

## Extended-Nose Emergency Collets Instructions B-096C

Hardinge® Extended-Nose Subemergency Collets for Swiss-type machines and QUEST® TwinTurn® 65 Lathes

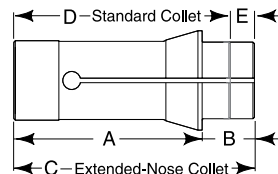
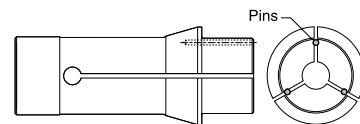
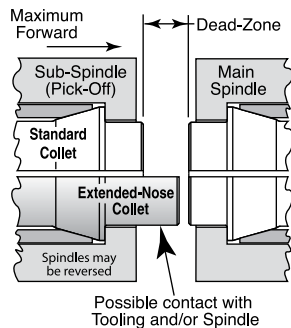
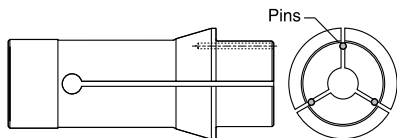
Emergency collets are soft for machining to fit the specifications of your workpiece. They have an extended nose to the length indicated in the chart on reverse side. "E" is the extension beyond the face of a standard collet. "D"

is the overall length of a standard collet.

### Machining

Insert the 3 pins (supplied) into the face of the collet.

Adjust the closing pressure to lightly grip the pins. Machine the collet to the desired specifications. Remove the collet from the spindle. Remove and save the pins for future use. Deburr the collet and replace it in the spindle. Adjust the closer to proper gripping pressure.



Style	Collet Part #	"A"	"B"	"C"	"D"	"E"	Pin Part #
TF15	4681-12	2.284" (58.00)	.424" (10.76)	2.708" (68.78)	2.520" (64.00)	.188" (4.77)	7722-00 $\frac{1}{8} \times \frac{43}{64}$ "
TF16	4683-12	2.284" (58.00)	.424" (10.76)	2.708" (68.78)	2.520" (64.00)	.188" (4.77)	7722-00 $\frac{1}{8} \times \frac{43}{64}$ "
TF20	4685-12	2.362" (60.00)	.464" (11.78)	2.826" (71.78)	2.638" (67.00)	.188" (7.31)	7724-00 $\frac{1}{8} \times \frac{47}{64}$ "
TF25	4687-12	2.638" (67.00)	.644" (16.35)	3.282" (83.36)	3.032" (77.00)	.250" (6.35)	7730-00 $\frac{1}{8} \times \frac{57}{64}$ "
TF30	4689-12	2.760" (70.10)	.889" (22.58)	3.649" (92.68)	3.149" (79.98)	.500" (12.70)	7726-00 $\frac{1}{8} \times 1\frac{11}{64}$ "
TF34	4691-12	2.760" (70.10)	.894" (22.70)	3.654" (92.81)	3.154" (80.11)	.500" (12.70)	7730-00 $\frac{1}{8} \times \frac{57}{64}$ "
TF37	4693-12	3.230" (82.04)	.892" (22.65)	4.122" (104.69)	3.622" (92.00)	.500" (12.70)	7726-00 $\frac{1}{8} \times 1\frac{11}{64}$ "
S16-HM	4695-12	2.165" (55.00)	.464" (11.78)	2.629" (66.78)	2.441" (62.00)	.188" (4.77)	7724-00 $\frac{1}{8} \times \frac{47}{64}$ "
S25-HS	4697-12	2.677" (68.00)	.972" (24.68)	3.649" (92.68)	3.149" (80.00)	.500" (12.70)	7728-00 $\frac{1}{8} \times 1\frac{11}{64}$ "
B-65 ( $\frac{3}{16}$ " pilot)	3743-14-13-001875	4.006" (101.75)	1.822" (46.27)	5.828" (148.03)	4.328" (109.93)	1.5" * (38.10)	TL0006648 $\frac{3}{16} \times 1"$

NOTE: These emergency collets have a  $\frac{1}{16}$ " (1.58mm) pilot hole. \* $\frac{1}{2}$ " diameter extension.

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