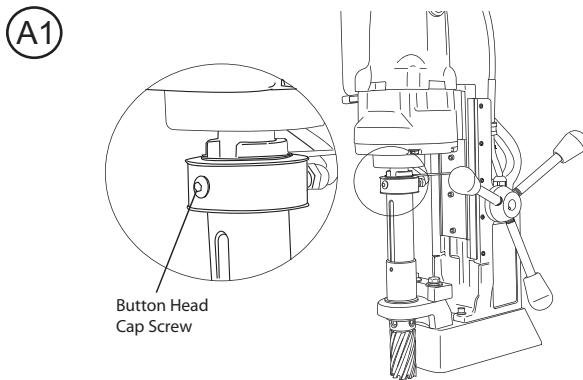


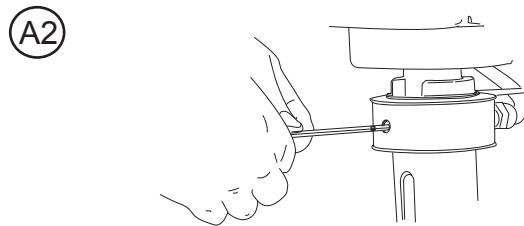
SPINDLE ADAPTER KIT 40341

For use on Hougen Drill Models 10914 & HMD914

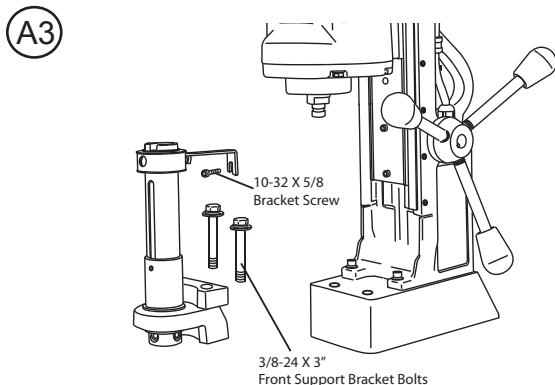
The 40341 Adapter Kit is used to install a Jacobs Chuck onto a 10914 & HMD914 spindle. These machines use 2 mounting styles. One style incorporates a set screw with an access window in the Brass Coolant Inducer (see diagrams A1-A3). The other style uses a retaining ring around the base of the Brass Coolant Inducer (see diagrams B1-B3).



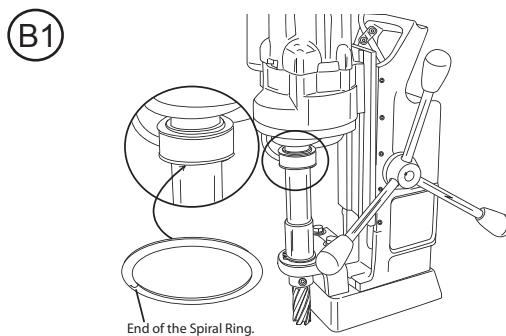
Locate and remove the 1/4-28 X 1/4 Button Head Cap Screw from the Coolant Inducer with a 5/32 Hex Wrench.



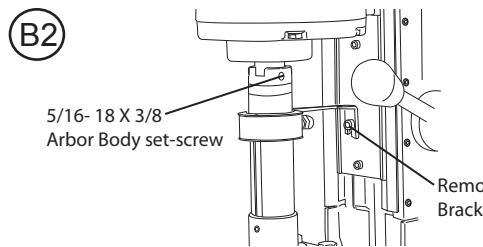
Rotate the Arbor Body so the 5/16-18 X 3/8 set screw inside, aligns with the hole in the Coolant inducer. Insert the 5/32 Hex Wrench and turn the inside set screw 1 full turn counterclock-wise or until loose.



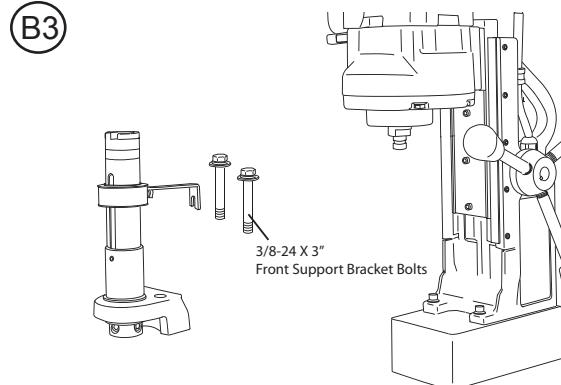
Locate and remove the 10-32 X 5/8" Bracket Screw with a 5/32 Hex Wrench. Remove both 3/8-24 X 3" Hex Bolts from the Front Support Bracket using a 9/16 wrench. Now the entire Arbor Body Assembly can be removed.



Locate the end of the Spiral Retaining Ring under the Brass Coolant Inducer, and with a pick, pull the end down. Once started, pull the rest of the Retaining Ring down the Arbor Body.



Remove the 10-32 X 5/8" Bracket Screw with a 5/32 Hex Wrench and slide the Brass Coolant Inducer down. Turn the 5/16-18 X 3/8 Set Screw until loose and slide the Arbor Body OFF the Motor Spindle.

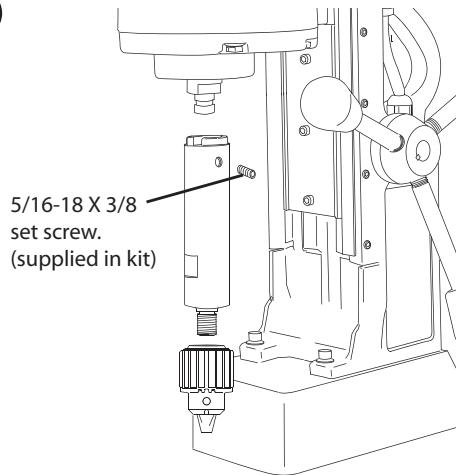


Remove both 3/8-24 X 3" Hex Bolts from the Front Support Bracket using a 9/16 wrench. Now the entire Arbor Body Assembly can be removed.

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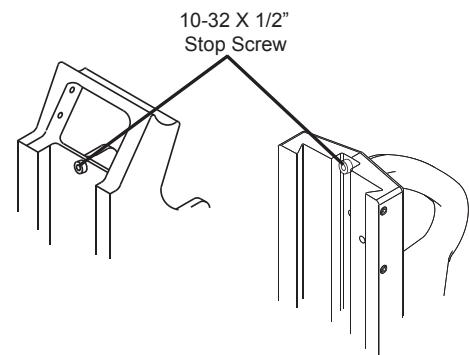


Installation of the Chuck and Adapter is the same on either system covered by the first page. Slide the Spindle Adapter (07301) up onto the Motor Spindle verifying the Spindle sits down in the slot of the Adapter. Install and tighten the 5/16-18 X 3/8 Set Screw (40256), supplied in the kit. Thread the Chuck onto the bottom of the Adapter until hand tight.

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With either system, verify that the 10-32 X 1/2" Stop Screw (10648) is in place and tight.

Your 3-Jaw Chuck is now installed. Select the proper twist bit for your application and follow Operating Procedures for the Hougen Magnet Based Drill you are using.



40341 SPINDLE ADAPTER KIT

