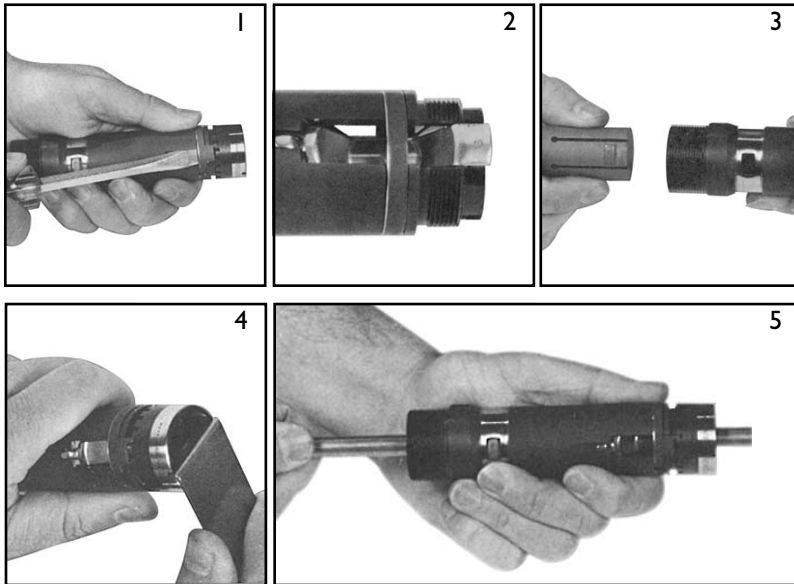


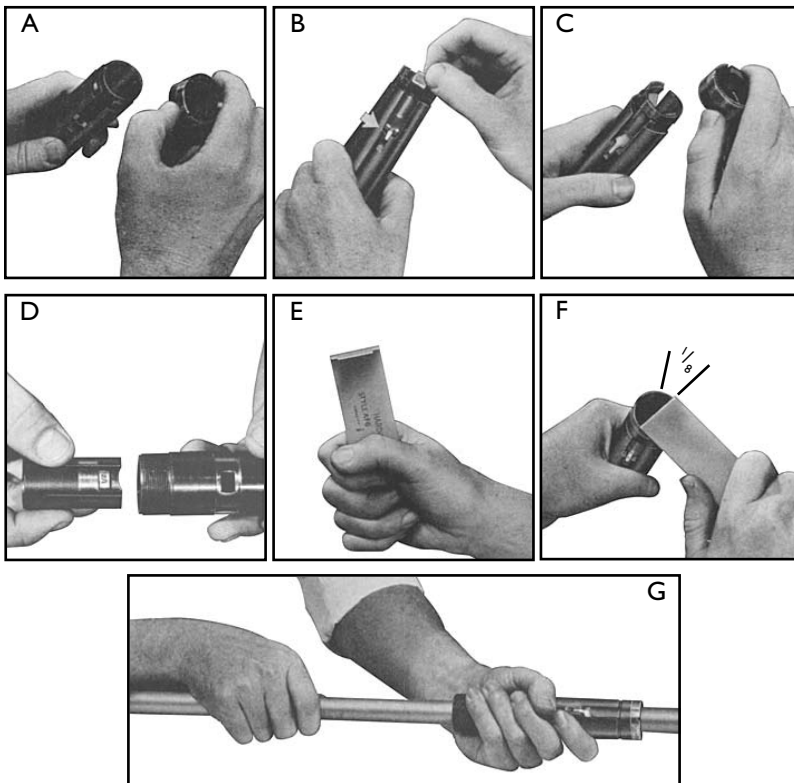
## Hardinge “AF” Master Feed Fingers with Pads

Installing Pads and Adjusting Tension  
for current model master feed fingers that have a spring lock cap



1. Lift the spring lock with a screw driver and turn slightly to the left so that the spring lock stays in the raised position. Remove the adjusting cap.
2. Position the pads in slots with outer side hook in the locating slot. The front of pad must be on the outside of the finger between the threads. Replace and tighten the adjusting cap until contact is made with the pads.
3. Depress the lug and apply a snap-in guide bushing to minimize bar whip. To remove, depress the lug down and to the rear with a screw driver.
4. Use the wrench provided to adjust the cap one notch at a time. **One notch will be a tension change of 5 to 8 pounds**, depending on the size of the master feed finger: Do not tighten or loosen the cap with stock in the pads. Move the spring lock into the notch of the adjusting cap.
5. Test the pad tension with stock. Stock should be gripped but still slip through pads with hand pressure. Install the master feed finger in the machine and check the feed. If added tension is required, remove the bar stock and adjust the cap one notch at a time. Test run in the machine under actual operation.

**Caution: Do NOT tighten the cap with stock in the feed finger and do NOT overtighten. Too much tension will only result in excessive wear.**



Installing Pads and Adjusting Tension  
for older model master feed fingers without locking caps

- A. Remove the cap.
- B. Drop the pads in the slots, placing the outer side hook into the locating slot. The front of the pad must be on the outside of the finger between threads.
- C. Apply and tighten the cap until in contact with the pads. You are now ready to apply tension to suit your feed requirements.
- D. Depress the lug and apply a snap-in guide bushing to minimize bar whip. To remove, depress the lug down and to the rear with a screw driver.
- E. To adjust tension always use the “AF” wrench provided.
- F. Adjust tension of pads by tightening the cap 1/8 turn at a time. Do not tighten or loosen the cap with stock in pads.
- G. Tighten the cap until the stock is gripped by the pads but still slips through the pads with hand pressure. Install the master in the machine and check the feed. If added tension is required, remove the bar stock and adjust by turning the cap 1/8 turn. Test run in the machine under actual operation.