



Finish Turning Procedure:

With actuation screws loose, measure the body diameter at all actuation areas over the working length of the mandrel in this RELAXED condition. (Actuation areas can be seen through slits)

Tighten the set screws until you measure .002"-.003" expansion at each actuation area, of the mandrel.

Turn your required diameter to size at the low limit of the work piece diameter tolerance (your MMC).

This method will give you clearance, to mount, and dismount your work piece.

Your set up will determine the precision of total run out. The standard Xpandrel is designed to readily obtain a minimum of 0.001 TIR

*** **CAUTION** ***

Do not over tighten the Xpandrel without a work piece on the mandrel. This could damage the mandrel beyond repair.

Call us at 800-660-6680 ext101 with any questions.