



### 5C Universal Collet Stop Set

The Hardinge® Universal Collet Stop Set will convert Hardinge 5C collets without internal threads into Solid Stop or Spring Ejector Stop Collets. The two solid inserts and the two inserts for the spring ejector housing can be machined to suit varying requirements. The front end of the collet stop body has a standard 1/2" - 20 thread for convenient application of other sizes and special-shaped stops. The solid inserts of the spring ejector are adjustable in or out in the stop body to arrive at the desired chucking depth. The locking screw and brass plug hold the insert or spring ejector in the predetermined position. Once that is done, merely place the collet stop in the back of the collet and tighten the lock screw. This causes the locking plugs to securely anchor the collet stop inside the collet. Application does not require machining of the collet. The stop is merely placed in the collet.

One Collet Stop Set fits all 1" capacity collets and all of the machines shown in the chart to the right. Dimension "A" is the maximum depth to which a part may be chucked in the assembled stop collet.

#### Four Collet Stop combinations with one Universal Collet Stop Set!

### 5C Universal Collet Stop Set Parts List

Key	Description	Part Number	Model
<b>Universal Stop Set - including: 1019-00-00-000000 G10</b>			
1	— Hex Jam Nut 3/8-24 std.	U-0004141-C	—
2	— Retaining Spring	1025-00-00-000000	RX-107-C
3	— Brass Plug	N37-0000483	—
4	— Set Screw 10-32 x 3/16 std.	0550303	—
5	— Locking Screw	1031-00-00-000000	RX-107-G
6	— Lock Pins [6]	1021-00-00-000000	RX-107-A
7	— Collet Stop Body	1029-00-00-000000	RX-107-F
8	— Solid Insert, 1/4" Diameter <sup>1</sup>	1027-00-00-000000	RX-107-E
9	— Solid Insert, 9/16" Diameter <sup>1</sup>	1023-00-00-000000	RX-107-B
10	— Spring Ejector Body	1033-00-00-000000	RX-107-H
11	— Cap Screw 10-32 x 3/8 std.	0100306	—
12	— Spring for Plunger	1039-00-00-000000	RX-107-R
13	— Plunger, 1/4" Diameter <sup>1</sup>	1037-00-00-000000	RX-107-N
14	— Plunger, 9/16" Diameter <sup>1</sup>	1035-00-00-000000	RX-107-L

<sup>1</sup> - Can be altered to different lengths.

Collet Stop Set "A" For Collet Styles Machines	Dimension	Collet Stop Set For 1" Collet Capacity
5C Hardinge Lathes; Chuck; Hamilton;	0 to 1 <sup>3</sup> / <sub>8</sub> "	1" Hardinge Second Op Machine and 1", 10", 16" and 18" South Bend; 1" 5C Hardinge-Sjogren Speed Collet 1" Sheldon; 12" and 16" Sebastian; 1" Rivett; 12" Porter-Cable; 14" 1" Elgin; 10" Monarch
1J Hardinge Chuck	0 to 1 <sup>1</sup> / <sub>8</sub> "	1" Hardinge-Sjogren Speed Collet
5PN Hardinge	0 to 1 <sup>1</sup> / <sub>2</sub> "	1" Pratt and Whitney
42S Hardinge	0 to 1 <sup>13</sup> / <sub>16</sub> "	4-1 <sup>1</sup> / <sub>2</sub> " Stark
8WN Hardinge	0 to 2"	1" Wade; 16" and 18" Lehmann

Dimension "A" applies for solid stops. The maximum depth for spring ejector stops is 9/16" less than the maximum shown above due to the space required for the spring ejector construction.