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COLLET CLOSERS
HIGH PRESSURE HYDRAULIC
(P/N: 110162, 110163, 110164)

Specifications:

- Max pressure – 5,000 psi
- Clamping force @ 5,000 psi – 10,000 lbs

Safety:

- Use only fittings, hoses, manifolds or other components rated for use at 5000 psi.
- Before operating pump, all connections must be tightened with the proper tools. Do not over tighten. Connections should only be tightened securely and leak-free. Over tightening can cause premature thread failure or high-pressure fittings to split at lower than their rated capacities.
- Should a hydraulic component ever rupture or burst or need to be disconnected, immediately shut off the pump and shift the control valve twice to release all pressure. Never attempt to grasp a leaking pressurized hose with your hands. The force of escaping hydraulic fluid could cause serious injury.

Application:

The collet closers can be used singly or in multiple closer arrays. When used in arrays the assembly footprint and hose requirements can be greatly reduced by using the optional connector bushing (P/N 100169). Simply remove the pressure plugs (two each) on the two adjoining closers and replace with two connector bushings.

Care should be taken to layout arrays so that the collet locking screws of each closer is accessible.

A 4-way hydraulic valve and power source rated at 5,000 psi should be used to actuate the closers. See Figure 1 for a typical application.

The mounting surface should be flat and free of defects. Each closer has two locating holes in the base for use with 3/8" (not included) diameter dowel pins and is secured to the mounting surface by four socket head cap screws (not included). See Figure 2 for details.

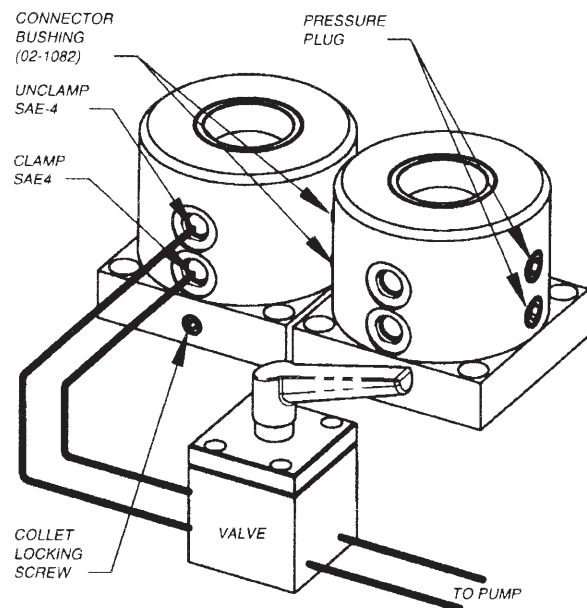
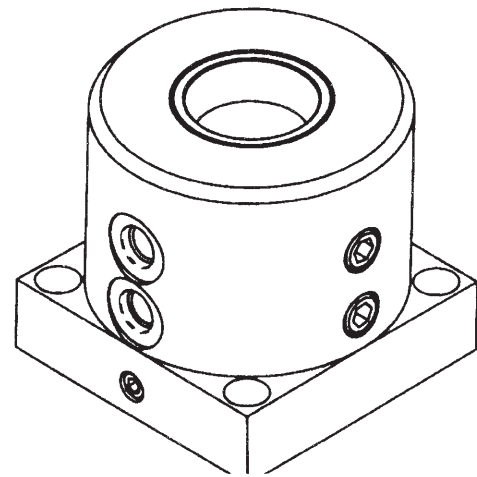


FIGURE 1

Collet Installation:

To install a collet, first make sure the closer is in the unclamped position, and then loosen the collet locking screw located in the base of the closer. Insert the collet into the bore of the closer and rotate counter clockwise using the collet wrench supplied with the closer. Tighten until the taper on the collet makes contact with the taper on the closer. Continue to turn until the slot in the collet aligns with the collet locking screw. Snug up the locking screw.

Operation:

Load parts into the collets and actuate the valve to clamp. Actuate the control valve in the opposite direction to unclamp. **To avoid injury keep fingers away from the collet when actuating the closers.**

Maintenance:

Visually inspect closers, hoses, and other components for leakage or worn parts. Any worn parts should be replaced immediately.

Parts:

See Figure 3.

ITEM No.	QTY.	DESCRIPTION
1	1	BASE
2	1	PISTON
3	1	BODY
4	8	LOCK WASHER
5	8	SCREW, SHC
6	6	PRESSURE PLUG SCREW
7	1	PIN
8	1	BACK-UP RING
9	1	COLLET LOCKING SCREW
10	1	O-RING, LOWER PISTON
11	6	O-RING, PRESSURE PLUG
12	2	O-RING, MIDDLE PISTON & BASE
13	1	O-RING, UPPER PISTON
14	2	BACK-UP RING
15	1	BACK-UP RING

* Repair Kit part numbers: 110162 - 301033
110163 - 301034
110164 - 301035

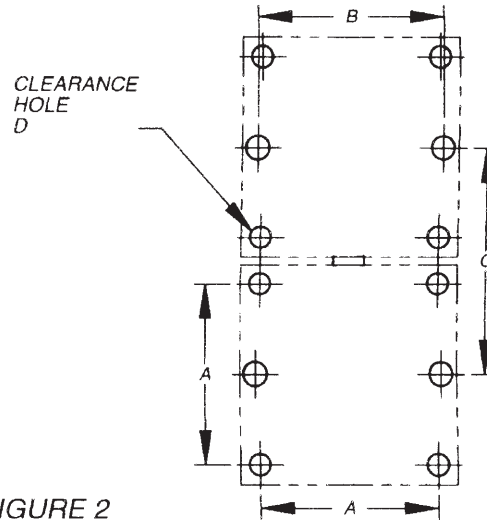


FIGURE 2

MODEL	A	B	C	D
110162(5C)	2.875	3.000	3.625	5/16 SHCS
110163(16C)	3.250	3.000	4.125	3/8 SHCS
110164(3J)	3.250	3.000	4.125	3/8 SHCS

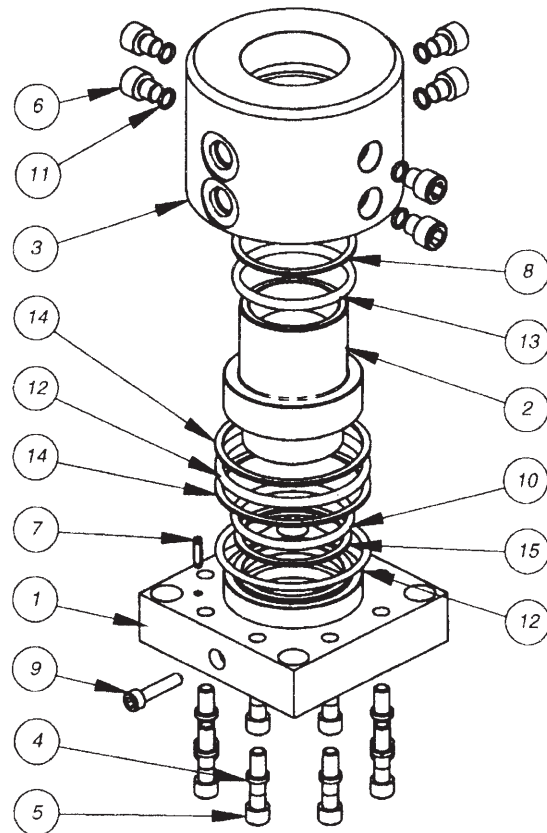


FIGURE 3