

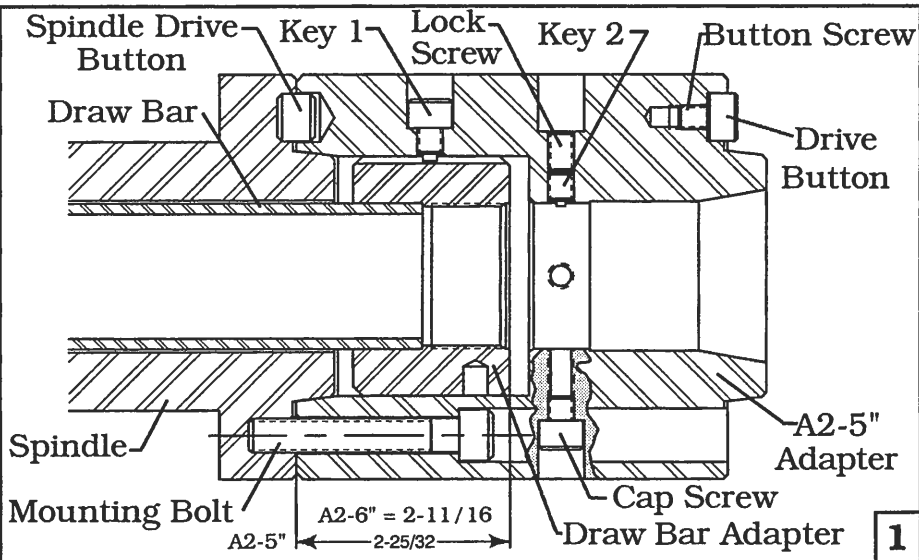
# A2-5" TO A2-5" 16C & A2-6" to A2-5" 16C SPINDLE ADAPTER

INSTRUCTIONS & PARTS LIST B -0009500-0079

**QUICK START** Instructions quickly guide you through the procedure. Read the main instructions first to thoroughly understand how to use the product.

## QUICK START

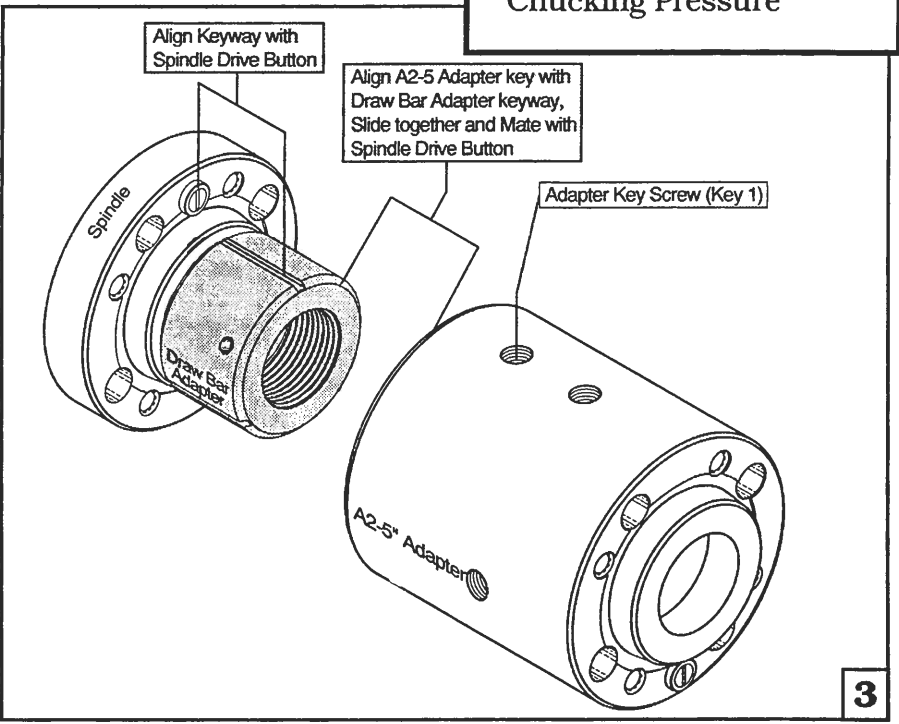
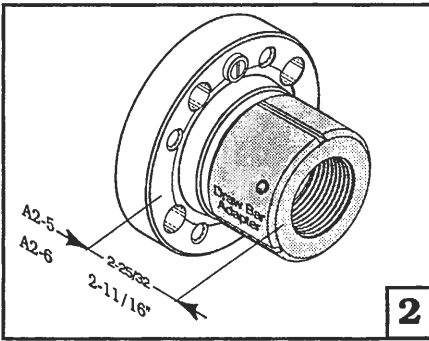
- Clean Parts, Spindle & Mount
- Draw Bar Forward
- Assemble **Draw Bar Adapter** to Machine's Draw Bar: A2-5 = 2-25/32", A2-6 = 2-11/16"
- Lubricate **D. B. Adapter**
- Align Keyway to **Spindle Drive Button**
- Slide **Adapter** on & align **Key 1** with **Draw Bar Adapter Keyway** & **Spindle Drive Button**
- Bolt in place
- Remove **Lock screw, Key 2, & the 3 Cap Screws**
- Insert 16C Collet & tighten until Angles are mated
- Continue Tightening collet until Keyway lines up with one of the 4 holes in the **Adapter**
- Insert **Key 2**, bottom out & back off 1/4 Turn
- Lock **Key 2** with **Lock Screw**
- Insert & Tighten 3 **Cap Screws** in Remaining 3 holes
- Insert Stock & Adjust Chucking Pressure



A2-5" TO A2-5" 16C Spindle Adapter Assembly  
( See Fig. 4 for A2-6 to A2-5" 16C Spindle Adapter Assembly)

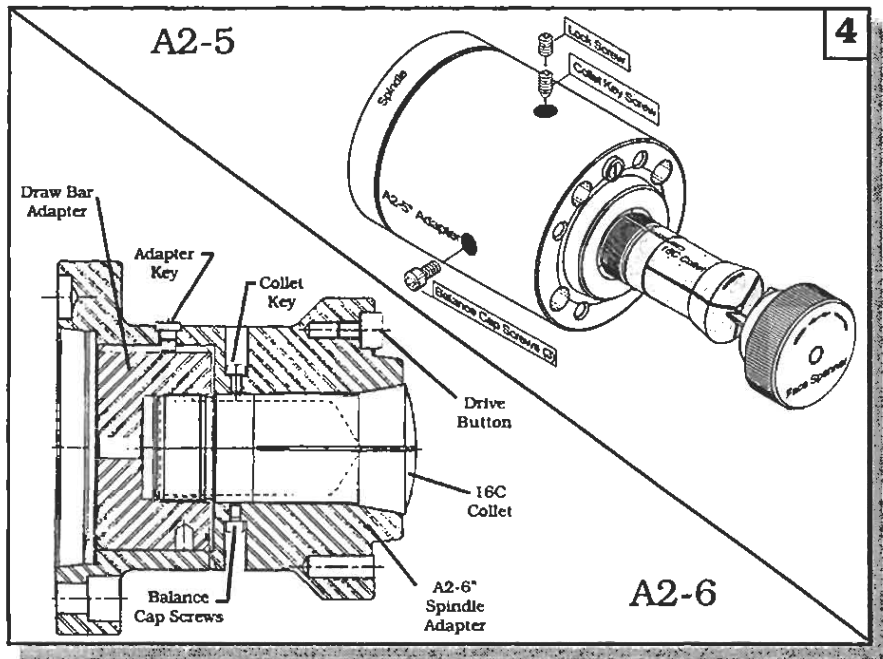
## INSTRUCTIONS

- Remove the existing spindle tooling and clean both the spindle mounting surfaces and the 16C Adapter mounting surfaces.(Figure 1)
- Activate the machine's Draw Bar Actuator to place the **Draw Tube** to its forward position.
- Assemble and position the **Draw Bar Adapter**,(A2-5=2-25/32", A2-6=2-11/16") from the spindle face. (Figure 1 & 2)
- Lubricate the O.D. of the **Draw Bar Adapter** with Die Makers Grease. (Figure 3)
- There are three keyway slots on the O.D. of the **Draw Bar Adapter**. Only one will be used. Align the nearest keyway with **Drive Button** on the Spindle.
- Assemble the Adapter by sliding it over the **Draw Bar Adapter**, while aligning the **Adapter Key Screw (Key 1)** with the Keyway on the **Draw Bar Adapter** and with the machine's **Spindle Drive Button**.
- Assemble using the **Mounting Bolts**. Inch & Metric Bolts provided. (Figure 1) A2-5C=4Bolts A2-6"=6 Bolts. Tighten Criss Cross with 60 Ft. Lbs. or 81N.M Torque



[Continued from the reverse side]

- Make certain that the **Draw Tube** is still at its forward position.
- Remove **Lock Screw** (A2-5" only), **Collet Key Screw** (Key 2) and the 3 **Balance Cap Screws** From the **Adapter**.
- Thread in the 16C Spindle Tooling until the head angle is seated with the adapter's mating spindle angle.
- Continue tightening the spindle tooling (Collet) until the collet key-way lines up with the nearest of the four **Collet Key Screw** positions.
- Re-assemble the **Collet Key Screw**. Bottom the key out in the keyway and then back off 1/4 turn.
- Thread in the **Lock Screw** bottoming it out against the **Collet Key Screw**.



- Re-assemble and tighten the three **Balance Cap Screws** in the three remaining threaded holes.
- Insert Stock and adjust chucking pressure. Do not exceed 7,000 Lbs. of draw force.

**NOTE:** When the 16C tooling is installed as instructed, chips will not get between the collet angle and the spindle angle when the actuator is in the open position (Forward).

When using collets or step chucks, make certain that the workpiece can be easily loaded when the actuator is in the open position.

## PARTS LIST: A2-5" to A2-5" 16C and A2-6" to A2-5" 16c Spindle Adapters

DESCRIPTION	A2-5" Part No.	Qty	A2-6" Part No.	Qty
<b>A2-5" Adapter Assembly</b>	7833-00-00-000000	1	<b>7903-00-00-000000</b>	
A2-5" to A2-5" 16C Adapter	7835-00-00-000000	1	7905-00-00-000000	1
*Drive Button - Figure 1	A2 -0011920	1	A2 -0011920	1
*Button Screw - Figure 1	A2 -0011920-S	1	A2 -0011920-S	1
*Key 1 (Screw) Figure 1	7839-00-000000	1	7865-00-00-000001	1
Collet Key Screw (Key 2)	7841-00-000000	1	7801-00-00-000002	1
Socket Head Cap Screw	0100905	2	7801-00-00-000003	2
*Mounting Bolt(Metric)Figure 1	MS 0104028	4	MS 0104220	6
*Mounting Bolt(English)Figure 1	0101244	4	N/A	
Lock Screw	0550908	1	N/A	
<b>Draw Bar Adapter</b> (Blank) Figure 1	7836-21-00-000000	1	7906-21-000000	1
Die Makers Grease	AH0010994	1	AH0010994	1

\* See Figure 1 on the reverse side



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