

- CHUCKING TOOLS
- ADAPTER
- ADAPTADORES
- ADAPTATEURS
- ADATTATORI



GB Complete program of modular chucking tools with MHD' arbor that meets several milling, drilling and tapping needs.

D Das gesamte Programm modularer Adapter D'Andrea mit MHD'-Integralanschluss, das verschiedenen Fräs-, Bohr-, und Gewindebohrarbeiten gerecht wird.

E El programa completo de adaptadores modulares D' Andrea con unión MHD', satisface varias exigencias de elaboración en fresado, roscado y taladrado.

F La gamme complète d'adaptateurs modulaires D'Andrea avec mandrin MHD', répondant aux exigences d'usinage les plus variées en matière de fraisage, forage et taraudage.

I Il completo programma di adattatori modulari D'Andrea con attacco MHD', che soddisfa svariate esigenze di lavorazione in fresatura, foratura e maschiatura.



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GB CHUCKING TOOLS

- PE.** Collet chucks to DIN 6499 - ER 11, ER 16, ER 20, ER 25, ER 32, ER 40.
MHD' FORCE. Ultra-light toolholder FORCE.
AW. Combi-toolholders Weldon (DIN 1835 B) and Whistle Notch (DIN 1835 E).
PF. Universal milling cutter-holders for disc cutters and facing cutters.
CM. Toolholders with internal morse taper for tools with thread to DIN 228-A and tang to DIN 228-B.
AM. Tapping chuck holders for high production thread cutting.
B16. Drill chuck-holders with internal taper B16 to DIN 238.
NS. Semi-finished toolholders for special tools with hardened and ground.
ACR/NC. Coolant chucking tools NC.
ACR. Coolant chucking tools

D SPANNZEUGE

- PE.** Spannzangenfutter nach DIN 6499 - ER 11, ER 16, ER 20, ER 25, ER 32, ER 40.
MHD' FORCE. Spannzangenfutter mit hochfester Werkzeugschraubung.
AW. Werkzeugaufnahme für Weldon (nach DIN 1835-B) und Whistle Notch (nach DIN 1835-E).
PF. Kombiaufsteckfräsdorne für Scheibenfräser und Planfräser.
CM. Werkzeugaufnahmen mit Morseinnenkegel für Werkzeuge mit Rückzuggewinde nach DIN 228-A und Lappen nach DIN 228-B.
AM. Gewindeschneidspannfutter für höchste Beanspruchung in der Serienfertigung.
B16. Bohrerfutteraufnahme mit Innenkegel B16 nach DIN 238.
NS. Werkzeugaufnahmenrohlinge mit gehärtetem.
ACR/NC. Spannzeuge für Kühlmittel NC.
ACR. Aufnahme mit Kühlmittelübergabe.

E ADAPTADORES

- PE.** Adaptadores portapinzas elásticas DIN 6499 - ER 11, ER 16, ER 20, ER 25, ER 32, ER 40.
MHD' FORCE. Adaptadores de gran apriete FORCE.
AW. Adaptadores combinados Weldon (DIN 1835 B) y Whistle Notch (DIN 1835 E).
PF. Adaptadores portafresas combinados para fresas a disco y de planear.
CM. Adaptadores combinados para cono morse con agujero roscado DIN 228-A y con uña DIN 228-B.
AM. Adaptadores para roscar para alta producción.
B16. Adaptadores para mandrinos portabrocas con acoplamiento B16 DIN 238.
NS. Adaptadores semielaborados para herramientas especiales.
ACR/NC. Adaptadores para líquido refrigerante NC.
ACR. Adaptadores para líquido refrigerante

F ADAPTATEURS

- PE.** Adaptateurs porte-pinces DIN 6499 - ER 11, ER 16, ER 20, ER 25, ER 32, ER 40.
MHD' FORCE. Adaptateurs à serrage fort FORCE.
AW. Adaptateurs combinés Weldon (DIN 1835 B) et Whistle Notch (DIN 1835 E).
PF. Adaptateurs porte-fraises combinés pour fraises à disque et fraises à surfacer.
CM. Adaptateurs avec cône morse pour outils avec filetage DIN 228-A et tenon DIN 228-B.
AM. Adaptateurs de taraudage pour forte fabrication en série.
B16. Adaptateurs pour mandrins porte-forets avec filetage B16 DIN 238.
NS. Adaptateurs semi-finis pour outils spéciaux.
ACR/NC. Adaptateurs pour liquide d'arrosage NC.
ACR. Adaptateurs pour liquide d'arrosage.

I ADATTATORI

- PE.** Adattatori portapinzas elastiche DIN 6499 - ER 11, ER 16, ER 20, ER 25, ER 32, ER 40.
MHD' FORCE. Adattatori a forte serraggio FORCE.
AW. Adattatori combinati Weldon (DIN 1835 B) e Whistle Notch (DIN 1835 E).
PF. Adattatori portafrese combinati per frese a disco e spianare.
CM. Adattatori combinati per cono morse con foro filettato DIN 228-A e con dente DIN 228-B.
AM. Adattatori di maschiatura per forte produzione.
B16. Adattatori per mandrini portapunte con attacco B16 DIN 238.
NS. Adattatori semilavorati per utensili speciali.
ACR/NC. Adattatori per liquido refrigerante NC.
ACR. Adattatori per liquido refrigerante.

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p. 134 • NS



p. 135 • ACR/NC



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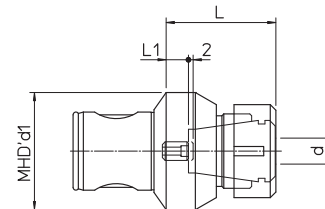


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- COLLETS CHUCKING TOOLS
- SPANNZANGENFUTTER
- ADAPTADORES PARA PINZAS ELÁSTICAS
- ADAPTATEURS POUR PINCES DE SERRAGE
- ADATTATORI PER PINZE ELASTICHE

ER DIN 6499

PE

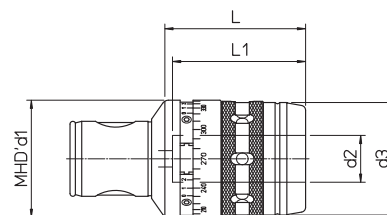


- Supplied without collets and clamping wrenches
- Ohne Spannzangen und Spannschlüssel.
- Pinzas elásticas y llaves de apriete excluidas
- Sans pinces et clés de serrage
- Pinze elastiche e chiavi di serraggio escluse

REF.	CODE	MHD' d1	d	L	L1	kg			N·m
PE 16 / ER11M	655701600110	16	0.5 ~ 7	25	2.5	0.03	ER-11M	E11M	30
PE 20 / ER16M	655702000160	20	0.5 ~ 10	32	1	0.06	ER-16M	E16M	40
PE 25 / ER20M	655702500200	25	1 ~ 13	40	2.5	0.15	ER-20M	E20M	80
PE 32 / ER25M	655703200250	32	1 ~ 16	42	1.5	0.25	ER-25M	E25M	160
PE 40 / ER25	655704000250	40		45	5	0.4	UM/ER25	E25	200
PE 50 / ER25	655705000250	50	1 ~ 16	48	7	0.7	UM/ER25	E25	200
PE 50 / ER32	655705000320			55	8	1			
PE 63 / ER32	655706300320	63	2 ~ 20	59	12	1.3	UM/ER32	E32	220
PE 63 / ER40	655706300400		3 ~ 26	64		1.5	UM/ER40	E40	250

- ULTRA-TIGHT TOOLHOLDER FORCE
- FORCE SPANNZANGENFUTTER MIT HOCHFESTER WERKZEUGSPANNUNG
- ADAPTADORES DE GRAN APRIETE FORCE
- ADAPTATEURS À SERRAGE FORT FORCE
- ADATTATORI A FORTE SERRAGGIO FORCE

MHD' FORCE



- Supplied without collets and clamping wrenches
- Ohne Spannzangen und Spannschlüssel.
- Pinzas elásticas y llaves de apriete excluidas
- Sans pinces et clés de serrage
- Pinze elastiche e chiavi di serraggio escluse

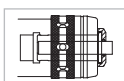
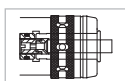
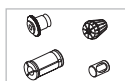
REF.	CODE	MHD' d1	d2	d3	L	L1	kg
FORCE 50/20 HS	656305000205	50	20	48	60	60	1
FORCE 63/32 HS	656306300325	63	32	66	80	80	2

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- WELDON WHISTLE NOTCH CHUCKING TOOLS
- WELDON / WHISTLE NOTCH WERKZEUGAUFNAHMEN
- ADAPTADORES WELDON WHISTLE NOTCH
- ADAPTATEURS WELDON WHISTLE NOTCH
- ADATTATORI WELDON WHISTLE NOTCH

DIN 1835 B-E

AW

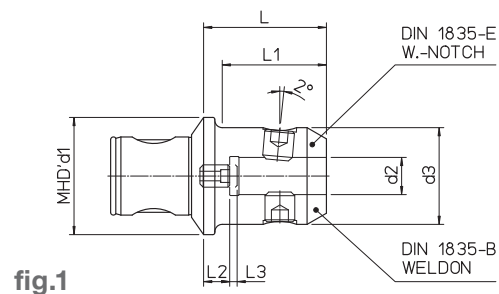


fig.1

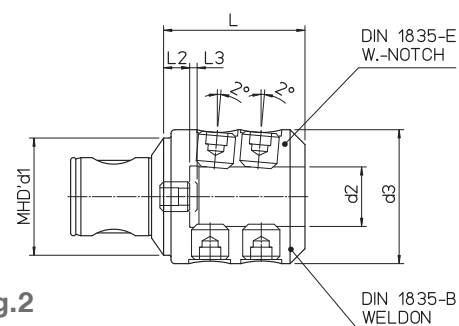


fig.2

REF.	CODE	MHD' d1	d2 ^{H5}	d3	L	L1	L2	L3	kg	fig.	
AW 50/6	655805000060	50	6	25	44	32.5	7	2	0.5	1	
AW 50/8	655805000080		8	28		33					
AW 50/10	655805000100		10	35		42					
AW 50/12	655805000120		12	42		48					
AW 50/14	655805000140		14	48	67	61	17	3	1.1		
AW 50/16	655805000160		16	51							16
AW 50/20	655805000200		20	63	-	22	1.8	2			
AW 50/25	655805000250		25	80	80	22	1.8	2			
AW 63/16	655806300160	63	16	48	64	53	14	4	1.4	1	
AW 63/20	655806300200		20	52	66	56			1.5		
AW 63/25	655806300250		25	64	74	16			2.1		
AW 63/32	655806300320		32	72	76	-			14	2.5	2
AW 80/40	655808000400		80	40	80	83			12	3.2	

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- DISC AND FACING CUTTER HOLDERS
- SCHEIBEN- UND PLANFRÄSERAUFSTECKDORNE
- ADAPTADORES PARA FRESAS A DISCO Y DE PLANEAR
- ADAPTATEURS POUR FRAISES À DISQUE ET À SURFACER
- ADATTATORI PER FRESE A DISCO E A SPIANARE

PF

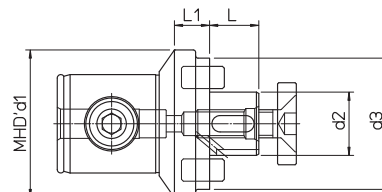
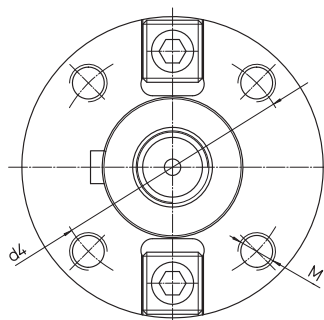
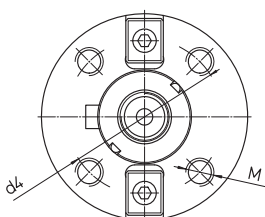


fig.1

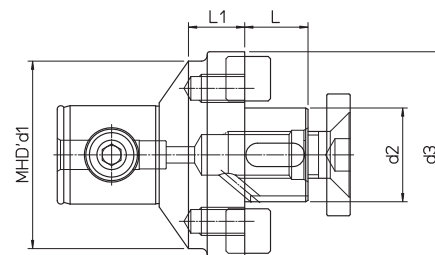


fig.2

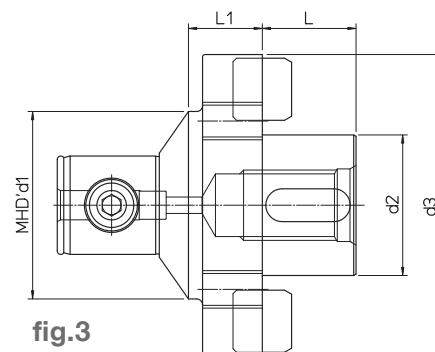
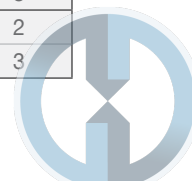


fig.3

REF.	CODE	MHD' d1	d2	d3	d4	M	L	L1	kg	fig.
PF 40/16	655904020165	40	16	32	-	-	17	15	0.3	1
PF 40/22	655904020225		22	40			19	13	0.4	
PF 50/16	655905000160	50	16	32			17	15	0.5	
PF 50/22	655905000220		22	40			19		0.6	
PF 50/27	655905000270		27	50			21		0.7	
PF 50/32	655905000320		32	60			24		0.9	
PF 63/22	655906300220	63	22	60			19	24	1.1	
PF 63/27	655906300270		27	63			21		1.2	
PF 63/32	655906300320		32	80			24		1.7	
PF 80/32	655908000320		32	84			66.7		M12	
PF 80/40	655908000400	80	50	90	-	-	30	2.0	2	
PF 80/50	655908000500		60	128.5	101.6	M16	40	31.5	3.5	3
PF 80/60	655908000600		60	128.5	101.6	M16	40	36	6	3
PF 110/40	655911000400	110	40	88	66.7	M12	27	20	4.2	2
PF 110/60	655911000600		60	128.5	101.6	M16	40	36	6	3
PF 140/40	655914000400	140	40	88	66.7	M12	27	26	6.2	2
PF 140/60	655914000600		60	140	101.6	M16	40		7.8	3

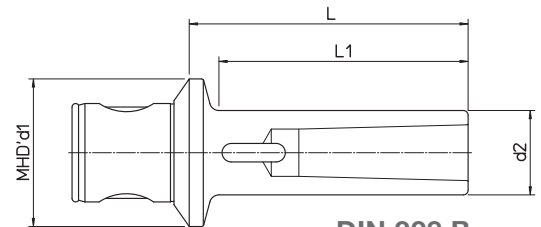


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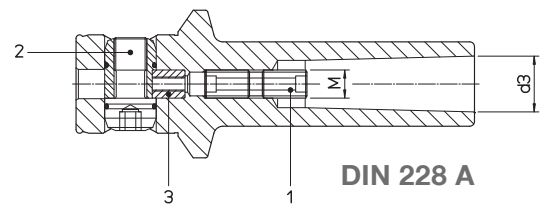
- MORSE TAPER CHUCKING TOOLS
- MORSEKEGELAUFNAHMEN
- ADAPTADORES PARA CONO MORSE
- ADAPTATEURS POUR CÔNE MORSE
- ADATTATORI PER CONO MORSE

DIN 228 A-B

CM



DIN 228 B



DIN 228 A

REF.	CODE	MHD' d ₁	MORSE	d ₂	d ₃	L	L ₁	M	kg
CM 50/1	656005000010	50	1	20	12.065	80	68	M6	0.6
CM 50/2	656005000020		2	30	17.780	100	86	M10	0.7
CM 50/3	656005000030	63	3	36	23.825	120	110	M12	1
CM 63/3	656006300030		4	48	31.267	150	133		M16
CM 63/4	656006300040								2

GB MT DIN 228-A. To chuck a morse taper tool with thread proceed as follows:

a. Drive in screw 1; b. Remove expanding pin 2 and sleeve 3 to allow the Allen wrench to be introduced from the rear; c. Fit the tool and tighten screw 1 clockwise; d. Reassemble expanding pin 2 and sleeve 3.

MT DIN 228-B. To chuck a morse taper tool with tang remove screw. 1. Combi-chucking tools for morse taper with DIN 228-A thread bore and with DIN 228-B tooth.

D MK DIN 228-A. Zum Einspannen eines Morsekegelwerkzeuges mit Rückzuggewinde folgendermaßen vorgehen:

a. Schraube 1 eindrehen; b. Spreizbolzen 2 und Buchse 3 entfernen, um den Sechskantschlüssel von hinten einführen zu können; c. Werkzeug einsetzen und Schraube 1 im Uhrzeigersinn festziehen; d. Buchse 3 und Spreizbolzen 2 wieder einsetzen.

MK DIN 228-B. Zum Einspannen eines Morsekegelwerkzeuges mit Austreiberlappen Schraube 1 herausdrehen. Werkzeughalter mit Morseinnekegel für Werkzeuge mit Rückzuggewinde nach DIN 228-A und Austreiberlappen nach DIN 228-B.

E CM DIN 228-A. Para montar una herramienta con cono morse con agujero roscado se precisa:

a. Montar roscando completamente el tornillo 1; b. Quitar el perno expansible 2 y el casquillo 3 para permitir el paso posterior de la llave exagonal; c. Montar la herramienta y rosar en sentido horario el tornillo 1; d. Montar otra vez el casquillo 3 y el perno expansible 2.

CM DIN 228-B. Antes de montar una herramienta con cono morse con uña de arrastre, se precisa quitar el tornillo 1. Adaptadores combinados para cono morse con agujero roscado DIN 228-A y con uña DIN 228-B.

F CM DIN 228-A. Pour monter un outil cône morse avec filetage procéder de cette façon:

a. Poser la vis 1; b. Enlever la tige expansible 2 et la douille 3 pour permettre le passage postérieur de la clef hexagonale; c. Monter l'outil et serrer la vis 1 dans le sens des aiguilles d'une montre; d. Remonter la tige 2 et la douille 3.

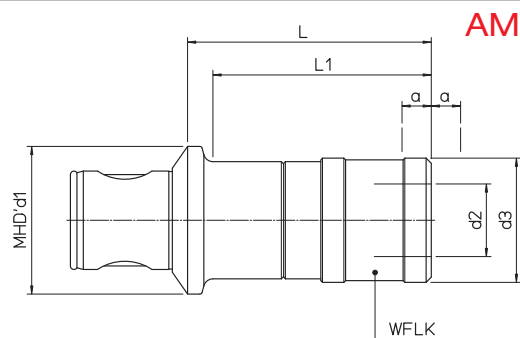
CM DIN 228-B. Avant de monter un outil cône morse avec tenon, enlever la vis 1. Adaptateurs combinés pour cône morse avec trou fileté DIN 228-A et avec dent DIN 228-B.

I CM DIN 228-A. Per montare un utensile a cono morse con attacco filettato occorre: a. Montare avvitando interamente la vite 1; b. Togliere il perno espandibile 2 e la bussola 3 per permettere il passaggio posteriore della chiave esagonale; c. Montare l'utensile e avvitare in senso orario la vite 1; d. Rimontare bussola 3 e perno espandibile 2.

CM DIN 228-B. Prima di montare un utensile a cono morse con tenone occorre togliere la vite 1. Adattatori combinati per cono morse con foro filettato DIN 228-A e con dente DIN 228-B.

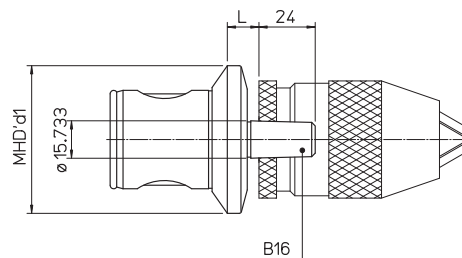
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- TAPPING CHUCK HOLDERS
- GEWINDESCHNEIDSPANNFUTTER
- ADAPTADORES PARA ROSCAR
- ADAPTATEURS DE TARAUDAGE
- ADATTATORI DI MASCHIATURA



REF.	CODE	MHD' d1	WFLK	Capacity	L	L1	d2	d3	a	kg
AM 50/M3-12	656505000100	50	WFLK 115B/A 308	M 3 ~ 12	72	60	19	36	7.5	0.9
AM 50/M8-20	656505000200		WFLK 225B/A 308	M 8 ~ 20	106	-	31	53	12.5	1.2
AM 63/M3-12	656506300100	63	WFLK 115B/A 308	M 3 ~ 12	70	58	19	36	7.5	1
AM 63/M8-20	656506300200		WFLK 225B/A 308	M 8 ~ 20	104	93	31	53	12.5	1.3

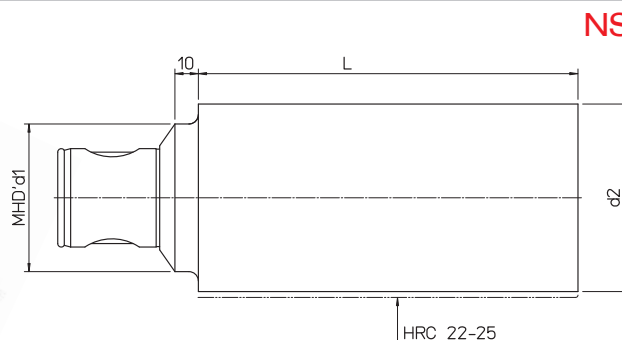
- DRILLING CHUCK HOLDERS B16 D238
- BOHRFUTTERAUFNAHME B16 D238
- ADAPTADORES PARA MANDRINOS B16 D238
- ADAPTATEURS POUR MANDRIN B16 D238
- ADATTATORI PER MANDRINO B16 D238



- Drilling chuck holders with B16 DIN 238 thread.
- Bohrfutteraufnahme mit Innenkegel B16 nach DIN 238.
- Adaptadores para mandrinos portabrocas con acoplamiento B16 DIN 238.
- Adaptateurs pour mandrin porte-forets avec cône B16 DIN 238.
- Adattatori per mandrini portapunte con attacco B16 DIN 238.

REF.	CODE	MHD' d1	L	kg
B 50/16	656105000160	50	10	0.4
B 63/16	656106300160	63	13.5	0.8

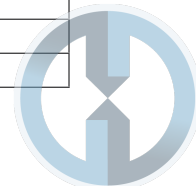
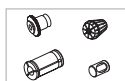
- SEMIFINISHED CHUCK HOLDERS
- WERKZEUGAUFNAHMERÖHLING
- ADAPTADORES SEMIELABORADOS
- ADAPTATEURS SEMI-FINIS
- ADATTATORI SEMILAVORATI



REF.	CODE	MHD' d1	d2	L	kg
NS 50	657205001600	50	63	160	4.2
NS 63	657206302000	63	80	200	8.7
NS 80	657208002500	80	100	250	16
NS 110	657211002500	110	130		18
NS 140	657214002500	140	150		30

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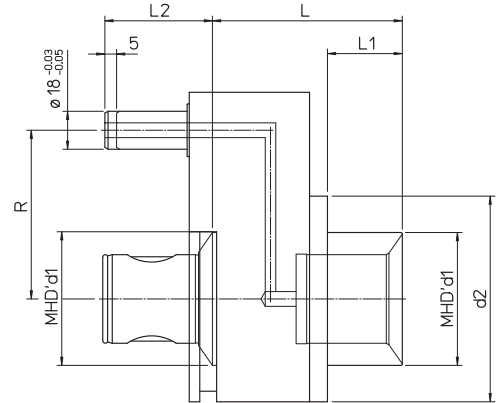
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- COOLANT CHUCKING TOOLS NC
- AUFNAHME MIT KÜHLMITTELÜBERGABE NC
- ADAPTADORES PARA LÍQUIDO REFRIGERANTE NC
- ADAPTATEURS POUR LIQUIDE D'ARROSAGE NC
- ADATTATORI PER LIQUIDO REFRIGERANTE NC

ACR/NC

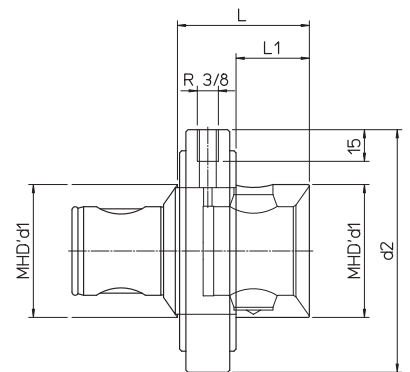


- **Important note.** Activate the coolant before the chuck rotation not to damage internal gaskets.
- **Wichtger Hinweis.** Das Kühlmittel vor der Spindelumdrehung einschalten, um die inneren Dichtungen nicht zu beschädigen.
- **Atención.** Accionar el líquido refrigerante antes de la ROTACIÓN del mandrino para preservar los retenes internos.
- **Note importante.** Actionner le liquide d'arrosage avant la ROTATION du mandrin afin de ne pas endommager les joints intérieurs.
- **Attenzione.** Azionare il liquido refrigerante prima della ROTAZIONE del mandrino per non danneggiare le guarnizioni interne.

REF.	CODE	MHD' d1	R	d2	L	L1	L2	RPM max	BAR	kg
ACR/NC 50/50	656705000501	50	65	80	72	28.5	43	7000	max 10	1.9
ACR/NC 50/50	656705000500		80							2.5
ACR/NC 63/63	656706300630	63	80	100	88	37	51	5600		5

- COOLANT CHUCKING TOOLS
- AUFNAHME MIT KÜHLMITTELÜBERGABE
- ADAPTADORES PARA LÍQUIDO REFRIGERANTE
- ADAPTATEURS POUR LIQUIDE D'ARROSAGE
- ADATTATORI PER LIQUIDO REFRIGERANTE

ACR



- **Important note.** Activate the coolant before the chuck rotation not to damage internal gaskets.
- **Wichtger Hinweis.** Das Kühlmittel vor der Spindelumdrehung einschalten, um die inneren Dichtungen nicht zu beschädigen.
- **Atención.** Accionar el líquido refrigerante antes de la ROTACIÓN del mandrino para preservar los retenes internos.
- **Note importante.** Actionner le liquide d'arrosage avant la ROTATION du mandrin afin de ne pas endommager les joints intérieurs.
- **Attenzione.** Azionare il liquido refrigerante prima della ROTAZIONE del mandrino per non danneggiare le guarnizioni interne.

REF.	CODE	MHD' d1	d2	L	L1	RPM max	BAR	kg
ACR 63/63	656706310630	63	115	63	35	3500	max 10	2.9

