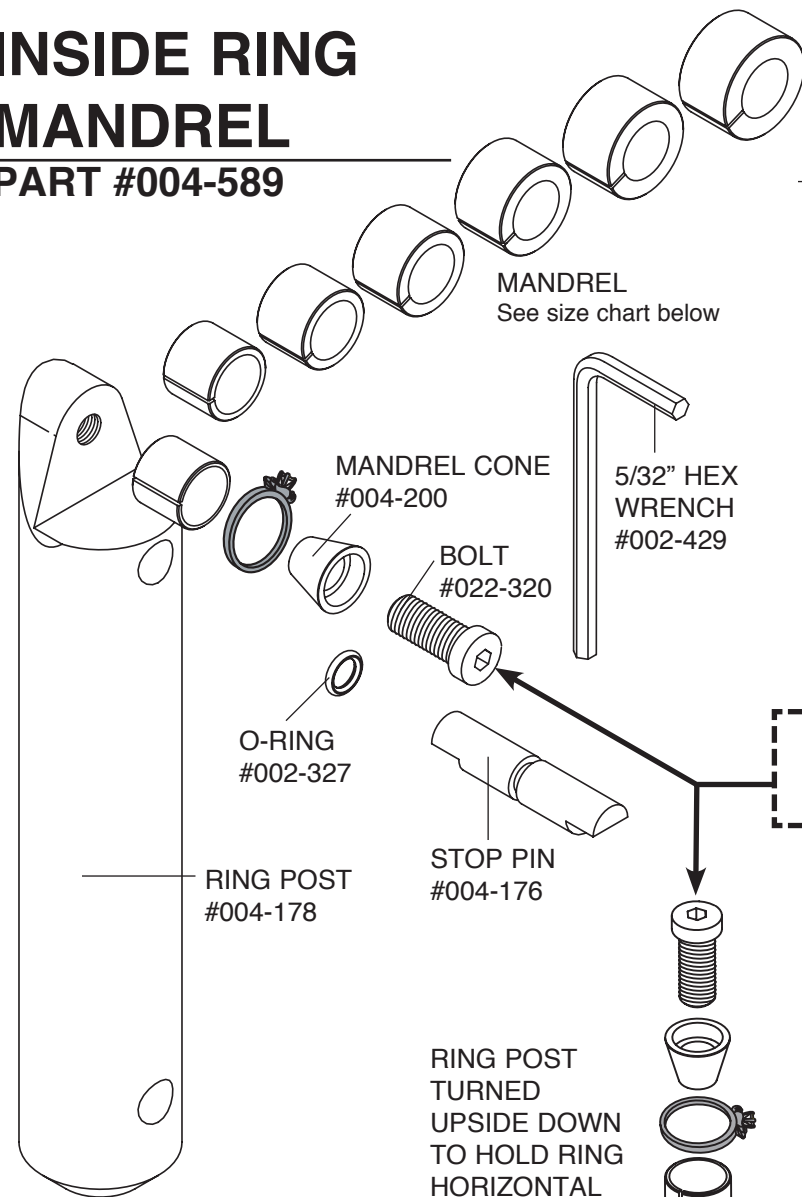


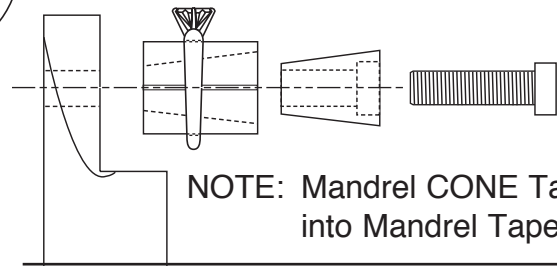
# INSIDE RING MANDREL

PART #004-589



MANDREL	
Select the mandrel which is slightly smaller than the inside ring diameter.	
004-170	.575"
004-171	.625"
004-172	.675"
004-173	.725"
004-174	.775"
004-216	.825"
004-217	.875"

SEE OTHER SIDE FOR  
DOUBLING MANDRELS FOR  
LARGE / WIDE RINGS



## INSTRUCTIONS:

### To hold a ring VERTICAL

Insert the bolt through the mandrel cone and place cone into the tapered end of the mandrel you have selected. (See Illustration above) Position ring on the selected mandrel. Turn the bolt into the Ring Post with the supplied wrench until the ring is snug.

**DO NOT OVER TIGHTEN** - Damage may occur to the ring being held.

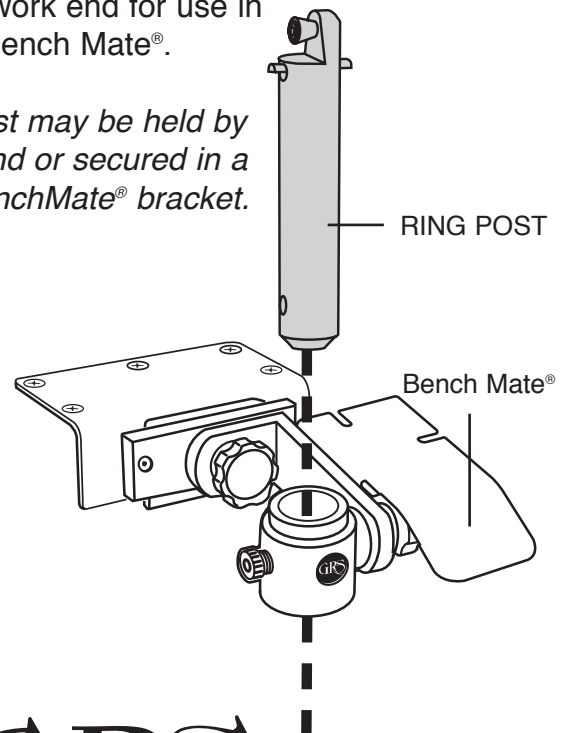
### To hold a ring HORIZONTAL

Turn the Ring Post upside down and use the threaded hole on the bottom to secure the mandrel and cone assembly. Place Stop Pin into the side hole located closest to work end for use in a Bench Mate®.

*Post may be held by hand or secured in a BenchMate® bracket.*

RING POST  
TURNED  
UPSIDE DOWN  
TO HOLD RING  
HORIZONTAL

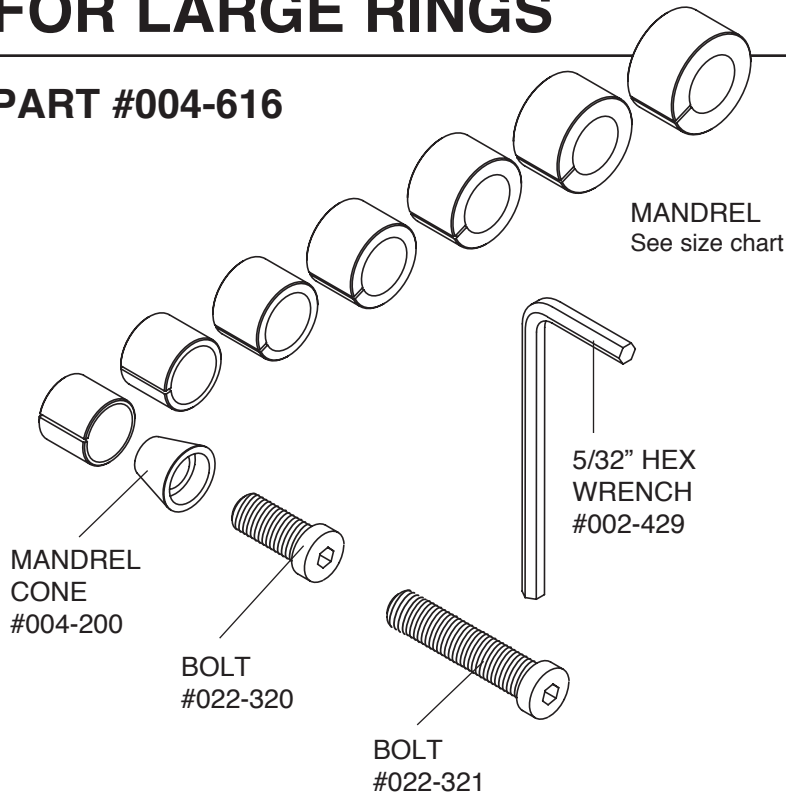
Move  
STOP PIN  
to hole  
closest to  
work.



# EXTRA SET OF MANDRELS FOR LARGE RINGS



**PART #004-616**

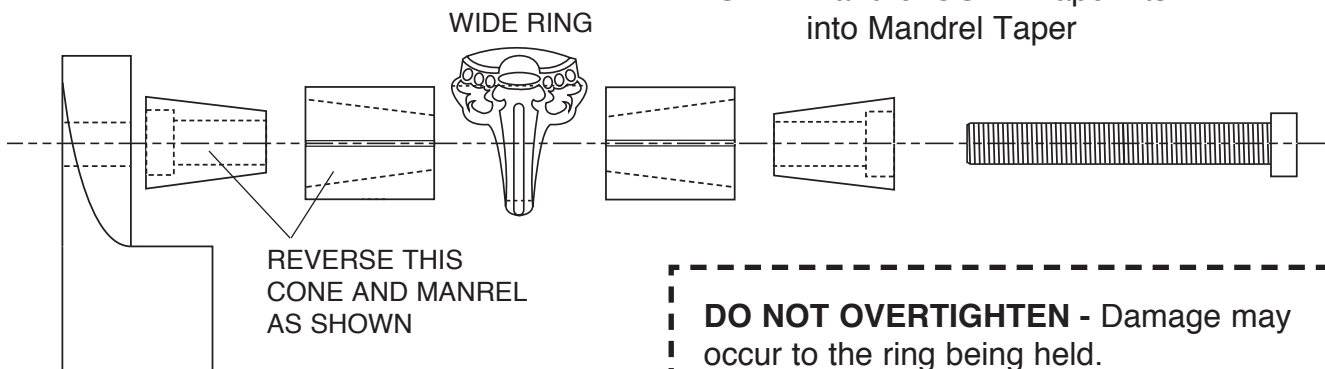


## MANDREL

Select the mandrel which is slightly smaller than the inside ring diameter.

- 004-170 .575"
- 004-171 .625"
- 004-172 .675"
- 004-173 .725"
- 004-174 .775"
- 004-216 .825"
- 004-217 .875"

NOTE: Mandrel CONE Taper fits into Mandrel Taper



## INSTRUCTIONS:

### To hold a ring VERTICAL

To hold large / wide rings use TWO of the SAME SIZE mandrels and TWO mandrel cones. Insert the long bolt through the first mandrel cone and place cone into the tapered end of the mandrel you have selected. Then reverse the second mandrel and place on bolt. Slide the second cone into that mandrel so that the taper angles match. (See Illustration above) Position ring on the selected mandrel. Tighten the socket head screw into the Ring Post with the supplied wrench until the ring is snug.

### To hold a ring HORIZONTAL

Turn the Ring Post upside down and use the threaded hole on the bottom to secure the mandrel and cone assembly. Switch the Stop Pin to the side hole that is closest to the work for use in a BenchMate®.

*SEE OTHER SIDE FOR  
MORE INFORMATION*