



**Drill adaptor, conventional clamping**

**Application:**

Clamping chuck for drill bits with 10 mm shank diameter and driving flat for drilling spindles with threaded adaptor.

**Technical information:**

Stable and secure clamping of drills by 2 clamping screws. Smallest spindle pitch in the drilling unit: 21 mm. For narrower pitches, 8 mm shank chucks and drills must be used.

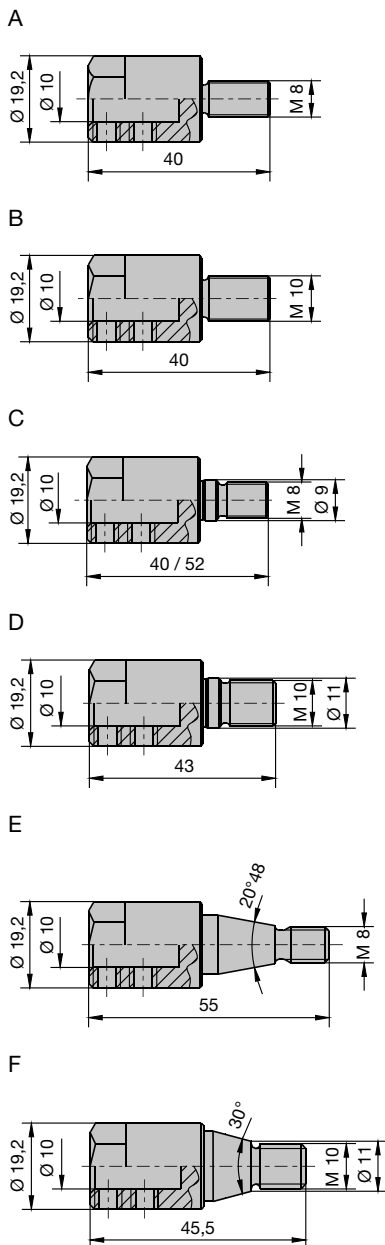
**Clamping chuck for drills with 10 mm shank and driving flat**

PM 320 0 28, PM 320 0 29, PM 320 0 30, PM 320 0 32, PM 320 0 34, PM 320 0 40, PM 320 0 42, PM 320 0 46, PM 320 0 50

| Machine  | GL<br>mm | Pic. | ID<br>LH | ID<br>RH |
|--|----------|------|----------|----------|
| Nottmeyer (old machine type)   | 40       | A    | 033088 ● | 033089 ● |
| Ayen, Brandt, Holzma, Knoevenagel,<br>Mayer, Reichenbacher, Torwegge, Zubiola  | 40       | B    | 033092 ● | 033093 ● |
| Lehbrink, Nottmeyer (new machine type)   | 40       | C    | 033080 ● | 033081 ● |
| Lehbrink, Nottmeyer (new machine type)   | 52       | C    | 033082 ● | 033083 ● |
| Alberti, Balestrini, Biesse,<br>Böttcher & Gessner, Busellato, Goma,<br>Grotefeld, Holz-Her, Hüllhorst, Koch,<br>Morbidelli, Reimall, Torwegge,<br>Vitap (from YOM 4/91 on), Weeke | 43       | D    | 033086 ● | 033087 ● |
| Bilek, Knoevenagel   | 55       | E    | 033084 ● | 033085 ● |
| Alberti, Balestrini, Bilek, Busellato,<br>Dubus, Goma, Grotefeld, Ompec, Reimall,<br>Schleicher, SCM, Tanzani, Viciani,<br>Vitap (up to YOM 4/91), Weingärtner                     | 45.5     | F    | 033090 ● | 033091 ● |
| Morbidelli   | 51       | G    | 033094 ● | 033095 ● |
| Scheer   | 45       | H    | 033096 ● | 033097 ● |

**Spare parts:**

| BEZ         | ABM<br>mm | ID       |
|-------------|-----------|----------|
| Allen key   | SW 3      | 005433 ● |
| Allen screw | M6x5      | 005836 ● |



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## 7. Clamping systems

### 7.3 Clamping chucks

#### 7.3.5 Drill adaptors



#### Drill adaptor, quick clamping design

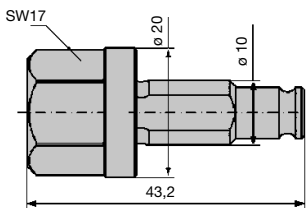
##### Application:

Quick clamping chuck for drills with 10 mm shank and driving flat for drilling spindles with threaded adaptor.

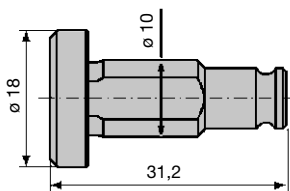
##### Technical information:

The drill is held in the chuck by the length adjusting screw (ID **009157**). Ideal if the hole diameter must be changed quickly. Quick clamping chucks not in use should be covered using the optional dust cover.

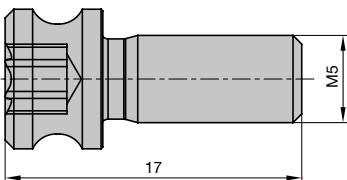
**Note:** The drill shanks require an appropriate shank and driving flat dimensional tolerance to ensure trouble free operation. Drills from the Leitz range guarantees functional reliability. Speed up to 12000 min<sup>-1</sup> (quick change drill adaptor without drill must be covered with the dust cover ID **115521** for speeds exceeding 9000 min<sup>-1</sup> to prevent unbalance).



Mounting device ID **115522**



Dust cover ID **115521**



Length adjustment screw ID **009157**

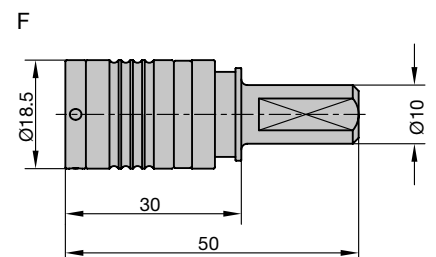
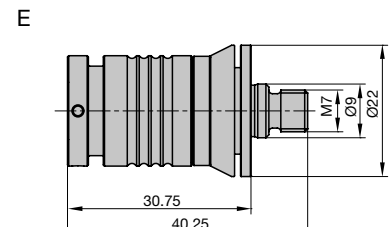
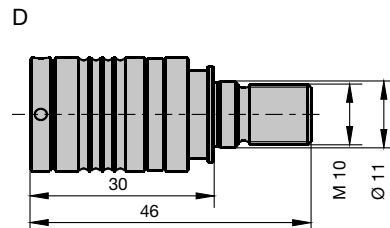
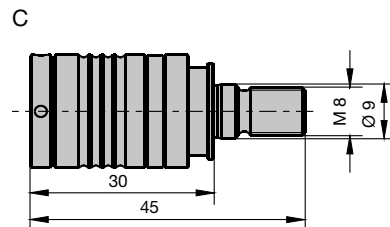
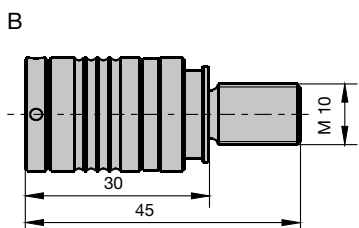
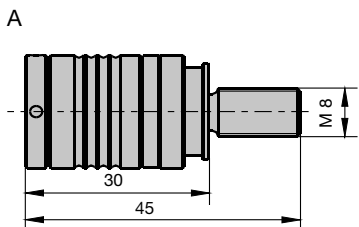
#### Clamping chuck for drills with 10 mm shank and driving flat

PM 320 0, PM 320 0 55, PM 320 0 56, PM 320 0 57, PM 320 0 58, PM 320 0 59

| Machine  | BEM              | GL<br>mm | Pic.<br>A | ID<br>LH        | ID<br>RH        |
|--|------------------|----------|-----------|-----------------|-----------------|
| Lehbrink, Nottmeyer<br>(new machine type)  |                  | 45       | A         | <b>033102</b> ● | <b>033103</b> ● |
| Ayen, Brandt, Holzma,<br>Knoevenagel, Mayer,<br>Reichenbacher, Torwegge,<br>Zubiola  |                  | 45       | B         | <b>033104</b> ● | <b>033105</b> ● |
| Nottmeyer (old machine type)   |                  | 45       | C         | <b>033098</b> ● | <b>033099</b> ● |
| Alberti, Biesse,<br>Böttcher & Gessner,<br>Busellato, Goma, Grotefeld,<br>Holz-Her, Hüllhorst, Koch,<br>Morbidelli, Reimall, Torwegge,<br>Vitap (from YOM 4/91 on),<br>Weeke |                  | 46       | D         | <b>033100</b> ● | <b>033101</b> ● |
| Weeke  | from YOM 2/04 on | 40.25    | E         | <b>033109</b> ● | <b>033110</b> ● |
| Universal  | Shank D-10 mm    | 50       | F         | <b>033106</b> ● | <b>033106</b> ● |

#### Spare parts:

| BEZ                              | ABM<br>mm            | ID              |
|----------------------------------|----------------------|-----------------|
| Dust cover                       | d8/10/D18/L31.2      | <b>115521</b> ● |
| Mounting device                  | d8/10/D20/L43.2/SW17 | <b>115522</b> ● |
| Length adjustment screw Torx® 20 | M5x17                | <b>009157</b> ● |



## 7. Clamping systems

### 7.3 Clamping chucks

#### 7.3.4 Weldon chucks

#### Clamping chuck with steep taper for CNC aggregates



##### Application:

Precision tool chuck for clamping shank tools with cylindrical shank and shank diameters up to  $d_{\max} = 16$  mm.

##### Technical information:

Steep taper design for Flex 5+ aggregates (Homag Group) and 5-motion-Plus aggregate (Felder Format-4). High stability for medium difficult cutting operations. Easy tool change through opening of the radial clamping screw. Tool adaptor fine balanced. Maximum tool protrusion (length projecting of the chuck) 60 mm.

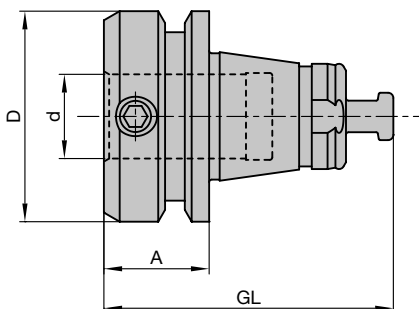
##### A = 20 mm, clamping diameter 16 mm

PM 320 0 53

| Machine                         | D<br>mm | d<br>mm | A<br>mm | GL<br>mm | Weight<br>kg | ID              |
|---------------------------------|---------|---------|---------|----------|--------------|-----------------|
| Felder Format-4,<br>Homag Group | 40      | 16      | 20      | 55       | 0.3          | <b>037722</b> □ |

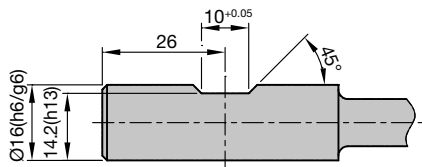
##### Spare parts:

| BEZ            | ABM<br>mm | ID              |
|----------------|-----------|-----------------|
| Clamping screw | M8x10     | <b>007800</b> □ |
| Allen key      | SW 4      | <b>005434</b> ● |



Weldon clamping chuck

Required shank design:



## 7. Clamping systems

### 7.3 Clamping chucks

#### 7.3.5 Drill adaptors

##### Drill adaptor



**Application:**

For mounting dowel drills, through hole drills and hinge boring bits on point-to-point drilling machines, through feed drilling machines and stationary drilling machines.

**Technical information:**

Wear resistant material, ground surface. High concentricity for clean holes and long drill life time.

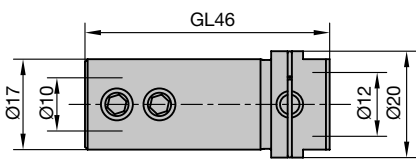
**For Weeke through-feed machines**

PM 320 0

| Machine | D  | d  | GL | ID              |
|---------|----|----|----|-----------------|
|         | mm | mm | mm |                 |
| Weeke   | 20 | 10 | 46 | <b>033107 ●</b> |

**Spare parts:**

| BEZ         | ABM  | ID              |
|-------------|------|-----------------|
|             | mm   |                 |
| Allen key   | SW 3 | <b>005433 ●</b> |
| Allen screw | M6x4 | <b>005837 ●</b> |



Drill adaptor for Weeke

##### Drill adaptor



**Application:**

For mounting dowel drills, through hole drills and hinge boring bits on point-to-point drilling machines, through feed drilling machines and stationary drilling machines.

**Technical information:**

Wear resistant material, ground surface. High concentricity for clean holes and long drill life time.

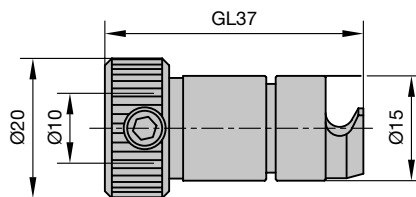
**For Biesse boring units**

PM 320 0

| Machine | D  | d  | GL | ID              |
|---------|----|----|----|-----------------|
|         | mm | mm | mm |                 |
| Biesse  | 20 | 10 | 37 | <b>033108 ●</b> |

**Spare parts:**

| BEZ         | ABM  | ID              |
|-------------|------|-----------------|
|             | mm   |                 |
| Allen key   | SW 3 | <b>005433 ●</b> |
| Allen screw | M6x5 | <b>005836 ●</b> |



Drill adaptor for Biesse

## 7. Clamping systems

### 7.3 Clamping chucks

#### 7.3.5 Drill adaptors



#### Quick change drill adaptor, spare parts for previous system

##### Tool adaptor for drills with 10 mm shanks

PM 320 0 02

| D  | d  | ID       | ID       |
|----|----|----------|----------|
| mm | mm | LH       | RH       |
| 20 | 10 | 033270 ● | 033271 ● |

##### Spare parts:

| BEZ         | ABM  | ID       |
|-------------|------|----------|
|             | mm   |          |
| Allen key   | SW 3 | 005433 ● |
| Allen screw | M6x5 | 005836 ● |

##### Tool adaptor for drills with 8 mm shanks

PM 320 0 01

| D    | d  | ID       | ID       |
|------|----|----------|----------|
| mm   | mm | LH       | RH       |
| 15.5 | 8  | 033170 ● | 033171 ● |

##### Spare parts:

| BEZ         | ABM  | ID       |
|-------------|------|----------|
|             | mm   |          |
| Allen key   | SW 3 | 005433 ● |
| Allen screw | M6x5 | 005836 ● |

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