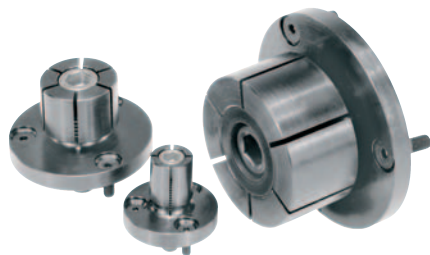


Mandrel collets



Material:

Mandrel mild steel.

Taper-head screw low-carbon steel

Version:

Mandrel black oxidised.

Taper-head screw case-hardened.

Sample order:

nIm 03157-081420

Note:

The mandrel collet is ideal for finish machining turned parts. The

diameter "D" can be turned or milled to suit the workpiece ID.

Low design - no interfering clamp straps.

Tightened using a hex socket wrench or hydraulics.

* D min. = smallest diameter to which "D" may be turned or milled.

Assembly:

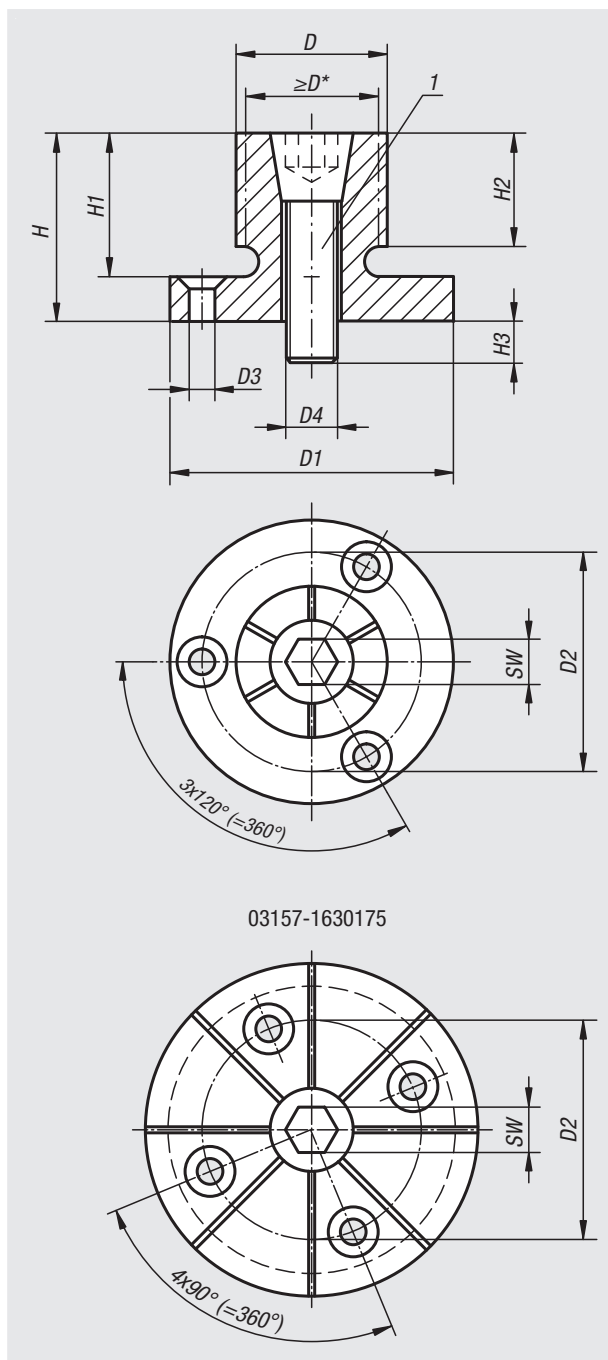
Expand the mandrel approx. 0.1 mm over the relaxed diameter.

Turn or mill the mandrel to suit the internal diameter of the

workpiece. The base flange can be centred in a pocket or using dowel pins.

Drawing reference:

1) taper-head screw



Order No.	D	D min.	D1	D2	D3 for screw ISO 10642	D4 Tapered-head bolt	H	H1	H2	H3	SW Tapered-head bolt	Tightening torque max. Nm	Clamping force max. kN
03157-020407	7,4	4,1	20 h9	13,7	M2	M2	10,7	7,6	6,1	4,1	1,5	0,7	1,1
03157-040812	12,4	8	29,72 h9	21	M3	M4	21,8	16	15	8	3	5	4,2
03157-061214	14,2	12,2	31,5 h9	23,1	M3	M6	24,9	19	15	12	5	17	8,5
03157-081420	20	13,5	37,5 h9	29	M3	M8	24,9	19	15	14	6	34	11,1
03157-062027	27	18	50 h9	39,4	M4	M10	28,6	22,2	17,5	17	8	60	20
03157-102535	35,3	23	56 h9	45,5	M4	M12	31,8	25,4	20,6	21	10	150	26,3
03157-123442	42	29,3	69,5 h8	55,9	M5	M16	39,6	31,8	27	22	14	280	44,5
03157-123452	51,5	29,3	75,5 h9	63,9	M5	M16	39,6	31,8	27	22	14	280	44,5
03157-163077	77,7	29,3	107,5 h9	92,5	M6	M16	45,5	37,6	32,3	20	14	280	44,5
03157-1630103	103	29,3	132,9 h9	118	M6	M16	45,5	37,6	32,3	20	14	280	44,5
03157-1630175	175	29,3	132,9 h9	118	M6	M16	45,5	37,6	32,3	20	14	280	44,5

Mandrel collets

with side lock



Material:

Mandrel mild steel.
Clamping screw carbon steel.

Version:

Mandrel black oxidised.
Clamping screw tempered to 10.9, hardened and PTFE coated.

Sample order:

nlm 03157-118029

Note:

The side lock make these mandrel collets ideal for finish machining parts with blind internal diameters. The diameter "D" can be turned or milled to suit the workpiece ID.

Manual tightening with hexagon socket wrench.

* D min. = smallest diameter to which "D" may be turned or milled.

Assembly:

Expand the mandrel approx. 0.1 mm over the relaxed diameter. Turn or mill the mandrel to suit the internal diameter of the workpiece. A locking ring is included for machining.

The shank or flange is centred in a reamed hole or pocket.

Form A is supplied with 6 fastening screws.

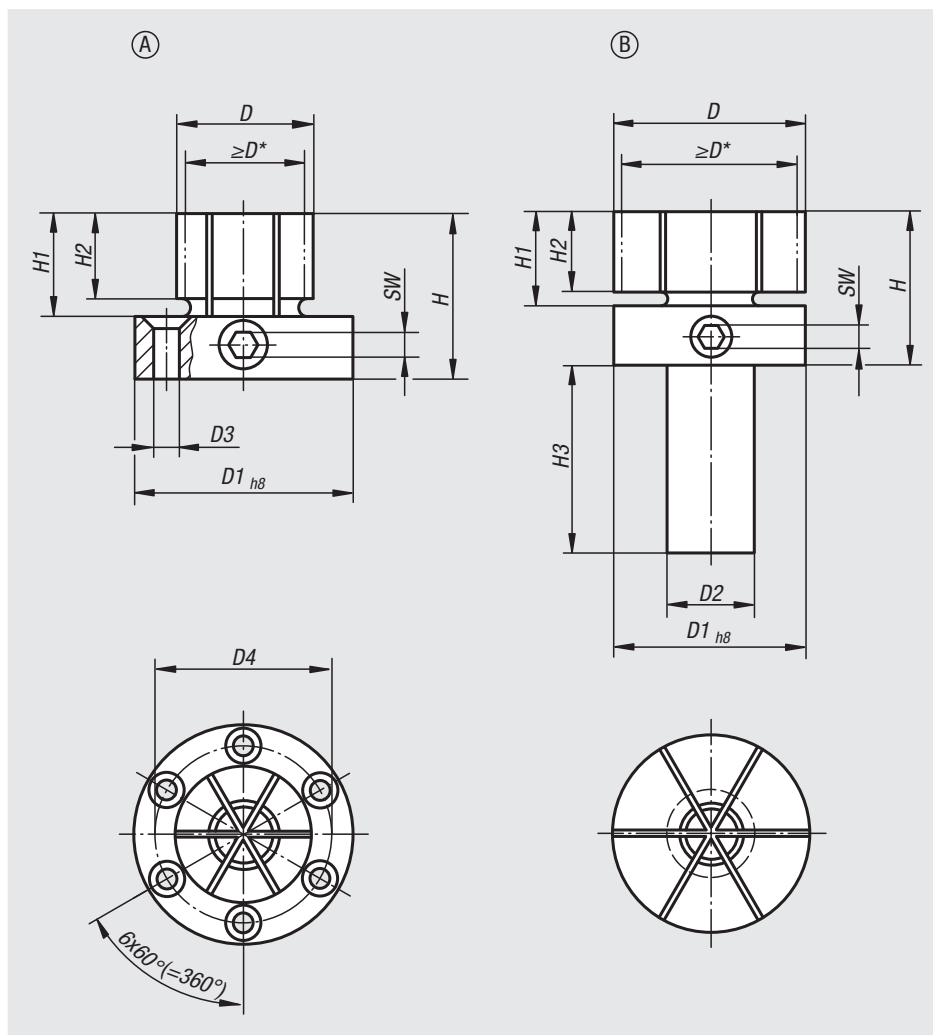
Drawing reference:

Form A:

for machining centres, drilling and milling machines

Form B:

with shaft for holding in lathe chucks



Order No.	Form	D	D min.	D1	D2	D3 for screw ISO 10642	D4	H	H1	H2	H3	SW	Tightening torque max. Nm	Clamping force max. kN
03157-118029	A	28,7	17,8	50	-	M4	39,4	41,3	22,4	17,5	-	6	66	20
03157-218053	B	53,3	18	53,3	25	-	-	44,4	25,4	21	45	6	66	20