



## ***Mounting Instructions***

### **Models: all C-Style, S-Style & J-Style For American Std. and Select Flat-Nose Spindles**

- 1) Remove existing chuck, fixtures and any face plate attachments. Thoroughly clean the mounting surface of the spindle free from any chips or debris.
  - 2) Extend the machine's drawtube to a forward/open position.
  - 3) ***For shipping purposes, the drawtube adapter may be placed in the adapter bore of the chuck body.*** If the drawtube adapter is in the chuck body, remove it. Locate the supplied "O" ring(s) in the installation package. Slide the "O" ring(s) over the outside of the drawtube adapter. Place the "O" ring(s) into the machined "O" ring groove(s) on the drawtube adapter.
  - 4) Apply a small amount of grease onto the threads of the drawtube adapter, and if applicable, onto the "O" ring(s) before installation. Thread the drawtube adapter onto the machine's drawtube, until it has bottomed out. Lock the drawtube adapter onto the machine's drawtube with a universal spanner wrench (***not included***). Make sure that the drawtube adapter is completely tightened onto the machine's drawtube. Retract the machine's drawtube.
  - 5) Clean both the machine's spindle taper and the collet chuck mounting taper.
  - 6) **AMERICAN STANDARD SPINDLES:**  
Line up the machine's drive pin, located on the machine's spindle, with one of the drive pinholes on the collet chuck-mounting surface. Mount the collet chuck onto the machine's spindle. Install and completely tighten the mounting bolts in an alternating sequence, (crisscross).
- SELECT FLAT-NOSE SPINDLES:**  
Most select flat-nose spindles **WILL NOT** have a drive pin located on the machine's spindle or a drive pin hole located on the collet chuck mounting flange. For select flat-nose spindles, do not completely tighten mounting bolts, this allows the collet chuck body to be properly indicated to the spindle.
- 7) **AMERICAN STANDARD SPINDLES:**  
To ensure proper installation, place a .0001" dial indicator on the closing taper of the collet chuck. Turn the collet chuck by hand, checking for any run out. The collet chuck should indicate at .0005" T.I.R. or better.

#### **SELECT FLAT-NOSE SPINDLES:**

For select flat-nose spindles, collet chuck should be properly adjusted and indicated at zero T.I.R. Once properly adjusted and indicated, completely tighten the mounting bolts.



## Pull Back Collet Chucks

- 8) Remove the anti-rotation screw from the collet chuck body to allow for collet installation.
- 9) Locate the anti-rotation slot in the collet. Mark the face of the collet in relation to the anti-rotation slot.
- 10) Thread the collet into the collet chuck body with an ATS collet wrench, until the closing tapers of the collet and the chuck body come in contact with one another.  
**“C” & “J” STYLE SYSTEMS:**  
For “C” and “J” Style systems install the collet approximately .004” to .007” over the diameter size of the desired workpiece.  
**“S” STYLE SYSTEMS:**  
For “S” Style systems install the master collet (with collet pads) approximately .010” to .020” over the diameter size of the desired workpiece. For “S” style systems please refer to Instruction for Hardinge® Style “S” Sure-Grip Master Collets and Pads.  
**Note:** S30 and S16 Master Collets have a Left Hand Thread, master collets must be turn Counterclockwise to be install.
- 11) It is recommended that the desired workpiece diameter does not exceed .002” - .003” over or under the nominal diameter size of the desired collet or collet pads.
- 12) Line up the collet slot with the nearest anti-rotation screw hole.
- 13) **AMERICAN STANDARD SPINDLES:**  
Insert the anti-rotation screw until it bottoms out, then back it out a 1/4 turn, allowing for unrestricted movement of the collet. **DO NOT** back out the anti-rotation screw in “S” Style systems.  
**SELECT FLAT-NOSE SPINDLES:**  
For select flat-nose spindles, insert a second anti-rotation screw into the collet chuck body, locating the second anti-rotation screw exactly 180 degrees apart from the previously installed anti-rotation screw. This ensures proper balance of the collet chuck system.
- 14) Adjust the machine’s drawtube pressure to the desired pressure needed to sufficiently hold the workpiece. Insert a workpiece into the collet then actuate the system.

***NEVER ACTUATE THE SYSTEM WITHOUT A  
WORKPIECE IN THE COLLET***