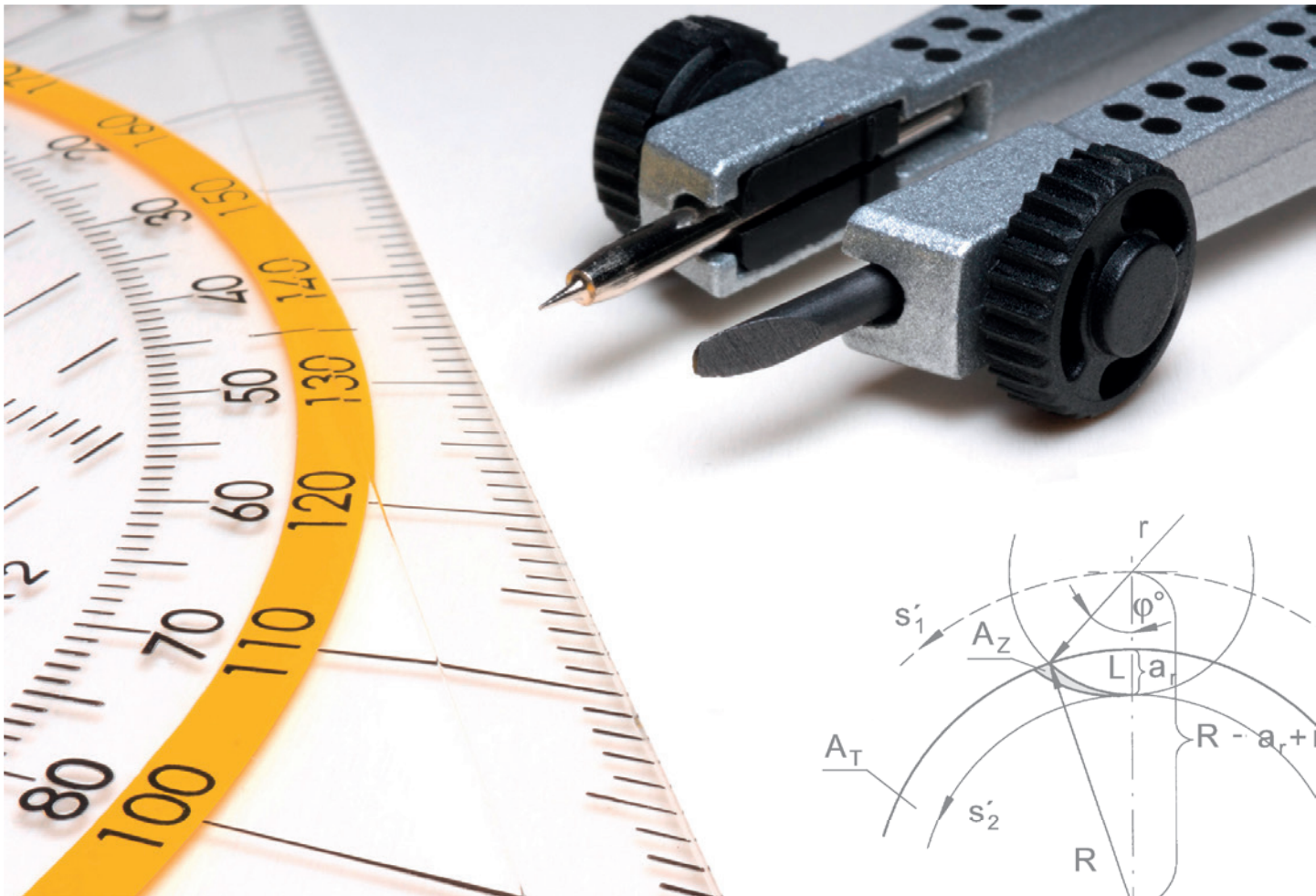




Seite/Page

Modulares Stechsystem 220
Modular grooving system 220

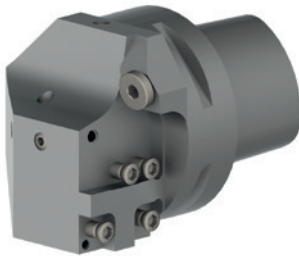
2

Grundhalter und Stechhaltestücke
Basic Toolholder and grooving toolholder

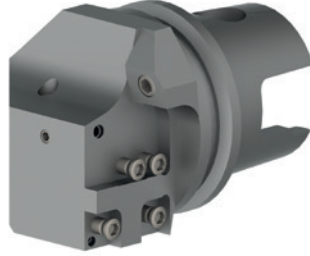
5

Grundhalter mit Schnittstelle 220

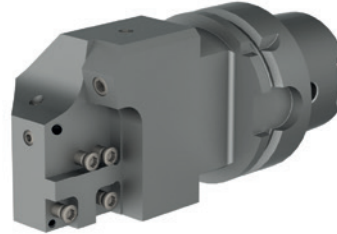
Basic holder with interface 220



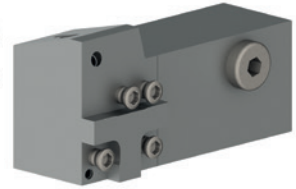
Polygon



TS



HSK
HSKT



Klemmhalter
Toolholder

Kassetten mit Schnittstelle 220

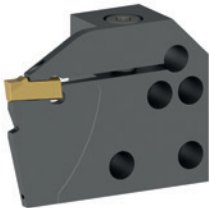
Cassettes with interface 220

Einstecken radial
Grooving radial

Schneidplatte
Insert

Einstecken axial
Grooving axial

Schneidplatte
Insert



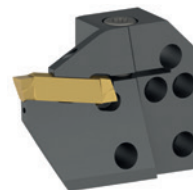
S100



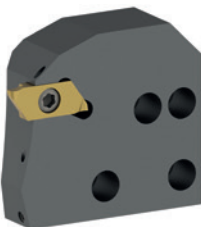
**S15A
S25A**



**S224
S229**



**S224
S229**



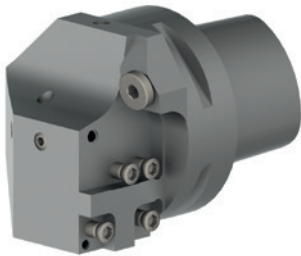
S274



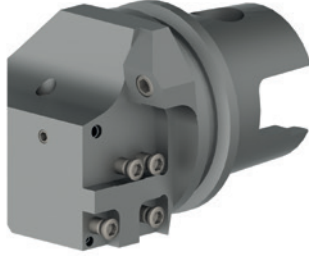
S34T

Grundhalter mit Schnittstelle 220

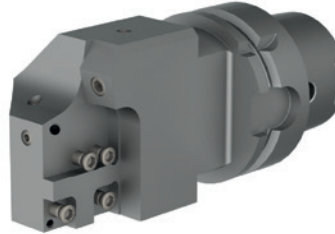
Basic holder with interface 220



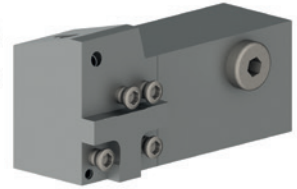
Polygon



TS



HSK
HSKT



Klemmhalter
Toolholder

Kassetten mit Schnittstelle 220

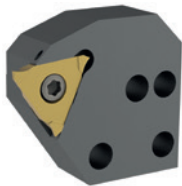
Cassettes with interface 220

Einstechen radial
Grooving radial

Schneidplatte
Insert



312



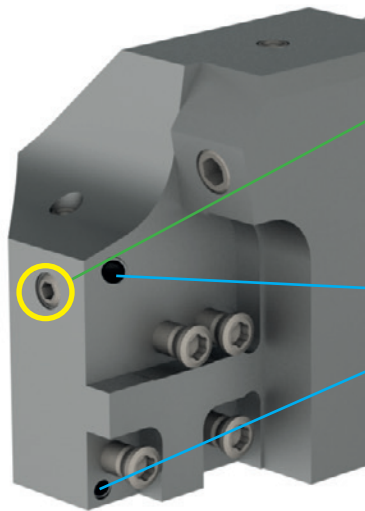
315
S315



64T

Grundhalter mit Schnittstelle 220

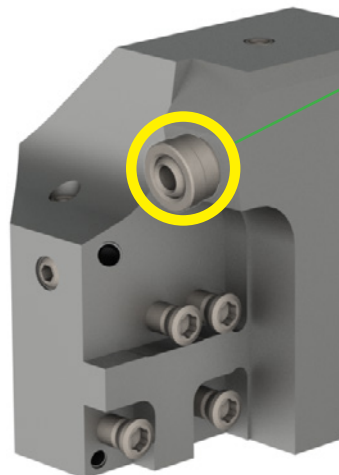
Basic holder with interface 220



Verschluss der oberen Kühlmittelübergabe
an die Kassette durch Zylinderschraube

Closure of the upper coolant supply
to the cassette by cylinder head screw

Kühlmittelzufuhr
Coolant supply

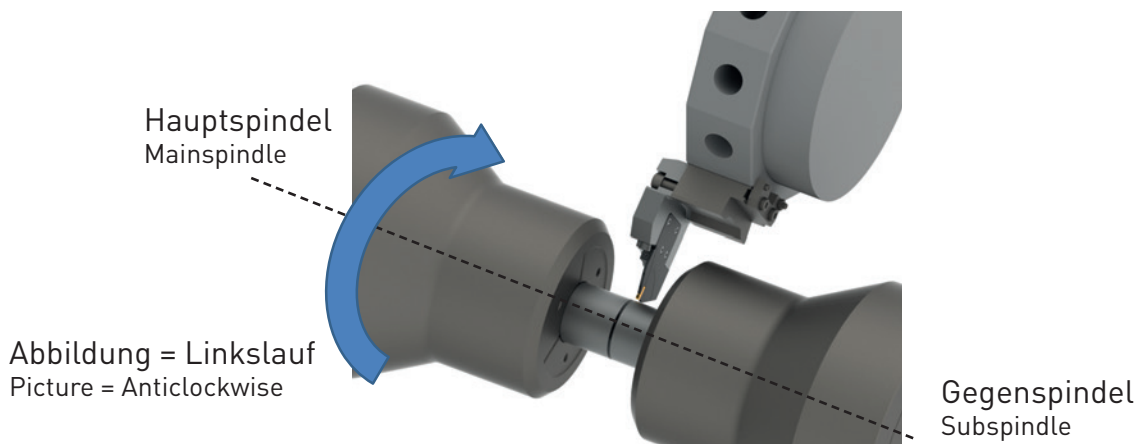


Einsatz von Kassetten ohne innere Kühlmittel-
zufuhr unter Verwendung der Kugelspritzdüse

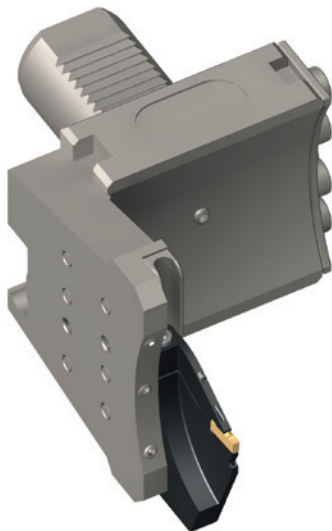
Verschluss der oberen Kühlmittelübergabe
an die Kassette durch Zylinderschraube

Use of cassettes without internal coolant supply using
the coolant spray nozzle

Closure of the upper coolant supply
to the cassette by cylinder head screw



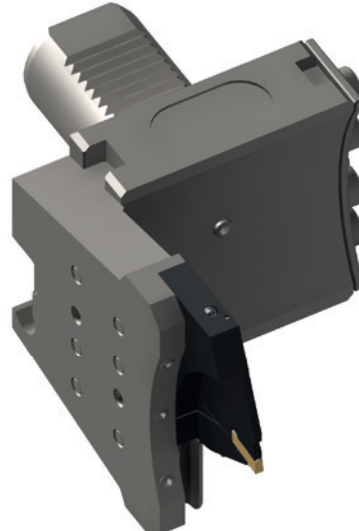
Abstechen an der Gegenspindel im
Linkslauf
Parting off on the subspindle in
anti-clockwise rotation



Stechhaltestück
Grooving toolholder
960.I.0.845...

Kassette
Cassette
RNK100.0845...

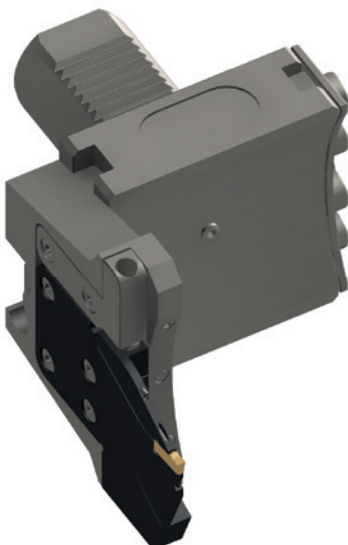
Abstechen an der Gegenspindel im
Rechtslauf
Parting off on the subspindle in
clockwise rotation



Stechhaltestück
Grooving toolholder
960.I.0.845...

Kassette
Cassette
LNK100.0845...

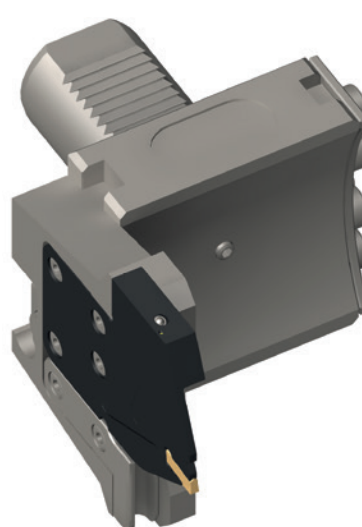
Abstechen an der Hauptspindel im
Linkslauf
Parting off on the main spindle in
anti-clockwise rotation



Stechhaltestück
Grooving toolholder
960.A.0.845...

Kassette
Cassette
LNK100.0845...

Abstechen an der Hauptspindel im
Rechtslauf
Parting off on the main spindle in
clockwise rotation



Stechhaltestück
Grooving toolholder
960.A.0.845...

Kassette
Cassette
RNK100.0845...

Grundhalter Basic toolholder	
BMT-Größe festlegen Select size BMT	BMT40
Auswahl Grundhalter Select basis toolholder	960.BMT40.C0.00101
Maß notieren Notice dimension	$l_2 = 9 \text{ mm}$
Stechhalterstück Grooving toolholder	
Außenliegende Kassette External cassette	960.A....
Innenliegende Kassette (höhere Bauform) Internal cassette (higher construction)	960.I....
Auswahl Stechhalterstück Select grooving toolholder	960.I.0.845.0003.IK
Ermittlung der Referenzlänge, Maß notieren Determining the reference length, Notice dimension	
Grundhalter 960.BMT40... ($l_2 = 9 \text{ mm}$) Stechhalterstück 960.I...0003 ($l_2 = 80,5 \text{ mm}$) Basic toolholder 960.BMT40... Grooving toolholder 960.I...0003	$l_g = l_2 9 + l_2 80,5 \text{ mm} = 89,5 \text{ mm}$ $f = 66,8 \text{ mm}$
Kassette Cassette	
Vorgaben Dimensions	Stangen-Ø 65 mm, Breite 3 mm bar diameter 65 mm, width 3 mm
Auswahl Kassette Select cassette	LNK100.0845.34.4.73.IK
Maß notieren Notice dimension	$l_k = 46 \text{ mm}$

Berechnung Gesamthöhe Halter Calculation of total height for toolholder	Werkzeugdaten Tool data	
$l_g 89,5 \text{ mm} + l_k 46 \text{ mm} = 135,5 \text{ mm}$	x	z
	$r = 135,5 \text{ mm}$ $\varnothing = 271,0 \text{ mm}$	$f = 66,8 \text{ mm}$

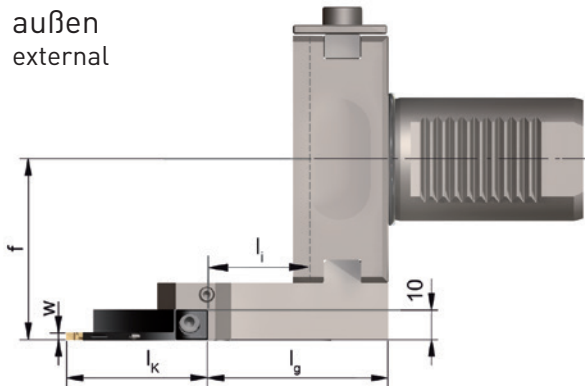
Berechnung Umlaufdurchmesser Spannmittel Calculation of swing diameter clamping device
$135,5 \text{ mm} - l_1 (27 \text{ mm}) = 108,5 \text{ mm}$ ergibt einen Umlaufdurchmesser von max. 217 mm $135,5 \text{ mm} - l_1 (27 \text{ mm}) = 108,5 \text{ mm}$ results in a maximum circular diameter of 217 mm

Ermittlung der Referenzlänge

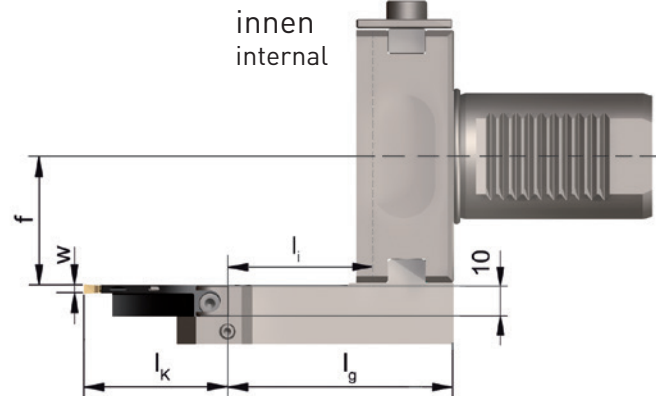
Determining the reference length



außen
external



innen
internal



$$\begin{array}{l} l_K \text{ (Kassettenmaß)} + l_g \text{ (} l_2 \text{ Stechhaltestück} + l_2 \text{ Grundhalter)} \\ l_K \text{ (Length of cassette)} + l_g \text{ (} l_2 \text{ Grooving toolholder} + l_2 \text{ Basic toolholder)} \end{array}$$

Abbildung VDI
Picture VDI

Grundlegende Hinweise

Bitte max. Schwenkkreis-Ø des Maschinenherstellers beachten.
Umlauf-Ø von Spannfutter zum Abstechhalter prüfen.

Basic Recommendations

Please note the max. swing circle Ø of the machine manufacturers.
Check rotation Ø of the chuck to the toolholder.

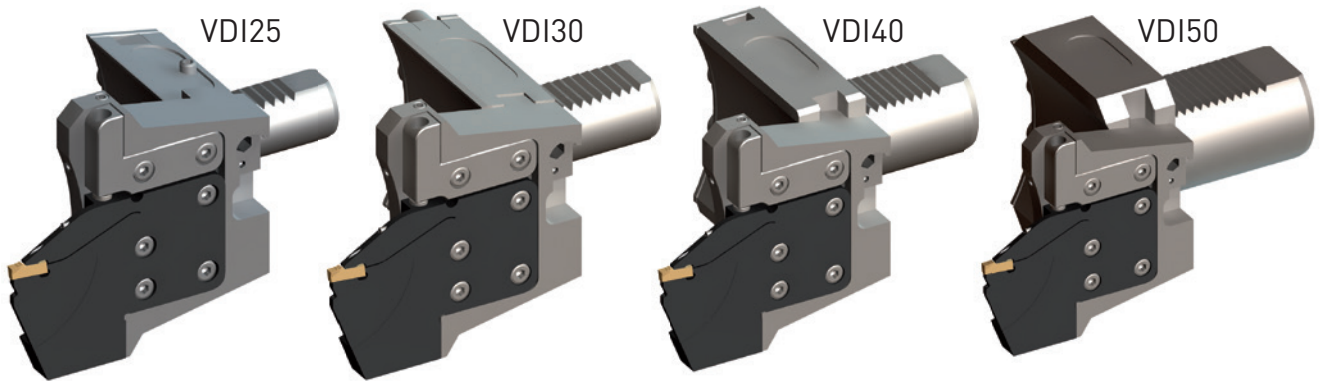
Übersicht 845 Kassetten + VDI Grundhalter

Overview of cassettes 845 + basic toolholder VDI



VDI-Halter für alle Größen - 1 Stechhaltestück für alle Größen

1 Grooving toolholder fits all basic VDI toolholders

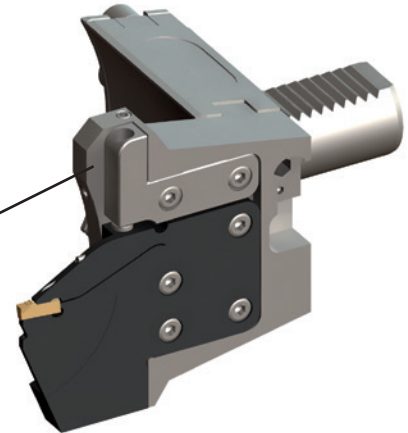
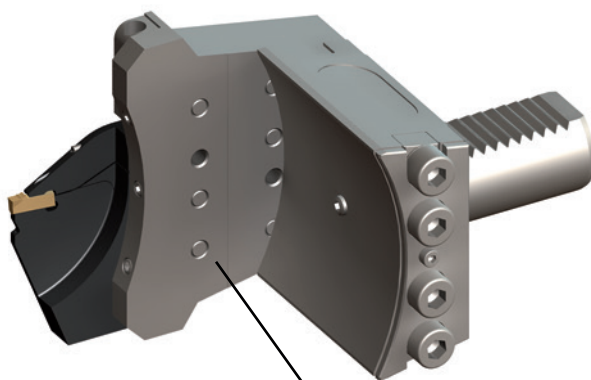


1 Grundhalter + 1 Stechhaltestück = 4 Möglichkeiten des Zusammenbaus

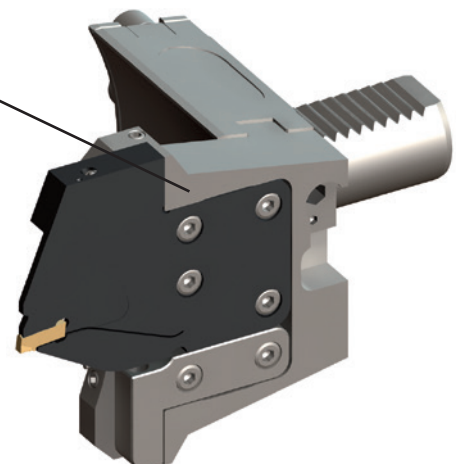
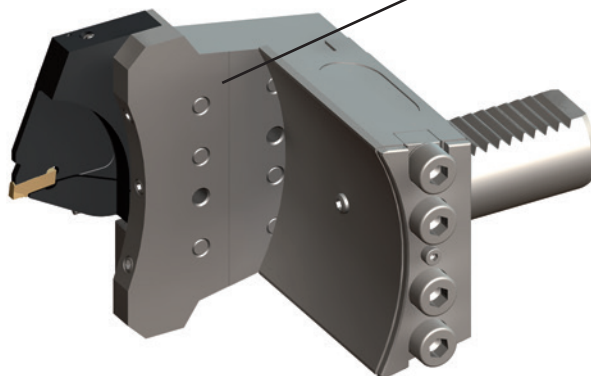
1 Basic toolholder + 1 Grooving toolholder = 4 possibilities of assembling

Links - Normallage
Left - normal position

Rechts - Normallage
Right - normal position



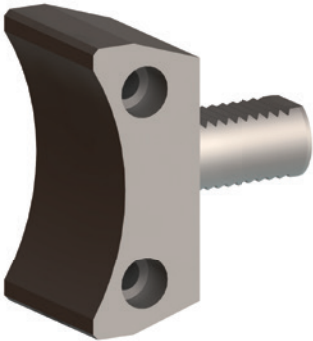
Identisches Stechhaltestück
Identical grooving toolholder



Links - Überkopf
Left - overhead position

Rechts - Überkopf
Right - overhead position

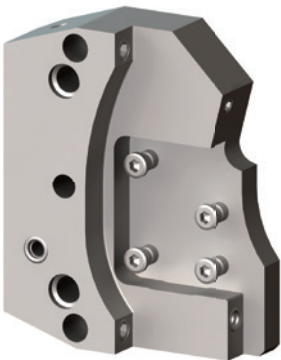
für Traub TNC 42/65
for Traub TNC 42/65



77...



R/L991.X842...R.IK



R/L991.X842...L.IK

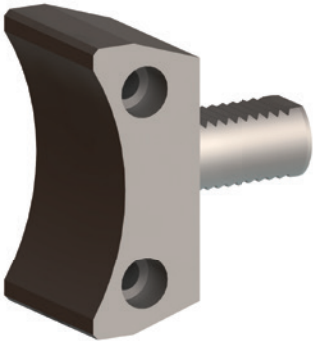


RNK...0842...



LNK...0842...

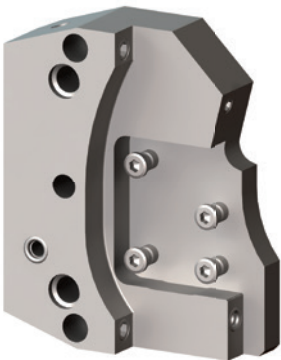
für Traub TNC 42/65
for Traub TNC 42/65



77...



R/L991.X842...R.IK



R/L991.X842...L.IK

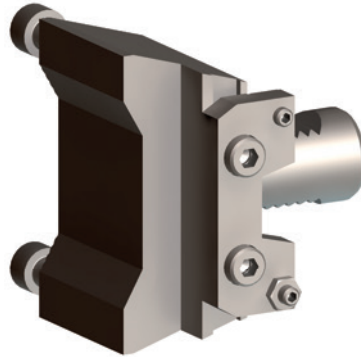


RNK...0842...

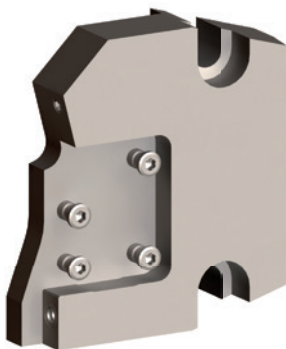


LNK...0842...

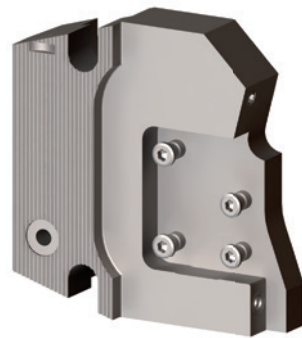
für Traub und Index
for Traub and Index



W13... / W14...



R/L990.X845...R.IK



R/L990.X845...L.IK

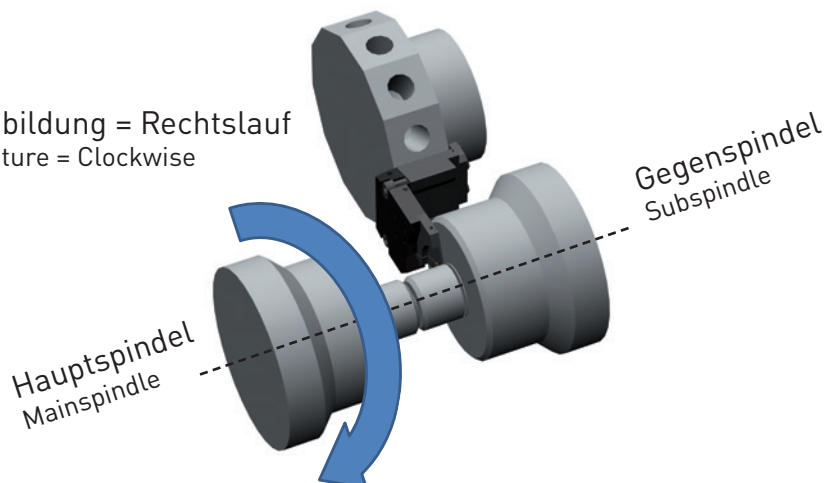


RNK100.0845...



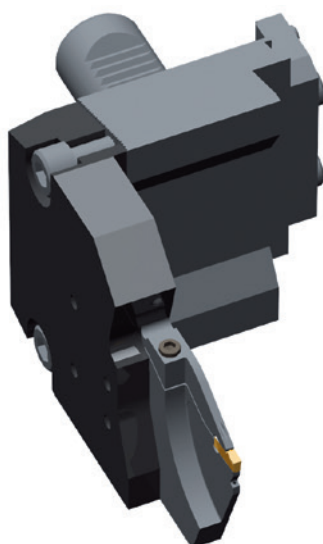
LNK100.0845..

Abbildung = Rechtslauf
Picture = Clockwise



Abstechen an der Gegenspindel im
Linkslauf

Parting off on the subspindle in
anti-clockwise rotation

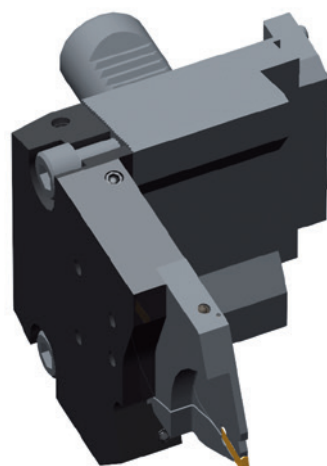


Stechhaltestück
Grooving toolholder
L990.X845...R.IK

Kassette
Cassette
RNK100.0845...

Abstechen an der Gegenspindel im
Rechtslauf

Parting off on the subspindle in
clockwise rotation

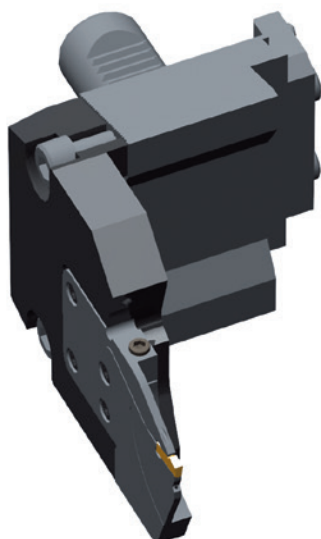


Stechhaltestück
Grooving toolholder
R990.X845...L.IK

Kassette
Cassette
LNK100.0845...

Abstechen an der Hauptspindel im
Linkslauf

Parting off on the mainspindle in
anti-clockwise rotation

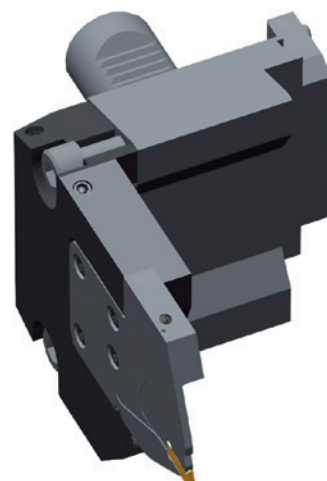


Stechhaltestück
Grooving toolholder
L990.X845...L.IK

Kassette
Cassette
LNK100.0845...

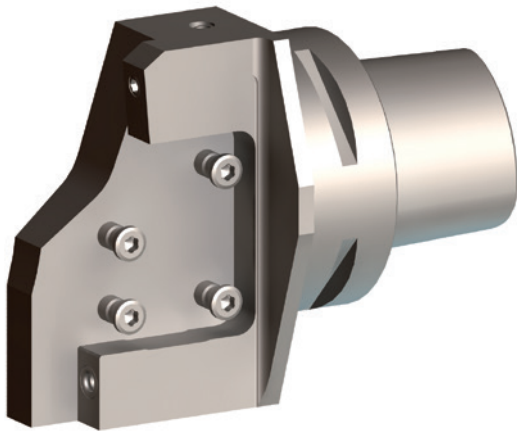
Abstechen an der Hauptspindel im
Rechtslauf

Parting off on the mainspindle in
clockwise rotation

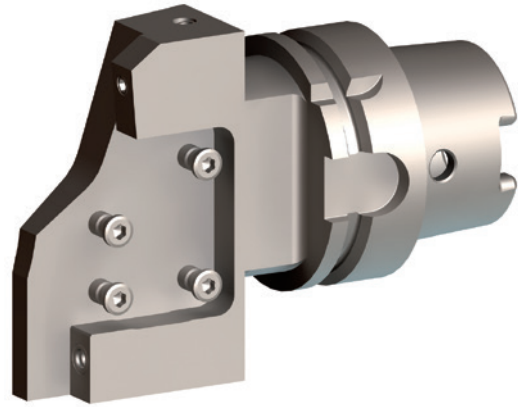


Stechhaltestück
Grooving toolholder
R990.X845...R.IK

Kassette
Cassette
RNK100.0845...



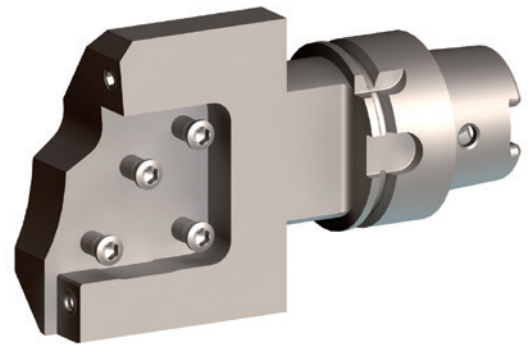
C3.../C5.../C6...



HSKT63...



L/RNK...0842...
L/RNK...0845...

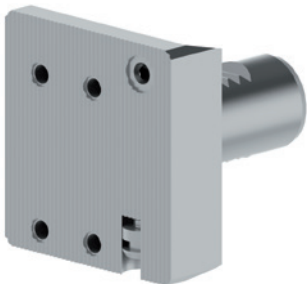


HSKT40...

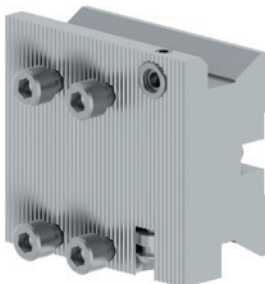


L/RNK100.0842...

INDEX



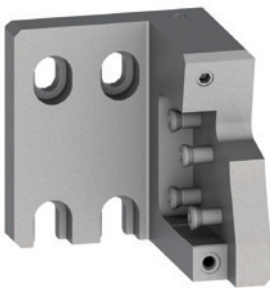
W1250031



W8900015



R/L940.X842...R.IK



R/L940.X842...L.IK

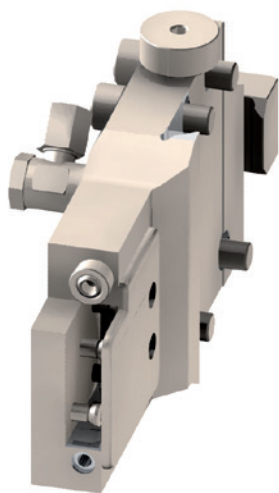


RNK100.0842...

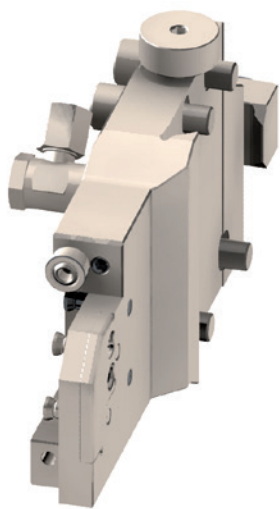


LNK100.0842...

INDEX



R968...



L968...



R/LNK100.0842...



R/LK842.SD...



R/LK842.SV...

INDEX

Mehrspindler
multi-spindle machine



MS52



MS32 - MS40



MS16 - MS22

INDEX

INDEX MS24-6

Verfahrwege X-NC 1.1 - 6.2

X-Weg = 62 mm

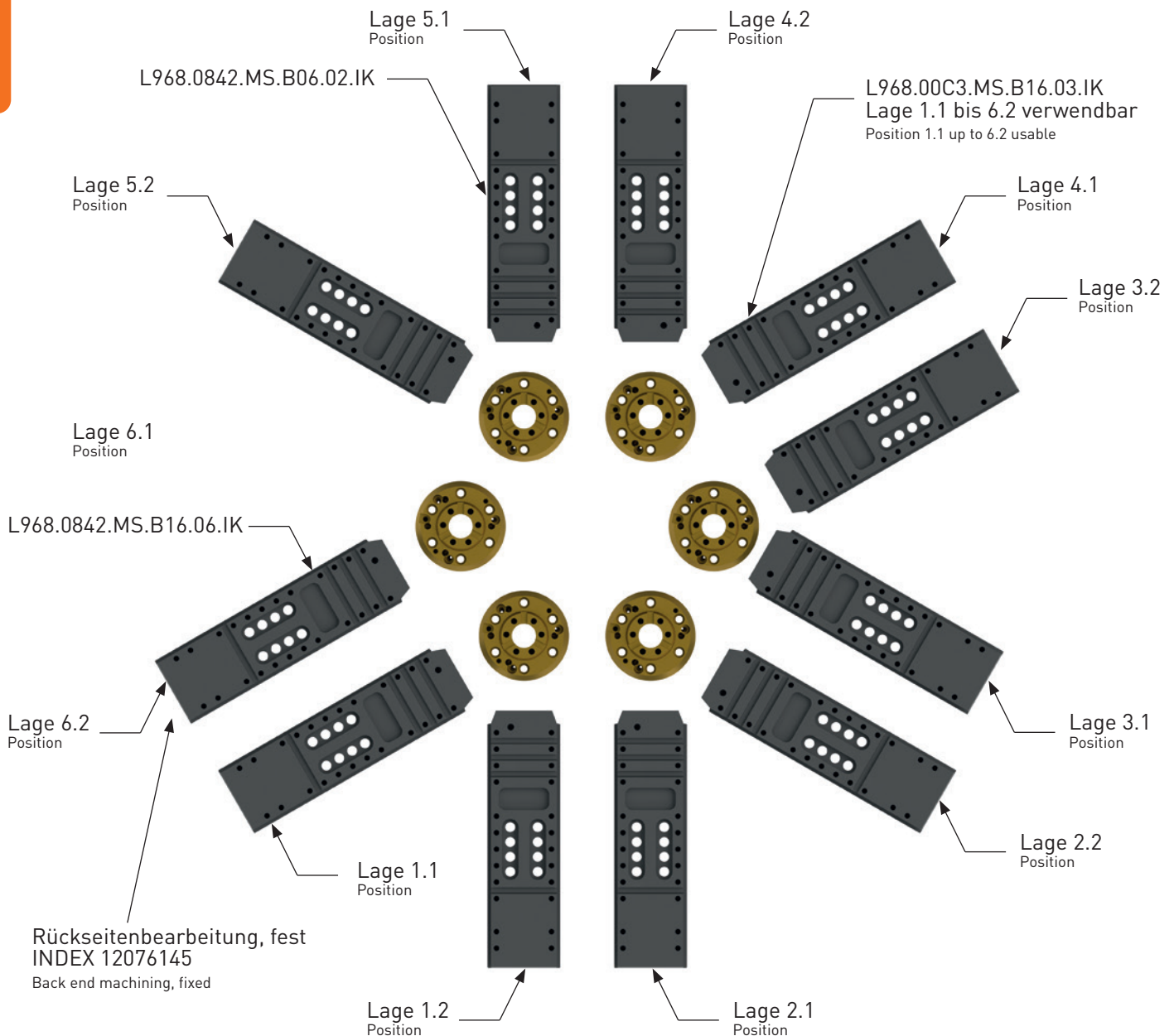
Z-Weg = 85 mm

Strokes X-NC 1.1 - 6.2

X-axis stroke = 62 mm

Z-axis stroke = 85 mm

D



INDEX

INDEX MS24-8

Verfahrwege X-NC 7-NC 1.1 - 8.2

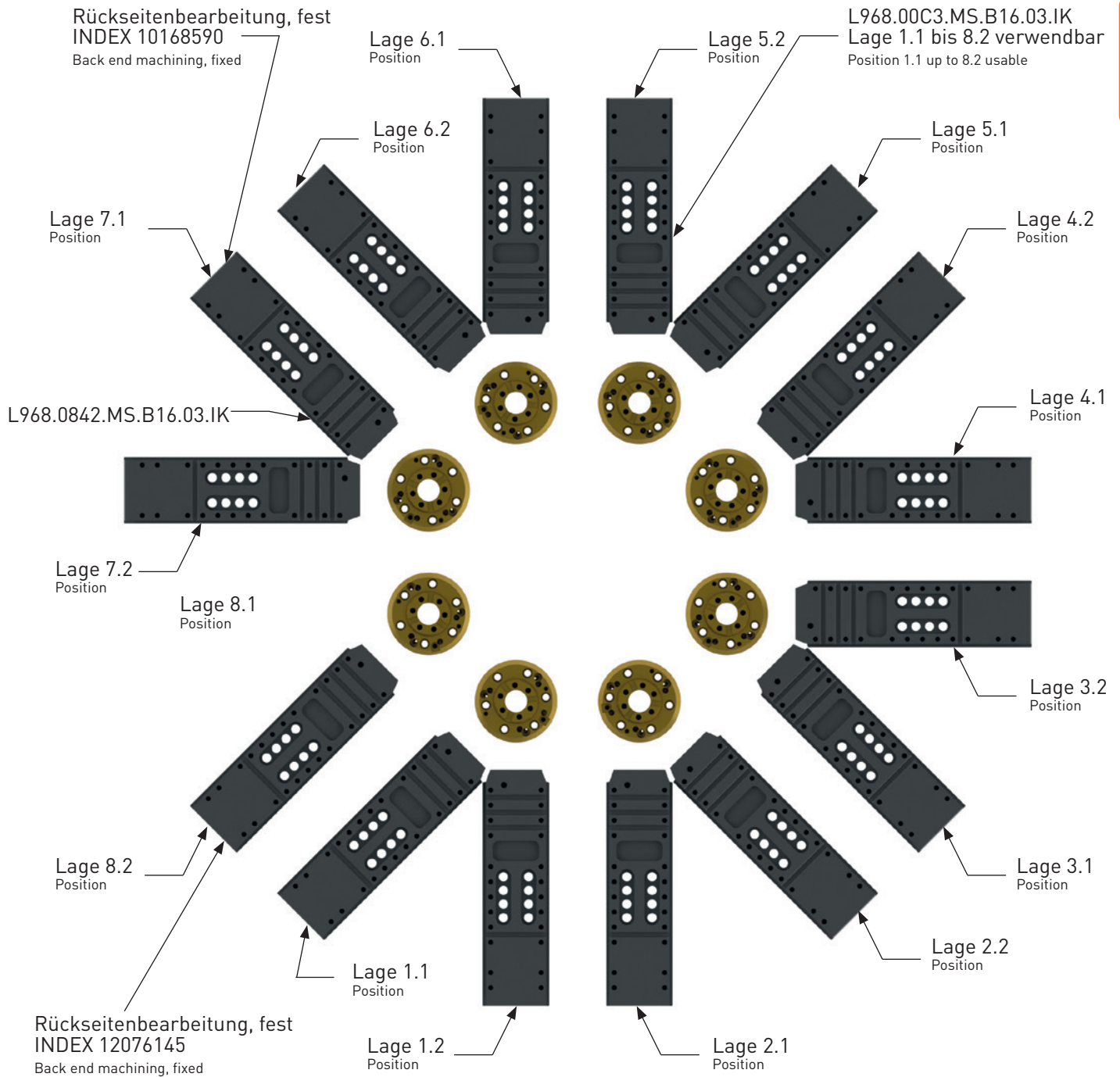
X-Weg = 62 mm

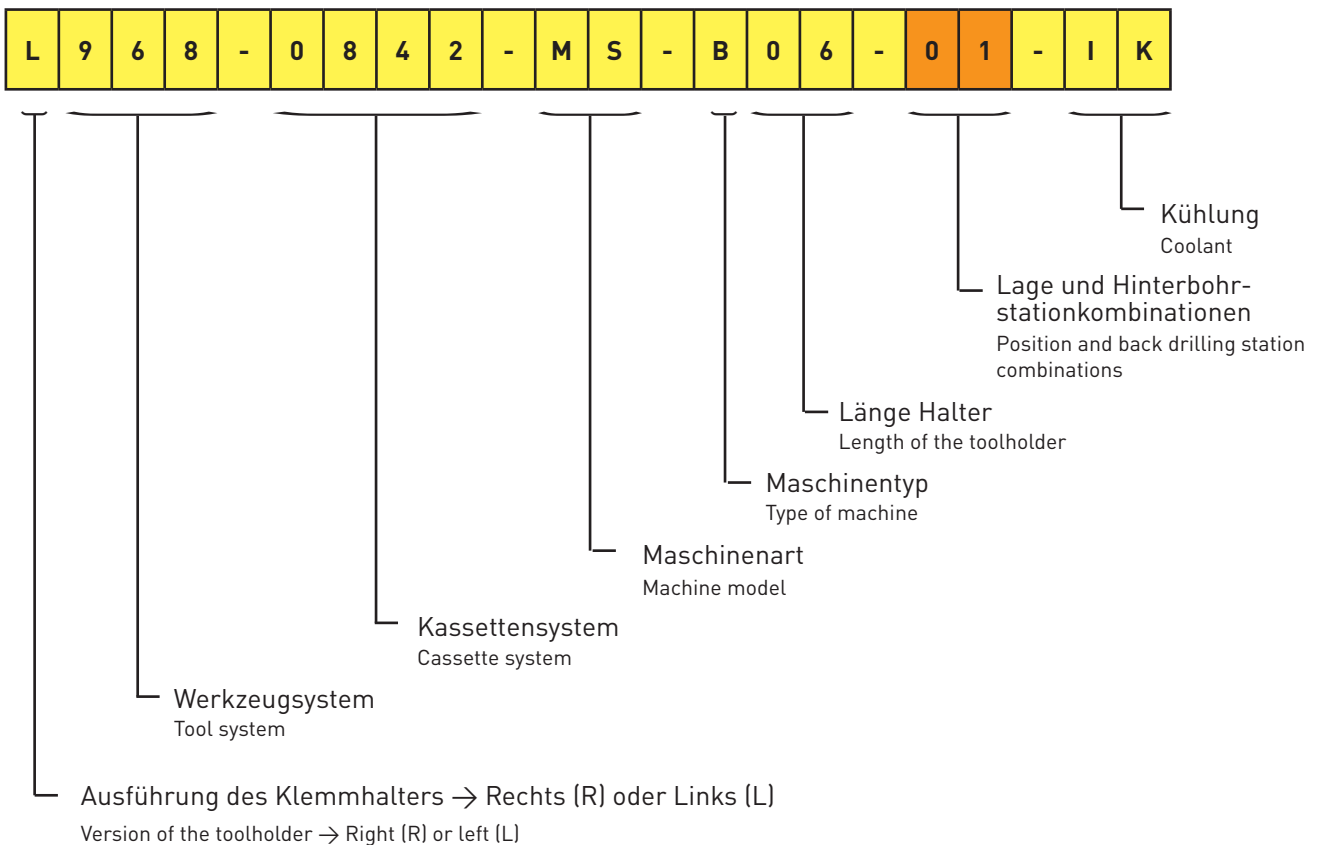
Z-Weg = 85 mm

Strokes X-NC 7-NC 1.1 - 8.2

X-axis stroke = 62 mm

Z-axis stroke = 85 mm





Lage und Hinterbohrstationkombinationen

Position and back drilling station combinations



Aussparungsausführungen:

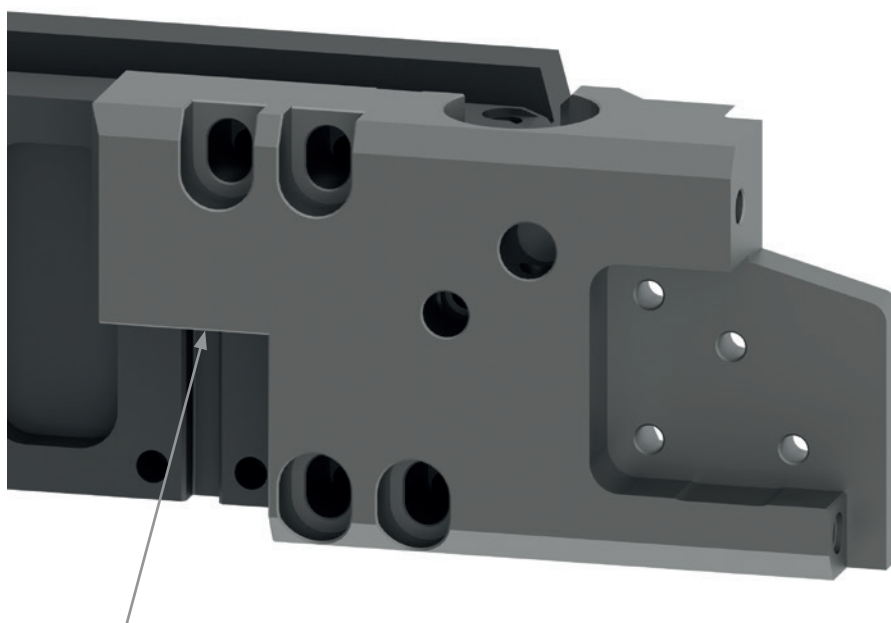
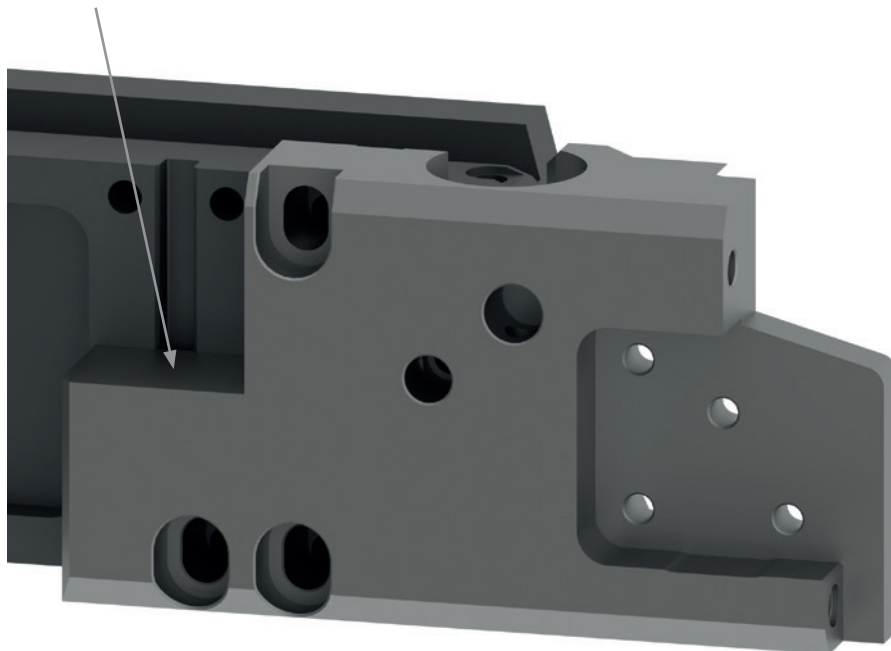
- 01** = Aussparung oben, Abstechen Lage 6.2 / 8.2
- 02 = Aussparungen unten, Abstechen Lage 5.1 / 7.1
- 03 = Nur Spannpratzen
- 04 = Aussparung oben + Aufnahme über Nutenstein (Lage 6.2 für angetriebene Einheit)
- 05 = Aussparung unten + Aufnahme über Nutenstein (noch keine Konstruktion)
- 06 = Aufnahme nur über Schrauben + Schwalbenschwanz
(MS24-6 Lage 6.2 mit angetriebener Hinterbohrstation)

Recess versions:

- 01** = Top recess, parting off position 6.2 / 8.2
- 02 = Bottom recesses, parting off position 5.1 / 7.1
- 03 = Clamping claws only
- 04 = Top recess + mounting via slot nut (position 6.2 for driven unit)
- 05 = Bottom recess + mounting via slot nut (no design yet)
- 06 = Mounting only via screws + dovetail
(MS24-6 position 6.2 with driven back drilling station)

Aussparung oben
L968.0842.MS.B16.01.IK
für Lage 6.2 / 8.2

Top recess
L968.0842.MS.B16.01.IK
for position 6.2 / 8.2



Aussparung unten
L968.0842.MS.B16.02.IK
für Lage 5.1 / 6.1

Bottom recess
L968.0842.MS.B16.02.IK
for position 5.1 / 6.1



Mehrspindler multi-spindle machine



für Kassette System 842
for cassette system 842



für Kassette System 840
for cassette system 840



für Klemmhalter mit Quadratschaft
for toolholder with square shank