**INSIDE RING MANDREL**

**PART #004-589**

**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.

**NOTE:** Mandrel CONE Taper fits into Mandrel Taper

**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.

**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**

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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