HARDINGE
SJOGREN
SPEED

COLLET CHUCK

"Supplied with Hardinge Precision Collets"

Needs No Key
Increases Capacity
Increases Output
Saves Time and Motion
Is Practical and Efficient
Pays for Itself
HARDFNE

SJOGREN

FOR YOUR

TOOL ROOM AND ENGINE LATHES

Are you getting full value from your investment in tool room and engine lathes?

A Hardinge-Sjogren Speed Collet Chuck gives greater capacity, saves time, increases accuracy and assures better results.

It is readily adapted for use on the spindle nose of your lathes, takes precision collets—enabling the operator to do better work ... faster!

— FOR USE ON —

American
Baye & Emmes
Carroll & Jameson
Chard
Cincinnati
Davis

Flather
Greaves-Klasman
Hamilton
Hendey
LeBlond
Lehman

Monarch
Porter Cable
Fratt & Whitney
Rahn-Larmon
Reed-Prentice
Rockford

Sebastian
Seneca Falls
Stidney
South Bend
Springfield
Worcester

AND ALL OTHER TOOL ROOM AND ENGINE LATHES

INCREASES CAPACITY: The Hardinge-Sjogren Speed Collet Chuck increases lathe capacity from 25% to 40%. The ordinary collet attachment has a cumbersome draw tube inside the spindle hole. This reduces lathe capacity. By eliminating this space wasting draw tube entirely, the Hardinge-Sjogren Speed Collet Chuck will accurately hold any bar that can be passed through the spindle.

ELIMINATES KEYS AND WRENCHES: The machinist no longer wastes valuable production time looking for a lost or misplaced wrench or key because the Hardinge-Sjogren needs none!

SAVES TIME: The amazingly fast action of the Hardinge-Sjogren Speed Collet Chuck gives it full right to its name! An almost effortless turn of the hand wheel, one way or the other, automatically opens or closes the collet, releasing or gripping the work as desired. Its grip is adjustable and sure. Most operators simply lay a hand on the wheel and run the lathe forward to tighten the collet ... reverse to loosen.

INCREASES PRODUCTION: With the Hardinge-Sjogren Speed Collet Chuck, the operator is always in front of his work and he stays there! There is no need to reach over—or to walk back of the lathe headstock—to grip or release material in the collet.

Through the increased production and machinist efficiency, caused by the elimination of lost time and waste motion, the Hardinge-Sjogren Speed Collet Chuck more pays for itself!

THE cut-away illustration of the chuck and adapter plate gives a clear picture of the compact construction, showing the proper collet closing arrangement, the precision ball thrust and inserted hardened and ground steel collet seat.

The properly shaped knurled hand wheel is made from a durable fabric base plastic material.

Every Hardinge-Sjogren chuck is tested for accuracy and carries full guarantee against defect in materials and workmanship.

Note: The Hardinge-Sjogren Speed Collet Chuck is adaptable not only to lathes, but also to other machines, such as milling machines, turret lathes, grinders and special production machines.

FURNISHED IN THREE SIZES

<table>
<thead>
<tr>
<th>No. 1 Chuck</th>
<th>No. 2 Chuck</th>
<th>No. 3 Chuck</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 inch capacity</td>
<td>1 1/8 inch capacity</td>
<td>1 1/4 inch capacity</td>
</tr>
</tbody>
</table>

(See pages three and four for specifications and prices)
TOOL ROOM and engine lathes with threaded nose spindle require an adapter plate to fit the Hardinge-Sjogren Speed Chuck. It is mounted in the same manner as an ordinary 3 or 4 jaw chuck.

A semi-finished adapter plate may be readily obtained from the builder of the lathe with which the Hardinge-Sjogren Speed Chuck is to be used. If desired, we furnish an adapter plate casting for the purpose—refer to accompanying specifications.

Your careful machining and fitting of the adapter plate will result in greater precision in the chucking of parts and bar stock. Also, make certain that lathe thrust bearings do not cause run-out.

Four hollow head cap screws are furnished with each plain back Hardinge-Sjogren Speed Chuck. They are 1/8" diameter with 16 threads. The length under screw head is 2", 2 1/4", and 2 1/2" respectively for No. 1, 2 and 3 Hardinge-Sjogren Speed Chucks.

STANDARD TAPERED KEY-DRIVE MOUNT: Hardinge-Sjogren Speed Chucks are made to fit lathes with No. 1 or No. 2

STANDARD CAM-LOCK MOUNT: Hardinge-Sjogren Speed Chucks are made to fit directly on lathes with standard D.1 3", D.1 4", D.1 5", D.1 6", or D.1 8" Cam-Lock spindle nose. They are furnished complete, ready for use and do not require an adapter plate.

**TYPICAL APPLICATIONS**

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Back view of Plain Back Chuck showing Adapter Plate ready for application.

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**ADAPTER CASTING SPECIFICATIONS (Dimensions in Inches)**

<table>
<thead>
<tr>
<th>Chuck</th>
<th>A</th>
<th>B</th>
<th>C</th>
<th>D</th>
<th>E</th>
</tr>
</thead>
<tbody>
<tr>
<td>No. 1</td>
<td>0 1/8</td>
<td>2 1/4</td>
<td>3 1/4</td>
<td>1 1/8</td>
<td>1 1/8</td>
</tr>
<tr>
<td>No. 2 &amp; No. 3</td>
<td>1 1/4</td>
<td>2 3/4</td>
<td>3 1/2</td>
<td>1 1/8</td>
<td>1 1/8</td>
</tr>
</tbody>
</table>

**PLAIN BACK CHUCK SPECIFICATIONS (Dimensions in Inches)**

<table>
<thead>
<tr>
<th>Dim.</th>
<th>No. 1</th>
<th>No. 2</th>
<th>No. 3</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cap.</td>
<td>6 1/4</td>
<td>6 1/4</td>
<td>6 1/2</td>
</tr>
</tbody>
</table>

**NOTE:** When finished to size, dimension "B" should be 3/8" longer than spindle nose. This dimension "B" when finished to size should be at least 3/8" for No. 1 chuck, 1/4" for No. 2 chuck and 1/8" for No. 3 chuck. Dimension "A" should be at least 1/4" when finished to size. Casting prices listed on page four.

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IN USE ON MILLING MACHINE

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IN USE ON ENGINE LATHE

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Hardinge-Sjogren Speed Collet Chucks in Three Sizes—See Page Four for Prices
HARDINGE SPRING COLLETS are furnished with HARDINGE-SJOgren SPEED CHUCKS
(COLLET ILLUSTRATIONS ARE ACTUAL SIZE)

HARDINGE SPRING COLLETS are furnished for use in HARDINGE-SJOgren Speed Collet Chucks and embody those elements of precision which have characterized their products since 1890. The combination naturally assures the greatest degree of accuracy in the holding of bar stock or parts to be machined.

Specifications For Three Collets Illustrated

<table>
<thead>
<tr>
<th>HARDINGE SJOgren CHUCK</th>
<th>No. 1</th>
<th>No. 2</th>
<th>No. 3</th>
</tr>
</thead>
<tbody>
<tr>
<td>Collet Used . . .</td>
<td>1&quot;</td>
<td>2&quot;</td>
<td>3&quot;</td>
</tr>
<tr>
<td>Round Capacity . . .</td>
<td>1&quot;</td>
<td>1-1/2&quot;</td>
<td>1-3/4&quot;</td>
</tr>
<tr>
<td>Hexagon Capacity . . .</td>
<td>7/8&quot;</td>
<td>7/8&quot;</td>
<td>33/32&quot;</td>
</tr>
<tr>
<td>Square Capacity . . .</td>
<td>1&quot;</td>
<td>1-1/4&quot;</td>
<td>1-3/4&quot;</td>
</tr>
</tbody>
</table>

Illustrations are actual size to enable you to visualize actual capacity.

Hardinge Collet durability comes from special steel, uniform heat-treated threads, hardened surfaces for gripping or bearing, and spring temper for proper operation.

The stamping on the face indicates that finishing grinds are made after hardening to assure concentricity.

** Prices for Collet Chucks and Collets **

Plain Back Type Requiring Adapter Plate

<table>
<thead>
<tr>
<th>CHUCK DESCRIPTION</th>
<th>ROUND</th>
<th>APPROX. WEIGHT</th>
<th>CHUCKS EACH</th>
<th>COLLETS EACH</th>
<th>ADAPTER CASTINGS EACH</th>
</tr>
</thead>
<tbody>
<tr>
<td>No. 1</td>
<td>1&quot;</td>
<td>15 lbs. $66.00</td>
<td>$6.00</td>
<td>$2.50</td>
<td>$84.00</td>
</tr>
<tr>
<td>No. 2</td>
<td>1-1/8&quot;</td>
<td>19 lbs. $74.00</td>
<td>$8.00</td>
<td>$3.00</td>
<td>$98.00</td>
</tr>
<tr>
<td>No. 3</td>
<td>1-3/8&quot;</td>
<td>23 lbs. $86.00</td>
<td>$10.00</td>
<td>$3.00</td>
<td>$104.00</td>
</tr>
</tbody>
</table>

* Note: Collets interchange between Plain, Cam-Lock and Taper Key-Drive Chucks of similar capacity. Collet prices are for round fractional sizes from $1/4" to capacity. Add $3.00 for fractional hexagon or square sizes above $1/4". For any round odd decimal, metric or wire gauge size collets, add $ .25 to regular fractional size price. Prices for step collets, special shape collets, etc., upon application. Round collet prices F.O.B. destination on West Coast of U.S.A. are $3.25 for No. 1, $6.25 for No. 2 and $10.25 for No. 3 Chucks.

When ordering, specify the required cam-lock or tapered key-drive mounting size desired.

** DISTRIBUTED BY **

HARDINGE BROTHERS, INC.
ELMIRA, NEW YORK

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