Installation Instructions for the Hardinge®
16C Universal Stop Assembly

The Hardinge Model 16C Universal Stop Assembly provides a fully adjustable positive stop for a wide range of long parts ranging from 7\(\frac{1}{4}\)" up to approximately 17 inches. The unit is mounted in the draw tube of the collet closer of any Hardinge 16C spindle lathe for the purpose of maintaining consistent part length. The assembly comes with a long stop rod and a short stop rod. The short stop rod will accommodate the longest possible part depth.
Assembly and Mounting Instructions

1. Be sure that execution of the active program has been completed; then, press the **RESET** key to stop spindle rotation.

2. Remove the access panel at the left (headstock) end of the machine.

3. The **End Stop** can be modified if the back end of the part needs to be located off a shoulder or between centers. (Refer to Figure 2)

CAUTION: Always engage at least four threads of the **Stop Rod** into the **End Stop** and **Body**. Do not remove the end **Plug** from the **Body**.

4. Thread the **End Stop** onto the **Stop Rod** and tighten the **Jam Nut "A"**.
5. Loosen the Jam Nut "B" and adjust the Stop Rod to obtain the desired depth. (Refer to Figure 1). Retighten the Jam Nut.

CAUTION: If the machine will not be operated with the universal stop in place, the spindle draw tube plug must be installed in the draw tube to prevent coolant and chips from entering the spindle drive compartment.

6. Remove the spindle draw tube plug from the rear of the spindle of your machine.

7. Apply a light coating of O-Ring lubricant to the O-Ring of the stop assembly, Figure 1.

8. Loosen the three Set Screws enough to permit the Nut to be tightened against the Pusher.

9. Slide the Universal Stop Assembly into the back of the draw tube in your machine.

10. Use a wrench to prevent the Body from turning and tighten the Nut (finger tight) to expand the Ringspan Discs.

11. Slide a workpiece into the collet against the stop and check the depth. If the depth adjustment is satisfactory, proceed to step 15. If further adjustment is required, go to step 12.

12. Loosen the Nut and remove the assembly from the spindle.

13. Loosen the Jam Nut "B" and adjust the stop rod as necessary.

14. Retighten the Jam Nut and repeat steps 9 through 11. If further fine adjustment is required, it can be accomplished using the "work shift offset" on the machine's control.

15. Use a wrench to prevent the Body from turning and tighten the Nut approximately one-eighth turn using a 1\(\frac{3}{8}\) inch wrench.

16. Tighten one Set Screw to secure the setting.
16C Spindle Stop Removal

1. Be sure that execution of the active program has been completed; then, press the **RESET** key to stop the spindle rotation.

2. Remove the access panel at the left (headstock) end of the machine.

3. Loosen the **Set Screws** on the **Universal Stop Assembly**.

4. Use a wrench to prevent the **Body** from turning and loosen the **Nut** using a 1 5/8 inch wrench.

5. Remove the **Universal Stop Assembly** from the spindle.

   **CAUTION:** If the machine will not be operated with a bar feed, the spindle draw tube plug must be in place to prevent coolant and chips from entering the spindle drive compartment.

6. Install the spindle draw tube plug in the spindle.

7. Re-install the access panel on the machine.

**Parts List**

**PARTS LIST**

16C UNIVERSAL STOP ASSEMBLY

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<th>PART NAME</th>
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