

Manually Operated Expanding Mandrel Actuator



Load the KEM-MA manual actuator into a three jaw or collet chuck, gripping on the 38mm location spigot.



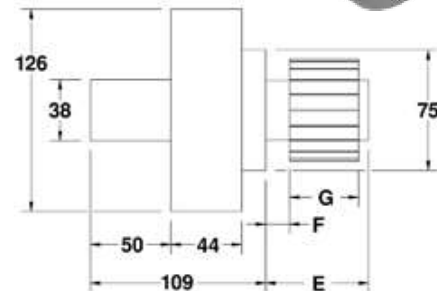
Actuate the power chuck to ensure KEM-MA is locked in position, adjust T.I.R as required.



Load a workpiece's internal diameter over the sleeve and actuate the mandrel using the key provided.



This cutaway image shows the unit's heavy-duty precision gear train. The mechanical advantage of the gears in combination with our unique double-angle expanding sleeves produces outstanding grip force on the workpiece.



- KEM Series includes a manually-operated expanding mandrel actuator (called the KEM-MA) incorporating a precision-ground 38mm diameter location spigot that enables the unit to be held in any collet or jaw chuck, reducing setup times by eliminating the need to change the machine's three jaw chuck or collet chuck.
- These models utilise the same precision mandrels, expanding sleeves and locators as our CNC Expanding Mandrels see previous pages.
- Side-actuated with an included square-drive key means that this unit can accommodate parts with blind bores as well as those with thru-holes.
- Precision-ground for high accuracy in squareness and concentricity. If higher accuracy is needed the mandrel can be clocked-in once the unit is gripped in a chuck.
- Universal location spigot mount enables this ID workholding system to be easily moved from machine to machine as jobs require.
- A great option for low/medium-volume production. For high-production environments, use the Expanding Mandrels featured on the previous pages is recommended.
- When ordering, be sure to also order the appropriate threaded expanding rod adapter.

MANUALLY OPERATED EXPANDING MANDREL ACTUATOR

Description	Part Number
Manually Operated Expanding Mandrel Actuator	KEM-MA
Expanding Rod Adaptor – Fits Model KEM-AS	KEM-AS-ERA
Expanding Rod Adaptor – Fits Model KEM-BS	KEM-BS-ERA
Expanding Rod Adaptor – Fits Model KEM-CS	KEM-CS-ERA
Expanding Rod Adaptor – Fits Model KEM-DS	KEM-DS-ERA
Expanding Rod Adaptor – Fits Model KEM-ES	KEM-ES-ERA