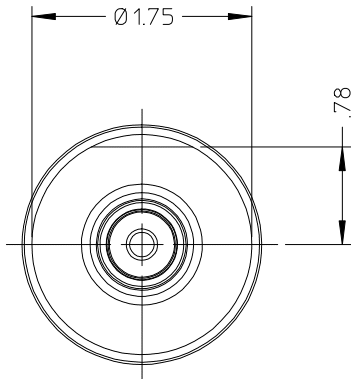


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REV	DESCRIPTION	DATE
S	REVISED & REDRAWN WITH NEW BORDER	



⑤
NOTES:

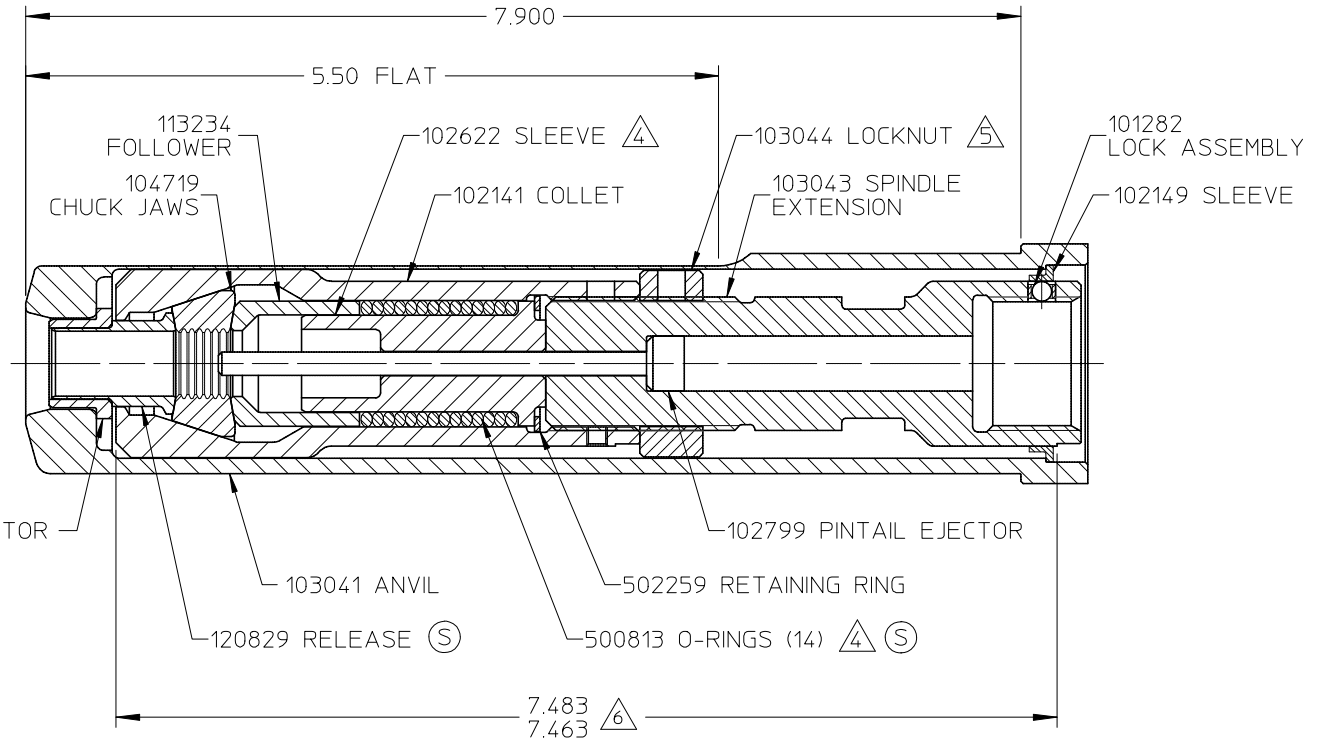
- COLLET ASSEMBLY P/N 116469
CONSISTS OF:
102141 COLLET (NOT AVAILABLE SEPARATELY)
120829 RELEASE
116467 EJECTOR
101282 LOCK ASSEMBLY
- RELEASE & EJECTOR KIT P/N 120836
CONSISTS OF:
120829 RELEASE
116467 EJECTOR
503657 LOCTITE
- SHIP WITH CAUTION TAG P/N 590152.

△ ASSEMBLE PER HUCK SPEC 42-491.

△ USE SPANNER WRENCH P/N 502891 (ARMSTRONG P/N 0-471-A) TO TIGHTEN LOCKNUT.

△ ASSEMBLE COLLET ASSEMBLY & SPINDLE EXTENSION ASSEMBLY TO DIMENSION SHOWN & ASSEMBLE TO TOOL PER HUCK SPEC 42-297.

⑤
116467 EJECTOR



MATERIAL:	-	SPEC: -	TOLERANCES UNLESS OTHERWISE SPECIFIED		HUCK INTERNATIONAL INC., I.E.D. 85 GRAND STREET, P.O. BOX 2270 KINGSTON, NEW YORK 12401		
HARDNESS:	-				NOSE ASSEMBLY -16 SELF RELEASING		
HEAT TREAT:	-	SPEC: -	.XX, .XXX ±	-	DET:SMR	CK:	DATE: 2-12-92
SURF. TREAT:	-	SPEC: -	INT. COR. RADII	-	FOC.	B	SCALE:FULL
SURFACE FINISH NOT TO EXCEED Ra			BREAK EDGES	-	FAC.		
IDENTIFICATION PER SPEC 42-311: ★ CHEMICAL ETCH			ANGLES ±	-			
SURFACES TO BE ◎, //, ⊕, ⊥, & ▽ WITHIN -			T.I.R.	FINAL ASSY: 504 STYLE			99-657-1