

## Hardinge HQC™ Quick-Change Collet Installation Instructions

The type of machine and the size of the collet head determines which collet wrench is used.

### Install the Hardinge HQC™ Quick-Change collet system as follows:

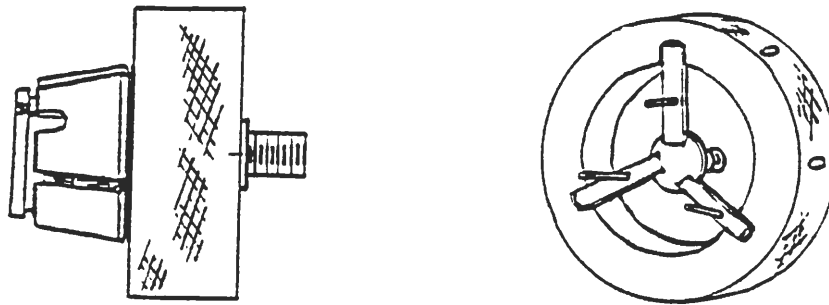
1. Index the spindle to the normal collet change position. Jogging the spindle until the keyway is vertical allows for an easier collet change reference.
2. Power down the machine and remove the collet.
3. Make certain that a collet head is attached to the collet body before installing it.

If there is no head on the body, mount a head as follows:

- A. Insert the Quick-Change collet wrench pins into the head.

#### - NOTE -

There is a 3/8 inch square drive opening at the top of the threaded adjuster on the collet wrench to accommodate either a "Tee" wrench, a ratchet wrench, or a power wrench. Turning the threaded adjuster compresses or expands the neck of the collet head. A power Quick-Change collet wrench is also available.



- B. Hold the wrench while turning the threaded adjuster counterclockwise to compress the neck of the collet head.
  - C. Align the three slots of the collet head with the lugs on the body and insert the locking lips of the head into the groove in the body.
  - D. Turn the threaded adjuster clockwise to expand the neck of the collet head until it is fastened in the body and the collet wrench is released from the head.
4. Align the keyway in the head with the key in the spindle and insert the body and head as an assembly into the spindle the same as a standard collet.
  5. Make contact with the draw tube threads and the threads on the body.
  6. Thread the draw tube to the body.
  7. Close the collet and check the chucking force against a piece of stock 4 inches [102 mm] long.
  8. Adjust the chucking force as needed.

**Once the collet body is in place, it is only necessary to change the collet head for the size and shape of the stock required for each job.**