

**SHERLINE
PRODUCTS**
INCORPORATED 1974

3C Collet Headstock

P/N 30113

About the 3C Collet Headstock

As with many of our accessories and machine modifications, our decision to make a 3C Collet Headstock was based on customers' requests. Many of our customers over the years have requested a spindle and collet that would allow larger diameter stock to go through the headstock. With the 3C collet, our customers can now hold stock up to 1/2" diameter that will pass through the headstock.

When we designed our 3C Collet Headstock we also designed it so it would be interchangeable with our standard headstock. The centerline height is the same. The mounting system is the same. Therefore you can easily switch from any of our other headstocks to the 3C headstock.

The 3C Spindle is electroless nickel plated to aid in rust prevention, and to increase the surface hardness of the spindle for durability.

Now we come to the 3C collets. We chose the 3C because of its size relative to our machine size, and because of the selection of collet sizes available.

We make all of our WW and mill collets right here at Sherline Products. However, when it comes to making the 3C collets we can't compete with the cheap import collets, and companies like Hardinge already make quality 3C collets in many sizes. Therefore, we leave it up to you to decide who you want to buy your collets from.

Hardinge.com carries 3C collets in round sizes from .020" to .542", 1/64" to 5/8", and 1 mm to 13 mm. In square collets, they carry 3/32" to 3/8". In hex collets, they carry

3/32" to 7/16". They also carry emergency collets that you can bore to specific sizes to match your needs. In 2016 the Hardinge collets ranged in price from \$50.00 to \$133.00 each depending on the size. You can find 3C collet sets on eBay for as little as \$13.00 each. The choice is yours. Beware; you get what you pay for.

We made the 1" spindle wrench (P/N 30129) to go with the headstock to tighten and loosen the collets. The wrench is in a size range that will allow you to exert sufficient force without exerting excessive force. It is also in a size range that will make it easier to handle (than a standard 1" wrench) when you are tightening and loosening the collet. Also included, is a "Tommy" bar that is inserted into one of the "Tommy" bar holes on the 3C headstock draw-bar knob. This is to aid in tightening and loosening the 3C collet.

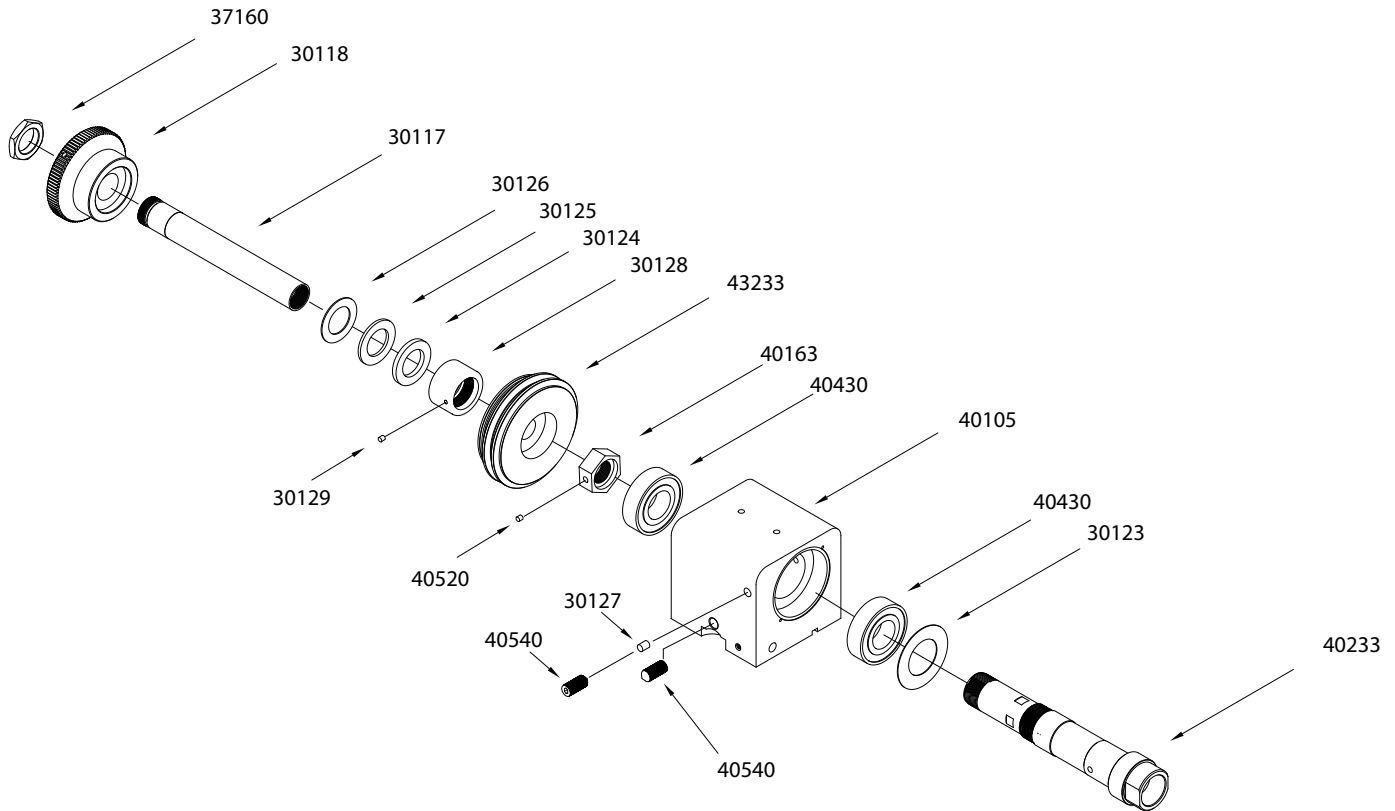
If you wish to use a chuck with the 3C headstock, you can purchase (P/N 10670) which is our 3C to 3/4-16 chuck arbor. All of our 3- and 4-jaw chucks with a 3/4-16 thread will fit on this arbor.

We believe that the 3C Collet Headstock is a great addition to our line of accessories and that it will add versatility to your Sherline Lathe.

Have fun making chips.

Thank you,
Sherline Products Inc.

3C Collet Headstock Exploded View and Part Numbers



Parts List

NO. REQ.	PART NO.	DESCRIPTION
1	40105	3C Headstock Case
1	40233	3C Headstock Spindle
1	43233	3C Main Spindle Pulley
1	40163	3C Preload Nut
2	40430	3C Headstock Bearings
1	40260	Precision Ground Head Key (not shown)
1	30117	3C Collet Draw Bar
1	30118	3C Collet Draw Bar Knob
1	30123	3C Headstock Spindle Bearing "Washer"
1	30124	3C Drawbar Thrust Washer "Inner" .126"
1	30125	3C Drawbar Thrust "Needle Bearing"
1	30126	3C Drawbar Thrust Washer "Outer" .032"
2	40540	5/16-18 X 3/4" Cone Point Set Screw
1	30127	3C Spindle Key Way Set Screw
1	30128	3C Spindle "End Cap"
1	37160	Rotary Table Preload Nut
1	43234	3C 1" Multi-Wrench
1	40520	10-32 x 3/16" Cup point Set Screw
1	30129	5-40 x 1/8" Cup Point Set Screw
1	40580	Spindle "Tommy" Bar (not shown)