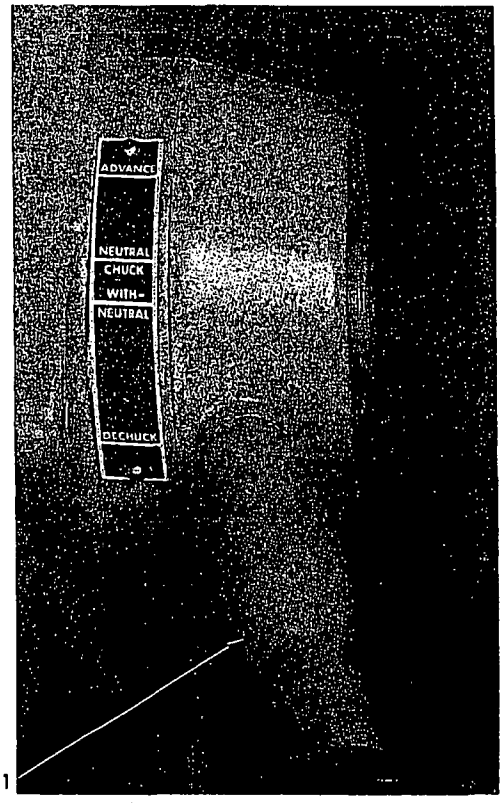


Fig. 8. This view located at 3 Fig. 1.

head to the desired value on the scale and vernier 4 Fig. 7 by inserting an Allen wrench in pinion 5 Fig. 7. Tighten the three nuts.

### 4. Adjust Hydraulic Chuck Pressure

Move lever 1 Fig. 8 to $\frac{\text{neutral}}{\text{chuck}}$ position. Adjust regulating valve at 6 Fig. 6 to proper tension as indicated by gage 7 Fig. 6 according to the value etched on the arbor. If no value is given on the arbor, use the value given in the table 3 Fig. 6.

### 5. Install Chuck and Drawrod

Move lever 1 Fig. 8 to the dechuck position. Turn off the main line switch and install the chuck 1 Fig. 9 in the work spindle, according to the procedure outlined on Page 27. Then install and tighten the drawrod onto the chuck stem 2 Fig. 9 by inserting an Allen wrench at 8 Fig. 6.

Thread the nut 5 Fig. 9 on the drawrod against the shoulder of the piston. Tighten the nut 4 Fig. 9 and adjust the nut 5 Fig. 9 for the amount of travel according to the chuck layout. Hold nut 5 Fig. 9 and tighten jam nut 6 Fig. 9.

### 6. Install Index Gears

Consult the 22.5/N index chart sent with the machine for the index change gears. The driver shaft is identified in the change gear compartment shown at 6 Fig. 10. Be sure to allow just enough backlash in each gear mesh to prevent the gears from binding. These gears determine how many teeth will be cut in the gear blank.

A set-over clutch is provided on the shaft 1 Fig. 10. It is used for turning the work spindle. Loosen the thumb screw 4 Fig. 10, open clutch by rotating knurled handle 3 Fig. 10, and turn clutch dial 5 Fig. 10 by rotating knurled handle 2 Fig. 10

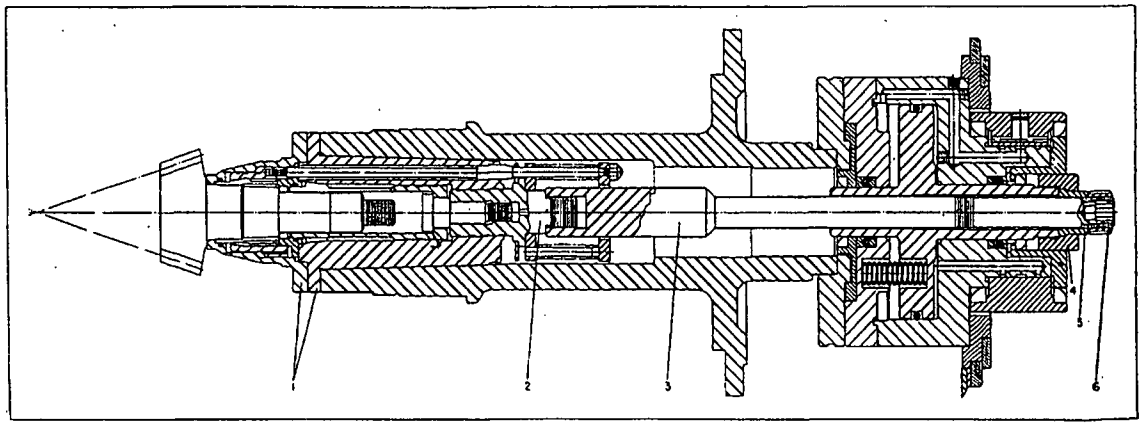


Fig. 9.



GLEASON-000223