

The procedure for checking spindle endplay is as follows:

- 1.) Set collet pressure to 200 psi.
- 2.) Close collet on piece of stock.
- 3.) Setup indicator on face of collet ring (see fig. 1) zero indicator.
- 4.) Adjust collet cylinder nut (see fig 3) so collet will go to full open position.
- 5.) With collet closed, measure distance from plunger shoe to spindle body. Cut a block of alum. or soft steel 1/4 in. shorter than this distance.
- 6.) Place block between plunger shoe and spindle body (see fig 2)
- 7.) Open collet, check indicator reading.
- 8.) Subtract .016 to .020 from reading and grind remaining amount from spacers B-79730 (see fig 1).
- 9.) Put spacers back and repeat steps 2 thru 7 to verify endplay.

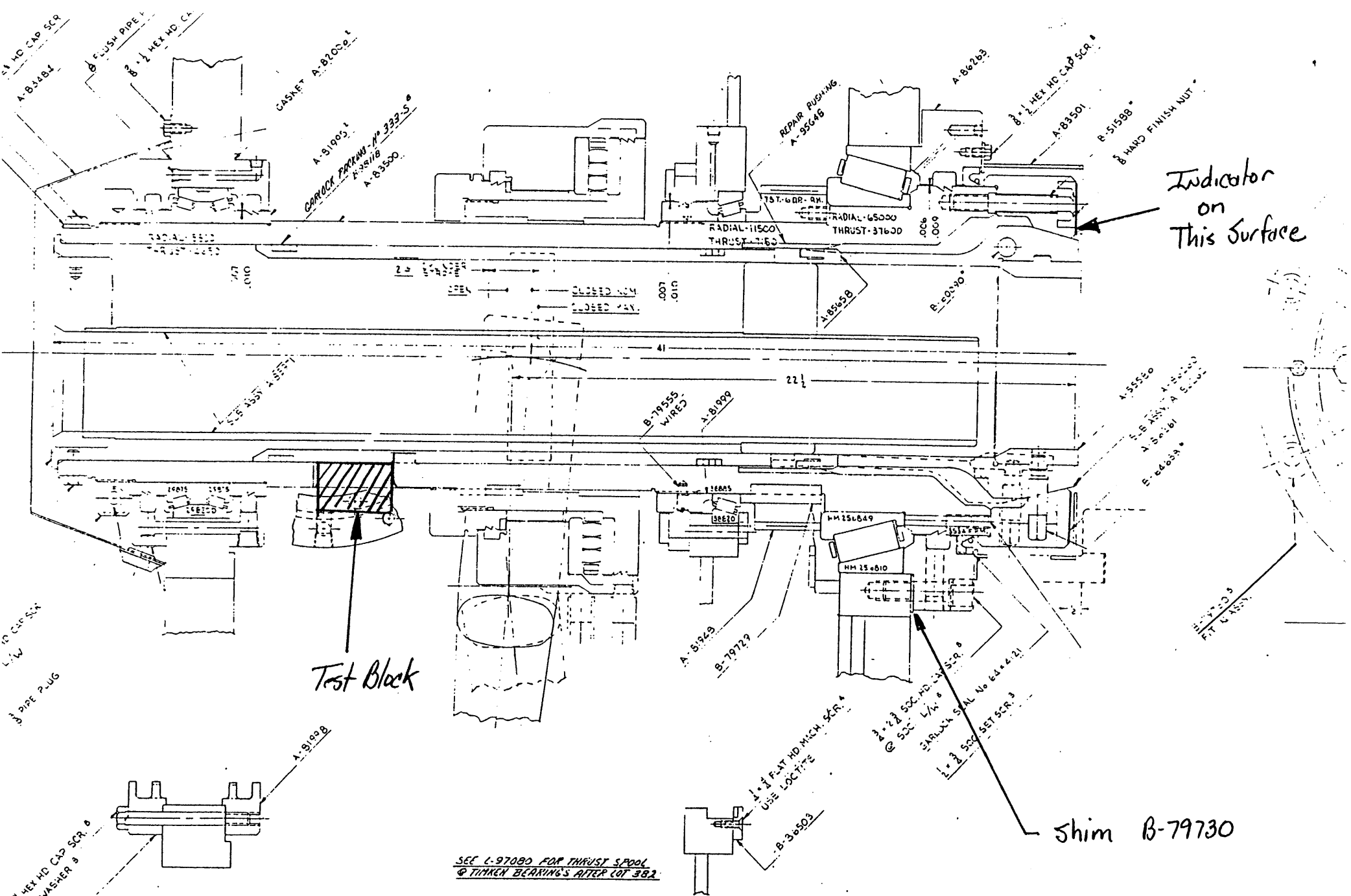
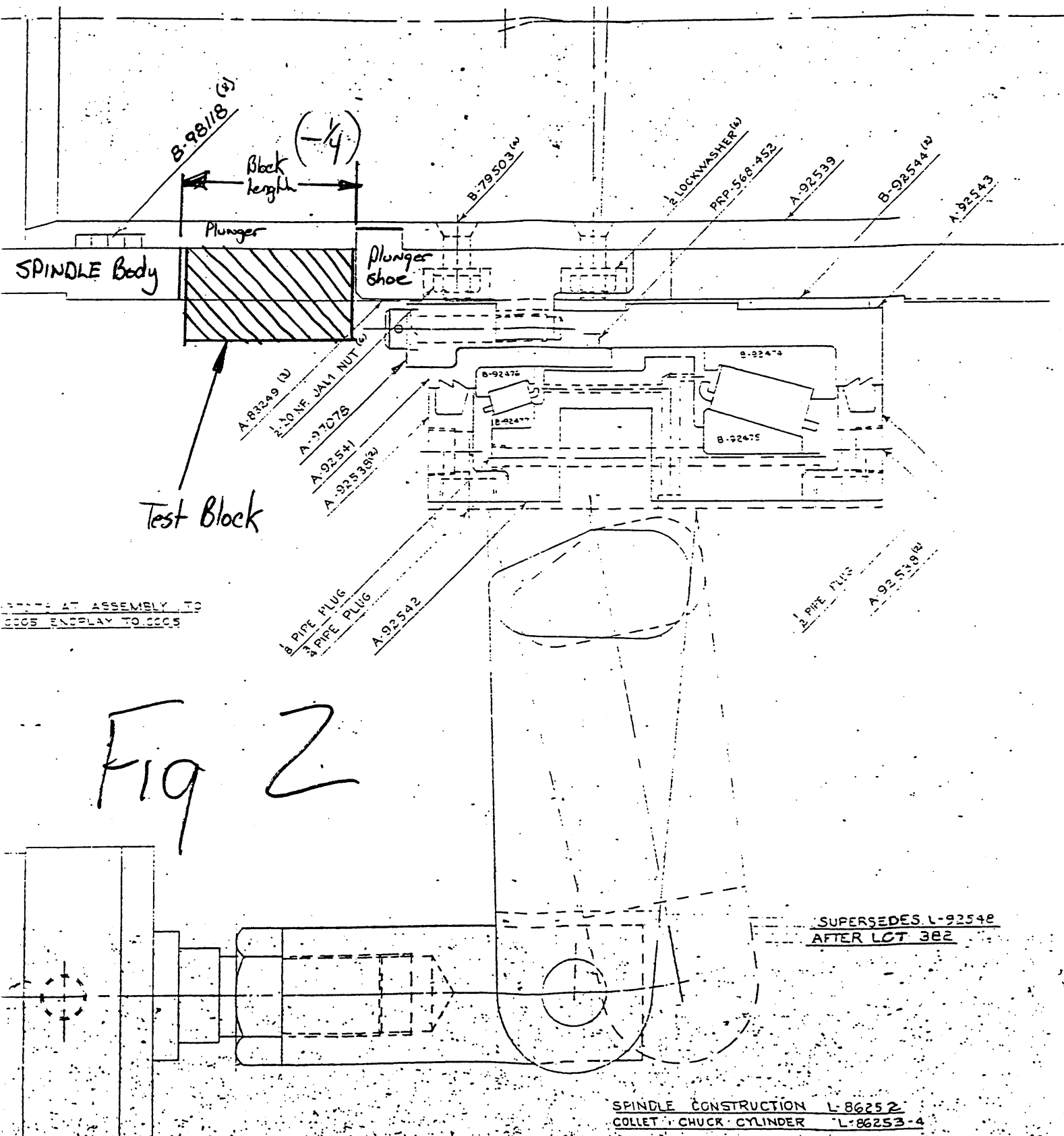


Fig. 1



START AT ASSEMBLY TO
CCCS ENCLAY TO CCCS

Fig 2

SUPERSEDES L-92548
AFTER LOT 382

3G ACL			
THRUST SPOOL - CONSTRUCTION			
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P/L 9119	SCALE 1-1	FILE 35ACL-1	
VOL		L-97080	

Fig # 3

