

Expanding Mandrels

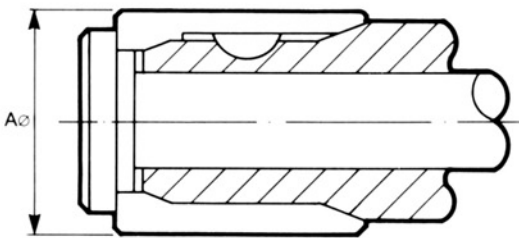
Standard length sleeve specifications



These sleeves are fully interchangeable i.e. any model 200 mandrel will accept any model 200 or 201 sleeve and provide the original accuracy.

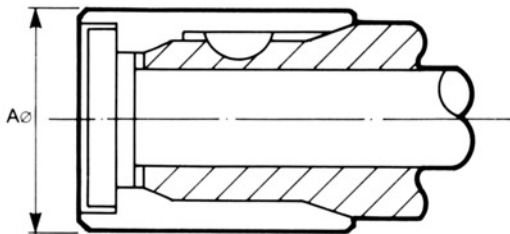
x.x.xxx = Sleeve Dia in mm
 i.e. 123.26mm = 1.2.326
 i.e. 30mm = 0.30.00

Standard Type Sleeve



Model	A		Length	Tool Nr
	Min	Max		
000	.500 12,5	.625 16,0	.875 22,0	000.92.2.x.x.xxx
050	.625 16,0	.875 22,0	1.063 27,0	050.92.2.x.x.xxx
100	.875 22,0	1.125 28,5	1.250 32,0	100.92.2.x.x.xxx
150	1.125 28,5	1.625 41,0	1.50 38,0	150.92.2.x.x.xxx
200	1.625 41,0	2.50 63,5	1.688 43,0	200.92.2.x.x.xxx
250	2.50 63,5	3.00 76,0	2.00 51,0	250.92.2.x.x.xxx
300	3.00 76,0	3.50 89,0	2.25 57,0	300.92.2.x.x.xxx
*350	3.50 89,0	5.125 130,0	2.50 63,5	350.92.2.x.x.xxx
*400	5.125 130,0	7.00 178,0	3.125 80,5	400.92.2.x.x.xxx

Flush Type Sleeve



Model	A		Length	Tool Nr
	Min	Max		
001	.656 16,5	.875 22,0	1.344 26,0	001.92.2.x.x.xxx
051	.875 22,0	1.125 28,5	1.25 32,0	051.92.2.x.x.xxx
101	1.125 28,5	1.563 40,0	1.469 38,0	101.92.2.x.x.xxx
151	1.563 40,0	2.00 51,0	1.75 45,0	151.92.2.x.x.xxx
201	2.00 51,0	2.875 73,0	1.969 50,0	201.92.2.x.x.xxx
251	2.875 73,0	3.50 89,0	2.344 60,0	251.92.2.x.x.xxx
301	3.50 89,0	4.00 102,0	2.719 69,0	301.92.2.x.x.xxx
*351	4.00 101,0	5.625 143,0	3.094 78,5	351.92.2.x.x.xxx
*401	5.625 143,0	7.00 178,0	3.906 99,5	401.92.2.x.x.xxx

*These items will be stocked as turned blanks only, and will therefore require an extended delivery.

The sleeves can be bonded to protect against the ingress of swarf onto the location angles, therefore prolonging sleeve life.

Tool Number with 92, refers to non bonded sleeve

Tool Number with 93, refers to bonded sleeve

Recommended expanding positions

Model	Expansion	Model	Expansion
000	0,13mm (.005")	200	0,26mm (.010")
050	0,13mm (.005")	250	0,26mm (.010")
100	0,13mm (.005")	300	0,26mm (.010")
150	0,13mm (.005")	350	0,39mm (.015")
		400	0,39mm (.015")

Order Example

- 1 Off Model 200 Face Plate Mandrel Drawbar operated Tool No. 2.200.90.1.
- 1 Off Model 200. Sleeve to grip 50,25mm. No Bond. Tool No. 200.92.2.050.25
- 1 Off Model 201. Sleeve to grip 60,25mm. Bonded Tool. No. 201.93.2.060.25