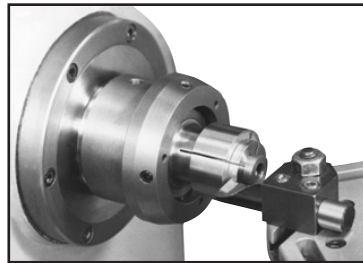
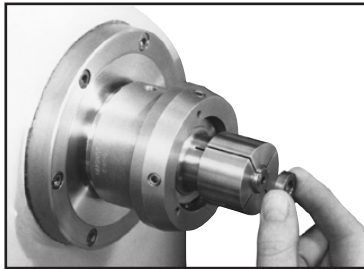


## Using Emergency Expanding Collets

Even with the best of planning, emergencies arise when your tool room or production department requires a step-type or an odd size expanding collet. On such occasions use Hardinge Emergency Expanding Collets. Hardinge Emergency Expanding Collets are used with models S, M and L Expanding Collet Systems. The collets have a hardened and finished-ground flange section and opening angle, however the outside diameter is soft to permit turning to a desired size.

## Turning to a desired size

Apply the limit ring to the collet. Set the collet chucking pressure to the very minimum to keep the limit ring from turning. Turn to the desired size or stepped sizes.



Model	Turning Range
S-E	.562" – .750"
M-EA	.751" – 1.359"
M-EB	1.360" – 1.750"
L-EA	1.751" – 2.000"
L-EB	2.001" – 2.500"
L-EC	2.501" – 3.000"

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