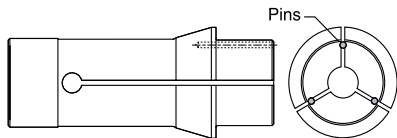


Extended-Nose Emergency Collets Instructions B-096C

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

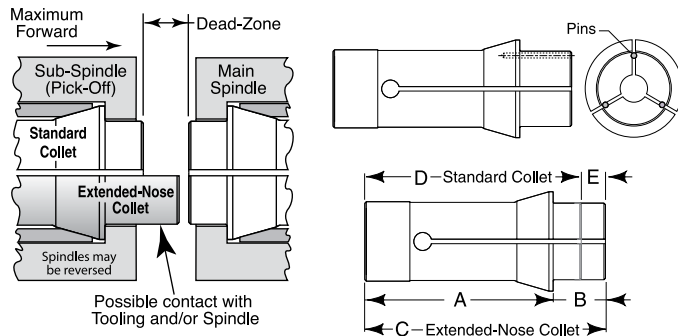
Insert the 3 pins (supplied) into the face of the collet.

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.

WARNING: If the collet is to be used as a standard length emergency collet, the extension must be faced off to the overall length of a standard collet, otherwise you may damage the machine tool, the tooling or cause personal injury.

WARNING: When using an extended-nose collet it will enter the dead-zone of the machine tool. With the collet in this area it may come into contact with cross slide tooling, end-working tooling and it may come into contact with the main spindle collet. This may result in damage to the machine tool, the tooling or cause personal injury.

PERSON INJURY - This term should be understood to include severe personal injury, possibly resulting in death.



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 1/8" x 3/64"
TF16	4683-12	2.284" (58.00)	.424" (10.76)	2.708" (68.78)	2.520" (64.00)	.188" (4.77)	7722-00 1/8" x 3/64"
TF20	4685-12	2.362" (60.00)	.464" (11.78)	2.826" (71.78)	2.638" (67.00)	.188" (7.31)	7724-00 1/8" x 7/64"
TF25	4687-12	2.638" (67.00)	.644" (16.35)	3.282" (83.36)	3.032" (77.00)	.250" (6.35)	7730-00 1/8" x 7/64"
TF30	4689-12	2.760" (70.10)	.889" (22.58)	3.649" (92.68)	3.149" (79.98)	.500" (12.70)	7726-00 1/8" x 1 1/16"
TF34	4691-12	2.760" (70.10)	.894" (22.70)	3.654" (92.81)	3.154" (80.11)	.500" (12.70)	7730-00 1/8" x 7/64"
TF37	4693-12	3.230" (82.04)	.892" (22.65)	4.122" (104.69)	3.622" (92.00)	.500" (12.70)	7726-00 1/8" x 1 1/16"
S16-HM	4695-12	2.165" (55.00)	.464" (11.78)	2.629" (66.78)	2.441" (62.00)	.188" (4.77)	7724-00 1/8" x 7/64"
S25-HS	4697-12	2.677" (68.00)	.972" (24.68)	3.649" (92.68)	3.149" (80.00)	.500" (12.70)	7728-00 1/8" x 1 1/16"
B-65 (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 3/16" x 1"

NOTE: These emergency collets have a 1/16" (1.58mm) pilot hole. *2 1/2" diameter extension.

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