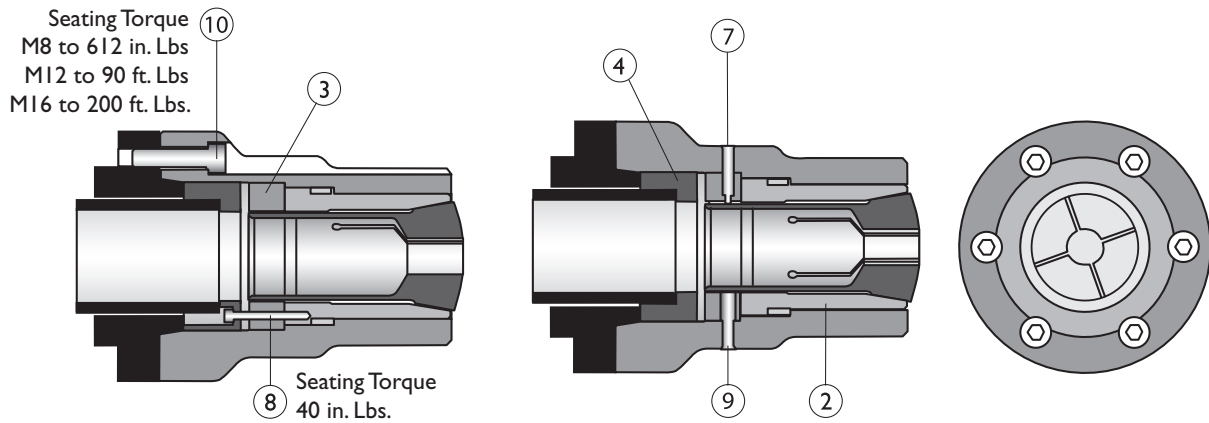


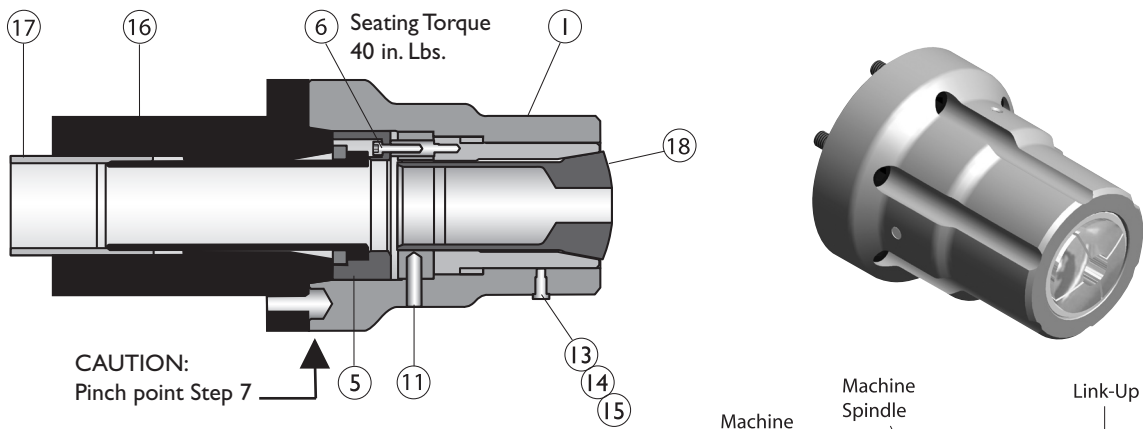
Hardinge Dead-Length® Collet Chuck A2-5, A2-6 and A2-8 to 5C, 16C and 3J

Installation Instructions and Parts Lists

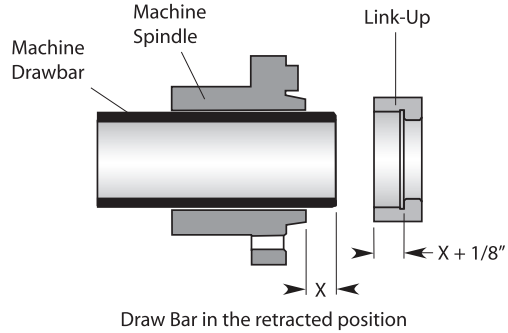
Dead-Length® Collet Chuck Instructions B-125



Non-Hardinge brand machine spindle views (above); Hardinge brand machine spindle view (below)



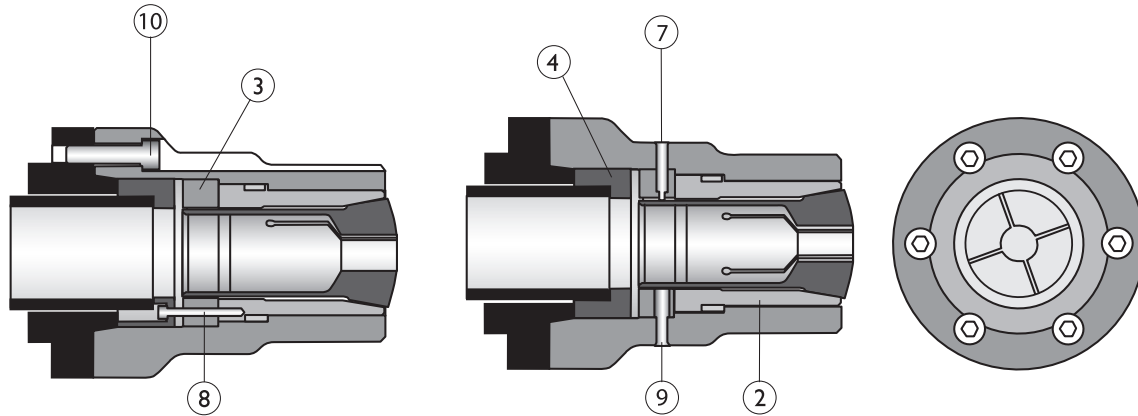
NOTE: A blank Link-Up (Item 4) for non-Hardinge machines is supplied with the adapter to be machined by the customer. Refer to "X" dimension shown to the right.



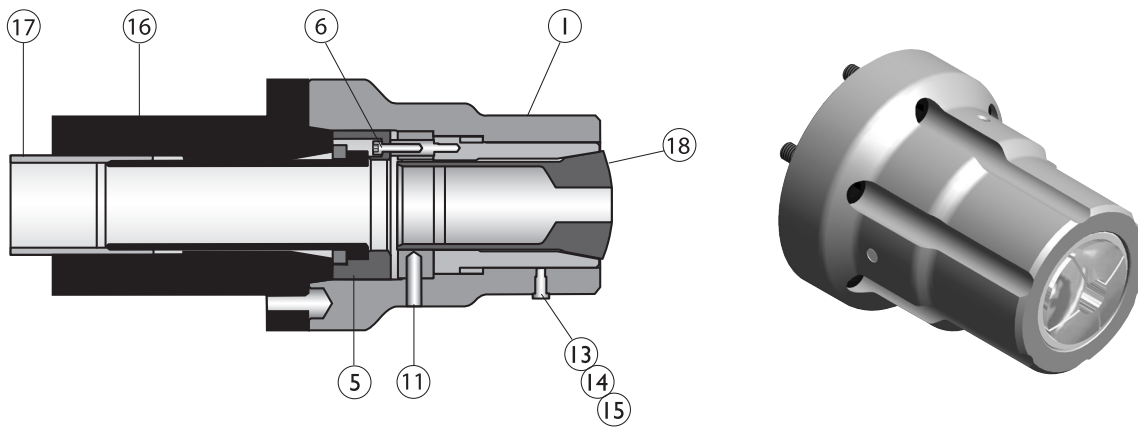
Installation:

- Step 1: Remove existing spindle tooling that may be on the machine.
- Step 2: Clean both the spindle mounting surface and the adapter mounting surface.
- Step 3: Activate the machine's draw bar actuator to place the draw bar in its forward position.
- Step 4: Assemble Link-Up (Item 5) and Adapter Assembly together with all six mounting screws (Item 6 & 8).
- Step 5: Thread the Link-Up and Adapter Assembly onto the draw bar until Link-Up shoulders on the Draw Bar.
- Step 6: Back off the Adapter until the drive button on your spindle lines up with the locating hole on the Adapter. Turn in one Mounting Screw (Item 10) to keep with the alignment.
- Step 7: Activate the machine's draw bar actuator to place the draw bar to its retracted position.
WARNING: This could cause a pinch point between the spindle and the adapter.
- Step 8: Insert the remaining Mounting Screws (Item 10) into the Adapter and tighten the Mounting Screws using a crisscross fashion.
- Step 9: Thread your Collet (Item 18) into the Adapter for proper loading of a part. Set the Spring Plunger Key (Item 7) to lock the Collet into place. Collets sold separately. To remove the Collet, back off the Spring Plunger Key to unthread the Collet.

Dead-Length® Collet Chuck Instructions B-125



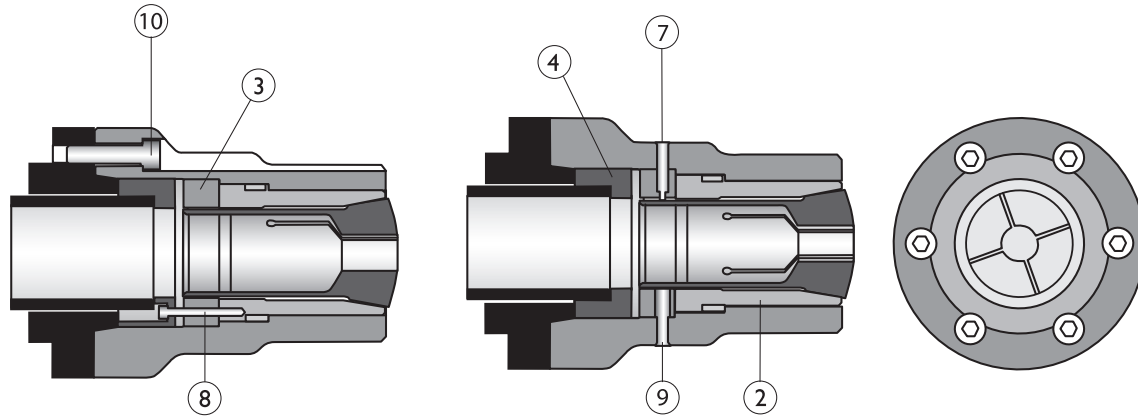
Non-Hardinge brand machine spindle views (above); Hardinge brand machine spindle view (below)



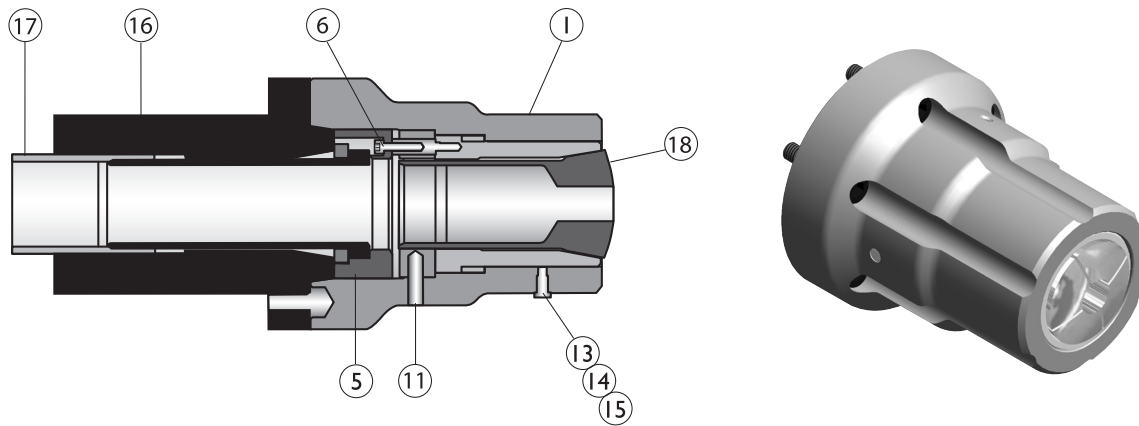
16C Parts List:

| ITEM | DESCRIPTION | QTY | A2-5 PART NO. | A2-6 PART NO. | A2-8 PART NO. |
|------|---------------------------------|----------|--------------------------|--|--------------------------|
| | 16C Dead-Length Assembly | 1 | 7817-00-00-000500 | 7819-00-00-000500 | 7821-00-00-000500 |
| 1 | Body | 1 | 7817-00-00-000501 | 7819-00-00-000501 | 7821-00-00-000501 |
| 2 | Sleeve Assembly | 1 | 7817-00-00-000502 | 7817-00-00-000502 | 7817-00-00-000502 |
| 3 | Threaded Bushing | 1 | 7817-00-00-000503 | 7817-00-00-000503 | 7817-00-00-000503 |
| 4 | Link-Up Blank, Non-Hardinge | 1 | 7817-00-00-000507 | 7819-00-00-000507 | 7821-00-00-000507 |
| 5 | Link-Up for Hardinge Machine | 1 | (16C) 7817-00-00-000512 | (20C) 7819-00-00-000512 (25C) 7819-00-00-000516 | (25C) 7821-00-00-000512 |
| 6 | 10-32 x 1/2 SHCS | 4 | 0100308 | 0100308 | 0100308 |
| 7 | Key | 1 | CE-00PH55A | CE-00PH55A | CE-00PH55A |
| 8 | 10-32 x 1 3/8 SHCS | 2 | 0100322 | 0100322 | 0100322 |
| 9 | Key Blank | 1 | 0570508 | 0570508 | 0570508 |
| 10 | Mounting Screws | 6 | MS-0104022 (M8) | MS-0104222 (M12) | MS-0104622 (M16) |
| 11 | Dowel | 2 | NC-0006709 | NC-0006709 | NC-0006709 |
| 13 | Fitting | 1 | CE-0001851 | CE-0001851 | CE-0001851 |
| 14 | Nozzle | 1 | CE-0000737 | CE-0000737 | CE-0000737 |
| 15 | Chevron Dura-Lith 2 Grease | .1 | CE-0000003 | CE-0000003 | CE-0000003 |
| 16 | Spindle | — | — | — | — |
| 17 | Draw Bar | — | — | — | — |
| 18 | 16C Collet | — | — | — | — |

Dead-Length® Collet Chuck Instructions B-125



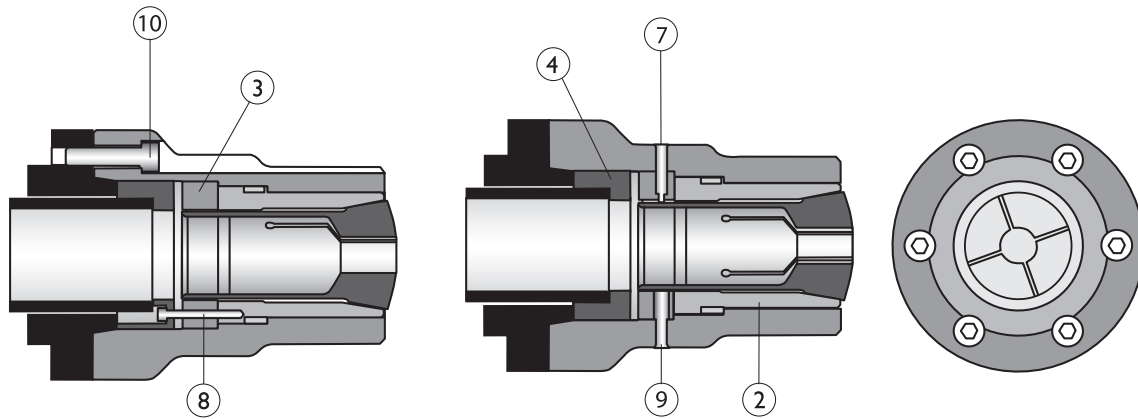
Non-Hardinge brand machine spindle views (above); Hardinge brand machine spindle view (below)



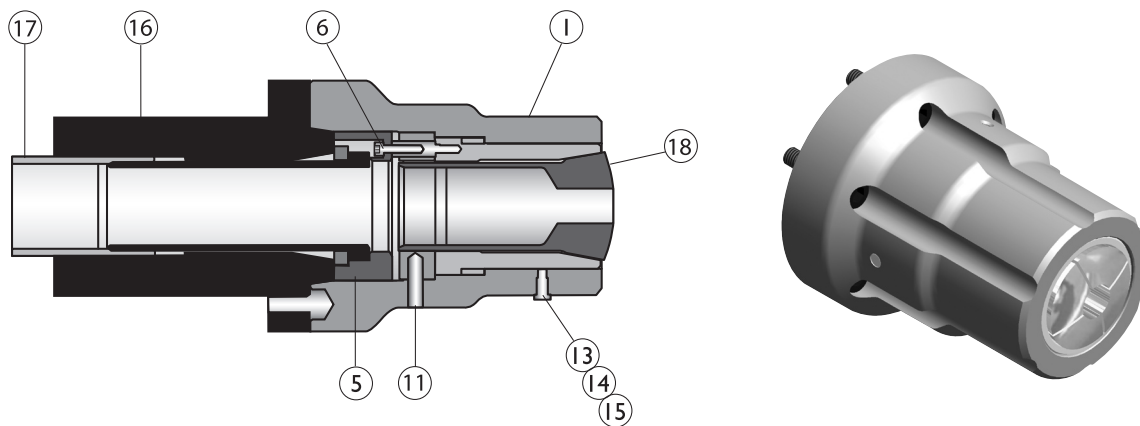
3J Parts List:

| ITEM | DESCRIPTION | QTY | A2-5 PART NO. | A2-6 PART NO. | A2-8 PART NO. |
|------|--------------------------------|-----|--------------------------|--|--------------------------|
| | 3J Dead-Length Assembly | 1 | 7811-00-00-000500 | 7813-00-00-000500 | 7815-00-00-000500 |
| 1 | Body | 1 | 7811-00-00-000501 | 7813-00-00-000501 | 7815-00-00-000501 |
| 2 | Sleeve Assembly | 1 | 7811-00-00-000502 | 7811-00-00-000502 | 7811-00-00-000502 |
| 3 | Threaded Bushing | 1 | 7811-00-00-000503 | 7811-00-00-000503 | 7811-00-00-000503 |
| 4 | Link-Up Blank, Non-Hardinge | 1 | 7817-00-00-000507 | 7819-00-00-000507 | 7821-00-00-000507 |
| 5 | Link-Up for Hardinge Machine | 1 | (16C) 7817-00-00-000512 | (20C) 7819-00-00-000512 (25C) 7819-00-00-000516 | (25C) 7821-00-00-000512 |
| 6 | 10-32 x 1/2 SHCS | 4 | 0100308 | 0100308 | 0100308 |
| 7 | Key | 1 | CE-00PH55A | CE-00PH55A | CE-00PH55A |
| 8 | 10-32 x 1 3/8 SHCS | 2 | 0100322 | 0100322 | 0100322 |
| 9 | Key Blank | 1 | 0570508 | 0570508 | 0570508 |
| 10 | Mounting Screws | 6 | MS-0104022 (M8) | MS-0104222 (M12) | MS-0104622 (M16) |
| 11 | Dowel | 2 | NC-0006709 | NC-0006709 | NC-0006709 |
| 13 | Fitting | 1 | CE-0001851 | CE-0001851 | CE-0001851 |
| 14 | Nozzle | 1 | CE-0000737 | CE-0000737 | CE-0000737 |
| 15 | Chevron Dura-Lith 2 Grease | .1 | CE-0000003 | CE-0000003 | CE-0000003 |
| 16 | Spindle | — | — | — | — |
| 17 | Draw Bar | — | — | — | — |
| 18 | 3J Collet | — | — | — | — |

Dead-Length® Collet Chuck Instructions B-125



Non-Hardinge brand machine spindle views (above); Hardinge brand machine spindle view (below)



5C Parts List:

| ITEM | DESCRIPTION | QTY | A2-5 PART NO. | A2-6 PART NO. |
|------|--------------------------------|----------|--------------------------|--|
| | 5C Dead-Length Assembly | 1 | 7803-00-00-000500 | 7805-00-00-000500 |
| 1 | Body | 1 | 7803-00-00-000501 | 7805-00-00-000501 |
| 2 | Sleeve Assembly | 1 | 7803-00-00-000502 | 7803-00-00-000502 |
| 3 | Threaded Bushing | 1 | 7803-00-00-000503 | 7803-00-00-000503 |
| 4 | Link-Up Blank, Non-Hardinge | 1 | 7817-00-00-000507 | 7819-00-00-000507 |
| 5 | Link-Up for Hardinge Machine | 1 | (16C) 7817-00-00-000512 | (20C) 7819-00-00-000512 (25C) 7819-00-00-000516 |
| 6 | 10-32 x 1/2 SHCS | 4 | 0100308 | 0100308 |
| 7 | Key | 1 | CE-00PH55A | CE-00PH55A |
| 8 | 10-32 x 1 3/8 SHCS | 2 | 0100322 | 0100322 |
| 9 | Key Blank | 1 | 0570508 | 0570508 |
| 10 | Mounting Screws | 6 | MS-0104022 (M8) | MS-0104222 (M12) |
| 11 | Dowel | 2 | NC-0006709 | NC-0006709 |
| 13 | Fitting | 1 | CE-0001851 | CE-0001851 |
| 14 | Nozzle | 1 | CE-0000737 | CE-0000737 |
| 15 | Chevron Dura-Lith 2 Grease | .1 | CE-0000003 | CE-0000003 |
| 16 | Spindle | — | — | — |
| 17 | Draw Bar | — | — | — |
| 18 | 5C Collet | — | — | — |

Maintenance:

Grease the collet chuck every 24 hours with Chevron Dura-Lith 2 or equivalent grease. Periodically remove the collet chuck and link-up from the spindle. Clean out contaminants from the collet chuck and link-up and inspect the internal parts. Frequency depends on collet chuck usage and the environment.