



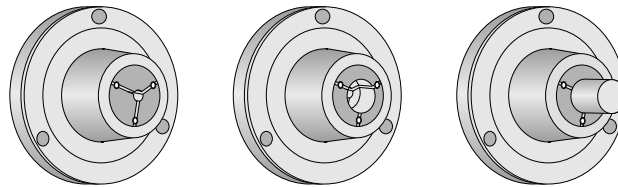
### Hardinge® Emergency Collets

Even with the best of planning, emergencies arise when you may require a stepped, odd size or special-shaped collet. Use a Hardinge Emergency Collet. The soft face and pilot hole permit rapid drilling, boring or stepping out to the exact size required. Pins are supplied for precision machining. Body and threads are heat-treated.

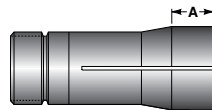
**Extended-Nose Emergency Collets** permit deeper counterbores when required and tool clearance for extended work.

### Boring to the desired size

Clean the spindle and the Hardinge Emergency Collet. Apply the collet to the spindle. Be sure pins are in place in the collet. Using lever closer or draw spindle, close the collet to the same tension used for chucking on the work piece. When straight through holding is required, bore the collet to the exact size of the part to be held. Use a dial bore gage or air gage to check the diameter of the part. If neither is available, use the work piece. When a stepped-type bore is required, finish bore to the exact size and then face the bottom of the bore to provide a square shoulder: Undercut the corner where the bore and shoulder meet in the collet to assure that the part will seat against the shoulder of the step. Remove the collet from the spindle. Remove the pins from the collet and deburr. Clean the slots and the bore of the collet as well as the machine spindle and you are ready to run production.



5C taper nose spindle illustrated.



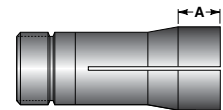
### Emergency Collets

Model	Part Number	Pilot Hole
<b>5C Emergency Collets - 3 / 4 Slots</b>		
5C-E1 Steel	1007-12-10-000000	1/16" (1.59)
5C-E1 Brass	1013-12-10-000000	1/16" (1.59)
5C-E2 Steel	1007-13-10-000000	1/8" (3.18)
5C-E2 Brass	1013-13-10-000000	1/8" (3.18)
5C-E0	1007-11-00-000000	—
<b>16C Emergency Collets - 3 Slots</b>		
16C-E	1717-14-00-000000	1/4" (6.35)
16C-E1	1717-12-00-000000	1/16" (1.59)
16C-E2	1717-13-00-000000	1/8" (3.18)
16C-E0	1717-11-00-000000	—
<b>20C Emergency Collets - 4 Slots</b>		
20C-E	1701-14-10-000000	1/4" (6.35)
20C-E0	1701-11-00-000000	—
<b>25C Emergency Collets - 4 Slots</b>		
25C-E	1801-14-10-000000	1/2" (12.70)
25C-E0	1801-11-00-000000	—
<b>3J Emergency Collets - 4 Slots</b>		
3J-E	1595-14-10-000000	1/4" (6.35)
3J-E1	1595-12-10-000000	1/16" (1.59)
<b>Replacement Pins</b>		
5C, 16C, 20C & 3J	7723-00-00	—
25C	7725-00-00	—

### Extended-Nose Emergency Collets

Model	Part Number	Pilot Hole	"A" Length
<b>5C Emergency Collets - 3 Slots</b>			
5C-EN1	1009-14-10-000000	1/4" (6.35)	1" (25.40)
5C-EN1-1	1009-12-10-000000	1/16" (1.59)	1" (25.40)
5C-EN1-2	1009-13-10-000000	1/8" (3.18)	1" (25.40)
5C-EN2	1011-14-10-000000	1/4" (6.35)	1/2" (12.70)
5C-EN2-1	1011-12-10-000000	1/16" (1.59)	1/2" (12.70)
5C-EN2-2	1011-13-10-000000	1/8" (3.18)	1/2" (12.70)
<b>5C Emergency Plug Chuck - Solid</b>			
5C Plug	1015-00-00-000000	—	1 3/4" (44.45)
<b>16C Emergency Collets - 3 Slots</b>			
16C-EN1	1717-12-13-000000	1/4" (6.35)	1" (25.40)
16C-EN1-1	1717-13-13-000000	1/16" (1.59)	1" (25.40)
16C-EN1-2	1717-14-13-	1/8" (3.18)	1" (25.40)
16C-EN2	1717-12-14-	1/4" (6.35)	1/2" (12.70)
16C-EN2-1	1717-13-14-	1/16" (1.59)	1/2" (12.70)
16C-EN2-2	1717-14-14-	1/8" (3.18)	1/2" (12.70)
<b>20C Emergency Collets - 4 Slots</b>			
20C-EN .75	1809-14-10-	1/4" (6.35)	3/4" (19.05)
20C-EN 1.5	1811-14-10-	1/4" (6.35)	1 1/2" (38.10)
<b>3J Emergency Collets - 4 Slots</b>			
3J-EN1	1593-12-13-	1/4" (6.35)	1" (25.40)
3J-EN2	1593-12-14-	1/4" (6.35)	1/2" (12.70)
<b>Replacement Pins</b>			
All Sizes	7731-00-00	—	—

NOTE: Millimeters in parentheses. Emergency collets not intended to be heat treated.



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5C-E2 Steel	1007-13-10-000000	1/8" (3.18)
5C-E2 Brass	1013-13-10-000000	1/8" (3.18)
5C-E0	1007-11-00-000000	—
<b>16C Emergency Collets - 3 Slots</b>		
16C-E	1717-14-00-000000	1/4" (6.35)
16C-E1	1717-12-00-000000	1/16" (1.59)
16C-E2	1717-13-00-000000	1/8" (3.18)
16C-E0	1717-11-00-000000	—
<b>20C Emergency Collets - 4 Slots</b>		
20C-E	1701-14-10-000000	1/4" (6.35)
20C-E0	1701-11-00-000000	—
<b>25C Emergency Collets - 4 Slots</b>		
25C-E	1801-14-10-000000	1/2" (12.70)
25C-E0	1801-11-00-000000	—
<b>3J Emergency Collets - 4 Slots</b>		
3J-E	1595-14-10-000000	1/4" (6.35)
3J-E1	1595-12-10-000000	1/16" (1.59)
<b>Replacement Pins</b>		
5C, 16C, 20C & 3J	7723-00-00	—
25C	7725-00-00	—

## Extended-Nose Emergency Collets

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<b>5C Emergency Collets - 3 Slots</b>			
5C-EN1	1009-14-10-000000	1/4" (6.35)	1" (25.40)
5C-EN1-1	1009-12-10-000000	1/16" (1.59)	1" (25.40)
5C-EN1-2	1009-13-10-000000	1/8" (3.18)	1" (25.40)
5C-EN2	1011-14-10-000000	1/4" (6.35)	1/2" (12.70)
5C-EN2-1	1011-12-10-000000	1/16" (1.59)	1/2" (12.70)
5C-EN2-2	1011-13-10-000000	1/8" (3.18)	1/2" (12.70)
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5C Plug	1015-00-00-000000	—	1 3/4" (44.45)
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16C-EN2-1	1717-13-14-	1/16" (1.59)	1/2" (12.70)
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<b>20C Emergency Collets - 4 Slots</b>			
20C-EN .75	1809-14-10-	1/4" (6.35)	3/4" (19.05)
20C-EN 1.5	1811-14-10-	1/4" (6.35)	1 1/2" (38.10)
<b>3J Emergency Collets - 4 Slots</b>			
3J-EN1	1593-12-13-	1/4" (6.35)	1" (25.40)
3J-EN2	1593-12-14-	1/4" (6.35)	1/2" (12.70)
<b>Replacement Pins</b>			
All Sizes	7731-00-00	—	—

NOTE: Millimeters in parentheses. Emergency collets not intended to be heat treated.