

## Operating Manual Centering Clamping Mandrels EH 23340

### [Centering Clamping Mandrels - EH 23340.](#)

Centering clamping mandrels are used for centering and clamping components with a locating bore. They are often used in mechanical engineering, but can be used in all industries due to their simple operation and quick assembly. The high accuracy depends on the machining process used. Very easy machining due to turning/milling process.

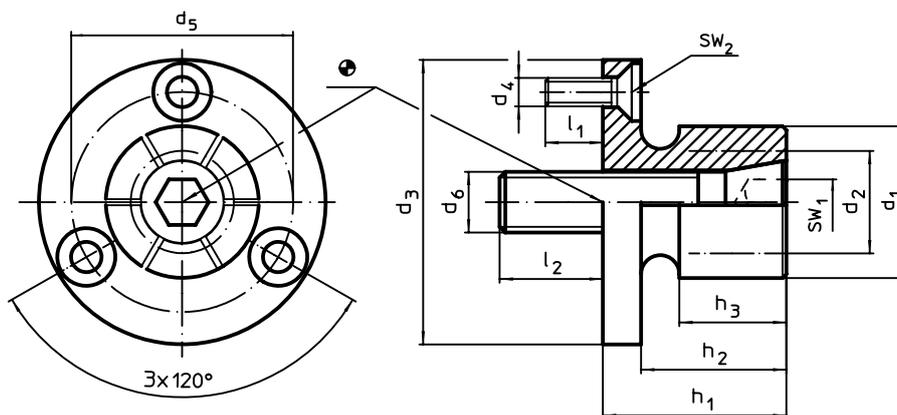
- Ideal for secondary operations on turned parts
- Clamping body very easy to machine
- Hardened and coated screw for long service life
- Can be actuated via hexagon socket or hydraulically/pneumatically

The centering clamping mandrels are available in two different versions, each with different basic bodies.

### Centering clamping mandrel with operation from above

The shell diameter  $d_1$  must be adapted to the bore diameter of the desired workpiece. To do this, the diameter must be expanded to approx. 0.1 mm and the screw fixed with the nut supplied. For the larger versions from  $\varnothing 77$  mm, locking rings are included to ensure that the individual segments remain rigid.

For this purpose, the rings supplied must be inserted and a tightening torque of approx. 55 Nm applied via the clamping screw so that the outer diameter has spread to approx. 0.1 mm. The centering clamping mandrel can be fastened at 3 points using the countersunk screws also supplied.



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### Centering clamping mandrels with lateral operation

This centering clamping mandrel is suitable for workpieces with a blind hole. The sheath diameter can be expanded by means of the hexagon socket on the side. Locking rings are also included with this version. Maximum tightening torque is 13 Nm.

The 6 holes allow the mandrel to be mounted on the fixture or other location. Like our standard centering clamping mandrels, the side operation version has the dead length feature which is critical for tight tolerance dimensions.

**Note:** We do not recommend you make a large infeed during machining.

