

HARDINGE®

COLLETS FOR HYDROMAT ROTARY TRANSFER MACHINES



Collets for Hydromat Rotary Transfer Machines

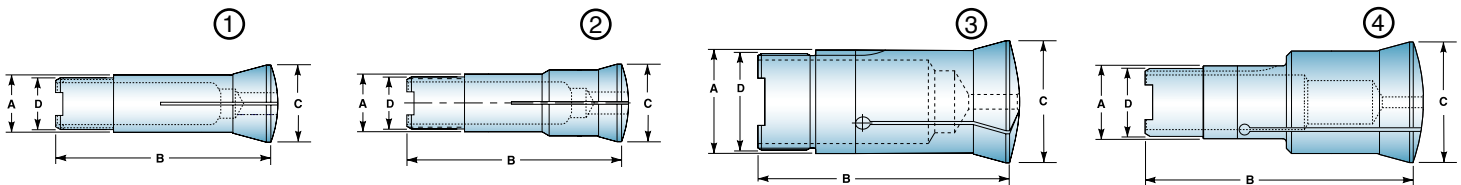
Hardinge manufactures Hydromat collets to rigid specifications including material, heat treatment and accuracy for the high production environment. Every Hydromat collet's thread, back bearing and spread are gaged, and the workpiece Total Indicator Reading (TIR) is taken before leaving the factory to ensure total quality.

Thru-hole and Stepped-collets are stocked in fractional round, hex and square sizes. Metric round sizes, special shapes and features are also available. All hex and square collets have two key-ways, one to the corner and one to the flat for synchronization.



Description	Hardinge Part Number	Fig.	Style	Hydromat Machine Model	Dimensions				Collet Capacity - Not Machine Capacity		
					A	B	C	D	Round	Hexagon	Square
					Back Bearing Diameter	Length	Collet Head Diameter	Thread			
25W – Thru-Collet	1901	1	5457	HW/25-12	.984" (24.99)	3.719" (94.46)	1.326" (33.68)	.970" x 15.24 RH Buttress	$\frac{3}{4}$ " (19.05)	$\frac{41}{64}$ " (16.27)	$\frac{17}{32}$ " (13.49)
25-W-OS – Thru-Collet	1903	2	5874	HW/25-12	.984" (24.99)	3.719" (94.46)	1.326" (33.68)	.970" x 15.24 RH Buttress	$\frac{3}{4}$ " (19.05)	$\frac{41}{64}$ " (16.27)	$\frac{17}{32}$ " (13.49)
25W-OS – Stepped-Hole	1903	2	5458	HW/25-12	.984" (24.99)	3.719" (94.46)	1.326" (33.68)	.970" x 15.24 RH Buttress	.751" - 1" (19.07 - 25.40)	.642" - $\frac{7}{8}$ " (16.30 - 22.22)	.532" - $\frac{3}{4}$ " (13.51 - 19.05)
B32 – Thru-Collet	2249	1	5873	HB/32-16	1.260" (32.00)	4.008" (101.80)	1.576" (40.03)	1.169 x 15 RH Buttress	.943" (23.95)	.817" (20.75)	.667" (16.94)
B32 – Stepped-Hole	2249	1	5873	HB/32-16	1.260" (32.00)	4.008" (101.80)	1.576" (40.03)	1.169 x 15 RH Buttress	.944" - $\frac{1}{4}$ " (23.97 - 31.75)	.818" - 1.091" (20.77 - 27.71)	.668" - .890" (16.96 - 22.60)
B32/45 – Thru-Collet	2239	4	5547	HB32/45-16	1.260" (32.00)	4.623" (117.42)	2.090" (53.08)	1.169 x 15 RH Buttress	$\frac{59}{64}$ " (23.41)	.817" (20.75)	.667" (16.94)
B32/45 – Stepped-Hole	2241	4	5548	HB32/45-16	1.260" (32.00)	4.623" (117.42)	2.090" (53.08)	1.169 x 15 RH Buttress	.922" - $\frac{13}{16}$ " (23.41 - 44.45)	.818" - $\frac{11}{16}$ " (20.77 - 38.10)	.668" - $\frac{11}{16}$ " (16.96 - 31.75)
B45 – Thru-Collet	2243	3	5549	HB/45-12	1.771" (44.98)	4.343" (110.31)	2.090" (53.08)	M42 x 1.5 Buttress	$1\frac{13}{32}$ " (35.71)	1.240" (31.49)	1.013" (25.73)
B45 – Stepped-Hole	2245	3	5550	HB/45-12	1.771" (44.98)	4.343" (110.31)	2.090" (53.08)	M42 x 1.5 Buttress	1.407" - $\frac{13}{16}$ " (35.73 - 44.45)	1.241" - $1\frac{1}{2}$ " (31.52 - 38.10)	1.014" - $1\frac{1}{4}$ " (25.75 - 31.75)
PRO20 – Thru-Collet	2247	2	5830	PRO20	.787" (20.00)	3.700" (93.98)	1.036" (26.31)	.775" x 15.24 RH Buttress	.5708" (14.49)	.4921" (12.50)	.3937" (10.00)
PRO20 – Stepped-Hole	2247	2	5830	PRO20	.787" (20.00)	3.700" (93.98)	1.036" (26.31)	.775" x 15.24 RH Buttress	.571" - .7874" (14.50 - 20.00)	.493" - .6693" (12.52 - 17.00)	.394" - .551" (10.00 - 13.99)

NOTE: Millimeters in parentheses. Collets available in smooth or serrated order holes.



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