

# TF25 Swiss Pickoff Collet

for internal gripping of threaded or thin-wall parts



TF25 Sub-spindle pickoff collet shows customer's workpiece on expanding head on left.

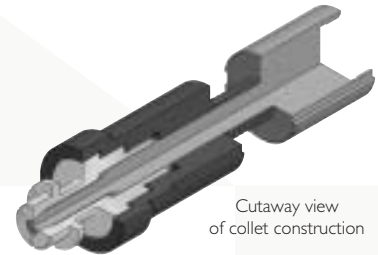
This custom designed Swiss-style pickoff collet is manufactured by Hardinge Inc. for Citizen 20mm machines and other brand screw machines that use TF-25 sub-spindle collets. Originally designed for Brookdale Associates (Agawam, Mass), this internal gripping solution played a key role in finalizing the sale of a Citizen machine, according to Randy Nickerson, Applications Engineer and Training Manager at Brookdale Associates. The job involved picking off a very thin-walled part from the main spindle for additional back-turning and facing of the part. The customer application incorporated automated loading of slugs into the main

spindle. They wanted to eliminate any second operation to finish this part complete with an unmanned operation, and would not accept any alterations to the sub-spindle. Hardinge designed a solution to fit within the existing draw tube parameters without having to shorten the draw tube. Without alterations, the sub-spindle is still able to function within its normal capabilities to run other jobs.

Randy commented that he depends on Hardinge's knowledge and expertise in the industry for a reliable product that he and his customer can depend on. "When

the customer has an unusual or complicated process where there is room for something to go wrong, we turn to Hardinge for the right solution," stated Randy Nickerson.

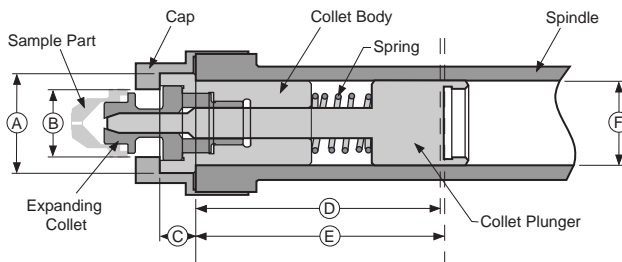
The TF-25 ID pickoff collet is application specific and grips just one part, however it could accommodate other similar jobs by changing out the expanding head portion of the assembly. With a universal collet body, Hardinge is able to quickly create variations of expanding heads for other customer requirements for Citizen, Hardinge, Star, Tornos Deco and Tsgami sub-spindles that use TF-25 collets.



Cutaway view of collet construction

**Let Hardinge quote an ID pickoff collet for your Swiss-style machine – fax us your dimensions:**

**Company** \_\_\_\_\_ **Name** \_\_\_\_\_ **Phone** \_\_\_\_\_



(must remove collet sleeve to use)

**Dimensions:**

- (A) Cap I.D. \_\_\_\_\_
- (B) Cap thru-hole \_\_\_\_\_
- (C) Spindle Face to Cap \_\_\_\_\_
- (D) Stroke Closed \_\_\_\_\_
- (E) Stroke Open \_\_\_\_\_
- (F) Spindle I.D. \_\_\_\_\_

Hardinge Inc. One Hardinge Drive | P.O. Box 1507 | Elmira, New York 14902-1507 USA  
 USA: 800-843-8801 or 607.378.4022 | Canada: 800-468-5946 | Fax: 607-734-3886

To Order Online: [www.hardingetooling.com](http://www.hardingetooling.com) | Corporate Homepage: [www.hardinge.com](http://www.hardinge.com) | E-mail: [info@hardingetooling.com](mailto:info@hardingetooling.com)



EXPECT MORE™

# Sure-Grip® Expanding Collet Assembly

for EuroTurn OD Pick-off Attachment



Standard OD Pickoff Attachment shown (left) with Hardinge ID Pick-off Collet Assembly (right).

Economical Pick-off Collet Assembly designed as low-cost alternative for Euroturn 6/32

## Manth-Brownell Saves \$40,655 – Increases Productivity and Improves Accuracy...

Hardinge designed an ID Pickoff Collet Assembly as an alternative to purchasing the machine tool builder's ID Pickoff Attachment and Kit. This allows the customer to change just the collet rather than the entire attachment, saving hours of setup time. The ID Pick-off Collet Assembly with built-in part ejector is available for Euroturn, Gildemeister and Tornos Deco's standard OD pick-off attachments and is application specific.



Wes Skinner, President (right) of Manth-Brownell (Kirkville, NY), Cal Macomber, Director Sales & Marketing, (left) Hardinge Workholding

Call Hardinge with your machine sub-spindle information to get a quote on an ID pickoff collet that could save you money! A few pre-engineered solutions are shown to the right.

COMPARE:	Hardinge Collet Assembly	Machine ID Attachment & Kit
Cost	\$2,995	\$43,650
Setup	15 minutes	8 hours
Length Control*	.0002-.0003	.004-.006
*finished part length		



EXPECT MORE™

Tornos Deco  
ID Pickoff Collet Assembly  
Part #91X-0000-82-2323R

Gildemeister GM-32/GM-35  
ID Pickoff Collet Assembly  
Part #94G-1732-82-7156R

Euroturn 6/32 (42mm)  
ID Pickoff Collet Assembly  
Part #94Z-2067-82-7292R

Euroturn 6/32  
ID Pickoff Collet Assembly  
Part #91X-0000-82-2323R

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