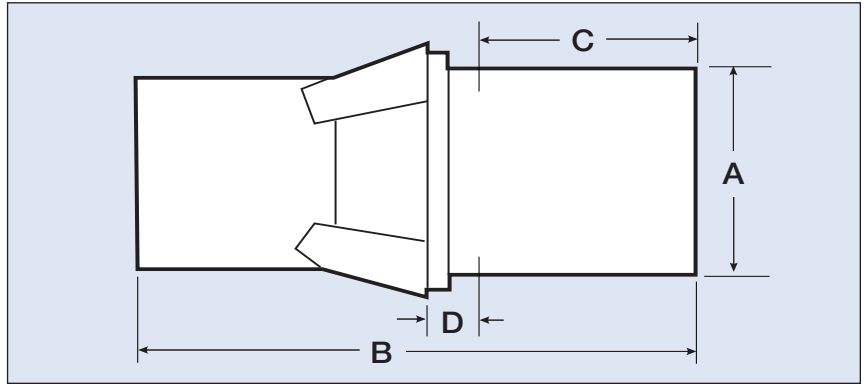


Crawford B42 and B60 Expanding Mandrel I.D. Collets



Expanding Mandrel I.D. Collets

The only I.D. collet body on the market which works on both Controlled length and pull type collet chucks simply by replacing an O.D. Collet with an I.D. Collet!

These Expanding Mandrel Collets are high quality B42 and B60 expanding collets and other special sizes with diameter capacities of .375" to 6" and expandable lengths from .375" to 3". They are designed for use with standard air collet or hydraulic cylinders or other collet fixtures. Expanding collets hold on the inside diameters or inside dimensions of workpieces.

The expanding collet provides an expanding member to locate and hold work from the inside, using your present B42 and B60 equipment - lathes, milling machines, grinders, fixtures, etc. with no extra attachments. Accuracy within .0005 is not unusual on concentricity and the expanding collet enables you to hold close shoulder tolerances.

- ⊕ Requires no special adapters
- ⊕ Rigid one piece body construction
- ⊕ Actuated by machine draw tube or collet fixture
- ⊕ Available from .375" to 6" diameter
- ⊕ Available from .375" to 3" expandable length
- ⊕ Available in dead length designs
- ⊕ Special expanding collet configurations available
- ⊕ Internal collet chucking
- ⊕ Economical and accurate

How are the Expanding Collets used?

The taper on the collet, once seated, on dead length collets there will be no variation of work part length if i.d. varies. The expanding collet may be removed and replaced in a machine without affecting its accuracy as with any standard collet. The expanding collet can operate with the spindle moving.

Expanding collets may be transferred to any machine using standard B42 and B60 collets. Therefore, it may be switched from machine to machine for use in turning, grinding, machining, drilling, milling, etc., saving valuable time.

B42 Push Type Expanding Mandrel Collets

Part No.	Size• A	Length B	Width C	Gage Length
B42P375	.375"-.499" (9.5 - 12.7mm)	5.093 (129.3mm)	.375" (9.5mm)	.468 (11.9mm)
B42P500	.500"-.624" (12.8 - 15.8mm)	5.218 (132.5mm)	.500" (12.7mm)	.468 (11.9mm)
B42P625	.625"-.749" (15.9 - 19mm)	5.343 (135.7mm)	.625" (15.9mm)	.468 (11.9mm)
B42P750	.750"-.874" (19.1 - 22.2mm)	5.468 (138.9mm)	.750" (19.1mm)	.468 (11.9mm)
B42P875	.875"-.999" (22.2 - 25.3mm)	5.875 (149.2mm)	.750" (19.1mm)	.468 (11.9mm)
B42P1000	1.000"-1.124" (25.4 - 28.5mm)	6.000 (152.4mm)	1.000" (25.4mm)	.468 (11.9mm)
B42P1125	1.125"-1.374" (28.6 - 34.8mm)	5.968 (151.6mm)	1.250" (31.7mm)	.468 (11.9mm)
B42P1375	1.375"-1.499" (34.9 - 38mm)	6.093 (154.7mm)	1.375" (34.9mm)	.468 (11.9mm)
B42P1500	1.500"-2.000" (38.1 - 50.8mm)	6.218 (157.9mm)	1.500" (38.1mm)	.468 (11.9mm)

B60 Push Type Expanding Mandrel Collets

Part No.	Size• A	Length B	Width C	Gage Length
B60P375	.375"-.499" (9.5 - 12.7mm)	5.093 (129.3mm)	.375" (9.5mm)	.468 (11.9mm)
B60P500	.500"-.624" (12.8 - 15.8mm)	5.218 (132.5mm)	.500" (12.7mm)	.468 (11.9mm)
B60P625	.625"-.749" (15.9 - 19mm)	5.343 (135.7mm)	.625" (15.9mm)	.468 (11.9mm)
B60P750	.750"-.874" (19.1 - 22.2mm)	5.468 (138.9mm)	.750" (19.1mm)	.468 (11.9mm)
B60P875	.875"-.999" (22.2 - 25.3mm)	5.875 (149.2mm)	.750" (19.1mm)	.468 (11.9mm)
B60P1000	1.000"-1.124" (25.4 - 28.5mm)	6.000 (152.4mm)	1.000" (25.4mm)	.468 (11.9mm)
B60P1125	1.125"-1.374" (28.6 - 34.8mm)	5.968 (151.6mm)	1.250" (31.7mm)	.468 (11.9mm)
B60P1375	1.375"-1.499" (34.9 - 38mm)	6.093 (154.7mm)	1.375" (34.9mm)	.468 (11.9mm)
B60P1500	1.500"-1.999" (38.1 - 50.7mm)	6.218 (157.9mm)	1.500" (38.1mm)	.468 (11.9mm)
B60P2000	2.000"-2.875" (50.8 - 73mm)	6.718 (170.6mm)	2.000" (50.8mm)	.468 (11.9mm)

*The size listed is a range for holding diameter. An exact size $\pm .001$ " must be selected within the chosen range. The collet will be to that exact size. Each collet has a total expansion .020" maximum.