



# MOUNTING INSTRUCTIONS and PARTS LIST for 16C DEAD LENGTH STEP CHUCK

## Mounting Instructions:

1. Machine the O.D. and front face of stop button "G", Figure 1, per the dimensions shown in Figure 2.
2. Bolt the proper size step chuck closer on the spindle.
3. Install step chuck "H" in the spindle as outlined in the operator's manual and place the three pins into the holes in the face of the step chuck.
4. Close the step chuck on the pins and bore to a depth of 1.250 by the diameter required to grip the part. Part should have a slip fit when the collet closer is open.
5. Remove the step chuck from the machine and remove the pins from the step chuck.
6. Remove two nuts "A" and spring "B" from draw bar "E".
7. Remove spring retainer "C" and adapter bushing "D" as an assembly. Make sure the spring retainer is screwed into the adapter bushing tightly and that fins "F" are assembled tightly to draw bar "E".
8. Thread the adapter bushing and spring retainer assembly into the back of the step chuck and tighten with a wrench.
9. Orient fins "F" with the slots in the front of the step chuck and slide the fin and draw bar assembly into the step chuck while guiding the draw bar through spring retainer "C".
10. Slide spring "B" over the draw bar and into spring retainer "C".
11. Thread two nuts "A" onto draw bar "E" until approximately 3/16 inch (4 or 5 threads) are exposed as shown in Figure 2.

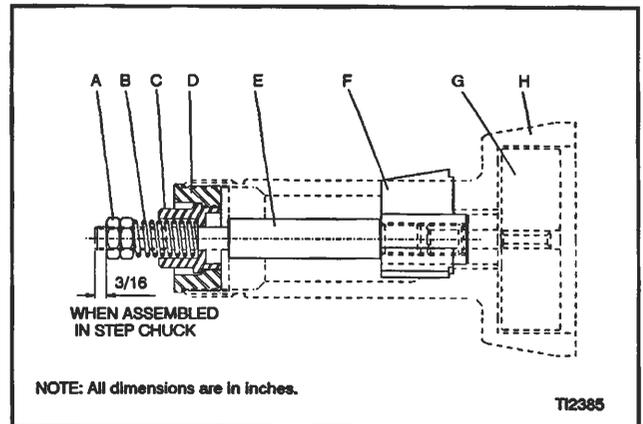


Figure 1 - Dead Length Step Chuck Assembly

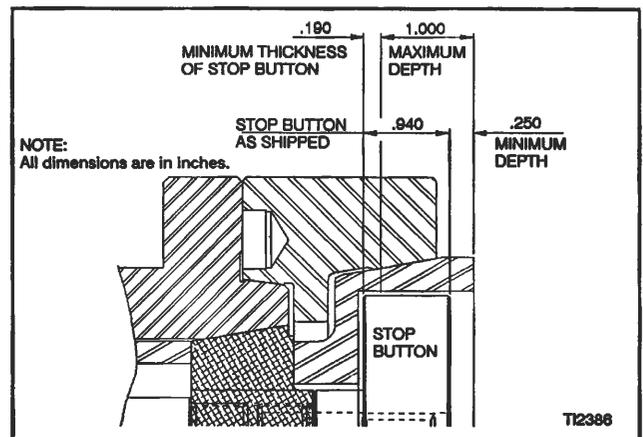


Figure 2 - Stop Button Dimensions

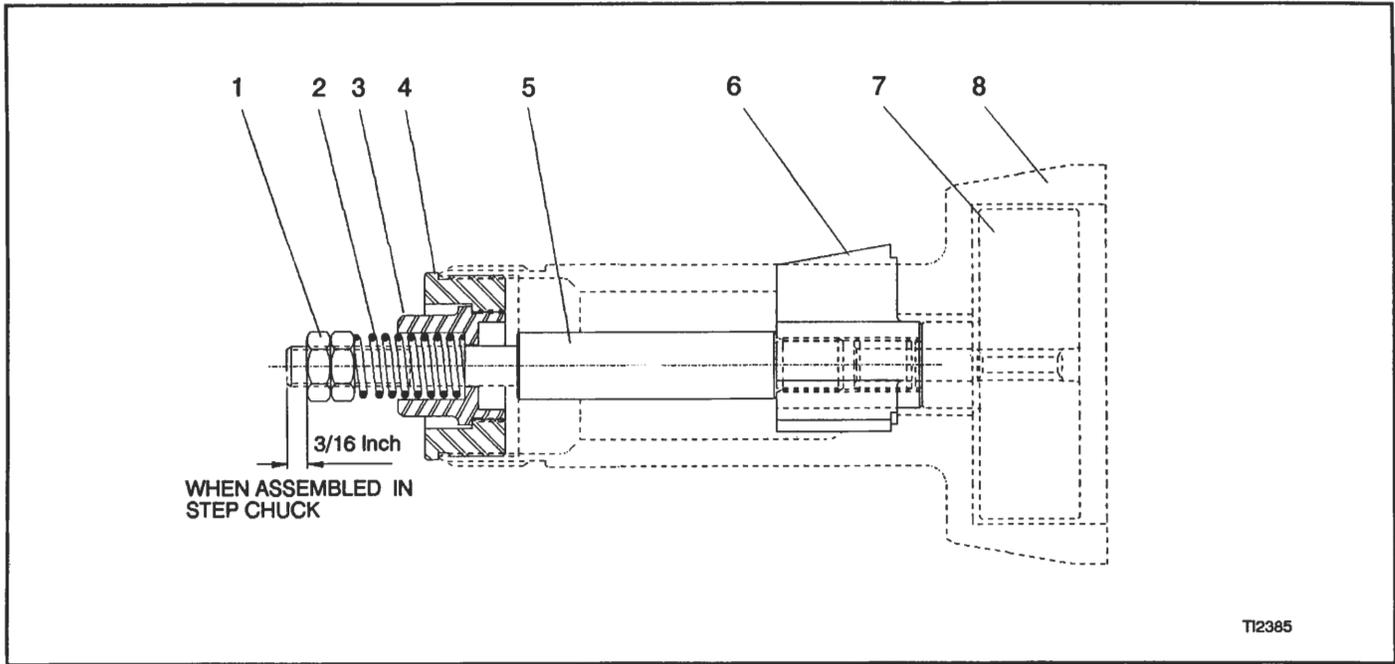
### - NOTE -

Assembly will be loose in step chuck. The closing angle in the machine spindle will apply spring pressure.

12. Lock the nuts together by holding one and tightening the other against it.
13. Install the step chuck in the machine.
14. Thread stop button "G" into the front of fin "F" using a 1/4 inch hex wrench.
15. If extreme accuracy is required from the locating face of the part to the machined surfaces, place the pins into the holes in the step chuck, close down on the pins, skim the face of the stop button, and remove the pins.
16. Adjust the collet closer for proper opening and closing on the workpiece as outlined in the operator's manual.

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# PARTS LIST



ITEM	PART NUMBER	QUANTITY	DESCRIPTION
-	1485-00-00-000000	1	Fin Assembly (Includes Items 1 through 6)
1	U-4141	2	Nut, 3/8-24
2	1165-00-00-000000	1	Spring
3	1163-00-00-000000	1	Spring Retainer
4	1155-01-00-000000	1	Collet Stop Adapter Bushing
5	1489-00-00-000000	1	16C Spider Stop Draw Bar
6	1487-00-00-000000	1	16C Spider Stop Fins
7	1491-00-00-000000	1	3 Inch Stop Button (Separate Item)
7	1493-00-00-000000	1	4 Inch Stop Button (Separate Item)
8	1327-00-00-000000	1	3 Inch Step Chuck (Separate Item)
8	1329-00-00-000000	1	4 Inch Step Chuck (Separate Item)