

**B99**

## Instructions – Quick-Change Jaw Chuck Assembly

Hardinge Inc. – One Hardinge Drive – Elmira, NY 14902-1507

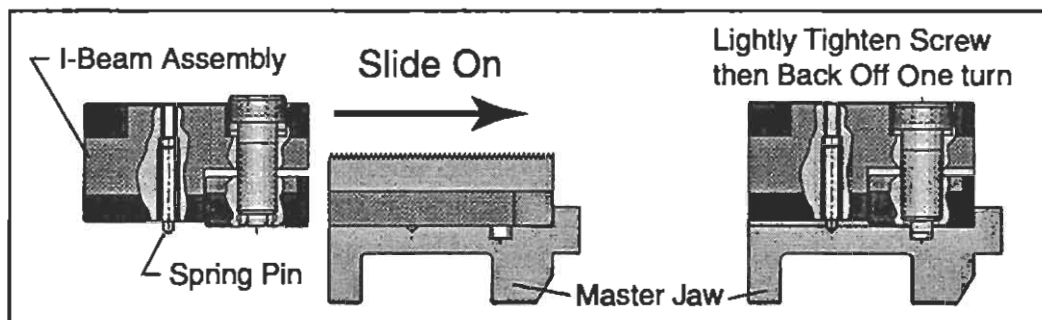
### Mounting the “I” Beams

- Slide the three “I” beams into the slots of the master jaws until their spring pins locate in the detents. (Depress spring pin while sliding I-Beam in T-Slot.)
- Tighten the piloted cap crew until it bottoms out, then back out one full turn.

**Warning:** If cap screw is backed out more than one turn and the spindle is turned on, the “I” beams may come out resulting in damage to the machine tool and/or personal injury.

- The “I” beams stay on the chuck and are not taken off when the quick-change top jaws are removed. The “I” beams are only removed if standard top jaws are to be used on the chuck.

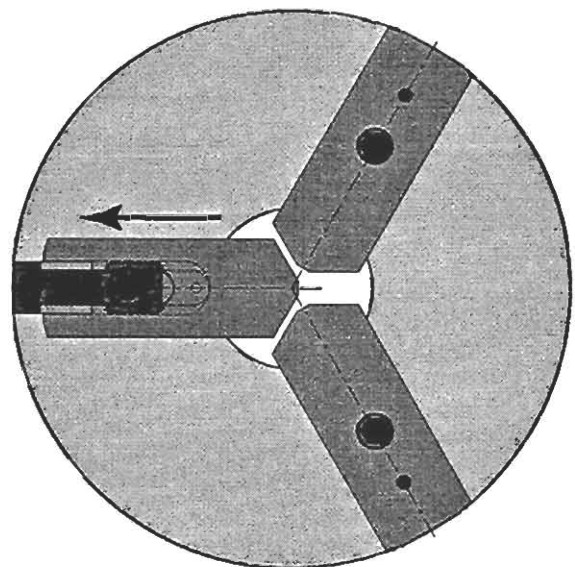
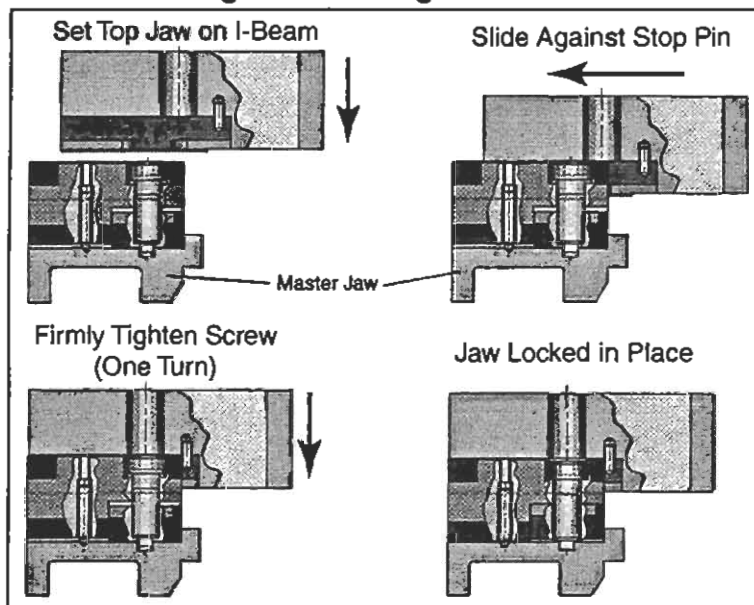
### Mounting I-Beam to Master Jaw of Chuck



### Mounting the Quick-Change Top Jaws

- Align the cutout in the bottom of the top jaw with the flange of the “I” beam. Place the top jaw onto the “I” beam.
- Slide the top jaw towards the OD of the chuck until it locates against the front of the “I” beam.  
**Note:** If the top jaw will not slide because the teeth are partially meshed with the master jaw, either don't push down so hard on the top jaw or back out the cap screw in the “I” beam another 1/4 turn.
- Hold the top jaw against the front of the “I” beam and tighten down the cap screw (approximately one full turn) with 30 Ft-lbs / 40.67 NM of torque.

#### Mounting Quick-Change Jaw To I-Beam



**Last Jaw Being Mounted**  
(I-Beam Shown for Clarity)

**Machining Top Jaws – See Sure-Grip™ Chuck Manual B-87R**