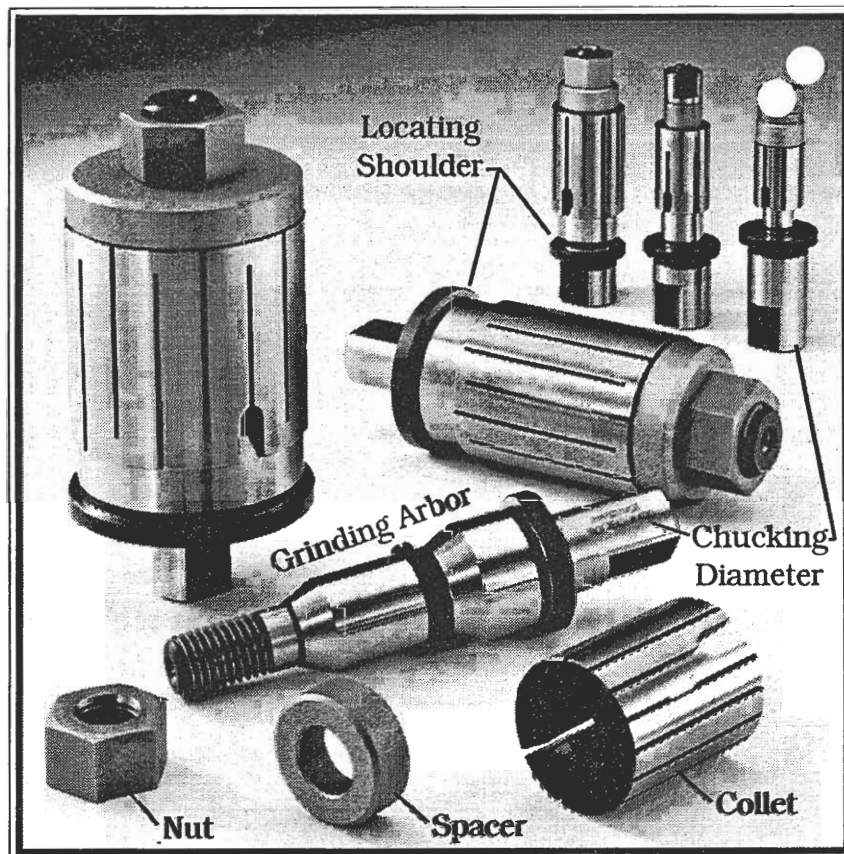


# B82A

## INSTRUCTIONS AND PARTS LIST

### Hardinge® Sure-Grip® Center Arbor



#### **The Hardinge Sure-Grip Center Arbor for Grinding and Turning.**

The arbor assembly is designed to be used on grinders and lathes. The arbor can be held between centers, or chucked on one end and supported by a center on the other end. This style expansion arbor assembly is manually adjusted.

#### **Range**

The arbors come in five sizes and will handle a range from .500" to 4" (12.70mm to 101.60mm). Nominal size Sure-Grip expanding collets are available from stock.

#### **Interchangeable Collets**

The Hardinge Sure-Grip Expanding Collet Systems use the same collets for the Grinding – Turning Arbor as they do for the spindle-mounted and collet-style assemblies. This allows you to use one set of collets for both your grinder and lathe applications.

#### **Locating Shoulder**

The arbors have a precision locating shoulder and diameter so you can fabricate custom workpiece stops.

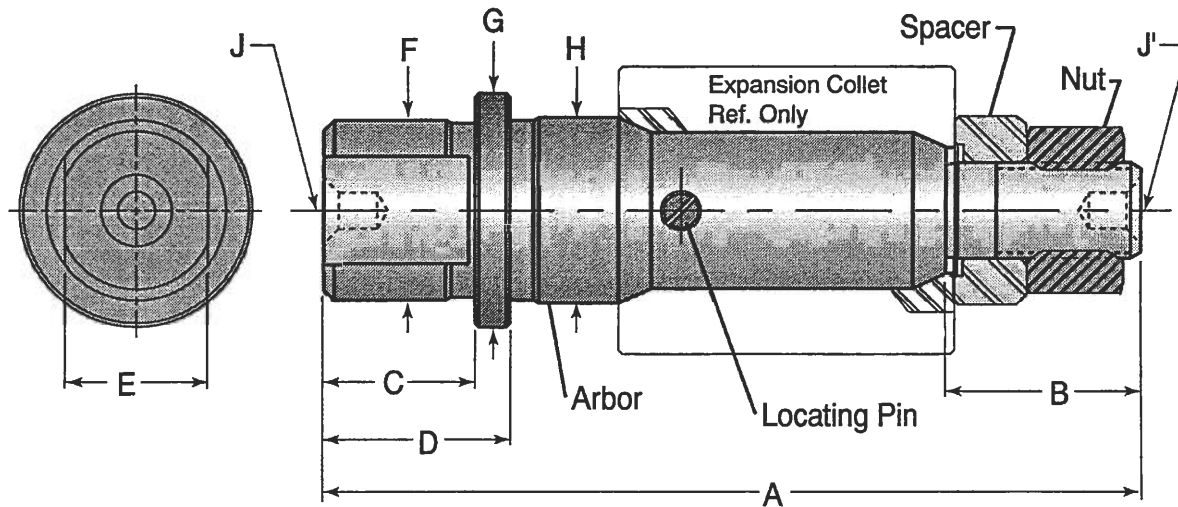
#### **Maximize Your Productivity**

Use two arbors. While one part is running, load the next part on the second arbor. You can then be ready to load another arbor into the spindle when the first part is done. This is a big time saver when chucking one end of the arbor in a collet.

#### **Mounting Collet to Arbor**

Clean locating surfaces of arbor and ID of expansion collet. Coat surfaces with anti-seize grease. Mount collet aligning with key. Assemble spacer and nut. Mount workpiece (locate against work stop when used), tighten nut with sufficient force to hold workpiece while being machined.

**NOTE:** See reverse for Dimensions, Range and Part Numbers



Model	A	B	C	D	E	F	G	H	J/J'
#200	4.250*(107.95)	1.01*(25.65)	1.688*(42.87)	1.875*(47.62)	.750*(19.05)	.937*(23.79)	1.220*(30.98)	.489*(12.42)	#5Rad/#4Rad
#250	4.250*(107.95)	1.01*(25.65)	1.150*(29.20)	1.340*(30.03)	.750*(19.05)	.937*(23.79)	1.220*(30.98)	.681*(17.29)	#5Rad/#4Rad
#300	4.250*(107.95)	1.01*(25.65)	.782*(19.86)	.969*(24.61)	.750*(19.05)	.937*(23.79)	1.220*(30.98)	.969*(24.62)	#5Rad/#5Rad
#400	6.500*(165.10)	1.54*(39.11)	1.625*(41.27)	1.875*(47.62)	.750*(19.05)	1.000*(25.40)	1.718*(46.63)	1.467*(37.26)	#5Rad/#5Rad
#500	6.500*(165.10)	1.54*(39.11)	1.250*(31.75)	1.500*(38.10)	.750*(19.05)	1.000*(25.40)	2.312*(58.72)	2.062*(52.37)	#5Rad/#5Rad
#600	6.500*(165.10)	1.54*(39.11)	1.250*(31.75)	1.500*(38.10)	.750*(19.05)	1.000*(25.40)	3.124*(79.34)	2.874*(72.99)	#5Rad/#5Rad

NOTE: Millimeters in parentheses.

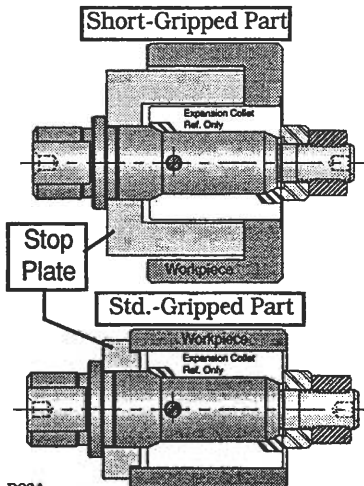
### Sure-Grip Grinding Arbor Parts List — Part Numbers

Description:	#200	#250	#300	#400	#500	#600
Complete Assembly	2231-00-00-000200	2231-00-00-000250	2231-00-00-000300	2231-00-00-000400	2231-00-00-000500	2231-00-00-000600
Arbor Nut	2237-00-00-000200	2237-00-00-000250	2237-00-00-000300	2237-00-00-000400	2237-00-00-500600	2237-00-00-500600
Arbor Spacer	2235-00-00-000200	2235-00-00-000250	2235-00-00-000300	2235-00-00-000400	2235-00-00-000500	2235-00-00-000600
Grinding Arbor	2233-00-00-000200	2233-00-00-000250	2233-00-00-000300	2233-00-00-000400	2233-00-00-000500	2233-00-00-000600
Locating Pin	7869-00-00-100200	7869-00-00-100200	7869-00-00-000300	7869-00-00-000400	7869-00-00-000400	7869-00-00-000400

### Expanding Collet Capacities

Arbor Style	Gripping Range	Arbor Overall Length ("A")	Collet Length
#200	.500" to .750" (12.70 to 19.05)	4.25" (107.95)	1.000" (25.40)
#250	.750" to 1.000" (19.05 to 25.40)	4.25" (107.95)	1.375" (34.92)
#300	1.000" to 1.500" (25.40 to 38.10)	4.25" (107.95)	1.750" (44.45)
#400	1.500" to 2.250" (38.10 to 57.15)	6.50" (165.10)	2.182" (55.42)
#500	2.250" to 3.000" (57.15 to 76.20)	6.50" (165.10)	2.781" (70.63)
#600	3.000" to 4.000" (76.20 to 101.60)	6.50" (165.10)	2.781" (70.63)

NOTE: Millimeters in parentheses.



### Work Stop

A customer fabricated work stop should be used to eliminate length control problems when grinding or turning faces. Counter bore and end clearance is required to make certain that the collet can expand and move adequately to grip the workpiece.

NOTE: When the full length of the collet grips the bore of the part, the I.D. of the workstop is bored to 1/64" (.3968mm) above the maximum part I.D. To reduce gripping problems, when holding on less than the full length of the collet (short gripping), the ID of the work stop should be no more than .002" to .003" (.0508mm to .0762mm) above the maximum bore diameter being gripped by the collet.

To Place an Order or for Information:

USA: 800-843-8801,  
 Canada: 800-468-5946  
 All others: 607-734-2281  
 Fax: USA 607-734-3886  
 Int'l 607-734-1701  
 Internet: [www.hardinge.com](http://www.hardinge.com)



**Hardinge Inc.**  
 One Hardinge Drive  
 PO Box 1507  
 Elmira, NY 14902-1507