

## Chuck Assembly

| Item<br>Number            | Part<br>Number | Description                        | Qty |
|---------------------------|----------------|------------------------------------|-----|
| 1                         | HHCS120131125  | 1/2-13UNC x 1 1/2" Lg HHCS (Gr. 5) | 3   |
| 2                         | see below      | Bushings                           |     |
| 3                         | HHCS340101125  | 3/4-10UNC x 1 1/2" Lg HHCS (Gr. 5) | 3   |
| 4                         | 18100071       | Top Cap Adapter                    | 1   |
| 5                         | HHCS120132145  | 1/2-13UNC x 2 1/4" Lg HHCS (Gr. 5) | 9   |
| 6                         | see below      | Jaw Set                            |     |
| 7                         | 18100194       | Jaw Retaining Ring                 | 2   |
| 8                         | 18100122       | Top Cap Holder                     | 1   |
| 9                         | HHCS120136125  | 1/2-13UNC x 6 1/2" Lg HHCS (Gr. 5) | 6   |
| 10                        | HHCS120138005  | 1/2-13UNC x 8" Lg HHCS (Gr. 5)     | 3   |
| 11                        | 18100058       | Top Spacer                         | 3   |
| 12                        | 18100067       | Chuck Bowl (12.5 deg)              | 1   |
| 13                        | 18100158       | Key Locking Spring                 | 1   |
| 14                        | 18100155       | Spring                             | 18  |
| 15                        | 18100041       | Key                                | 3   |
| 16                        | 18100059       | Bottom Spacer                      | 9   |
| 17                        | 18100156       | Oil Seal                           | 9   |
| 18                        | 18100091       | Housing                            | 1   |
| 19                        | HHCS120134125  | 1/2-13UNC x 4 1/2" Lg HHCS (Gr. 5) | 10  |
| 20                        | 18100065       | V-Ring                             | 1   |
| 21                        | PPSQHD0140     | 1/4" Square Head Pipe Plug         | 1   |
| 22                        | GF14028S       | 1/4" - 28 Grease Fitting           | 3   |
| 23                        | 18100024       | Cylinder                           | 1   |
| 24                        | 18100064       | Wear Ring                          | 1   |
| 25                        | 18100062       | U Cup Seal                         | 1   |
| 26                        | 18100123       | Actuator Sleeve                    | 1   |
| 27                        | 18100023       | Piston                             | 1   |
| 28                        | SP380112       | Spring Pin 3/8" x 1-1/2" Lg        | 4   |
| 29                        | 18100157-S     | Thrust Bearing - Steel Cage        | 1   |
| 30                        | 18100086       | Back Up Ring                       | 1   |
| 31                        | 18100285       | Retaining Ring                     | 1   |
| 32                        | 18100061       | U Cup Seal                         | 1   |
| 33                        | 18100063       | Wear Ring                          | 1   |
| 34                        | HHCS120131345  | 1/2-13UNC x 1 3/4" Lg HHCS (Gr. 5) | 10  |
| 35                        | 18100147       | Chuck Adapter                      | 1   |
| 36                        | NUTHH12013     | 1/2-13UNC Heavy Hex Nut            | 10  |
| <b>Jaw Set / Bushings</b> |                |                                    |     |
| 2                         | 18100068       | Bushing, B Rod                     | 1   |
| 2                         | 18100206       | Bushing, B Casing                  | 1   |
| 2                         | 18100153       | Bushing, N Rod                     | 1   |
| 2                         | 18100154       | Bushing, H Rod / N Casing          | 1   |
| 6                         | 18100012       | Jaw Set, B Rod                     | 1   |
| 6                         | 18100134       | Jaw Set, B Casing                  | 1   |
| 6                         | 18100135       | Jaw Set, N Rod                     | 1   |
| 6                         | 18100145       | Jaw Set, H Rod / N Casing          | 1   |

Date: June 27, 2012

### 18120001 Chuck Assembly (Exploded View)

