Directions for using the Xpandrel

Directions:

1. Slide work piece onto mandrel.
2. Tighten one actuator until part will not rotate on mandrel.
3. Tighten opposite actuator the equal amount.
4. The mandrel now needs to be tightened so that it can finish expanding to meet the work piece's entire bore surface.

Setting the torque value:

The torque value of an Xpandrel is subjective.
Every mandrel has different properties such as material, cross section, actuator placement, engagement length, and part bore tolerance.

It is very similar to clamping any part in a work vise, where feel is required to hold the part secure enough to perform the task without hurting the work piece.

In this case, the mandrel will move until contact is made with the bore, and any further torque will only stretch the mechanism.

We suggest you measure the torque value after securing the work piece, and then let that value be used as a guide.

Most machinists get used to the feel very quickly as the mandrel contacts the bore. From there they just add a little more pressure to set.

As with any workholding device, machining properties such as depth of cut, feed and speed may need to be adjusted appropriately.

Please call us at 800-660-6680 ext 101if you need assistance.

*** ***CAUTION*** ***

DO NOT OVER TIGHTEN THE XPANDREL
WITHOUT A WORK PIECE IN PLACE.
THIS COULD DAMAGE THE MANDREL BEYOND REPAIR.