



OPTOFORM COLLETS

Optoform collets are **common** to all Optoform machines (Models 30,40,50 and 80).

Optoform collets come in two distinct design types:

- (a) **Standard** collets.
- (b) **Deadstop** collets.

Standard collets are of a conventional taper design operated by a drawbar.

Deadstop collets are also of a conventional taper design, but have a separate backstop referenced directly on to the spindle shaft. This backstop design is used where a consistent part thickness is required, where the part diameter cannot be guaranteed, as small fluctuations in the diameter of the part will affect the position of the part relative to the spindle on standard collets.

A small range of collet designs are **commonly used** and are normally available from Sterling International's inventory. These are listed in the table below.

Also listed is the **complete range** of additional collets, which have been designed, drawn and manufactured at some time. These can be **special ordered** as the drawings are already on file.

It is also possible to design new collets which are not included in the list below. These will be quoted upon request and will also include any fees for constructing the manufacturing drawings.

NOTE:

It should be noted that certain collet designs listed below which provide deep internal bores tend to have noses which protrude slightly beyond the face of the spindle (for example 12.70 x 15.9 x 6.35). Only collet designs which do not protrude beyond the spindle nose can be used with the **LVDT Tool Set Station**. (The LVDT Tool Set Station is held partially in the collet when

mounted on the machine for tool set up and calibration.) Therefore when using extended bore collet designs it is necessary to set up with a regular non-protruding collet and then change collets to use the extended bore design. This change takes about 30 seconds and does not compromise the set up in anyway whatsoever.

OPTOFORM COLLETS (normally ex-stock)

<u>Sterling Part No.</u>	<u>Type of collet</u>	<u>Size (mm)</u>
		(Step Dia. X Depth x Secondary Dia.)
4893-001-2	Dead Stop	12.70 x 1.6 x 6.95
4893-001-3	Standard	12.70 x 1.6 x 6.95
4893-001-5	Dead Stop	12.70 x 10.0 x 6.95
4893-001-9	Standard	12.70 x 10.0 x 6.95
4893-001-13	Standard	12.70 x 15.9 x 6.95

Special Order Collets - Must be Quoted on a Case by Case Basis

<u>Sterling Part No.</u>	<u>Type of collet</u>	<u>Size (mm)</u>
		(Step Dia. X Depth x Secondary Dia.)
4893-001-1	Dead Stop	10.00 x 1.6 x 6.35
4893-001-2	Dead Stop	12.70 x 1.6 x 6.35
4893-001-3	Standard	12.70 x 1.6 x 6.35
4893-001-4	Dead Stop	12.51 x 1.6 x 6.35
4893-001-5	Dead Stop	12.70 x 10.0 x 6.35
4893-001-6	Dead Stop	12.03 x 10.0 x 6.35
4893-001-7	Dead Stop	10.40 x 1.6 x 6.35
4893-001-8	Dead Stop	9.30 x 10.0 x 6.35
4893-001-9	Standard	12.70 x 10.0 x 6.35
4893-001-10	Standard	12.03 x 10.0 x 6.35
4893-001-11	Standard	10.40 x 10.0 x 6.35
4893-001-12	Standard	9.30 x 10.0 x 6.35
4893-001-13	Standard	12.70 x 15.9 x 6.35
4893-001-14	Standard	7.94 x 13.3 x 6.35
4893-001-15	Dead Stop	9.40 x 10.0 x 6.35
4893-001-16	Dead Stop	12.30 x 10.0 x 6.35
4893-001-17	Dead Stop	6.00 x 16.0 x n/a
4893-001-18	Shipping Dummy	n/a
4893-001-19	Standard	12.00 x 15.9 x 6.35
4893-001-20	Standard	14.00 x 15.9 x 6.35

4893-001-21	Standard	12.70 x 19.05 x 6.35
4893-001-22	Standard	12.30 x 19.05 x 6.35
4893-001-23	Dead Stop	9.66 x 10.0 x 6.35
4893-001-24	SPECIAL	7.94 x 6.6 x 6.35
4893-001-25	Standard	13.10 x 10.0 x 6.35
4893-001-26	Standard	6.00 x 16.0 x 4.35
4893-001-27	Standard	8.00 x 16.0 x 6.35
4893-001-28	Standard	13.00 x 9.0 x 6.35
4893-001-29	Standard	15.00 x 16.0 x 6.35
4893-001-30	Standard	16.00 x 16.0 x 6.35
4893-001-31	Dead Stop	13.00 x 10.0 x 6.35
4893-001-32	Standard	7.62 x 16.0 x 6.35
4893-001-33	Standard	10.00 x 15.0 x 6.35
4893-001-34	Standard	10.50 x 10.0 x 6.35
4893-001-35	Standard	11.05 x 15.0 x 6.35
4893-001-36	Standard	11.40 x 15.0 x 6.35
4893-001-37	Standard	12.66 x 15.0 x 6.35
4893-001-38	Standard	9.00 x 10.0 x 6.35
4893-001-39	Standard	11.00 x 10.0 x 6.35
4893-001-40	Dead Stop	14.50 x 10.0 x 6.35
4893-001-41	Standard	15.00 x 10.0 x 6.35
4893-001-42	Dead Stop	10.07 x 8.9/9.0 x 6.35
4893-001-43	Dead Stop	11.08 x 9.9/10.0 x 6.35