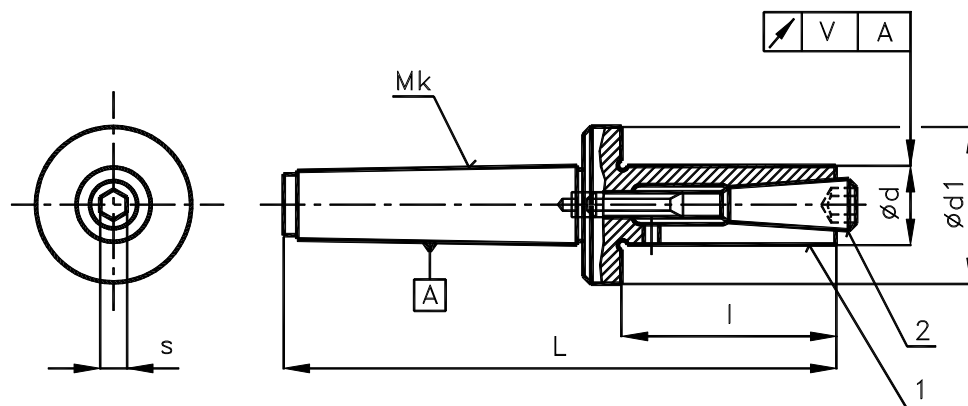


EXPANDING MANDRELS
ČSN 24 3375


The expanding mandrels are intended for the clamping of rotating workpieces on lathes and grinding machines. Workpieces with bore within the tolerance H6, H7, H8 and if the bore length is max. 1.5-multiple of the diameter of bore d . The workpiece is clamped by the expansion of flexible expansion section of the mandrel (1) by the expansion bolt (2). The mandrels are produced of tool steel No.19452 hardened to HRC 41-45. The expansion bolts are made of steel with tapers hardened to HRC 49-52. The mandrel is provided with the MORSE taper shank, ČSN 220420. (DIN 228) without the clamping thread. In a special version, also expanding mandrels of other diameters d and lengths l are available at the option of the customer.

$\varnothing d$	Mk	$\varnothing d1$	l	L	s	V	G
12	3	28	30	125	5	0.011	0.27
13							0.28
14							0.29
15		32	40	135	6		0.31
16							0.32
17							0.33
18		34	50	145	8		0.39
19							0.4
20							0.42
21		38	60	155	10		0.44
22	0.48						
23	0.5						
24	42	70	190	14	0.52		
25					0.55		
26					0.56		
27	4	46	80	200	0.013	0.56	
28						0.97	
29						1	
30		1.02					
31		1.06					
32		1.08					
33		1.15					
34		1.18					
35		1.23					
36		1.26					
38	1.32						
40	1.45						
42	1.58						
44	1.67						
45	1.73						

Dimensions in mm.

Legend:
 Mk ... MORSE taper
 V tolerance of run-out
 G weight of mandrel

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∅ d	Mk	∅ d1	l	L	s	V	G
46	5	64	100	248	17	0.016	2.68
48							2.71
50							2.82
52		68	110	258	22	0.019	2.95
55							3.35
56		73					
58	3.57						

Dimensions in mm.

Legend:

Mk ... MORSE taper

V tolerance of run-out

G weight of mandrel [kg]