

HEADSTOCK ASSEMBLY

2

PL-1C

KEY	PART NUMBER										PCS	NAME		
1	H	E		0	0	0	7	3	4	3		1	Nut For Hob	
2	H	H	C	V		0	0	0	8	2	5	9	1	Key For Hob
3	H	H	C	A		0	0	0	4	0	6	8	1	Spindle Nut
4	H	H	C	B		0	0	0	4	1	9	7	1	Cover
5						0	5	5	0	3	0	6	2	Screw For Cover
6	6	1	5			0	0	0	9	6	2	5	1	Belt
7	T	L				0	0	0	6	3	1	7	1	Key For Pulley
8	H	H	C	D		0	0	0	4	0	5	3	1	Spindle Pulley (60 Hz)
	H	H	C	H		0	0	0	4	0	5	3	1	Spindle Pulley (50 Hz)
9	H	H	C			0	0	0	0	2	6	5	1 pair	Bearing
10	C	C	W			0	0	0	4	0	5	7	1	Spacer
11	3	7	A			0	0	0	0	2	8	4	1	Key Screw
12	L	H				0	0	0	6	4	2	4	1	Gasket
13						0	5	5	0	3	0	8	1	Lockscrew (Taper Nose)
						0	5	5	0	3	1	0	1	Lockscrew (Thrd. Nose)
14	H	C	B			0	0	0	0	2	8	3	1	Spindle Assembly (Taper Nose)
	H	C	B			0	0	0	0	2	8	3	1	Spindle Assembly (Thrd. Nose)
15	L	H				0	0	0	0	2	7	9	1	Spindle Lock Pin
16	L	H	A			0	0	0	3	5	5	8	1	Lockscrew
* 16A						0	1	0	0	8	0	8	4	Screw
17	R					0	0	0	6	9	8	9	1	Stop Pin Set-Screw

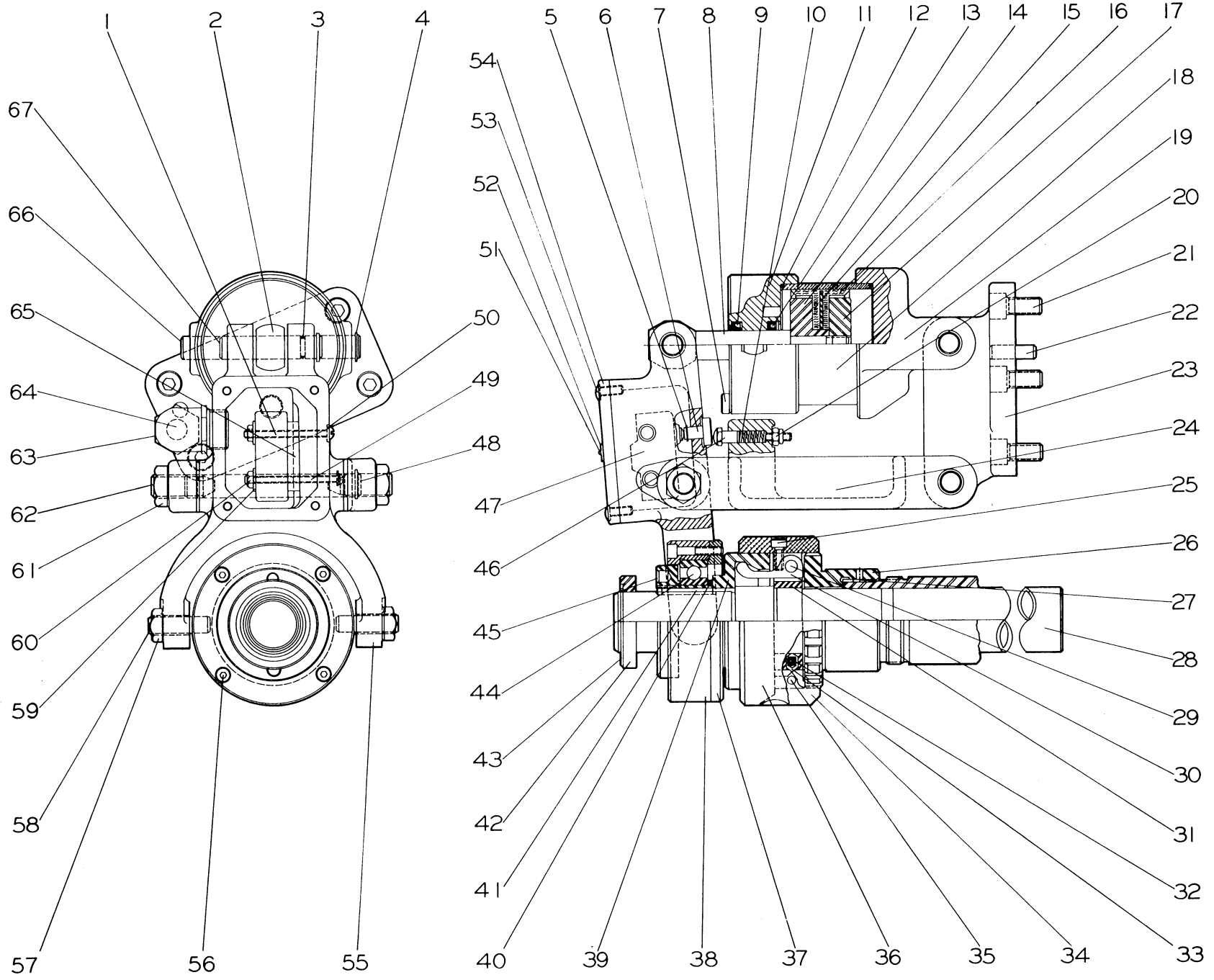
* 16A, 17A, and 18A are supplied only when vertical slide is omitted.

KEY	PART NUMBER										PCS	NAME		
* 17A	T	M				0	0	0	6	9	9	2	1	Pipe Plug
18	L	H				0	0	0	0	2	7	5	1	Front Cap
* 18A	A	H				0	0	0	1	5	3	6	1	Cover
19						0	1	0	0	8	2	8	6	Screw For Cap
† 20	H	L				0	0	1	0	3	3	1	8	Dot Plug
21	R					0	0	0	8	0	4	4	4	Escutcheon Pin
22	F	B				0	0	0	0	2	5	6	1	Rear Nameplate
23	L	H				0	0	0	9	9	2	3	1	Seal For Head
24	A	H				0	0	0	8	9	2	4	1	Lock Plug
25						0	5	5	1	0	0	5	1	Set-Screw
25A	K	H				0	0	0	9	9	3	8	1	Bushing
26	C	W				0	0	0	6	4	0	7	1	Splash Guard
27	L	H				0	0	1	1	0	6	3	1	Insulator
28	L	H				0	0	1	1	0	3	3	1	Nameplate Seal
29	L	H				0	0	1	0	2	2	4	1	Limit Switch
30						0	3	5	0	1	1	6	2	Limit Switch Screw
31	L	H				0	0	0	1	4	2	4	1	Plunger
32	7	9				0	0	0	8	3	5	1	1	Spring
33	H	L				0	0	1	0	0	5	3	4	Lockwasher
34						0	1	0	1	3	2	8	4	Mounting Bolt
35	A	H				0	0	0	0	2	6	3	1	Headstock Frame Assembly
36						0	3	0	0	1	0	6	4	Nameplate Screw
37	L	H				0	0	0	0	2	5	6	1	Front Nameplate

† Dot Plugs HL-10331 supplied when threading unit is omitted.

NOTE: For repairs to headstock spindle or bearings, headstock assembly must be returned to factory.

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STANDARD COLLET CLOSER

KEY	PART NUMBER										PCS	NAME	
1				0	3	5	0	1	2	8		1	Screw
2	C	A	A	0	0	1	0	7	7	2		1	Piston Rod
3	O	R		0	0	0	0	6	0	8		2	O-Ring
4	5	0		0	0	0	8	2	3	1	0 2	4	Retaining Ring
5	2	5		0	0	0	8	2	3	1	0 2	1	Retaining Ring
6	A	H	A	0	0	0	1	4	2	4		1	Plunger For Switch
7	A	H		0	0	0	0	7	9	6		1	Actuator Screw
8	C	A	A	0	0	1	0	7	7	2		1	Piston Rod
9	A	D	A	0	0	1	0	7	7	5	0 2	1	Wiper Ring
10	H	C	T	0	0	0	7	3	3	5		1	Spring
11	C	A	D	0	0	1	0	7	6	8		1	Cylinder End Cap
12	O	R		0	0	0	4	0	4	3		2	O-Ring
13	A	D		0	0	1	1	1	9	8	4 8	1	Piston Ring
14	C	A	B	0	0	1	0	7	6	9		1	Piston
15	C	A	A	0	0	1	0	7	7	0		1	Spacer
16	C	A	A	0	0	1	0	7	7	5		2	Jack Cups
17	C	A	B	0	0	1	0	7	7	6		1	Locknut
18	C	A	B	0	0	1	0	7	7	1		1	Piston Cylinder
19	C	A	A	0	0	1	0	7	6	6		1	Link For Cylinder
20	E	N		0	0	0	8	9	1	0		1	Elastic Stop Nut
21				0	1	0	1	0	1	2		4	Screw
22	T	L		0	0	0	6	7	0	9		2	Bracket Dowel Pin
23	C	A		0	0	0	0	4	7	9		1	Collet Closer Bracket
24	A	H		0	0	0	0	5	0	3		1	Connecting Link
25				0	1	0	0	3	0	8		4	Screw For Bracket & Guard
26	H	C		0	0	0	0	4	9	2		1	Adjusting Nut
27	3	7		0	0	0	0	4	9	3		1	Key
28	C	W	C	0	0	0	0	4	8	0		1	Spindle For Collet Closer
29	5			0	0	0	2	0	2	4		3	Retaining Pin For Clutch Finger
30	3	7	A	0	0	0	0	4	8	5		3	Clutch Finger
31	5	7	C	0	0	0	0	4	8	4		1	Bracket For Clutch Finger
32	3	7		0	0	0	0	4	9	0		1	Spring For Adjusting Finger
33	3	7		0	0	0	0	4	8	9		1	Cap For Spring

KEY	PART NUMBER										PCS	NAME	
34	3	7	B	0	0	0	0	4	8	7		1	Adjusting Finger
35	3	7		0	0	0	0	4	8	8		1	Retaining Pin For Adjusting Finger
36	R	G	A	0	0	0	0	4	9	4		1	Shell Guard
37	C	A		0	0	1	0	7	9	0		1	Plate For Bearing
38	C	A		0	0	1	0	7	9	2		1	Bearing Housing
39	5	7	A	0	0	0	0	4	9	6		1	Clutch Cone
40	C	A		0	0	1	0	7	9	1		1	Washer For Bearing
41	T	L		0	0	0	6	1	1	7		1	Key For Clutch Cone
42	5	7	A	0	0	0	0	4	8	1		1	Stop Ring For Clutch Cone
43	1	3	1	0	0	0	8	2	3	1	0 8	1	Retaining Ring For Stop Ring
44	C	A		0	0	0	8	2	3	3		1	Bearing
45	R			0	0	0	8	2	2	2		1	Retaining Nut For Bearing
46	A	H	A	0	0	0	0	5	8	3		1	Stop Pin
47	A	D		0	0	1	0	2	2	4	0 1	1	Limit Switch
48	C	A		0	0	0	0	5	0	4	0 1	1	Link Pin
49				0	3	5	0	1	3	2		1	Screw
50	S	L		0	0	0	8	1	3	7		2	Lockwasher
51	R			0	0	0	8	0	4	4		2	Escutcheon Pin
52	K	H		0	0	1	0	3	6	6	0 4	1	I.D. Tag (5 LS)
53				0	3	0	0	3	0	8		4	Screw
54	A	H	A	0	0	1	0	1	1	5	0 1	1	Cover For Lever Yoke
55	A	H		0	0	0	0	5	0	1		1	Lever Yoke
56				0	1	0	0	3	1	6		4	Screw For Housing
57	V	D		0	0	0	9	0	5	2		2	Nut
58	C	A		0	0	1	0	7	9	3		2	Swivel Screw
59	H	C		0	0	0	2	8	4	0		2	Washer
60	M	N		0	0	0	8	1	3	8		2	Nut
61	5			0	0	0	1	4	6	6		2	Nut
62	C	A		0	0	0	9	0	3	4		2	Pivot Screw
63	2	2		0	0	0	9	2	0	7	7 0	1	90° Cord Connector
64	1	6		0	0	0	3	0	1	1	0 4	88"	Cable
65	A	H		0	0	1	1	0	6	3	0 1	1	Insulator For Switch
66	C	A		0	0	0	0	5	0	4	L	1	Link Pin
67	C	A		0	0	0	0	5	0	4	0 2	1	Link Pin

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1	H	P	H	8	0	0	7	6	9	6			1	Blank Lead Screw
2				0	1	0	0	3	1	2			2	Screw
3	P	O		0	0	1	1	3	7	5	0	1	1	Adapter
4	P	O		0	0	1	1	0	5	6	0	1	1	Bracket
5	M	D		0	0	0	6	8	2	6			4	Washer
6				0	3	0	1	0	1	2			4	Screw
7	O	R		0	0	0	1	0	1	2			2	O-Ring
* 8	P	O		0	0	1	1	4	5	5			2	Exhauster Assembly
9	P	O		0	0	0	9	7	2	7	0	1	2	Plug
* 10	P	O		0	0	0	0	4	0	6			2	O-Ring
11	P	O		0	0	0	1	4	2	4			2	Plunger
12	P	O		0	0	0	7	3	3	5			2	Spring
13	C	A		0	0	0	8	2	3	3			2	Bearing
14	A	U	A	0	0	1	0	7	8	6			2	90° Elbow
15	P	O		0	0	1	1	0	9	2	0	3	1	3" Brass Nipple
16	P	O		0	0	1	1	0	9	2	0	4	1	4" Brass Nipple
17	P	O		0	0	1	1	1	9	4	0	1	1	Rotary Value Housing
* 18	P	O	A	0	0	0	4	0	6	8			1	Spindle Nut
19	P	O		0	0	0	0	4	8	0			1	Spindle & Sleeve Assembly
20	A	D		0	0	0	4	6	2	9			1	Dowel
21	4	2		0	0	1	1	1	5	1	2	4	1	Quad-Ring
22	O	R		0	0	0	9	2	9	5			1	O-Ring
23				0	1	0	0	3	1	0			6	Screw
24	P	O		0	0	1	0	7	6	8		F	1	Front Cap
25	P	O		0	0	0	9	2	6	2		B	1	Locating Ring Assembly
26	4	2		0	0	1	1	1	5	1	5	4	2	Quad-Ring
* 27	P	O		0	0	0	9	2	6	1			1	Piston

KEY	PART NUMBER										PCS	NAME		
28				0	6	4	0	3	0	2			1	Set-Screw
28A	P	O		0	0	0	4	0	6	8	0	1	1	Piston Nut
29	P	O		0	0	1	0	7	6	8		R	1	Rear Cap
30				0	1	0	0	6	1	0			4	Screw
31	4	2		0	0	1	1	1	5	1	2	2	1	Quad-Ring
32				0	5	5	0	3	0	3			3	Set-Screw
33	C	H		0	0	0	4	7	3	2			3	Brass Plug
34	P	O		0	0	0	0	4	8	0	0	3	1	Draw Spindle
35	K	H		0	0	0	3	5	0	4	0	1	1	Nipple
36	P	O		0	0	0	7	7	0	2	0	2	1	Tee
37	C	T		0	0	1	0	7	8	8			58"	Air Hose (2 Lines)
38	2	2		0	0	0	7	7	0	7		N	19"	1/8" OD Tubing
39	A	H		0	0	0	7	0	0	7			18"	1/4" OD Tubing
40	A	H		0	0	0	7	7	0	4	1	4	1	Nut & Sleeve
41	A	H		0	0	1	1	2	5	9	0	2	1	Adapter
42	8	8		0	0	0	7	7	0	3	0	2	1	Male Connector
43	P	O		0	0	1	0	7	8	7	0	2	2	Socket — Quick Disconnect
44	P	O		0	0	1	0	7	8	7	0	1	2	Plug — Quick Disconnect
45	R			0	0	0	4	8	5	3			1	Dowel

* There are some extremely close tolerances involved in the assembly of these components. Some are machined in place and must be ordered as one assembly. If any of the indicated components requires replacement, contact a Hardinge Service Engineer.

VARI-GRIP® COLLET CLOSER