

Workholding Solutions

for the Hardinge® ELITE® 27 MS CNC Lathe



ELITE 27 MS

Workholding Options:

	Main Spindle	Sub-Spindle
Collets (maximum capacities)	A2-4, 5C	S25 HS
Round-Smooth & serrated	1 1/16"	1"
Hex-Smooth	29/32"	.866"
Square-Smooth	3/4"	.707"
Collet Stops	Solid, Long, Ejector, Universal	n/a n/a
Emergency Collet (pilot hole size)	1/4", 1/16", 1/8", none	1/16"
Extended-Nose Emergency Collet (ext. length)	1/2" and 1"	1/2"
HQC® Quick-Change Collets (max. capacities)	A2-4, 5C	n/a
Round-Smooth & serrated	1 1/16"	n/a
Hex-Smooth	7/8"	n/a
Square-Smooth	3/4"	n/a
Sub-Spindle Parts Ejector	N/A	Yes
Sure-Grip® Expanding Collet System (capacity)		
Collet-Style	1/8" to 3.015"	n/a
Master Expanding Collets - emergency pads	1/4" to 3"	n/a
Step Chucks & Closers		
Regular-Depth Emergency (max. dia./depth)	2" to 6" / 1/2"	n/a
Extra-Depth Emergency (max. dia./depth)	2" to 6" / 1 1/4"	n/a
Regular-Depth Hardened & Ground (max. dia./depth)	2" to 6" / 1/2"	n/a
Extra-Depth Hardened & Ground (max. dia./depth)	2" to 6" / 1 1/4"	n/a
Force-Limiting Step Chuck	on application	n/a
Dead-Length Control - Emergency Style *		
Collet style (max. diameter bore)	55/64"	n/a
Thru-hole Collet (max. round capacity)	3/4"	n/a
Step Chuck (max. diameter bore)	2"	n/a
Sure-Grip® 3-Jaw Power Chuck (diameter)	4"	n/a
Hydraulic Shape Compliant Chuck	on application	n/a
Headstock Centers	YES	n/a
Fixtures		
Collet-Style	3 3/8" and 4 3/8"	n/a

* also available hardened and ground

Take your collet-ready lathe to the limit with flexible workholding options...



Hardinge is unique as a machine tool builder — we manufacture our own workholding products! Precision and accuracy is yours when you use Hardinge perfectly-mated workholding products...

Collets

Hardinge hardened and ground collets are inspected and measured in a Hardinge Super-Precision® spindle. Collets are available in fractional round, hex and square sizes, round metric, as well as round serrated fractional and metric sizes. Use adjustable, machinable collet stops for accurate part positioning.



Emergency Collets

Emergency collets have a soft face with a pilot hole for customer drilling, boring and stepping out to the exact size required. An optional extended nose permits deeper counterbores when required, and tool clearance for extended work.

HQC® Quick-Change Collet Systems

The spindle mount assembly incorporates interchangeable quick-change heads. Collets have a working range of $\pm 1/64$ " (.396mm), making them ideal for bar work. True parallel gripping affords high feed rates and spindle speeds.



Sure-Grip® Expanding Collet Systems

The Hardinge Sure-Grip expanding collet provides high precision internal gripping solutions with true parallel gripping. Collet-style design is gripped in the spindle.



Master Expanding Collets are a lower-cost alternative to Sure-Grip Expanding Collet Systems and include a dead-length feature.

Step Chucks and Closers

Step Chucks and closers are used to accurately hold larger diameter parts.



Force-Limiting Step Chuck

The Hardinge force-limiting step chuck has built-in force control to safely grip thin-wall parts. Maintain inside and outside concentricity in a fail-safe process while eliminating the nuisance of manually tweaking the draw bar.



Dead-Length® Systems

Maintain part length control by using Hardinge dead-length systems. Choose from dead-length collet assemblies, thru-hole collets and step chucks.



Shape-Compliant Chuck

Exclusive to Hardinge machines is the hydraulic shape-compliant chuck. It's the solution to high-accuracy roundness of thin-wall, thru-hardened parts. Multiple gripping locations grip the thin wall or out-of-round part. Independent travel distance for each gripping location eliminates distortion.



3-Jaw Power Chucks

Hardinge power chucks are lever operated, counter-centrifugal and dynamically balanced. Quick-change chucks are also available.



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