

Instructions B-175

CAUTION: Make sure that the workpiece is adequately gripped so that the workpiece will not come loose during the machining process. When clamping very short workpieces, the minimum clamping lengths must be observed. They depend on the selected clamping head size and shape – call Hardinge for guidance. Do not clamp tapered work pieces. In general the collet system should never be rotated without a clamped workpiece. Never rotate the collet system over 2,000 RPM without a clamped workpiece. When actuating the changing wrench, never reach inside the moving parts due to risk of severely damaging your hand.

Drawbar Linkup

The Hardinge FlexC Collet System requires a drawbar linkup to mate the specific machine drawbar (varies by machine brand and model) to the FlexC clamping sleeve. This linkup can be ordered from Hardinge or can be made by the customer.

Cleaning and Maintenance

The spindle, collet head and the spindle mount mating surfaces must be cleaned and free of chips and sludge whenever mounting to the spindle or changing out a collet head. Visually inspect collets for tearing or separation of rubber on a regular basis during long job runs and during setup. If you are using a high pressure coolant in your machining processes, you need to inspect the collets more frequently. Do NOT clean an open spindle with an air hose as chips and sludge may be forced into the spindle drawbar area. Clean and lubricate all moving parts with Chevron Ultra-Duty EP NLGI 2, Dow Corning BR-2-Plus, or Kluber ALTEMPQNB 50 grease. Store all unused products properly to prevent corrosion and keep free of dust and environmental particles.

Check to see that all mounting screws are in good condition and replace when worn. All components must be replaced with original Hardinge replacement parts.

NOTE: The "S" style pads must be removed to install or remove the "S" style master collet.
Failure to do so may cause damage to the collet wrench.