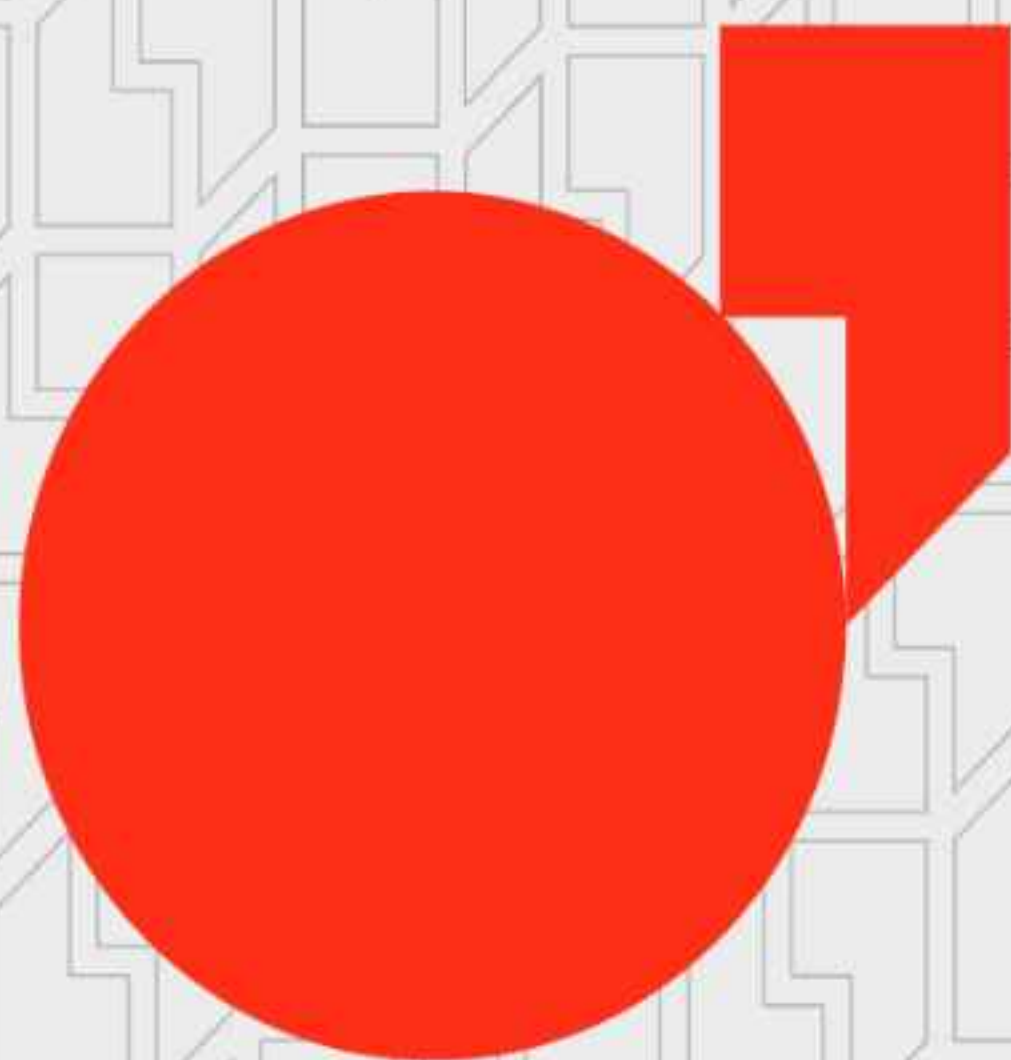




D'ANDREA®
TECHNOLOGY FOR HIGH PRECISION

TOOLS HEADS 2023



Golden Compass
award for industrial design

EVOLUTION
OF A LONG
TRADITION

Made in Italy



PRECISION IS OUR STRENGTH

D'ANDREA S.p.A. is an Italian company world leader in the production of high precision accessories for machine tools, founded in 1951 by Marino D'Andrea, who started the business with the first facing and boring head.

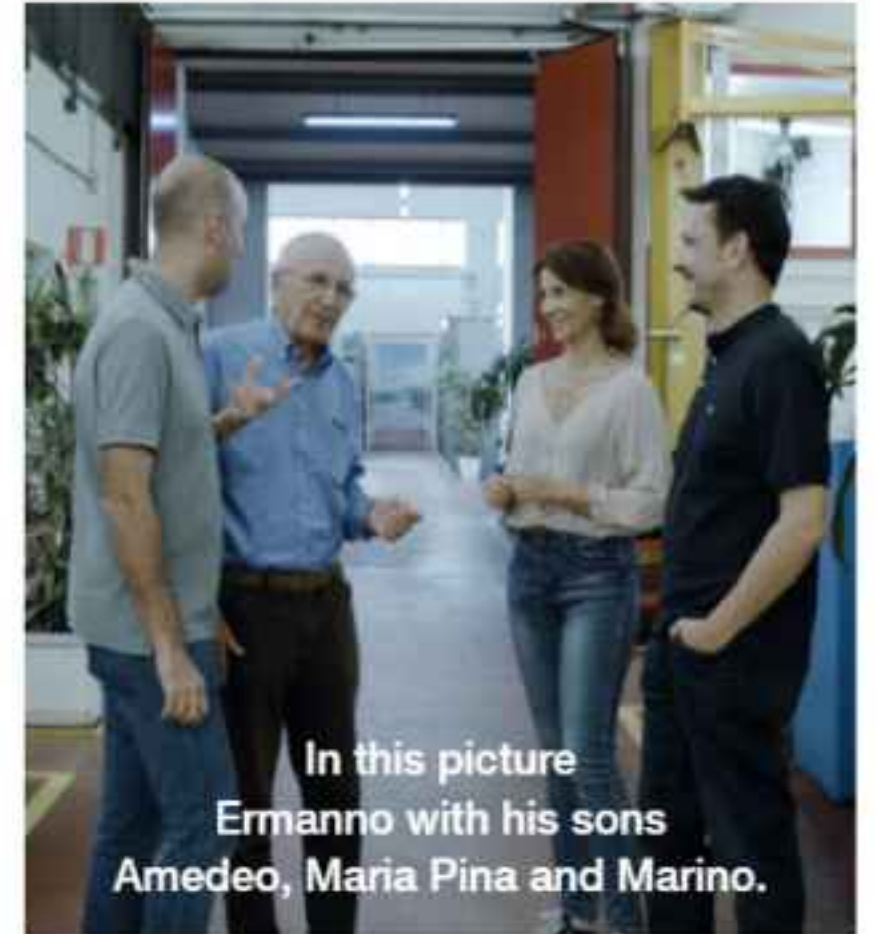
The D'Andrea brand is worldwide recognized, through a dealer network present in over 40 countries, both for the quality and reliability of its products.



D'Andrea Marino
The Founder



1951 - The first Head
for Boring and Facing



In this picture
Ermanno with his sons
Amedeo, Maria Pina and Marino.

A tradition of over 70 years in the manufacturing sector and a great passion for mechanics which today is inherited by the third generation, with the aim of responding to the increasingly demanding requests from the world of precision mechanics. Every year significant resources are invested in the Research and Development of new products which, thanks to advanced technological solutions, satisfy a highly qualified demand.





The production is divided between the headquarters in Lainate, at the doors of Milano, with over 7,000 mq of workshop, executive offices, and the plant in Castel Del Giudice (Isernia) where D'ANDREA MOLISE produces most of the semi-finished products which are subsequently finished, assembled and controlled in the headquarters.



Lainate (Milan)

Castel Del Giudice (Isernia)



D'ANDREA

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TOOLS
HEADS

TOOLS

MHD'

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BHT

ROUGHING

FINISHING 2 µm

ARBORS HT
PATENTED



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MONOforce



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MONOd'



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HEADS

U-TRONIC

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NC HEADS



66-71

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TA-TRONIC 2 TA-T2

NC HEADS



72-73

MILLING MACHINES

AR

AUTOMATIC
HEADS



74-75

MACHINING CENTERS MILLING MACHINES

TA-SENSITIV 2 TA-S2

FACING AND
BORING HEADS



76-77

MILLING-BORING MACHINE
CONVENTIONAL MACHINES

ACCESSORIES	INSERTS	SPARE PARTS	TECHNICAL DATA
47	48-49	50-53	54-57

**T
O
O
L
S

H
E
A
D
S**

MHD'

MODULAR
TOOLHOLDERS



TS
ROUGHING
HEADS

TRM - TRE
TESTAROSSA
2 μ m

TRC
TESTAROSSA
10 μ m

MHD' 16

MHD' 20

MHD' 25

MHD' 32

MHD' 40

MHD' 50

TS 16/16
 $\varnothing$ 18 ~ 22

TS 20/20
 $\varnothing$ 22 ~ 28

TS 25/25
 $\varnothing$ 28 ~ 38

TS 32/32
 $\varnothing$ 35.5 ~ 50

TS 40/40
 $\varnothing$ 50 ~ 68

TS 50/50 - 50/63
 $\varnothing$ 68 ~ 90



TRM 16
 $\varnothing$ 18 ~ 23

TRM 20
 $\varnothing$ 22 ~ 29

TRM 25
 $\varnothing$ 28 ~ 38

TRM 32
 $\varnothing$ 35.5 ~ 51.5

TRM 40
 $\varnothing$ 48 ~ 63

TRM 50 $\varnothing$ 2.5 ~ 108



TRC 16
 $\varnothing$ 18 ~ 24

TRC 20
 $\varnothing$ 22 ~ 30

TRC 25
 $\varnothing$ 28 ~ 40

TRC 32
 $\varnothing$ 35.5 ~ 53.5

TRC 40
 $\varnothing$ 48 ~ 66

TRC 50 $\varnothing$ 2.5 ~ 110



PSC

MONOLITHIC
TOOLHOLDERS

PSC50 - TS50
 $\varnothing$ 68 ~ 90

PSC 50



PSC63 - TS50
 $\varnothing$ 68 ~ 90

PSC 63



PSC - TS
ROUGHING
HEADS

PSC63 - TS63
 $\varnothing$ 90 ~ 120



PSC63 - TS80
 $\varnothing$ 120 ~ 200



new

PSC50 - TRM50
 $\varnothing$ 2.5 ~ 108



PSC63 - TRM50
 $\varnothing$ 2.5 ~ 108



PSC - TRM
TESTAROSSA 2 μ m

PSC63 - TRM63
 $\varnothing$ 2.5 ~ 125



PSC63 - TRM80
 $\varnothing$ 2.5 ~ 220



MONOforce

HIGH PRECISION
ULTRA-TIGHT
TOOLHOLDERS
 $\varnothing$ 12 / 20 / 32

DIN 69871



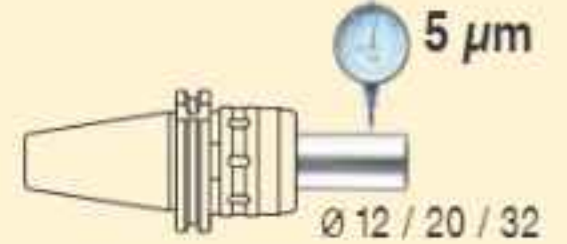
MAS BT



PSC



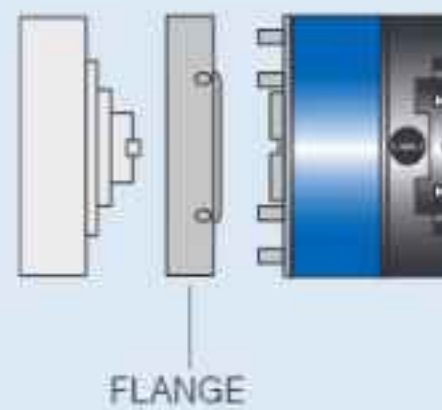
HSK-A



U-TRONIC

NC HEADS

UT 3-360
 $\varnothing$ max 800

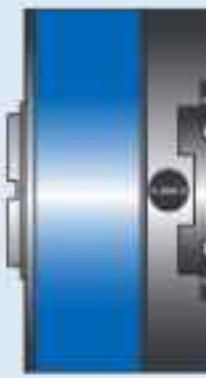


FLANGE

UT 5-500
 $\varnothing$ max 1000

UT 5-630
 $\varnothing$ max 1250

UT 5-800
 $\varnothing$ max 1600

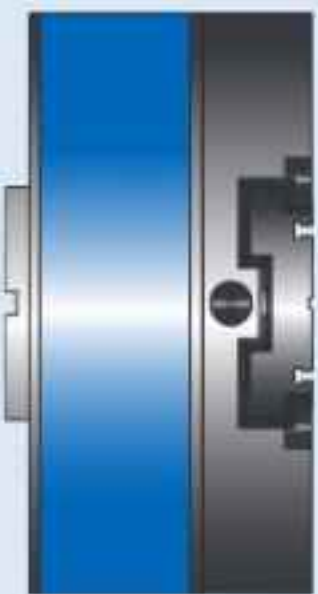


UT 8-800
 $\varnothing$ max 1600

UT 8-1000
 $\varnothing$ max 2000

UT 8-1250
 $\varnothing$ max 2500

UT 8-1600
 $\varnothing$ max 3200



BORING-MILLING MACHINES MEDIUM AND LARGE SIZES

TA-CENTER 2

NC HEADS

new



ARBORS HT

TA-C2.110
 $\varnothing$ max 200

TA-C2.170
 $\varnothing$ max 320

TA-TRONIC 2

NC HEADS

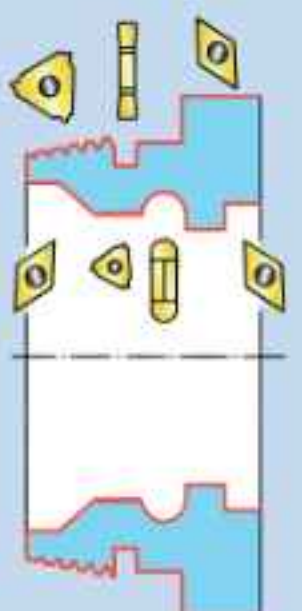
new



ARBORS HT

TA-T2.110
 $\varnothing$ max 200

TA-T2.170
 $\varnothing$ max 320



MACHINING CENTERS

MILLING MACHINES

MHD' 63

MHD' 80

TS 63/63
Ø 90 ~ 120



TS 80/80
Ø 120 ~ 200



TS 80/90
Ø 160 ~ 250



TRM 50/63 - 63/63
Ø 2.5 ~ 125



TRM 50/80 - 80/80
Ø 2.5 ~ 220



TRM 80/125
Ø 36 ~ 500



TRC 63 Ø 72 ~ 110



TRC 80 Ø 88 ~ 132



MILLING DRILLING

PE COLLET
CHUCKS



FORCE HIGH
CLAMPING POWER



AW WELDON
WHISTLE NOTCH



PF SHELL MILL HOLDERS



BHT

CROSS BARS

BHT 250
Ø 250 ~ 500

BORING
TURNING

BHT 500
Ø 500 ~ 750

new

ROUGHING

PATENTED
ARBORS HT



DIN
MAS
PSC
HSK
MHD

ADJUSTABLE
CARTRIDGE



FINISHING 2 µm



MILLING DRILLING

ER COLLET CHUCKS



FORCE HIGH CLAMPING POWER



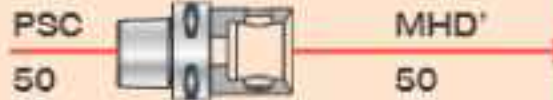
PF SHELL MILL HOLDERS



TCD' TURNING



REDUCTIONS TO MHD'



MONOd'

PRECISION
COLLET CHUCK
HOLDERS

ER 16 / 25 / 32

DIN 69871



MAS BT



PSC



HSK-A



GEARBOX



HOLE



DOUBLE SLIDE



HIGH SPEED (BALANCED)



ANGULAR HEADS



EXTENDED



SPECIALS

AR (AUTORADIAL)

AUTOMATIC
HEADS



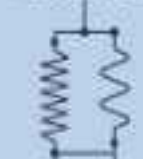
ARBORS MHD'

MACHINING CENTERS MILLING MACHINES

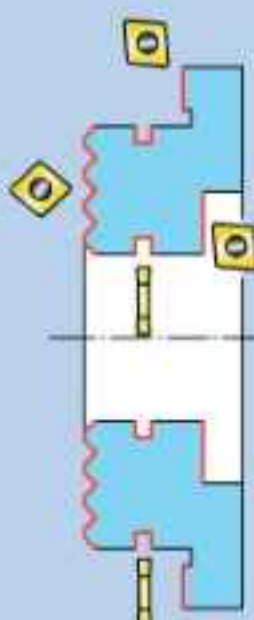
AR 125
Ø max 320

AR 160
Ø max 400

REVERSE



START-STOP



TA-SENSITIV 2

FACING AND
BORING HEADS

new



ARBORS MHD'

MILLING-BORING MACHINE-CONVENTIONAL MACHINES

TA-S2.120
Ø max 250

TA-S2.170
Ø max 400

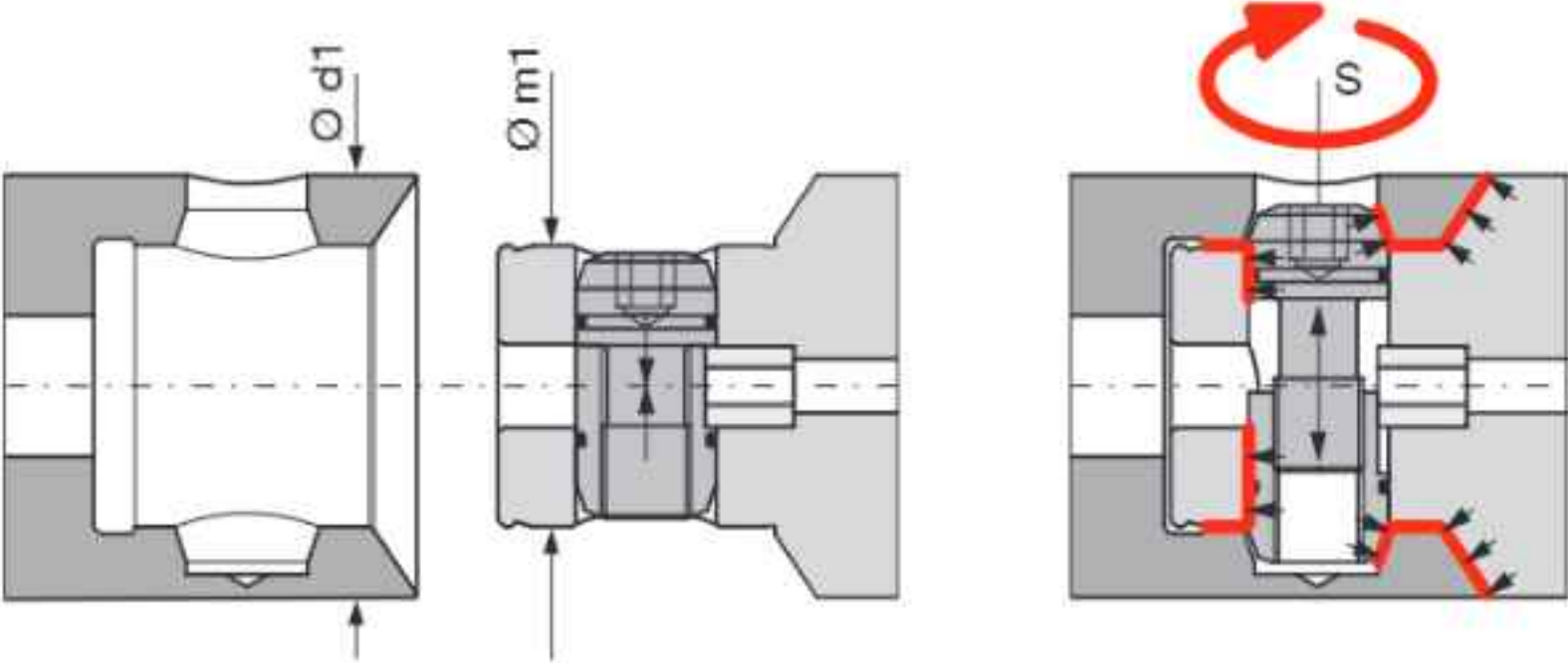


High-precision modular toolholders that allows to perform boring, milling and drilling operations with extreme flexibility and rigidity.

The MHD' coupling is the heart of the tool system Modulhard'andrea. Available in 8 sizes, it guarantees the interchangeability of all the elements of the system, which includes arbors, extensions, reductions and toolholder adapters.

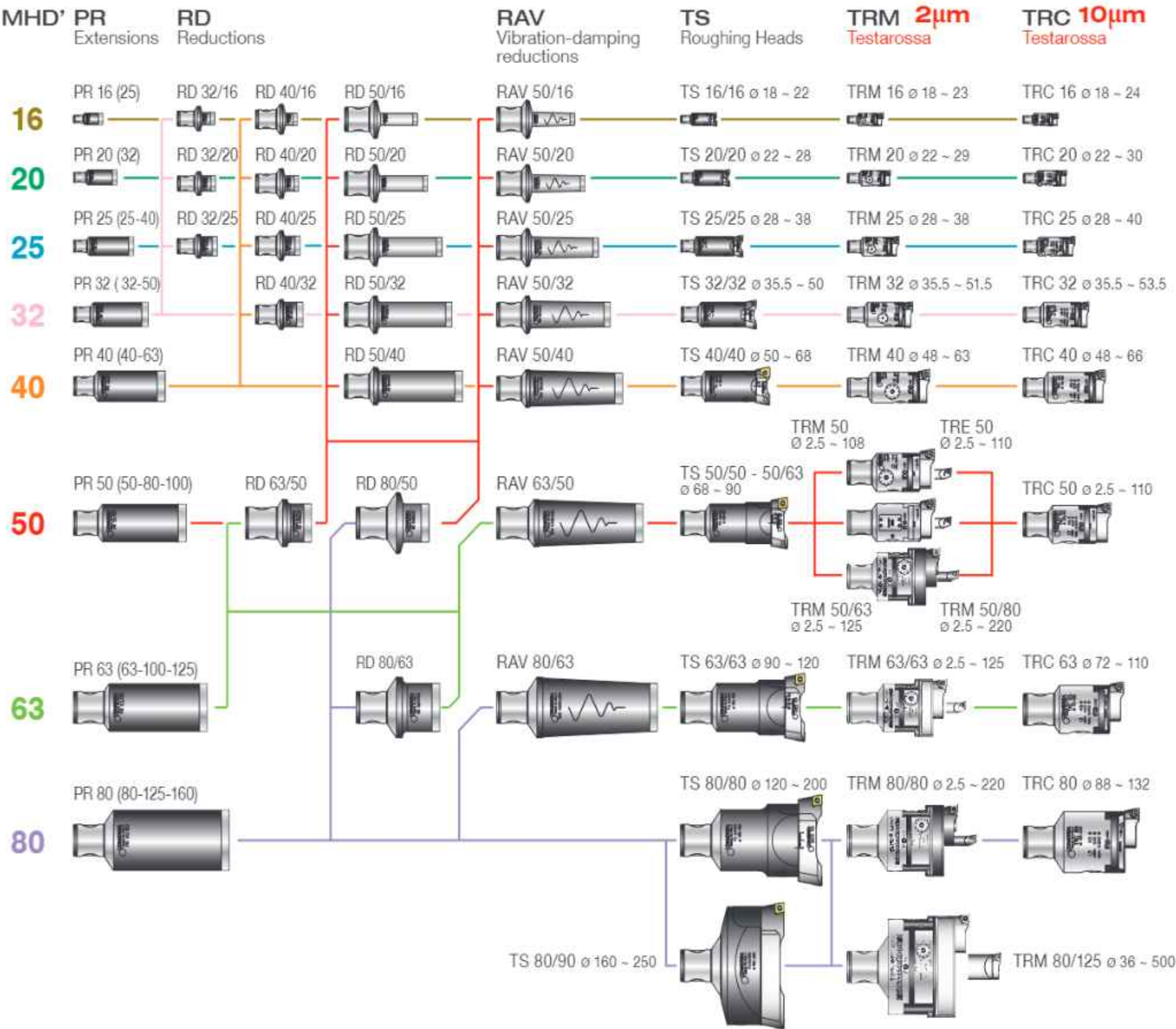


MHD' COUPLING



MHD'	Ø d1	Ø m1	⬡ S	N·m
16	16	10	2,5	2 - 2,5
20	20	13	3	4 - 4,5
25	25	16	3	6,5 - 7,5
32	32	20	4	7 - 8
40	40	25	5	16 - 18
50	50	32	6	30 - 35
63	63	42	8	70 - 80
80	80	42	8	70 - 80

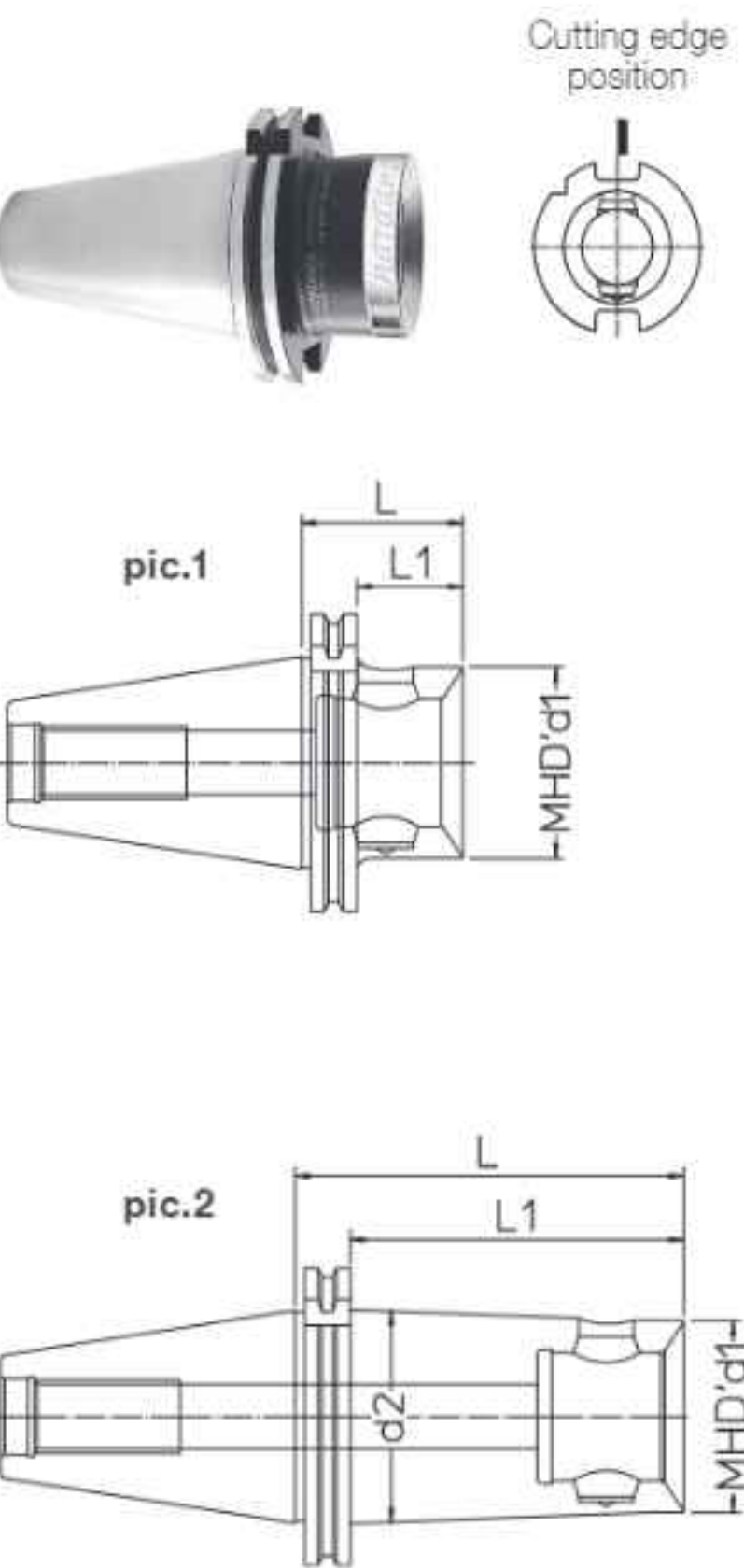
ARBORS
MHD'



CHUCKING
TOOLS



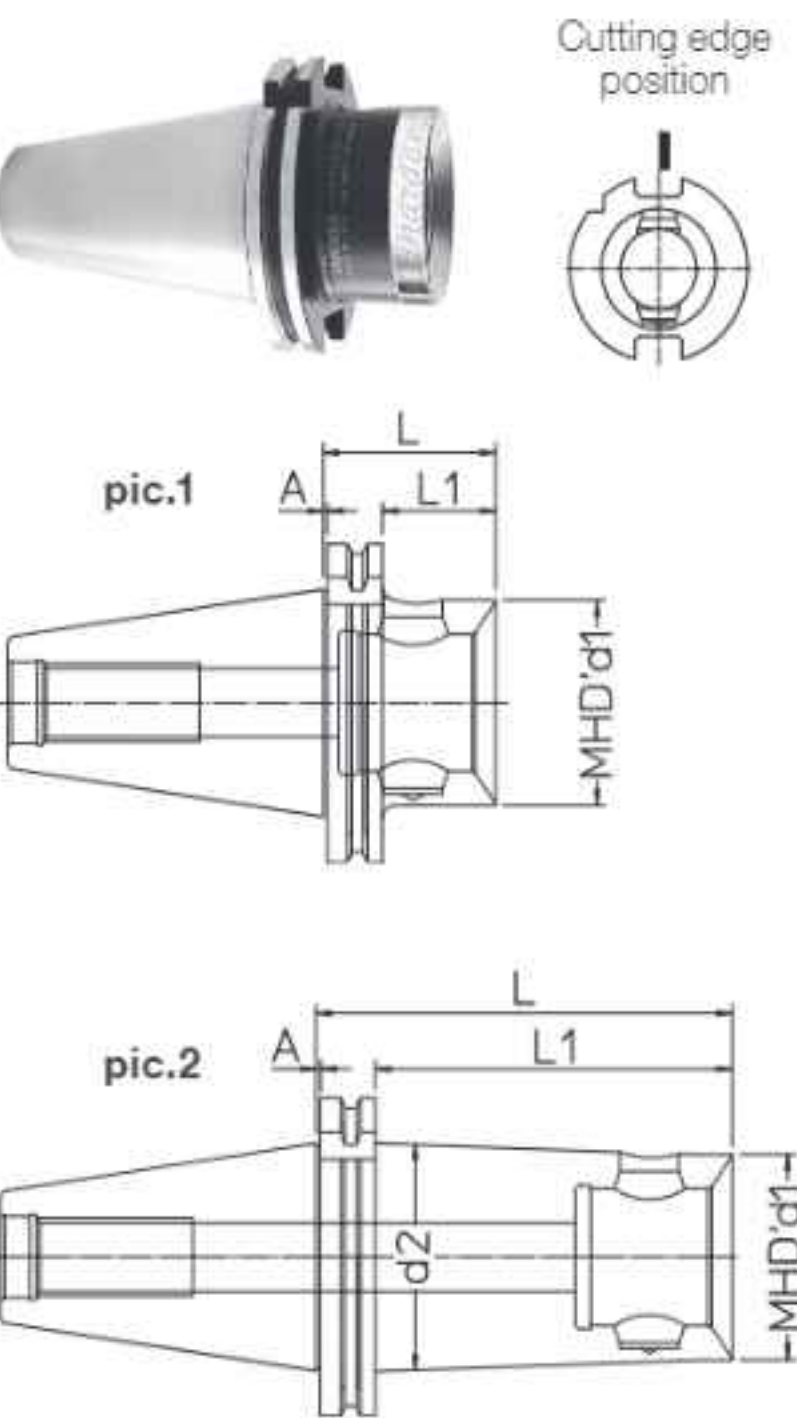
DIN 69871 AD



DIN	REF.	CODE	MHD' d1	d2	L	L1	kg	pic.		
30	DIN69871-AD30 MHD'50.60	416500103020	50		60		0.6	1		
40	DIN69871-AD40 MHD'16.40	416160414020	16		40	21	0.7	1		
40	DIN69871-AD40 MHD'16.63	416160614020	16	17.5	63	44	0.8	2		
40	DIN69871-AD40 MHD'16.100	416161014020	16	20	100	81	0.9	2		
40	DIN69871-AD40 MHD'20.50	416200514020	20		50	31	0.8	1		
40	DIN69871-AD40 MHD'20.80	416200814020	20	22.5	80	61	0.9	2		
40	DIN69871-AD40 MHD'20.125	416201214020	20	25.5	125	106	1	2		
40	DIN69871-AD40 MHD'25.50	416250514020	25		50	31	0.9	1		
40	DIN69871-AD40 MHD'25.80	416250814020	25	27	80	61	1	2		
40	DIN69871-AD40 MHD'25.125	416251214020	25	30	125	106	1.1	2		
40	DIN69871-AD40 MHD'32.50	416320514020	32		50	31	1	1		
40	DIN69871-AD40 MHD'32.80	416320814020	32	33.5	80	61	1.1	2		
40	DIN69871-AD40 MHD'32.125	416321214020	32	36.5	125	106	1.2	2		
40	DIN69871-AD40 MHD'40.45	416400104020	40		45	26	0.5	1		
40	DIN69871-AD40 MHD'40.120	416401214020	40	44.5	120	101	1.4	2		
40	DIN69871-AD40 MHD'50.48	416500104020	50		48	29	0.9	1		
40	DIN69871-AD40 MHD'50.120	416501214020	50		120	101	1.7	1		
40	DIN69871-AD40 MHD'63.80	416630104020	63		80		1.5	1		
50	DIN69871-AD50 MHD'50.48	416500105020	50		48	29	2.5	1		
50	DIN69871-AD50 MHD'50.120	416501215020	50	60	120	101	3.5	2		
50	DIN69871-AD50 MHD'63.56	416630105020	63		56	37	2.8	1		
50	DIN69871-AD50 MHD'63.150	416631515020	63	70	150	131	5	2		
50	DIN69871-AD50 MHD'80.62	416800105020	80		62	43	3.4	1		
50	DIN69871-AD50 MHD'80.180	416801815020	80		180	161	7.6	1		

B-shape arbors – on request

DIN 69871 FC AD FACE CONTACT

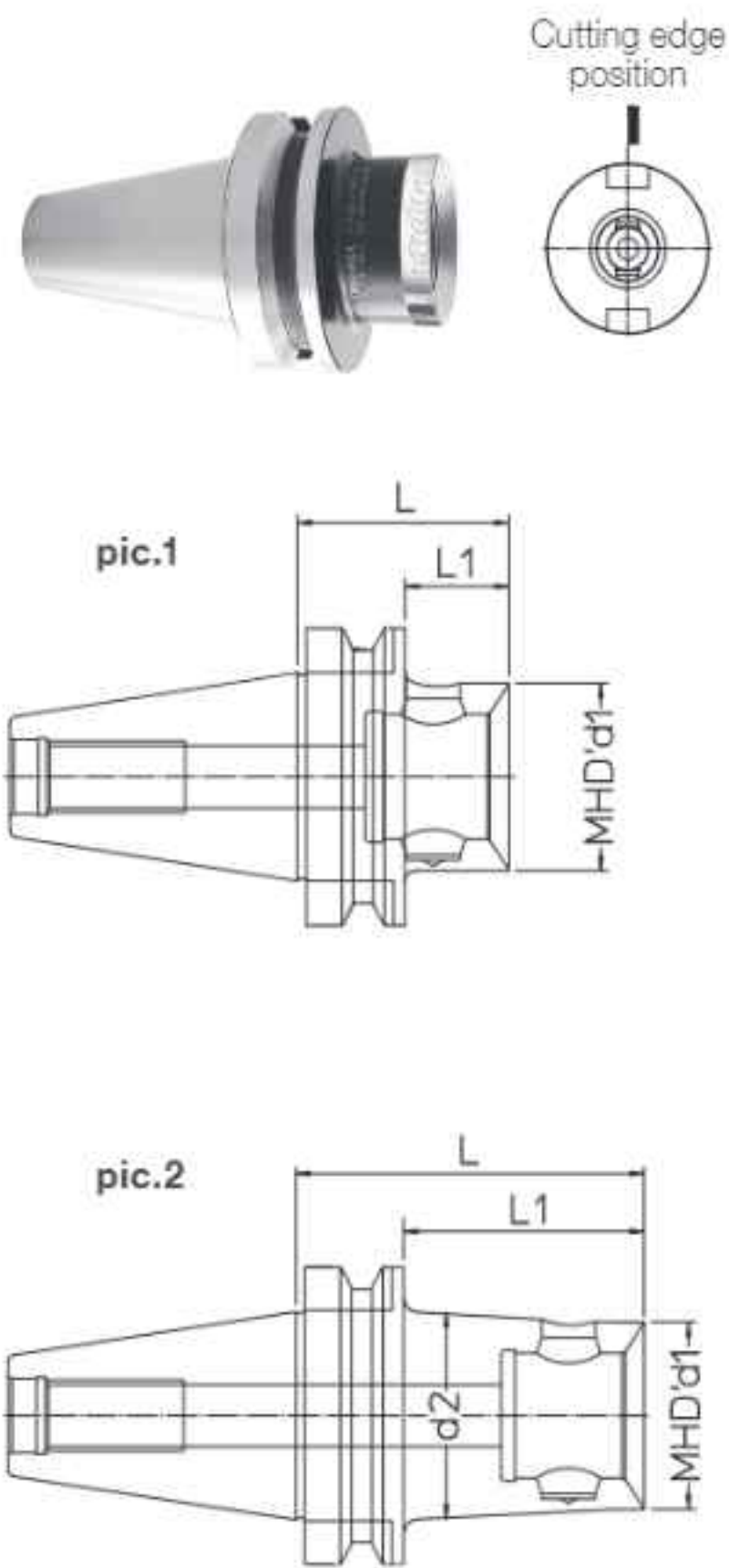


DIN	REF.	CODE	MHD' d1	d2	A	L	L1	kg	pic.		
40	DIN69871-AD40 FC MHD'50.48	416500104020F	50	1	48	29	0.9	1			
40	DIN69871-AD40 FC MHD'50.120	416501214020F	50	1	120	101	1.7	1			
40	DIN69871-AD40 FC MHD'63.80	416630104020F	63	1	80		1.5	1			
50	DIN69871-AD50 FC MHD'50.48	416500105020F	50	1.5	48	29	2.5	1			
50	DIN69871-AD50 FC MHD'50.120	416501215020F	50	59	1.5	120	101	3.5	2		
50	DIN69871-AD50 FC MHD'50.200	416502015020F	50	68	1.5	200	181	6.1	2		
50	DIN69871-AD50 FC MHD'63.56	416630105020F	63	1.5	56	37	2.8	1			
50	DIN69871-AD50 FC MHD'63.150	416631515020F	63	75.5	1.5	150	131	5.2	2		
50	DIN69871-AD50 FC MHD'63.250	416632515020F	63	80	1.5	250	231	7.1	2		
50	DIN69871-AD50 FC MHD'80.62	416800105020F	80	1.5	62	43	3.4	1			
50	DIN69871-AD50 FC MHD'80.180	416801815020F	80	1.5	180	161	6.9	1			
50	DIN69871-AD50 FC MHD'80.300	416803015020F	80	1.5	300	281	9.2	1			

B-shape arbors – on request

Manufactured according to DIN 69871 and MAS 403 BT standards,
made in case-hardened, tempered and grinded steel. BALANCING UP TO 8000 RPM.

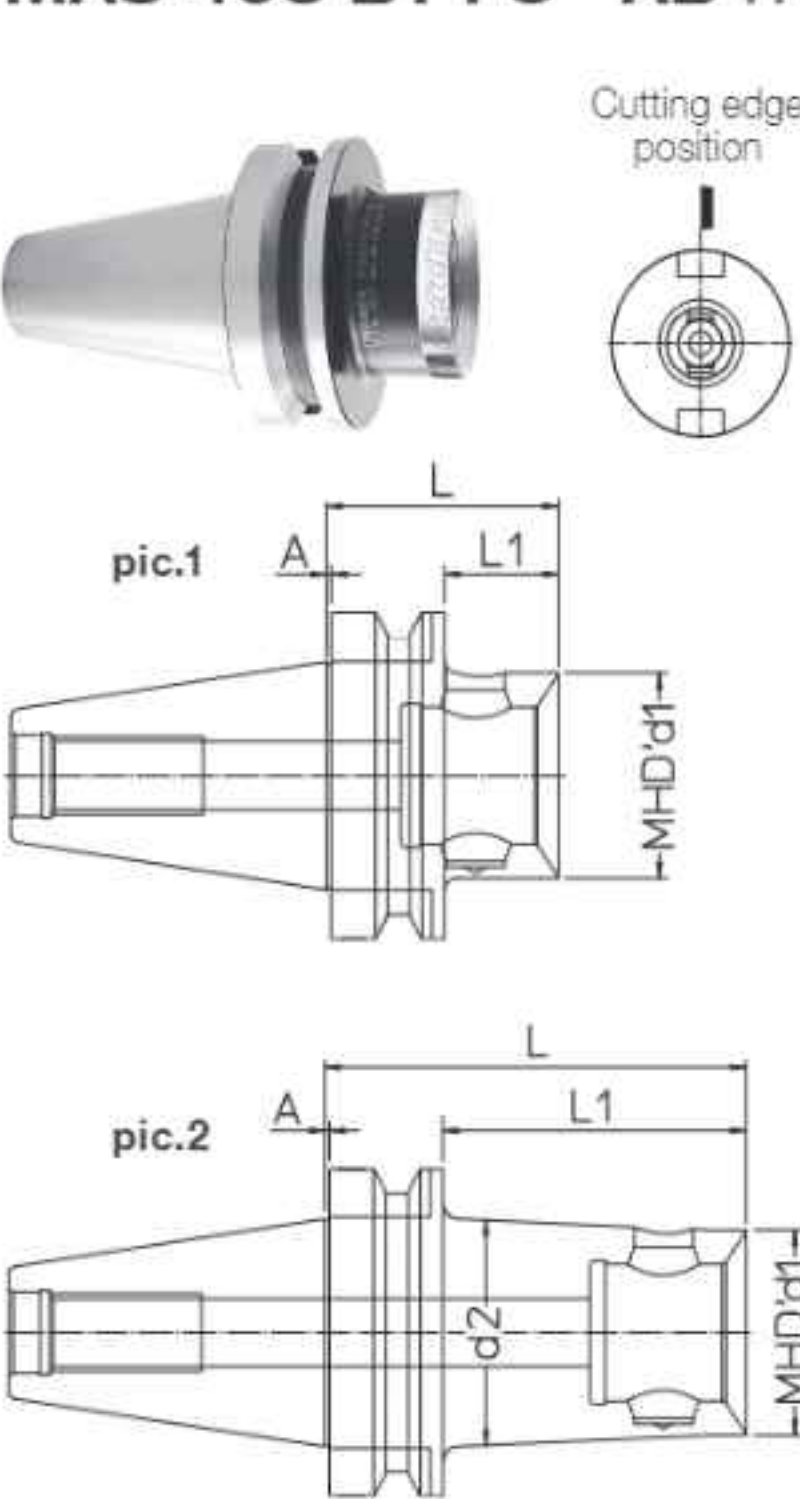
MAS 403 BT AD



BT	REF.	CODE	MHD' d1	d2	L	L1	kg	pic.		
30	MAS403 BT30-AD MHD'50.60	416500103030	50		60		0.7	1		
40	MAS403 BT40-AD MHD'16.45	416160414030	16		45	18	0.8	1		
40	MAS403 BT40-AD MHD'16.63	416160614030	16	17	63	36	0.9	2		
40	MAS403 BT40-AD MHD'16.100	416161014030	16	19.5	100	73	1	2		
40	MAS403 BT40-AD MHD'20.50	416200514030	20		50	23	0.9	1		
40	MAS403 BT40-AD MHD'20.80	416200814030	20	22	80	53	1	2		
40	MAS403 BT40-AD MHD'20.125	416201214030	20	25	125	98	1.1	2		
40	MAS403 BT40-AD MHD'25.50	416250514030	25		50	23	1	1		
40	MAS403 BT40-AD MHD'25.80	416250814030	25	26.5	80	53	1.1	2		
40	MAS403 BT40-AD MHD'25.125	416251214030	25	29.5	125	98	1.2	2		
40	MAS403 BT40-AD MHD'32.50	416320514030	32			23	1.1	1		
40	MAS403 BT40-AD MHD'32.80	416320814030	32	33	80	53	1.2	2		
40	MAS403 BT40-AD MHD'32.125	416321214030	32	36	125	98	1.4	2		
40	MAS403 BT40 AD MHD'40.45	416400104030	40		45	18	0.6	1		
40	MAS403 BT40-AD MHD'40.120	416401214030	40	44.5	120	93	0.9	2		
40	MAS403 BT40-AD MHD'50.48	416500104030	50		48	21	0.9	1		
40	MAS403 BT40-AD MHD'50.120	416501214030	50		120	93	1.9	2		
40	MAS403 BT40-AD MHD'63.66	416630104030	63		66		1.2	1		
50	MAS403 BT50-AD MHD'50.66	416500105030	50		66	28	3.3	1		
50	MAS403 BT50-AD MHD'50.120	416501215030	50	60	120	82	4.2	2		
50	MAS403 BT50-AD MHD'63.75	416630105030	63		75	37	3.7	1		
50	MAS403 BT50-AD MHD'63.150	416631515030	63	70	150	112	5.8	2		
50	MAS403 BT50-AD MHD'80.75	416800105030	80		75	37	4	1		
50	MAS403 BT50-AD MHD'80.180	416801815030	80		180	142	7.5	2		

B-shape arbors – on request

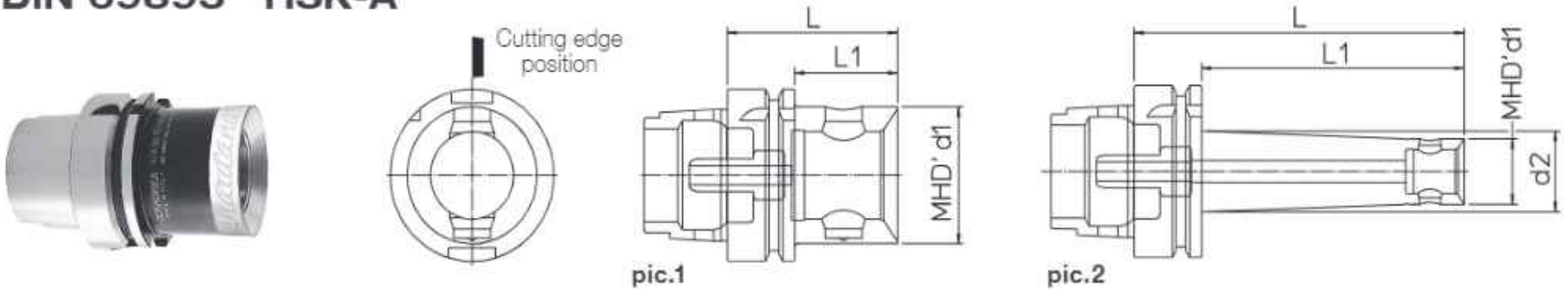
MAS 403 BT FC AD FACE CONTACT



BT	REF.	CODE	MHD' d1	d2	A	L	L1	kg	pic.		
40	MAS403 BT40-AD FC MHD'50.48	416500104030F	50		1	48	21	0.9	1		
40	MAS403 BT40-AD FC MHD'50.120	416501214030F	50		1	120	93	1.9	1		
40	MAS403 BT40-AD FC MHD'63.66	416630104030F	63		1	66		1.2	1		
50	MAS403 BT50-AD FC MHD'50.66	416500105030F	50		1.5	66	28	3.2	1		
50	MAS403 BT50-AD FC MHD'50.120	416501215030F	50	57.5	1.5	120	82	4.2	2		
50	MAS403 BT50-AD FC MHD'50.200	416502015030F	50	66	1.5	200	162	4.5	2		
50	MAS403 BT50-AD FC MHD'63.75	416630105030F	63		1.5	75	37	3.7	1		
50	MAS403 BT50-AD FC MHD'63.150	416631515030F	63	73.5	1.5	150	112	5.8	2		
50	MAS403 BT50-AD FC MHD'63.250	416632515030F	63	84	1.5	250	212	6.1	2		
50	MAS403 BT50-AD FC MHD'80.75	416800105030F	80		1.5	75	37	4	1		
50	MAS403 BT50-AD FC MHD'80.180	416801815030F	80		1.5	180	142	7.5	1		
50	MAS403 BT50-AD FC MHD'80.300	416803015030F	80		1.5	300	262	9.2	1		

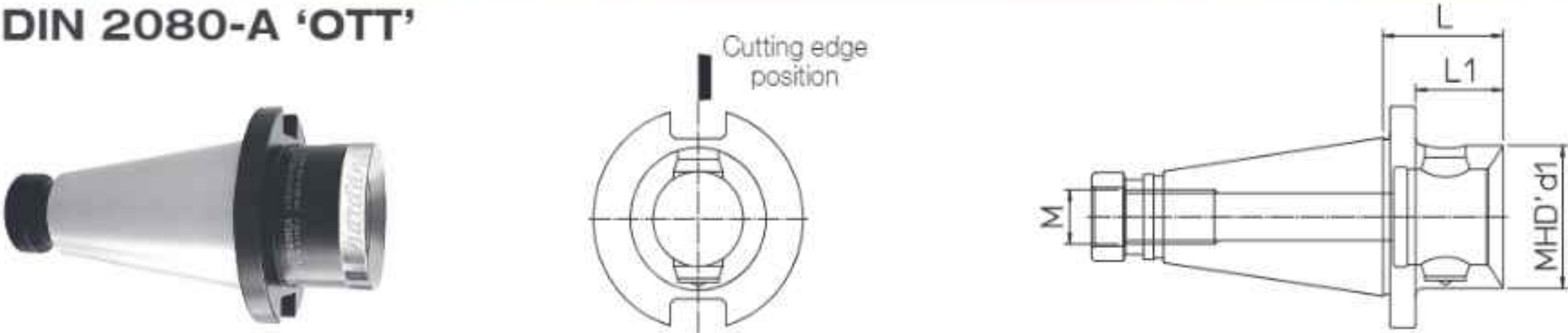
B-shape arbors – on request

DIN 69893 HSK-A



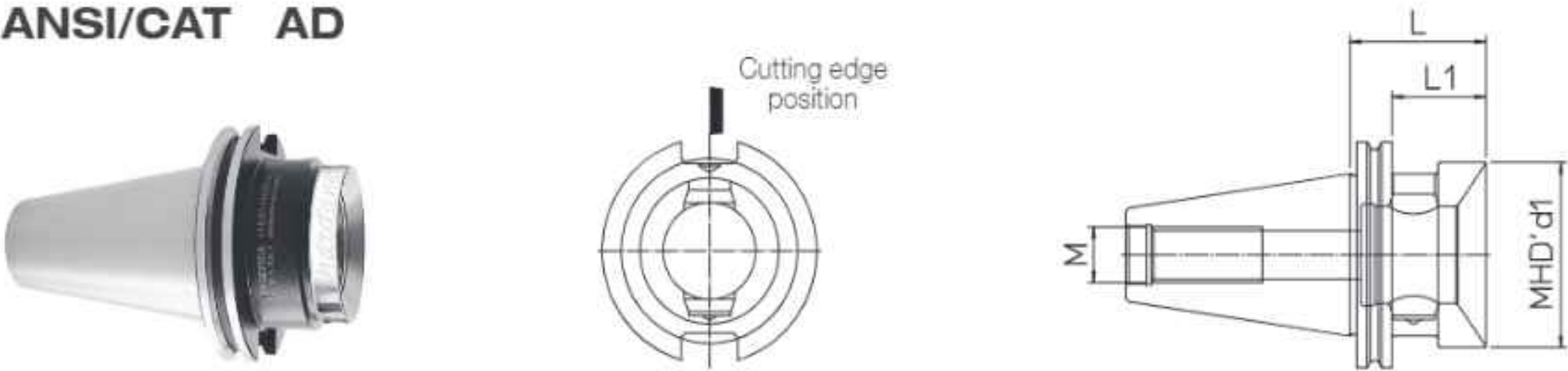
Supplied with coolant tube									
HSK-A	REF.	CODE	MHD' d1	d2	L	L1	kg	pic.	
50	HSK-A50 MHD'50.66	416501505020	50		66		0.6	1	
63	HSK-A63 MHD'16.100	416161056320	16	19.5	100	74	0.8	2	
63	HSK-A63 MHD'20.125	416201256320	20	25	125	99	0.9	2	
63	HSK-A63 MHD'25.125	416251256320	25	29.5	125	99	1	2	
63	HSK-A63 MHD'32.90	416320956320	32	33.5	90	64	1	2	
63	HSK-A63 MHD'32.125	416321256320	32	36	125	99	1.2	2	
63	HSK-A63 MHD'40.60	416401506320	40		60	34	0.7	1	
63	HSK-A63 MHD'40.120	416401506328	40	46	120	94	1.4	2	
63	HSK-A63 MHD'50.66	416501506320	50		66	40	0.9	1	
63	HSK-A63 MHD'50.120	416501506328	50		120	94	1.7	1	
63	HSK-A63 MHD'63.75	416631506320	63		75		1.1	1	
80	HSK-A80 MHD'50.70	416501508020	50		70	44	1.5	1	
80	HSK-A80 MHD'63.80	416631508020	63		80	54	1.8	1	
100	HSK-A100 MHD'50.72	416501510020	50		72	43	2.4	1	
100	HSK-A100 MHD'63.82	416631510020	63		82	53	2.7	1	
100	HSK-A100 MHD'50.120	416501510028	50	60	120	91	3.2	2	
100	HSK-A100 MHD'80.88	416801510020	80		88	59	3	1	
100	HSK-A100 MHD'63.150	416631510028	63	70	150	121	4.5	2	
100	HSK-A100 MHD'80.180	416801510028	80		180	151	6.5	1	

DIN 2080-A 'OTT'



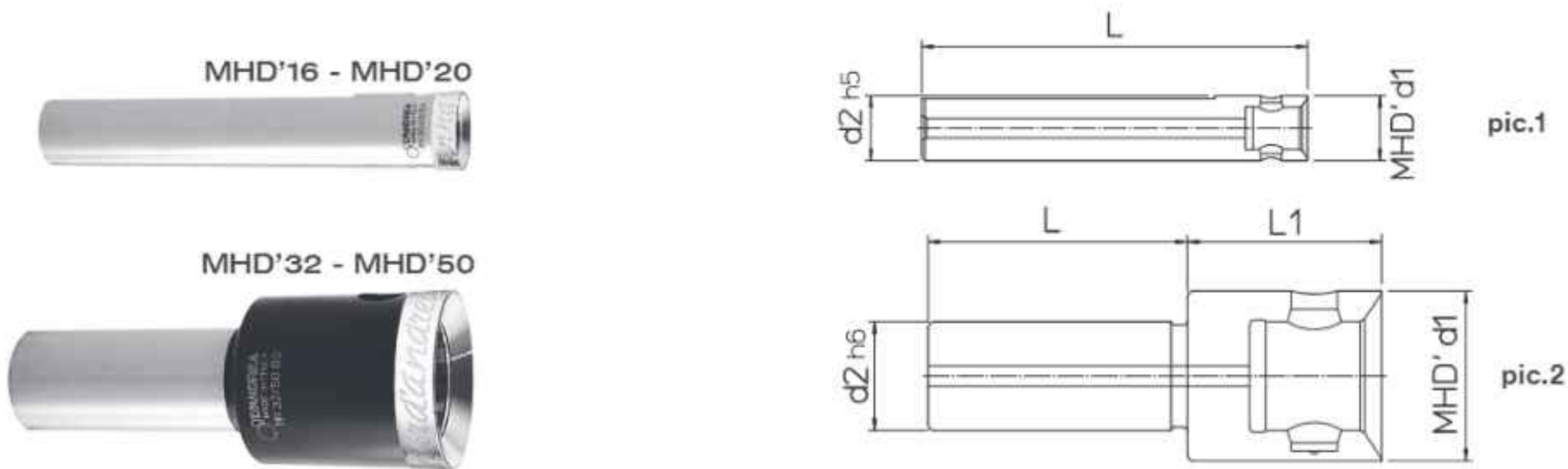
DIN	REF.	CODE	MHD' d1	L	L1	M	kg		
30	DIN2080-A30 MHD'50.58	416500103000	50	58		M12	0.6		
40	DIN2080-A40 MHD'50.48	416500104000	50	48	36.5	M16	0.9		
40	DIN2080-A40 MHD'63.60	416630104000	63	60		M16	1.2		
50	DIN2080-A50 MHD'50.48	416500105000	50	48	33	M24	2.6		
50	DIN2080-A50 MHD'63.56	416630105000	63	56	41	M24	2.7		
50	DIN2080-A50 MHD'80.60	416800105000	80	60	45	M24	3.2		

ANSI/CAT AD



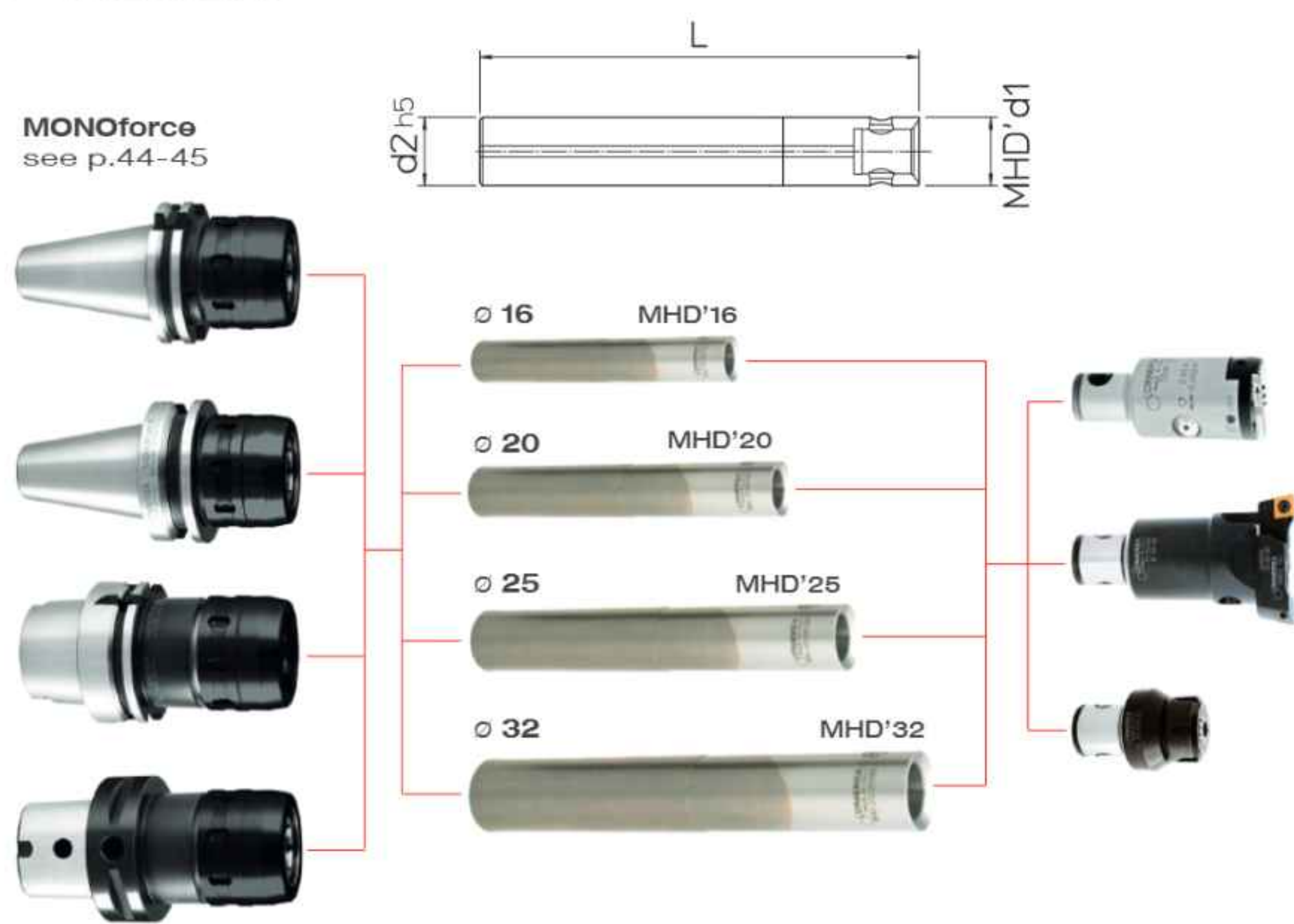
ANSI/CAT	REF.	CODE	MHD' d1	L	L1	M	kg		
40	ANSI/CAT40 MHD'50.66	416500104040	50	66	47	M16	1.1		
40	ANSI/CAT40 MHD'63.100	416630104040	63	100		M16	1.9		
50	ANSI/CAT50 MHD'50.48	416500105040	50	48	29	M24	2.4		
50	ANSI/CAT50 MHD'63.56	416630105040	63	56	37	M24	2.9		
50	ANSI/CAT50 MHD'80.62	416800105040	80	62	43	M24	3.2		

BR STEEL BARS



REF.	CODE	MHD' d1	L	L1	d2	kg	pic.		
BR 16/16.100	657081601001	16	100		16	0.15	1		
BR 20/20.125	657082001251	20	125		20	0.3	1		
BR 25/32.35	416320802500	32	65	35	25	0.7	2		
BR 32/50.60	416500803200	50	80	60	32	1	2		

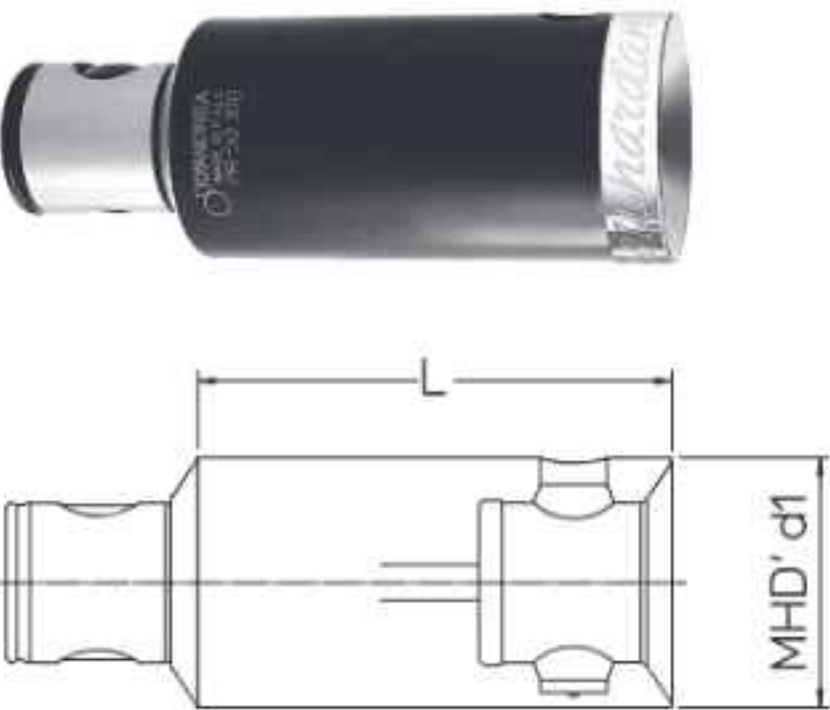
BMD CARBIDE BARS



REF.	CODE	MHD' d1	d2	L	kg		
BMD 16/16.110	657081601105	16	16	110	0.3		
BMD 16/16.140	657081601405	16	16	140	0.4		
BMD 16/16.170	657081601705	16	16	170	0.5		
BMD 20/20.135	657082001355	20	20	135	0.6		
BMD 20/20.170	657082001705	20	20	170	0.75		
BMD 20/20.210	657082002105	20	20	210	0.9		
BMD 25/25.160	657082501605	25	25	160	1		
BMD 25/25.205	657082502055	25	25	205	1.3		
BMD 25/25.255	657082502555	25	25	255	1.6		
BMD 32/32.195	657083201955	32	32	195	2.1		
BMD 32/32.250	657083202505	32	32	250	2.8		
BMD 32/32.315	657083203155	32	32	315	3.5		

PR EXTENSIONS

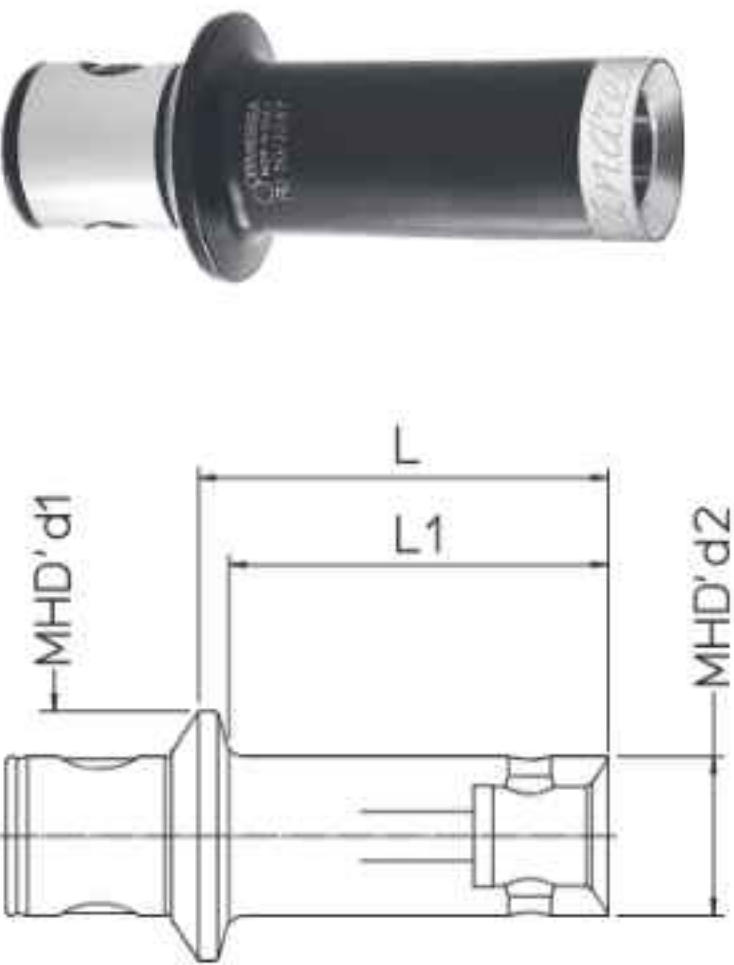
For each MHD size there are extensions of different lengths that can be used to achieve the desired machining depths.



REF.	CODE	MHD' d1	L	kg		
PR 16.25	656901600250	16	25	0.04		
PR 20.32	656902000320	20	32	0.07		
PR 25.25	656902500250	25	25	0.09		
PR 25.40	656902500400	25	40	0.15		
PR 32.32	656903200320	32	32	0.2		
PR 32.50	656903200500	32	50	0.3		
PR 40.40	656904000400	40	40	0.4		
PR 40.63	656904000630	40	63	0.6		
PR 50.50	656905000500	50	50	0.7		
PR 50.80	656905000800	50	80	1.1		
PR 50.100	656905001000	50	100	1.5		
PR 63.63	656906300630	63	63	1.4		
PR 63.100	656906301000	63	100	2.2		
PR 63.125	656906301250	63	125	2.9		
PR 80.80	656908000800	80	80	3		
PR 80.125	656908001250	80	125	4.6		
PR 80.160	656908001600	80	160	6.1		

RD REDUCTIONS

The reductions allow the use of MHD components of a smaller size thereby optimising the composition of the tool according to the overall dimensions.



REF.	CODE	MHD' d1	MHD' d2	L	L1	kg		
RD 20/16.20	657002000160	20	16	20	16	0.05		
RD 25/16.20	657002500160	25	16	20	15	0.07		
RD 25/20.25	657002500200	25	20	25	20	0.08		
RD 32/16.24	657003200160	32	16	24	18	0.10		
RD 32/20.25	657003200200	32	20	25	20	0.12		
RD 32/25.28	657003200250	32	25	28	23	0.14		
RD 40/16.24	657004000160	40	16	24	17	0.18		
RD 40/20.26	657004000200	40	20	26	20	0.2		
RD 40/25.28	657004000250	40	25	28	22	0.25		
RD 40/32.32	657004000320	40	32	32	27	0.3		
RD 50/16.24	657005000160	50	16	24	15	0.34		
RD 50/16.40	657005000162	50	16	40	32	0.2		
RD 50/16.74	657005000163	50	16	74	65	0.25		
RD 50/20.26	657005000200	50	20	26	18	0.37		
RD 50/20.70	657005000202	50	20	70	62	0.3		
RD 50/20.93	657005000203	50	20	93	85	0.35		
RD 50/25.28	657005000250	50	25	28	21	0.4		
RD 50/25.87	657005000252	50	25	87	80	0.6		
RD 50/25.117	657005000253	50	25	117	110	0.65		
RD 50/32.32	657005000320	50	32	32	25	0.45		
RD 50/32.87	657005000322	50	32	87	80	0.75		
RD 50/32.144	657005000323	50	32	144	137	1		
RD 50/40.36	657005000400	50	40	36	30	0.5		
RD 50/40.87	657005000402	50	40	87	80	0.9		
RD 50/40.176	657005000403	50	40	176	170	1.8		
RD 63/50.40	657006300500	63	50	40	34	0.9		
RD 80/50.45	657008000500	80	50	45	36	1.2		
RD 80/63.60	657008000630	80	63	60	52	1.7		

RAV VIBRATION-DAMPING



Anti-vibration reductions for deep or heavy-duty machining.

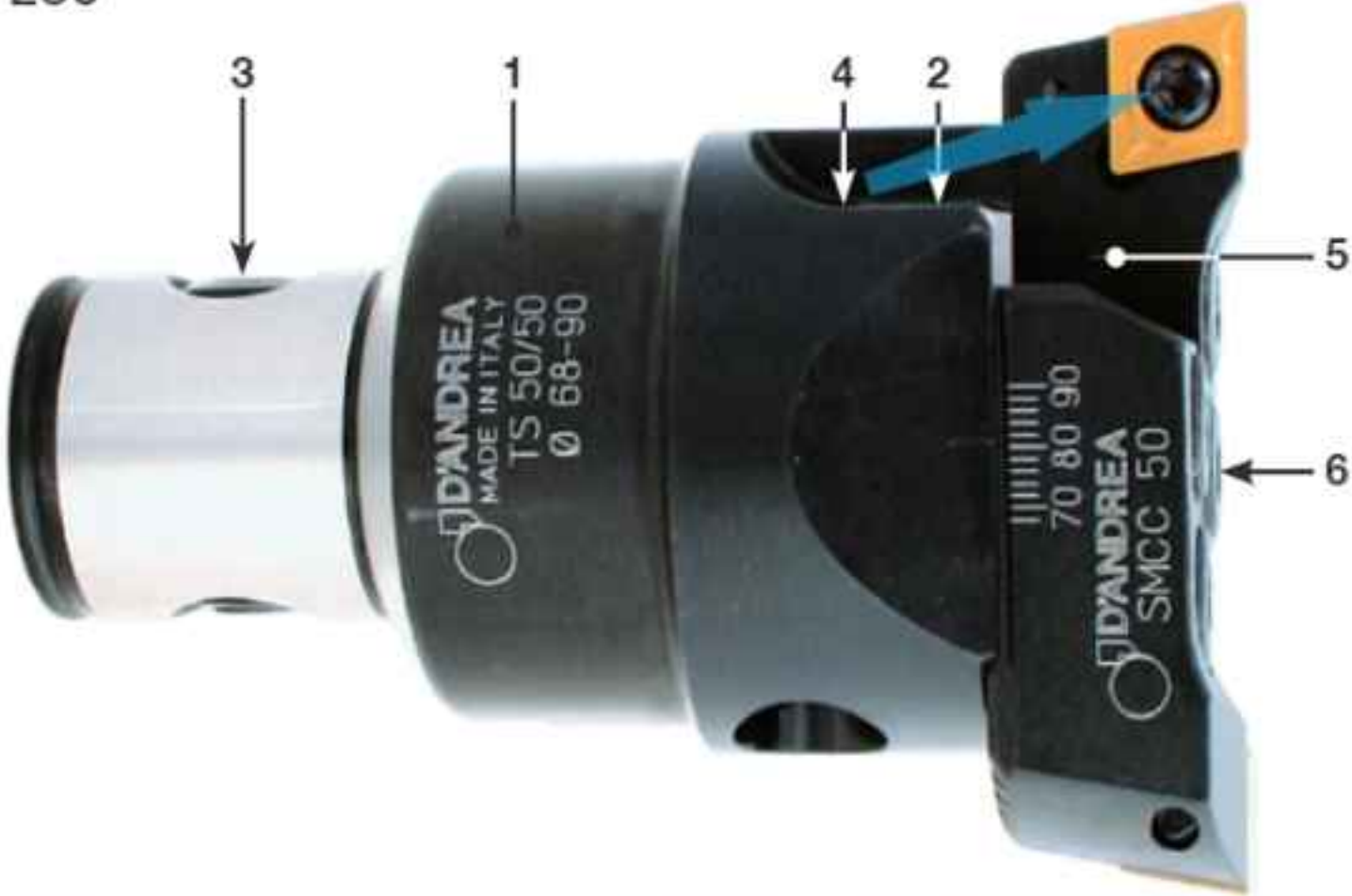
REF.	CODE	MHD' d1	MHD' d2	d3	L	L1	kg		
RAV 50/16.74	657005000165	50	16	17.5	74	65	0.4		
RAV 50/20.93	657005000205	50	20	21.5	93	85	0.5		
RAV 50/25.117	657005000255	50	25	27	117	110	0.8		
RAV 50/32.144	657005000325	50	32	35	144	138	1.4		
RAV 50/40.176	657005000405	50	40	47	176	170	2.5		
RAV 63/50.220	657006300505	63	50	60	220	214	5.6		
RAV 80/63.280	657008000635	80	63	77	280	272	10.6		

BORING



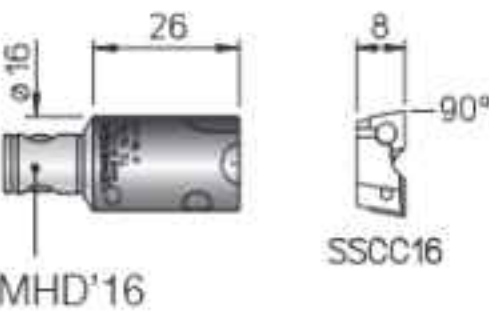
TS 16 ~ 80 Ø 18 ~ 250

Simple and extremely rigid roughing heads, thanks to the serrated surfaces between the head body and the bit holders. The constant distance between the bit holder clamping screw and the cutting edge guarantees the stability of the system.



- 1. Body
- 2. Setting screws
- 3. Expanding pin
- 4. Coolant outlets
Max BAR 40
- 5. Bit holders
- 6. Tools clamp screws

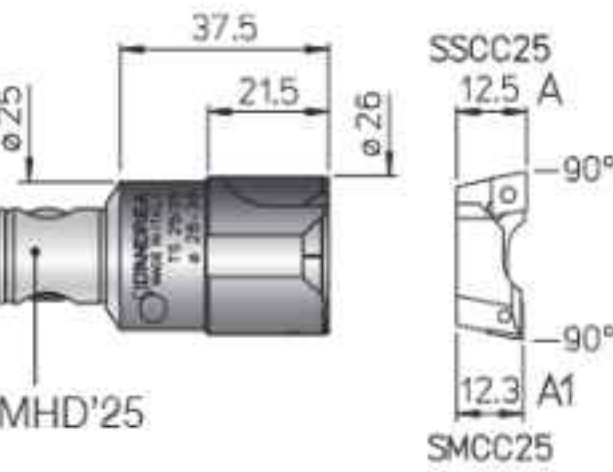
TS 16/16 Ø 18 ~ 22



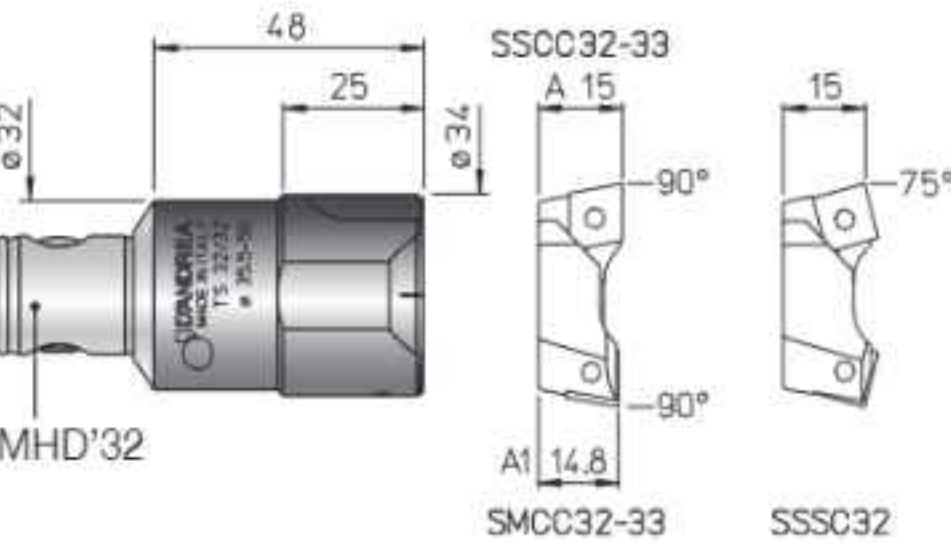
TS 20/20 Ø 22 ~ 28



TS 25/25 Ø 28 ~ 38

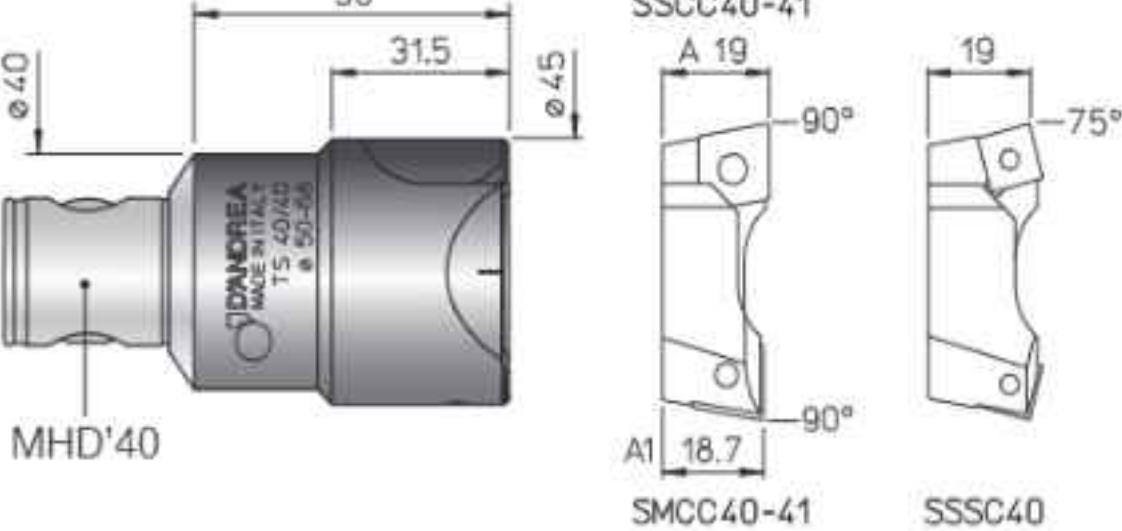


TS 32/32 Ø 35.5 ~ 50

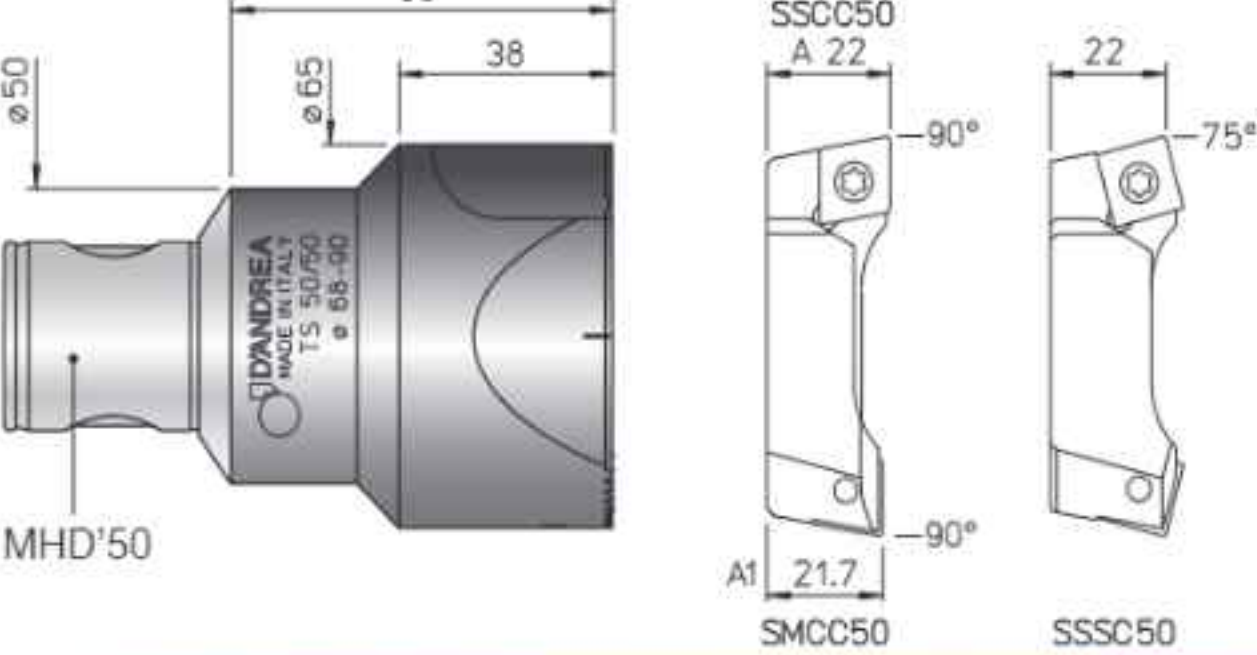


REF.	CODE	kg		
TS 16/16	455501600340	0.05		
TS 20/20	455502000400	0.09		
TS 25/25	455502500510	0.2		
TS 32/32	455503200638	0.35		
TS 40/40	455504040070	0.7		

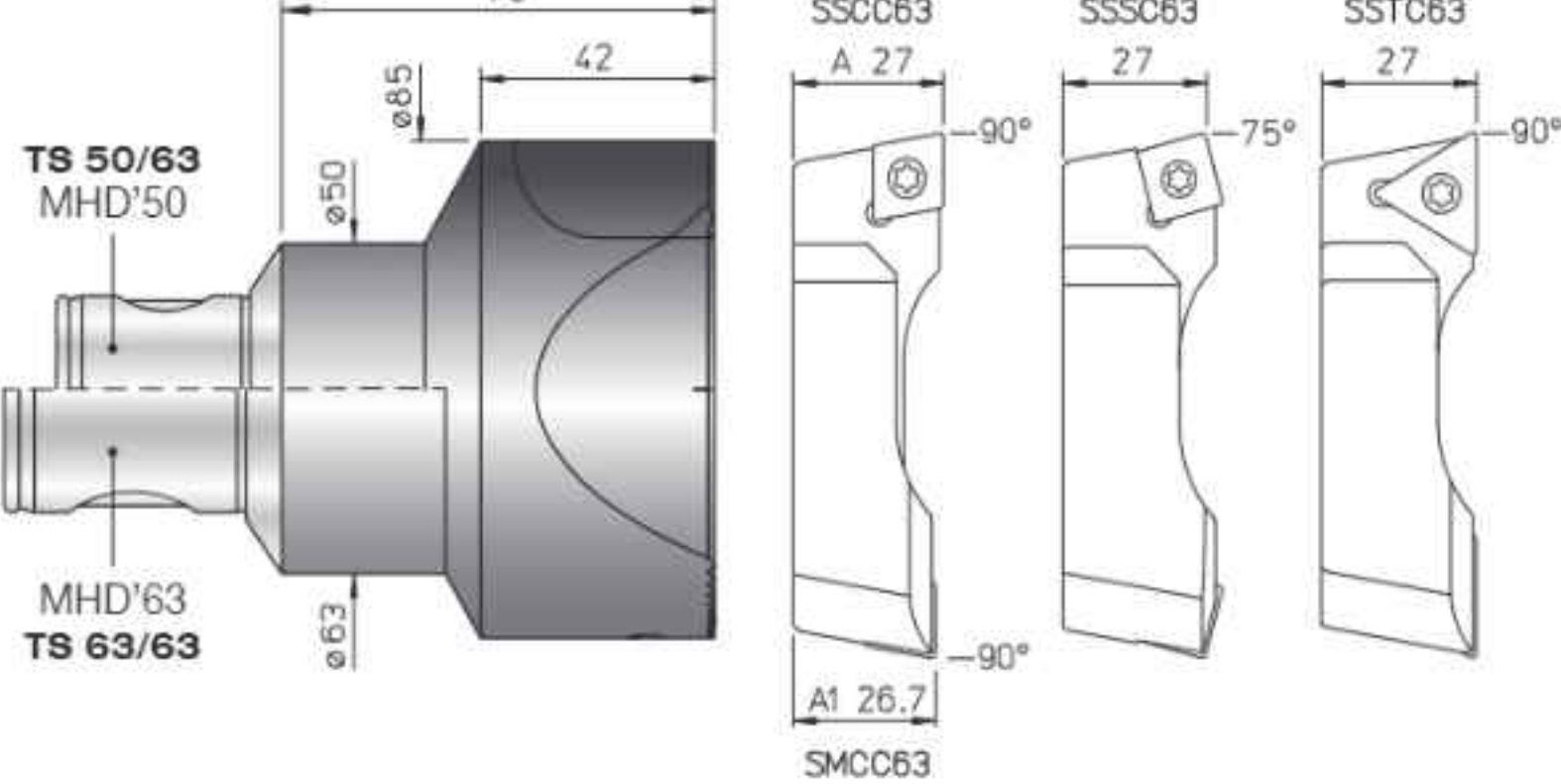
TS 40/40 Ø 50 ~ 68



TS 50/50 Ø 68 ~ 90

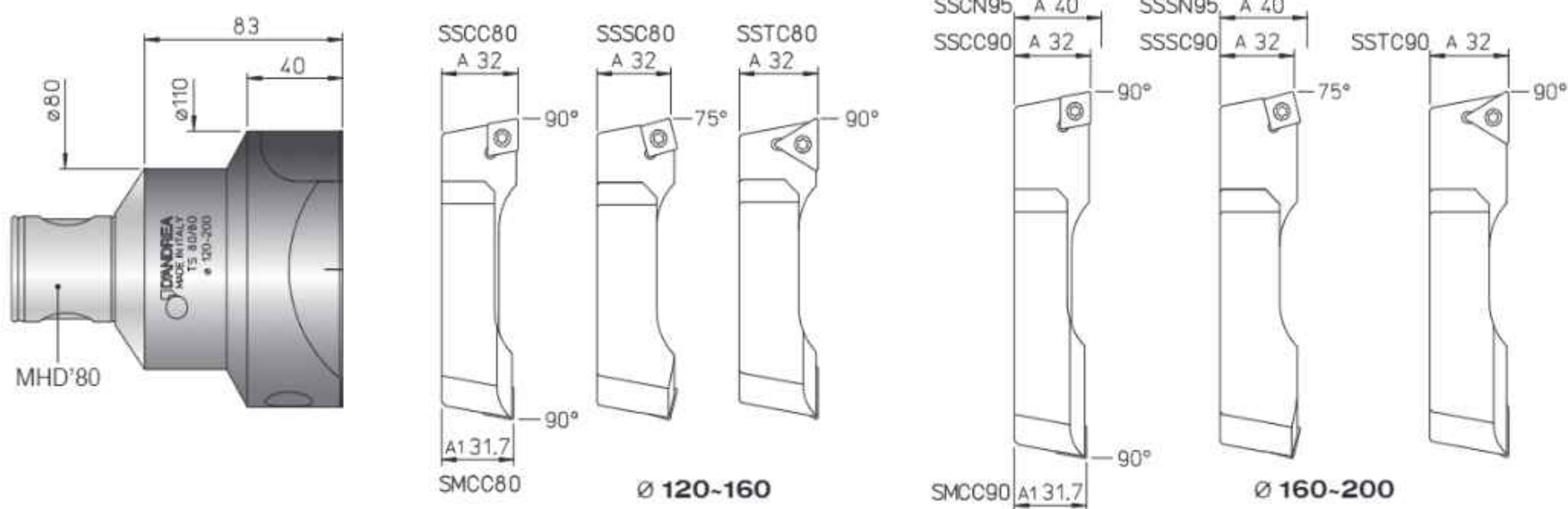


TS 50/63 - TS 63/63 Ø 90 ~ 120



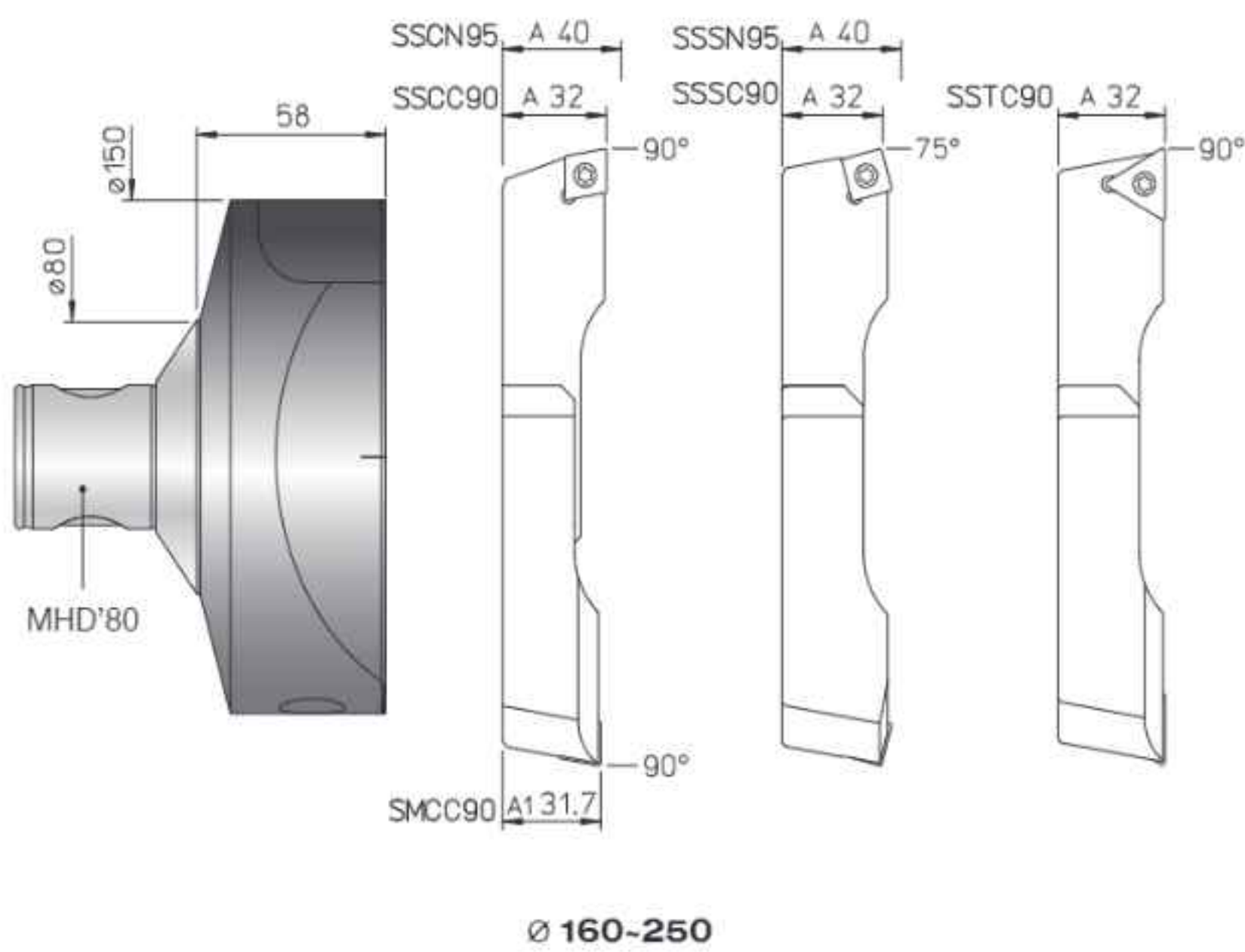
REF.	CODE	kg		
TS 50/50	455505050090	1.5		
TS 50/63	455505063100	2		
TS 63/63	455506363100	3		
TS 80/80	455508080110	5.3		
TS 80/90	455508090090	6.3		

TS 80/80 Ø 120 ~ 200



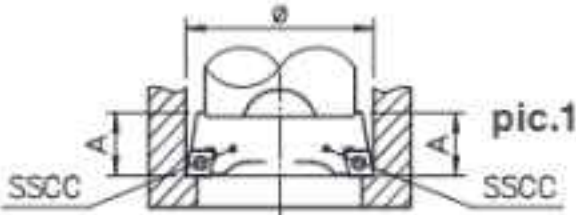
TS 80/90 Ø 160 ~ 250

USE

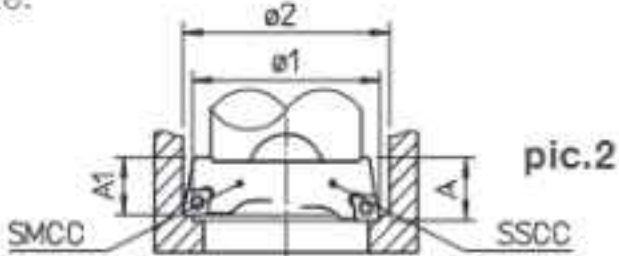


USE TS for ROUGHING end SEMI-FINISHING operations

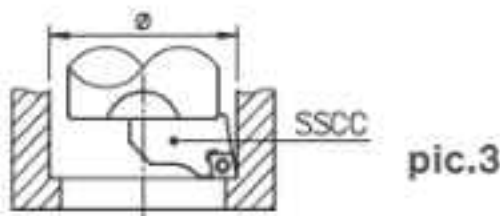
Roughing and semi-finishing operations. Cutting edges might be adjusted on a pre-setting bench and TS heads can be used in three different configurations, with a single cutting edge (pic. 3) or misaligned ones (pic.2) half the feed.



pic.1 with two SSCC bit holders aligned and on the same diameter for roughing operations with high feedrate.



pic. 2 with one SSCC bit holder and one SMCC bit holder staggered and on a different diameter for roughing operations with high depth of cut.



pic.3 with a single bit holder for roughing or semi-finishing operations.

REF.	CODE	TS TORX T	kg		REF.	CODE	TS TORX T	kg	
SSCC 16	470500516201	CCMT 0602..	25 08	0.003	SMCC 25	470500525203	CCMT 0602..	25 08	0.01
SSCC 20	470500520201	CCMT 0602..	25 08	0.006	SMCC 32	470500532203	CCMT 0602..	25 08	0.02
SSCC 25	470500525201	CCMT 0602..	25 08	0.1	SMCC 33	470500532205	CCMT 09T3..	4 15	0.025
SSCC 32	470500532201	CCMT 0602..	25 08	0.02	SMCC 40	470500540203	CCMT 09T3..	4 15	0.06
SSCC 33	470500532204	CCMT 09T3..	4 15	0.025	SMCC 41	470500540205	CCMT 1204..	5 25	0.06
SSCC 40	470500540201	CCMT 09T3..	4 15	0.06	SMCC 50	470500550205	CCMT 1204..	5 25	0.1
SSCC 41	470500540204	CCMT 1204..	5 25	0.06	SMCC 63	470500563203	CCMT 1204..	5 25	0.2
SSCC 50	470500550204	CCMT 1204..	5 25	0.1	SMCC 80	470500580203	CCMT 1204..	5 25	0.5
SSCC 63	470500563201	CCMT 1204..	5 25	0.2	SMCC 90	470500590203	CCMT 1204..	25 08	0.7
SSCC 80	470500580201	CCMT 1204..	5 25	0.5	SSSC 32	470500532202	SCMT 09T3..	4 15	0.02
SSCC 90	470500590201	CCMT 1204..	5 25	0.7	SSSC 40	470500540202	SCMT 09T3..	4 15	0.06
SSCN 95	470500595201	CNM. 1906..		0.9	SSSC 50	470500550202	SCMT 1204..	5 25	0.1
SSTC 63	470500563206	TCMT 2204..	5 25	0.2	SSSC 63	470500563202	SCMT 1204..	5 25	0.2
SSTC 80	470500580206	TCMT 2204..	5 25	0.5	SSSC 80	470500580202	SCMT 1204..	5 25	0.5
SSTC 90	470500590206	TCMT 2204..	5 25	0.7	SSSC 90	470500590202	SCMT 1204..	5 25	0.7
					SSSN 95	470500595202	SNM. 1906..		0.9

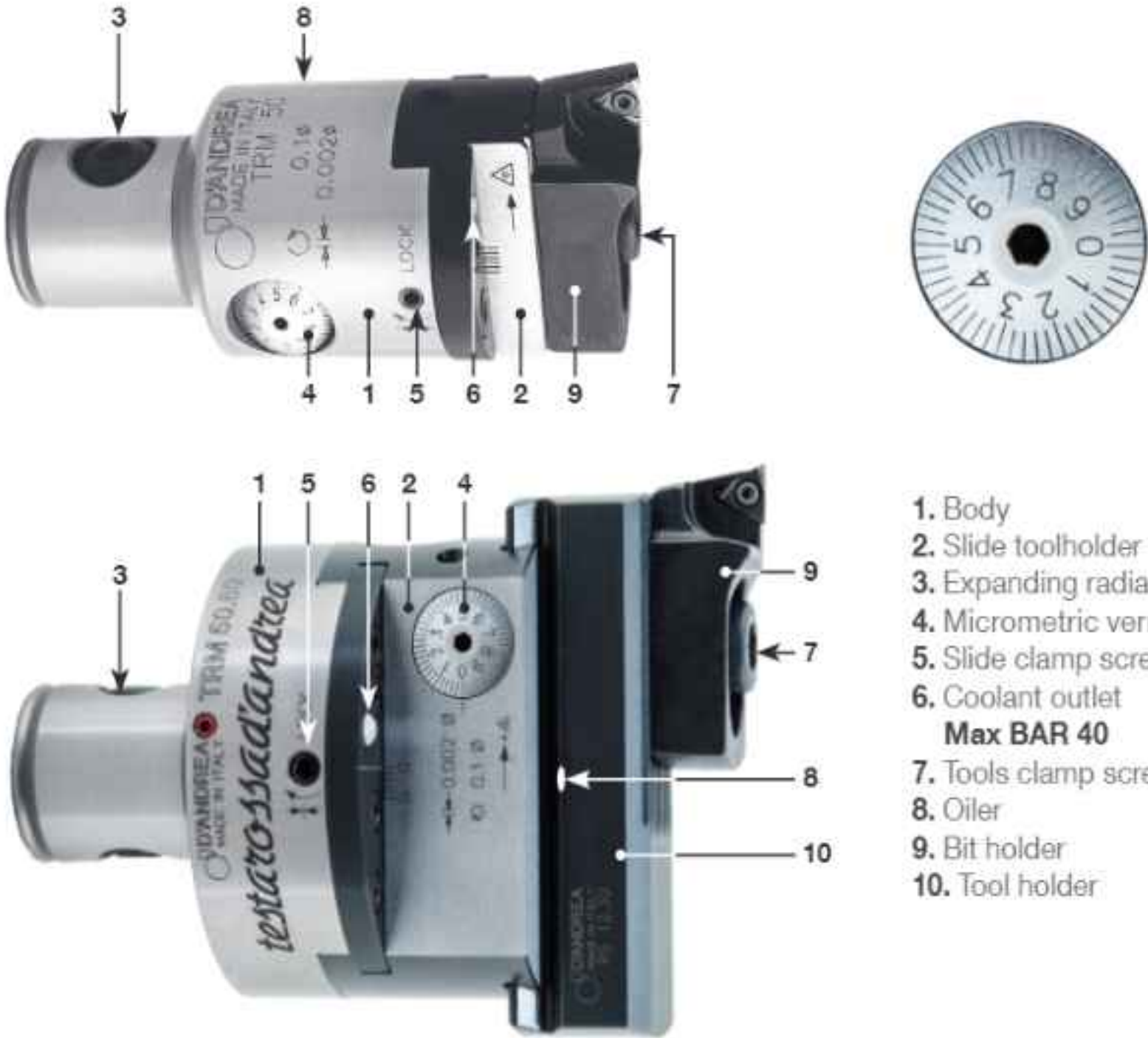
• For back-facing machining see p.26

TRM 16 ~ 125 Ø 2.5 ~ 500

TRM 16	RPM 12.000
TRM 20	RPM 12.000
TRM 25	RPM 10.000
TRM 32	RPM 10.000
TRM 40	RPM 8.000
TRM 50	RPM 8.000
TRM 63	RPM 6.000
TRM 80	RPM 5.000
TRM 125	RPM 4.000

TRM heads allow high precision machining and excellent surface finish in IT6 grade of tolerance. The adjustment sensitivity of **1 micron** on the radius is easily readable on the vernier scale and can also be performed in the machine.

TESTAROSSA MICROMETRIC



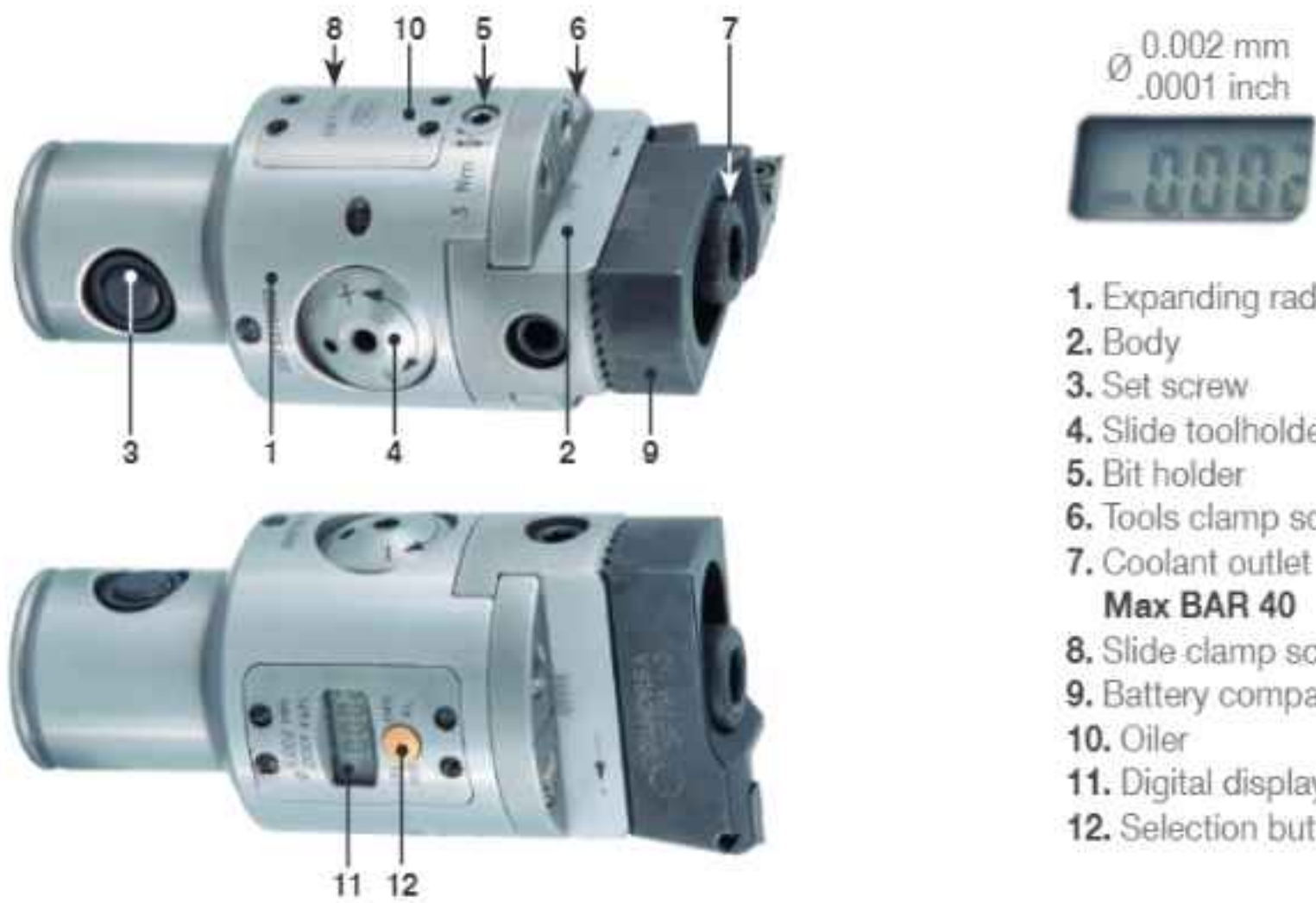
- 1. Body
- 2. Slide toolholder
- 3. Expanding radial pin
- 4. Micrometric vernier scale
- 5. Slide clamp screw
- 6. Coolant outlet
- Max BAR 40
- 7. Tools clamp screws
- 8. Oiler
- 9. Bit holder
- 10. Tool holder

TRE 50 IP69K Ø 2.5 ~ 110

TRE 50 69K	RPM 20.000
------------	------------

TRE heads allow high precision machining and excellent surface finish in IT6 grade of tolerance. The adjustment of **1 micron** on the radius is fast, accurate and easily readable on the integrated display. The TRE 50 is resistant to infiltrations according to the IP69K grade.

TESTAROSSA MICROMETRIC DIGITAL



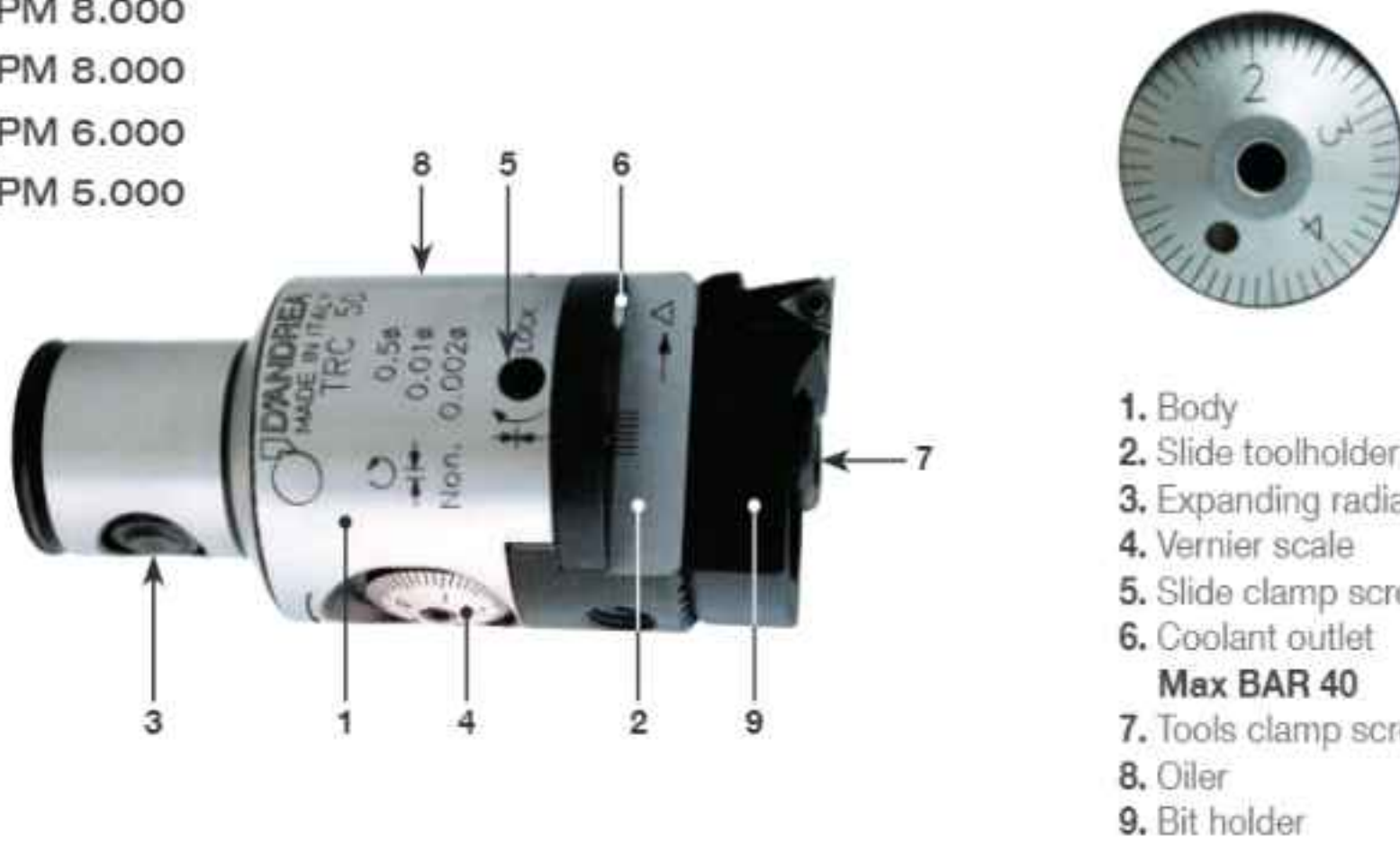
- 1. Expanding radial pin
- 2. Body
- 3. Set screw
- 4. Slide toolholder
- 5. Bit holder
- 6. Tools clamp screws
- 7. Coolant outlet
- Max BAR 40
- 8. Slide clamp screw
- 9. Battery compartment cover
- 10. Oiler
- 11. Digital display
- 12. Selection button

TRC 16 ~ 80 Ø 18 ~ 132

TRC 16	RPM 12.000	TRC 40	RPM 8.000
TRC 20	RPM 12.000	TRC 50	RPM 8.000
TRC 25	RPM 10.000	TRC 63	RPM 6.000
TRC 32	RPM 10.000	TRC 80	RPM 5.000

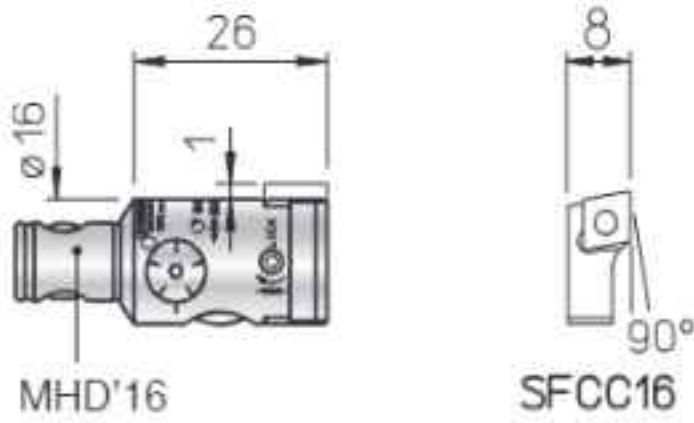
TRC heads allow high precision machining and excellent surface finish in IT7 grade of tolerance. The adjustment of **5 micron** on the radius is easily readable on the vernier scale and can also be performed on the machine.

TESTAROSSA CENTESIMAL

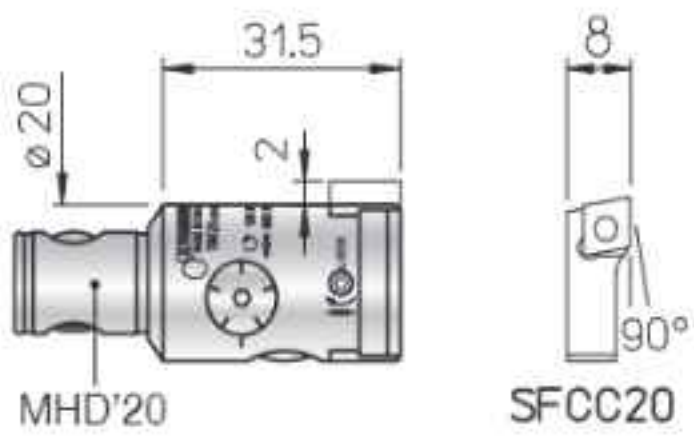


- 1. Body
- 2. Slide toolholder
- 3. Expanding radial pin
- 4. Vernier scale
- 5. Slide clamp screw
- 6. Coolant outlet
- Max BAR 40
- 7. Tools clamp screws
- 8. Oiler
- 9. Bit holder

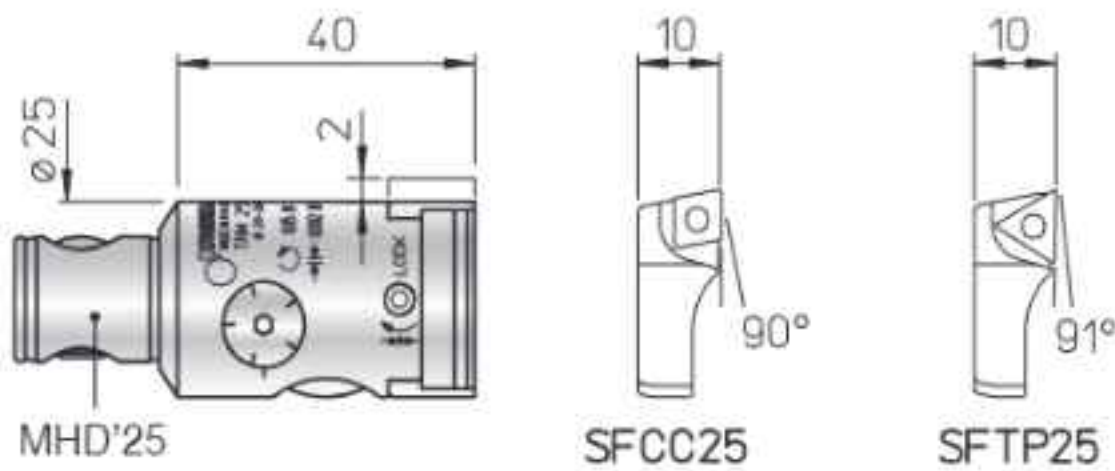
TRM 16 Ø 18 ~ 23



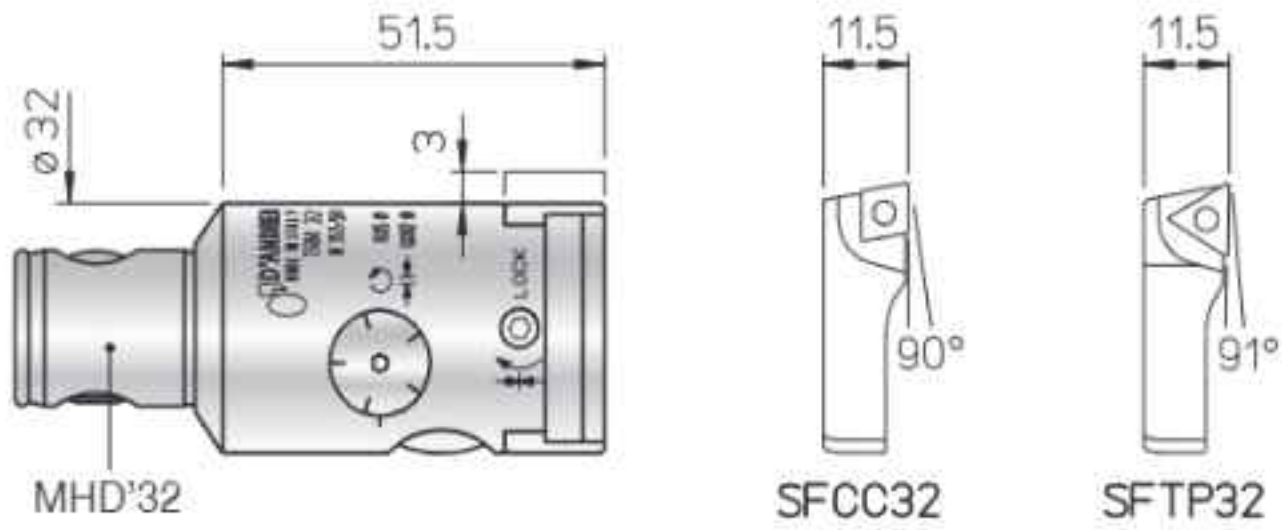
TRM 20 Ø 22 ~ 29



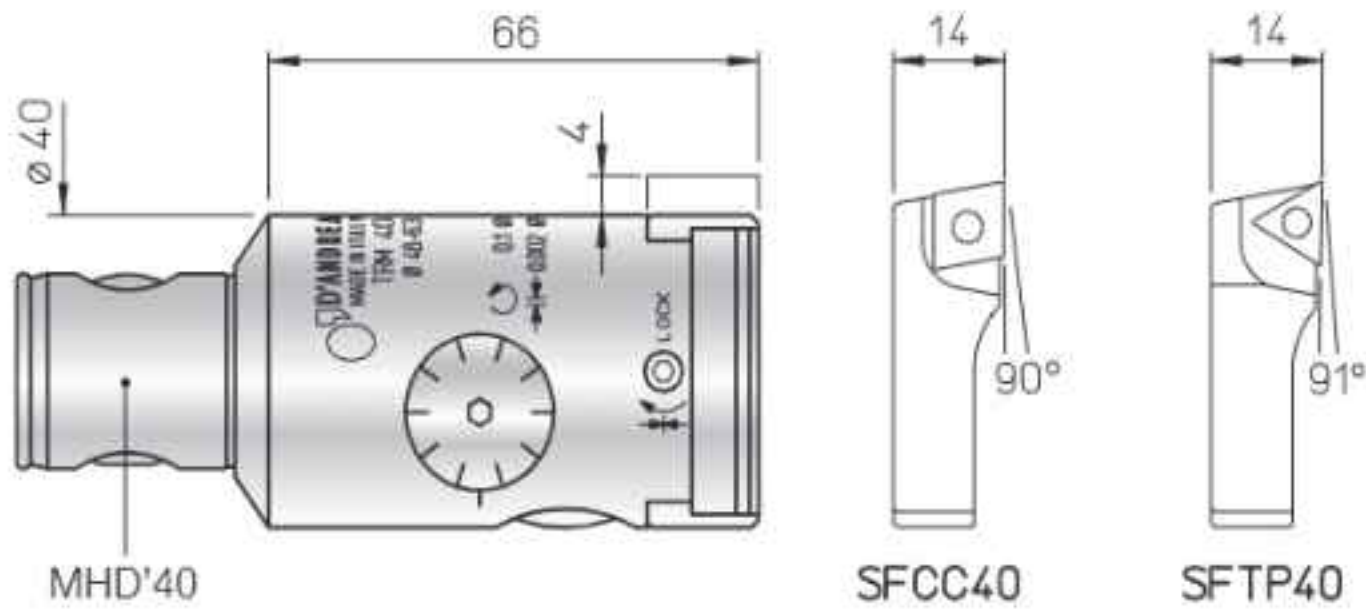
TRM 25 Ø 28 ~ 38



TRM 32 Ø 35.5 ~ 51.5



TRM 40 Ø 48 ~ 63



REF.	CODE	kg		
TRM 16	455001600341	0.05		
TRM 20	455002000401	0.1		
TRM 25	455002500500	0.2		
TRM 32	455003200630	0.35		
TRM 40	455004000800	0.7		

REF.	CODE		TORX T	kg		
SFCC 16	470500516002	CCGT 0602..	TS 25	08	0.003	
SFCC 20	470500520002	CCGT 0602..	TS 25	08	0.006	
SFCC 25	470500525002	CCGT 0602..	TS 25	08	0.01	
SFCC 32	470500532002	CCGT 0602..	TS 25	08	0.02	
SFCC 40	470500540002	CCGT 09T3..	TS 4	15	0.04	
SFTP 25	470500525001	TPGX 0902..	GS 250T	08	0.01	
SFTP 32	470500532001	TPGX 0902..	GS 250T	08	0.02	
SFTP 40	470500540001	TPGX 1103..	CS 300890T	08	0.04	

• For back-facing machining see p.26

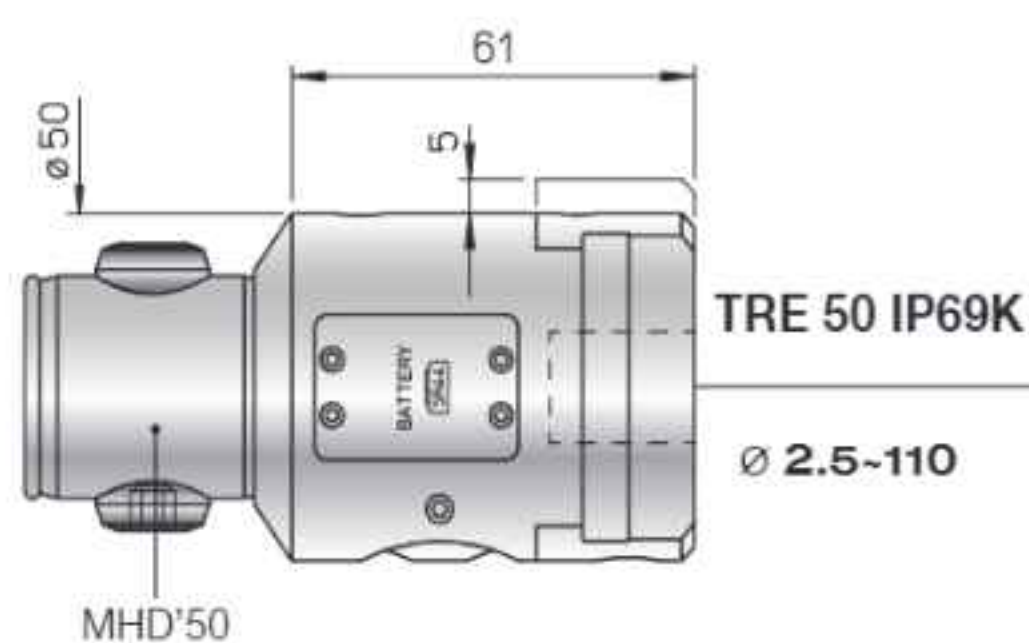
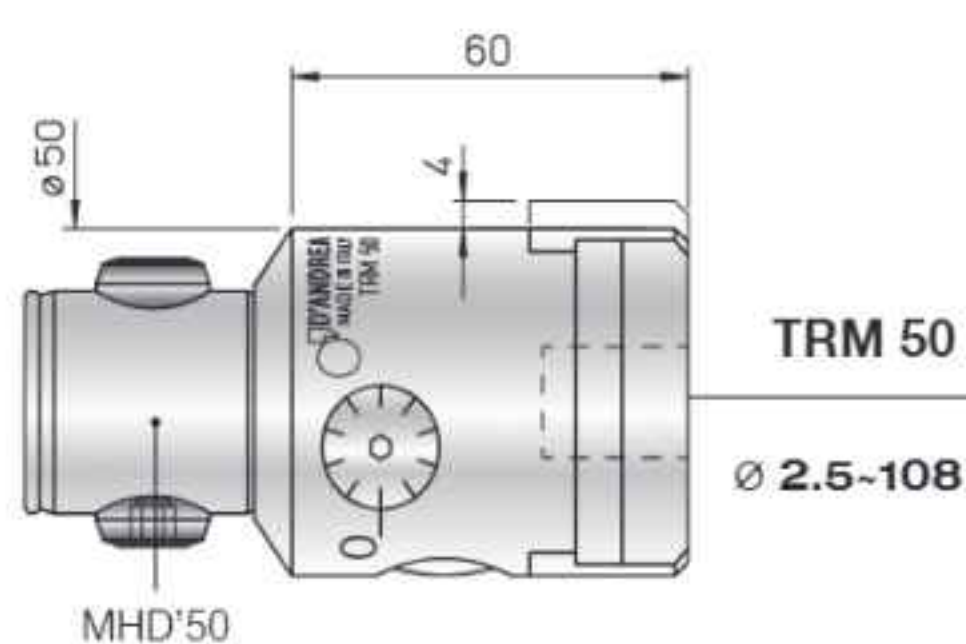
TRM 50 Ø 2.5 ~ 108



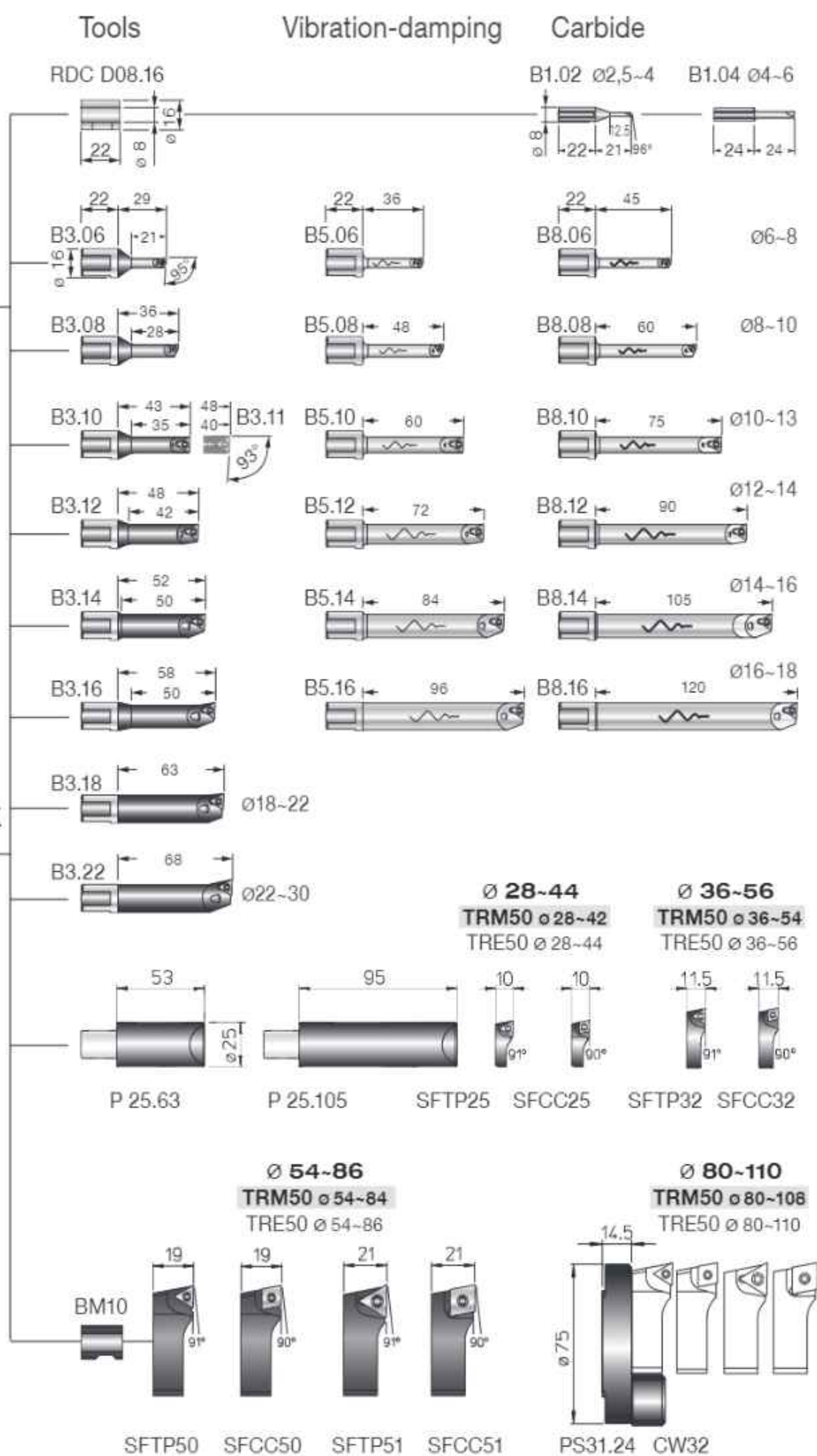
TRE 50 IP69K Ø 2.5 ~ 110



2 μm



REF.	CODE	kg
TRM 50	455005000500	1
TRE 50 IP69K	455200500501	1.1
D08.16	200560116082	0.02
P25.63	435116250631	0.5
P25.105	435116251051	0.8
PS 31.24	433024140751	0.19
CW 32	392011003201	0.07



KIT K01 TRM 50 Ø 6 ~ 108



- 1 TRM 50

1 B3.06

1 B3.08

1 B3.11

1 B3.16

1 B3.22
- 1 SFTP 25

1 SFTP 32

1 SFTP 50

1 P 25.63

1 PS 31.24

1 CW 32
- 5 TPGX 090202L DC100

1 TPGX 110302L DC100

2 WCGT 020102L DC10

REF.	CODE	kg		
KIT K01 TRM 50	655005010501	3.1		

KIT K01 TRE 50 IP69K Ø 6 ~ 110



- 1 TRE 50

1 B3.06

1 B3.08

1 B3.11

1 B3.16

1 B3.22
- 1 SFTP 25

1 SFTP 32

1 SFTP 50

1 P 25.63

1 PS 31.24

1 CW 32
- 5 TPGX 090202L DC100

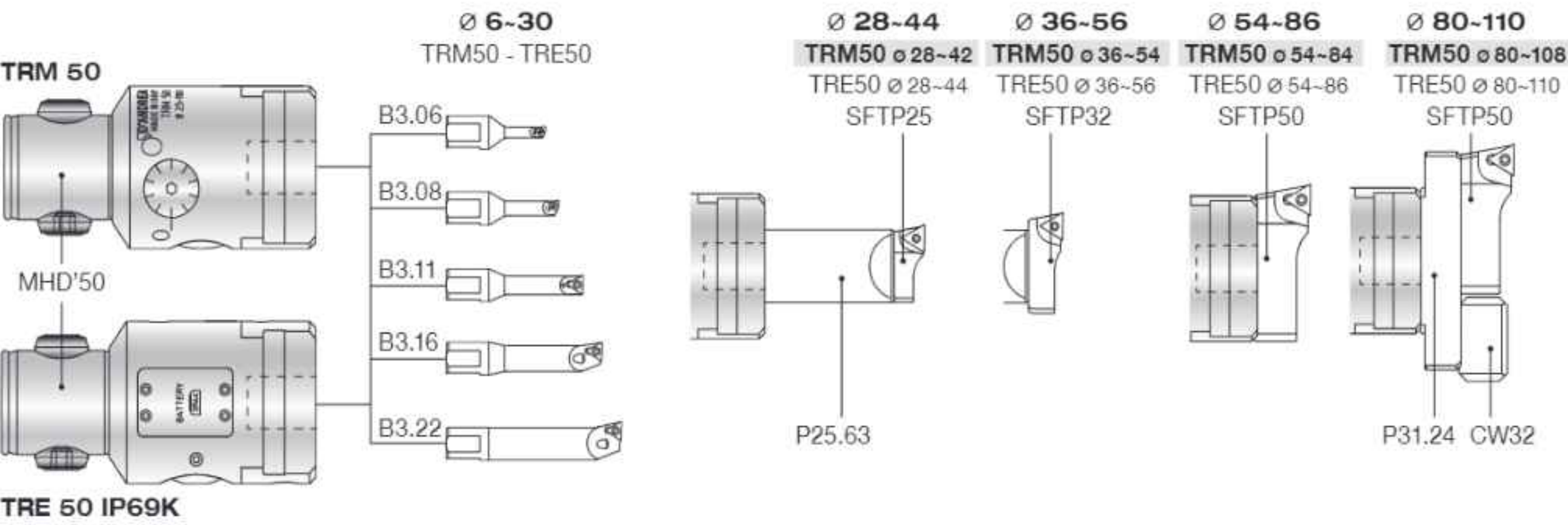
1 TPGX 110302L DC100

2 WCGT 020102L DC10

REF.	CODE	kg		
KIT K01 TRE 50 IP69K	655200500502	3.1		

KIT K01 TRM 50 - TRE 50 IP69K

Working Range



REF.	CODE		TORX T	kg
B1.02	572010502001			0.02
B1.04	572010504001			0.02
B3.06	572010506001	WCGT0201..	TS 21 06	0.035
B3.08	572010508001	WCGT0201..	TS 211 06	0.4
B3.10	572010510001	TPGX0902..	CS 250 T 08	0.05
B3.11	572010511001	TPGX0902..	CS 250 T 08	0.055
B3.12	572010512001	TPGX0902..	CS 250 T 08	0.06
B3.14	572010514001	TPGX0902..	CS 250 T 08	0.07
B3.16	572010516001	TPGX0902..	CS 250 T 08	0.07
B3.18	572010518001	TPGX0902..	CS 250 T 08	0.1
B3.22	572010522001	TPGX0902..	CS 250 T 08	0.1

REF.	CODE		TORX T	kg
B5.06	572010506105	WCGT0201..	TS 21 06	0.075
B5.08	572010508105	WCGT0201..	TS 211 06	0.09
B5.10	572010510105	TPGX0902..	CS 250 T 08	0.1
B5.12	572010512105	TPGX0902..	CS 250 T 08	0.1
B5.14	572010514105	TPGX0902..	CS 250 T 08	0.2
B5.16	572010516105	TPGX0902..	CS 250 T 08	0.3
B8.06	572010506108	WCGT0201..	TS 21 06	0.065
B8.08	572010508108	WCGT0201..	TS 211 06	0.08
B8.10	572010510108	TPGX0902..	CS 250 T 08	0.1
B8.12	572010512108	TPGX0902..	CS 250 T 08	0.2
B8.14	572010514108	TPGX0902..	CS 250 T 08	0.2
B8.16	572010516108	TPGX0902..	CS 250 T 08	0.3

REF.	CODE		TORX T	kg
SFTP25	470500525001	TPGX0902..	CS 250T 08	0.01
SFTP32	470500532001	TPGX0902..	CS 250T 08	0.02
SFTP50	470500550001	TPGX1103..	CS300890T 08	0.08
SFTP51	470500550003	TCMT16T3..	TS 4 15	0.09

REF.	CODE		TORX T	kg
SFCC25	470500525002	CCGT0602..	TS 25 08	0.01
SFCC32	470500532002	CCGT0602..	TS 25 08	0.02
SFCC50	470500550002	CCGT09T3..	TS 4 15	0.08
SFCC51	470500550004	CCMT1204..	TS 5 25	0.09

• For back-facing machining see p.26

TRM 50/63 - TRM 63/63
Ø 2.5 ~ 125



TRM 50/80 - TRM 80/80
Ø 2.5 ~ 220



2 µm

TRM 50/63
Ø 2.5-125

TRM 63/63

TRM 50/80
Ø 2.5-220

TRM 80/80

Tools

RDC D08.16

B3.06

B3.08

B3.10

B3.11

B3.12

B3.14

B3.16

B3.18

B3.22

P20.30

P02.30

P03.30

PS11.30

PS12.30

PS13.30

Vibration-damping

B5.06

B5.08

B5.10

B5.12

B5.14

B5.16

Ø 30-83

TRM63 Ø 30-66

TRM80 Ø 30-83

SFTP25

SFCC25

SFTP32

SFCC32

SFTP50

SFCC50

SFTP51

SFCC51

Ø 77-220

Carbide

B1.02 Ø2.5-4

B1.04 Ø4-6

B8.06

B8.08

B8.10

B8.12

B8.14

B8.16

Ø 6-8

Ø 8-10

Ø 10-13

Ø 12-14

Ø 14-16

Ø 16-18

Ø 18-22

Ø 22-30

Ø 35.5-95

TRM63 Ø 35.5-77

TRM80 Ø 35.5-95

REF.	CODE	kg
TRM 50/63	455005000631	1.1
TRM 63/63	455006300631	1.5
TRM 50/80	455005000801	2
TRM 80/80	455008000801	2.5
D08.16	200560116082	0.02
P20.30	431030160300	0.2
P02.30	431030250400	0.3
P03.30	431030250700	0.4
P04.30	431030251150	0.7
PS 11.30	433030260750	0.4
PS 12.30	433030260950	0.5
PS 13.30	433030261400	0.7

TRM63
Ø 77-100

TRM63 - TRM80
Ø 95-125 - Ø 95-140

TRM80
Ø 140-220

KIT K01 TRM 50/63 - 63/63

Ø 6 ~ 125



1 TRM 50/63 - 63/63

1 P20.30 1 B3.11
1 PS11.30 1 B3.16
1 P02.30 1 B3.22
1 P03.30 1 SFTP25
1 B3.06 1 SFTP32
1 B3.08 1 SFTP50

5 TPGX 090202L DC100
1 TPGX 110302L DC100
2 WCGT 020102L DC 10

KIT K01 TRM 50/80 - 80/80

Ø 6 ~ 220



1 TRM 50/80 - 80/80

1 P20.30 1 B3.08
1 PS12.30 1 B3.11
1 PS13.30 1 B3.16
1 P02.30 1 B3.22
1 P03.30 1 SFTP25
1 P04.30 1 SFTP32
1 B3.06 1 SFTP50

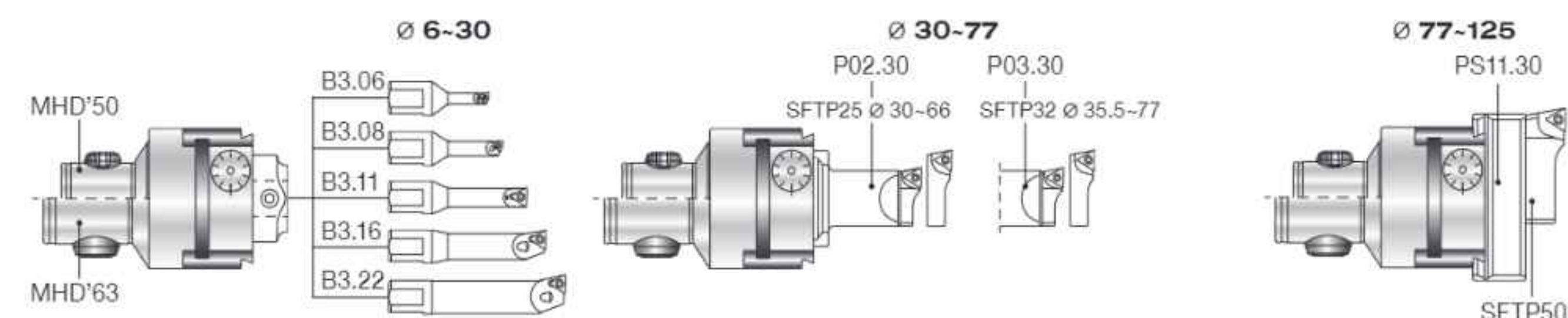
5 TPGX 090202L DC100
1 TPGX 110302L DC100
2 WCGT 020102L DC 10

REF.	CODE	kg		
KIT K01 TRM50/63	655005010632	3.9		
KIT K01 TRM63/63	655006310632	4.2		

REF.	CODE	kg		
KIT K01 TRM50/80	655005010802	6.2		
KIT K01 TRM80/80	655008010802	6.6		

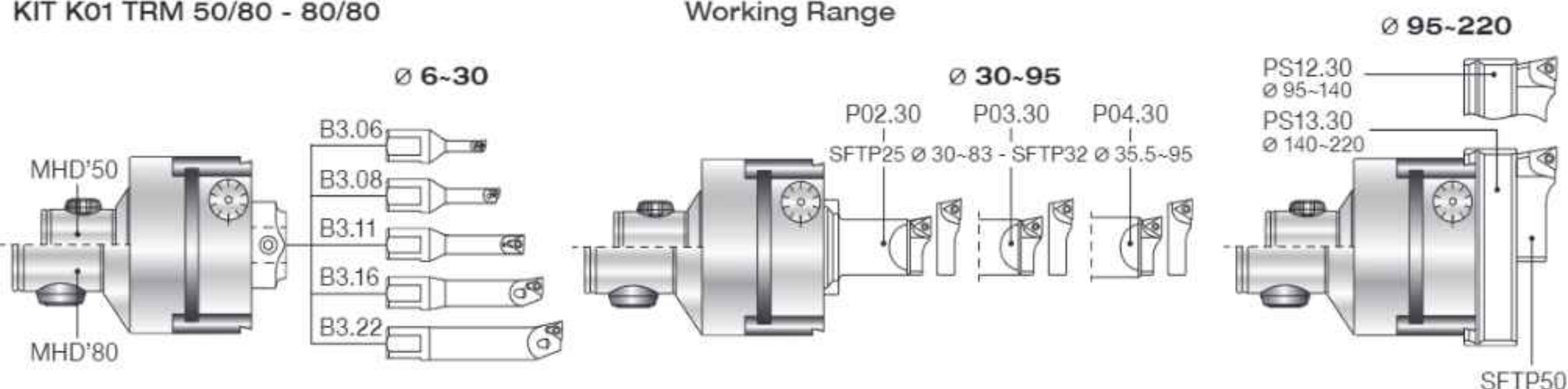
KIT K01 TRM 50/63 - 63/63

Working Range



KIT K01 TRM 50/80 - 80/80

Working Range



REF.	CODE		TORX T	kg	
B1.02	572010502001			0.02	
B1.04	572010504001			0.02	
B3.06	572010506001	WCGT0201..	TS 21 06	0.035	
B3.08	572010508001	WCGT0201..	TS 211 06	0.4	
B3.10	572010510001	TPGX0902..	CS 250 T 08	0.05	
B3.11	572010511001	TPGX0902..	CS 250 T 08	0.055	
B3.12	572010512001	TPGX0902..	CS 250 T 08	0.06	
B3.14	572010514001	TPGX0902..	CS 250 T 08	0.07	
B3.16	572010516001	TPGX0902..	CS 250 T 08	0.07	
B3.18	572010518001	TPGX0902..	CS 250 T 08	0.1	
B3.22	572010522001	TPGX0902..	CS 250 T 08	0.1	

REF.	CODE		TORX T	kg	
SFTP25	470500525001	TPGX0902..	CS 250T 08	0.01	
SFTP32	470500532001	TPGX0902..	CS 250T 08	0.02	
SFTP50	470500550001	TPGX1103..	CS300890T 08	0.08	
SFTP51	470500550003	TCMT16T3..	TS 4 15	0.09	

• For back-facing machining see p.26

REF.	CODE		TORX T	kg	
B5.06	572010506105	WCGT0201..	TS 21 06	0.075	
B5.08	572010508105	WCGT0201..	TS 211 06	0.09	
B5.10	572010510105	TPGX0902..	CS 250 T 08	0.1	
B5.12	572010512105	TPGX0902..	CS 250 T 08	0.1	
B5.14	572010514105	TPGX0902..	CS 250 T 08	0.2	
B5.16	572010516105	TPGX0902..	CS 250 T 08	0.3	
B8.06	572010506108	WCGT0201..	TS 21 06	0.065	
B8.08	572010508108	WCGT0201..	TS 211 06	0.08	
B8.10	572010510108	TPGX0902..	CS 250 T 08	0.1	
B8.12	572010512108	TPGX0902..	CS 250 T 08	0.2	
B8.14	572010514108	TPGX0902..	CS 250 T 08	0.2	
B8.16	572010516108	TPGX0902..	CS 250 T 08	0.3	

REF.	CODE		TORX T	kg	
SFCC25	470500525002	CCGT0602..	TS 25 08	0.01	
SFCC32	470500532002	CCGT0602..	TS 25 08	0.02	
SFCC50	470500550002	CCGT09T3..	TS 4 15	0.08	
SFCC51	470500550004	CCMT1204..	TS 5 25	0.09	

TRM 80/125

Ø 36 ~ 500

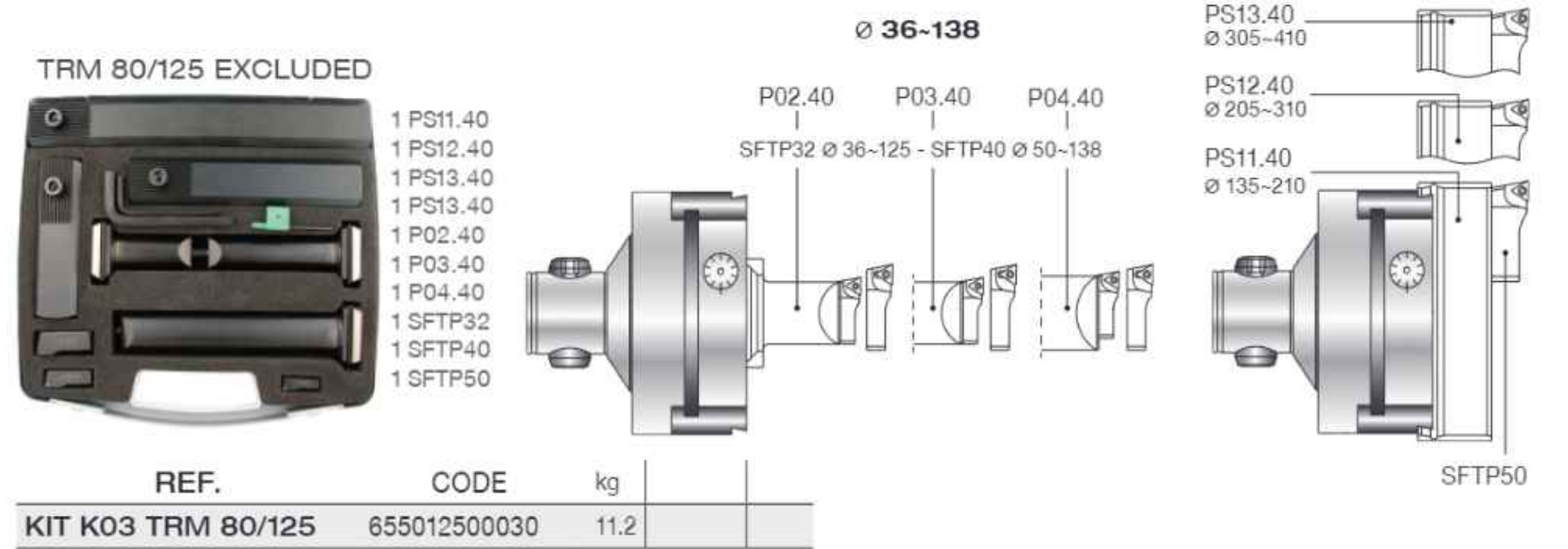


REF.	CODE	kg	
TRM 80/125	455008001251	5.5	
P02.40	431040320700	0.7	
P03.40	431040321150	1	
P04.40	431040321900	2	

REF.	CODE	kg	
PS 11.40	433040351500	1.5	
PS 12.40	433040352300	2.4	
PS 13.40	433040353300	3.5	
PS 14.40	433040354000	4.6	

KIT K03

Ø 36 ~ 410



REF.	CODE	kg	
KIT K03 TRM 80/125	655012500030	11.2	

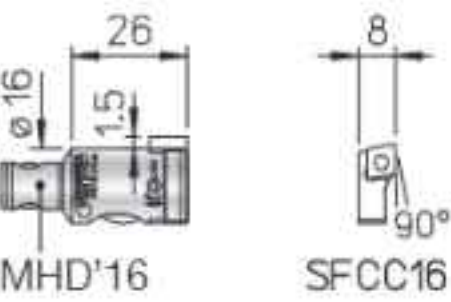
REF.	CODE	TPGX	CS	TORX T	kg	
SFTP32	470500532001	TPGX 0902..	CS 250T	08	0.02	
SFTP40	470500540001	TPGX 1103..	CS300890T	08	0.04	
SFTP50	470500550001	TPGX 1103..	CS300890T	08	0.08	
SFTP51	470500550003	TCMT 16T3..	TS 4	15	0.09	

REF.	CODE	CCGT	TS	TORX T	kg	
SFCC32	470500532002	CCGT 0602..	TS 25	08	0.02	
SFCC40	470500540002	CCGT 09T3..	TS 4	15	0.04	
SFCC50	470500550002	CCGT 09T3..	TS 4	15	0.08	
SFCC51	470500550004	CCMT 1204..	TS 5	25	0.09	

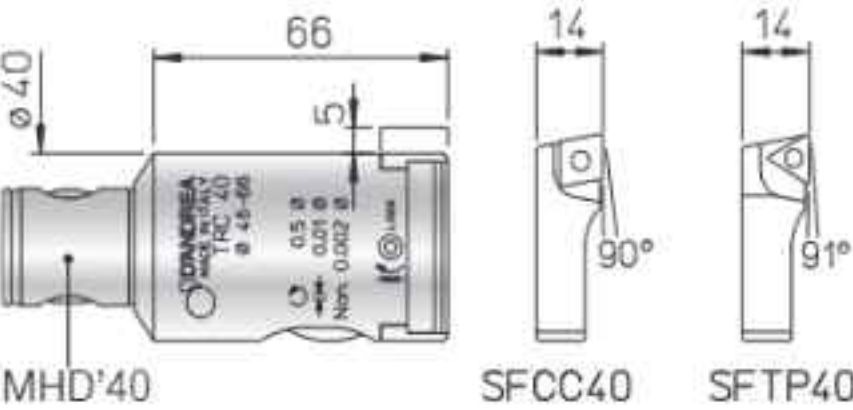
TRC 16 ~ 80 Ø 18 ~ 132



TRC 16 Ø 18 ~ 24



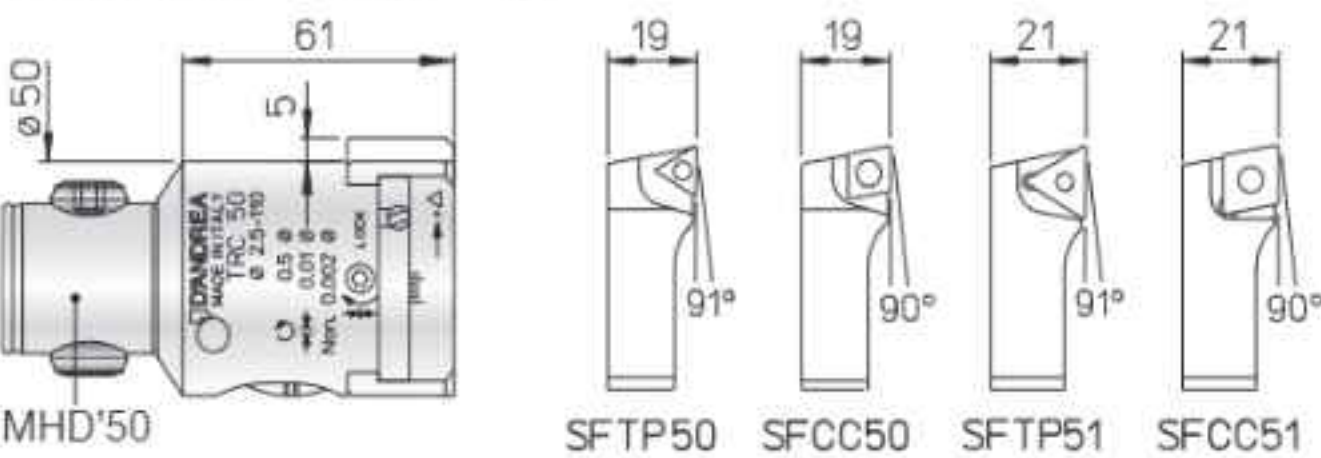
TRC 40 Ø 48 ~ 66



TRC 20 Ø 22 ~ 30

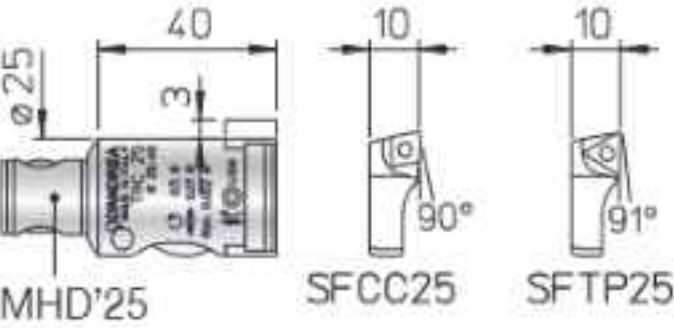


TRC 50 Ø 54 ~ 86

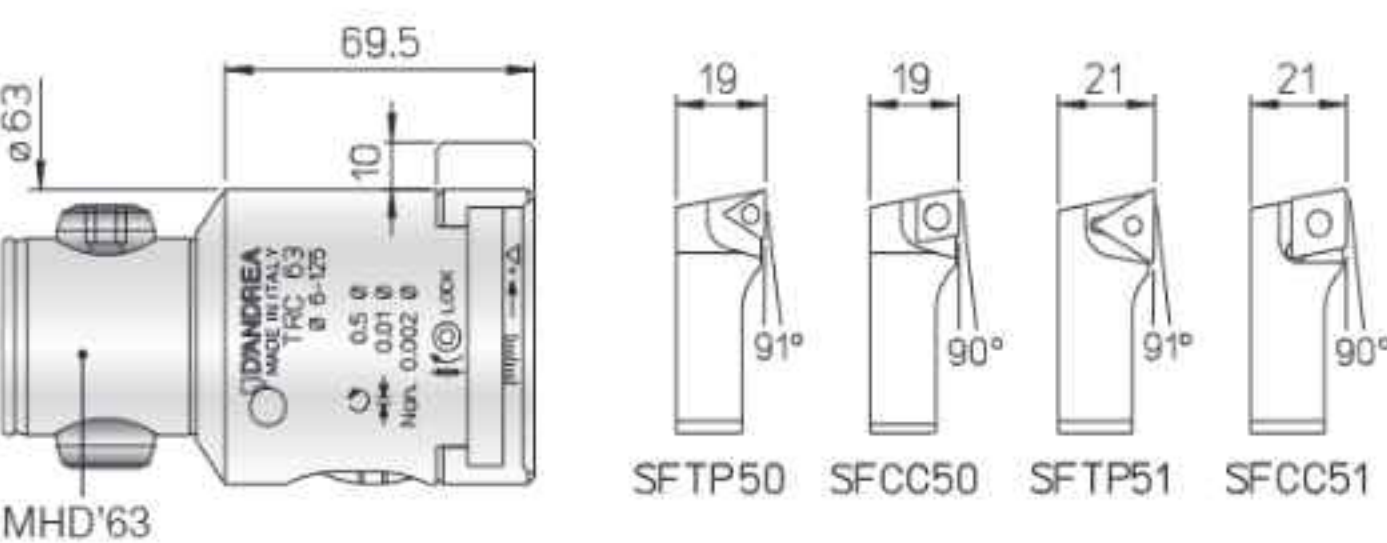


THE TRC50 USES ALL THE TOOLS SUPPLIED WITH TRM50 (P.20-21)

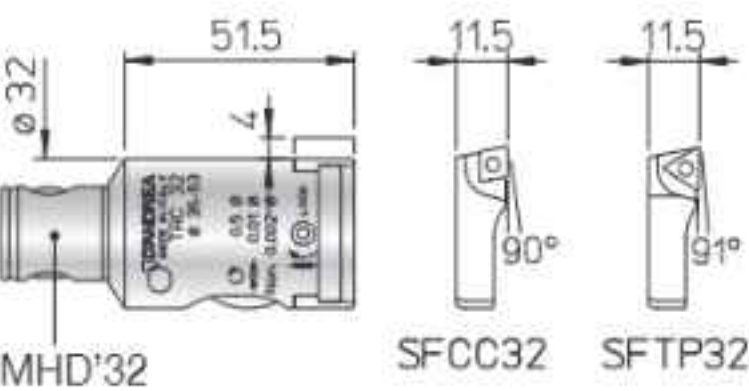
TRC 25 Ø 28 ~ 40



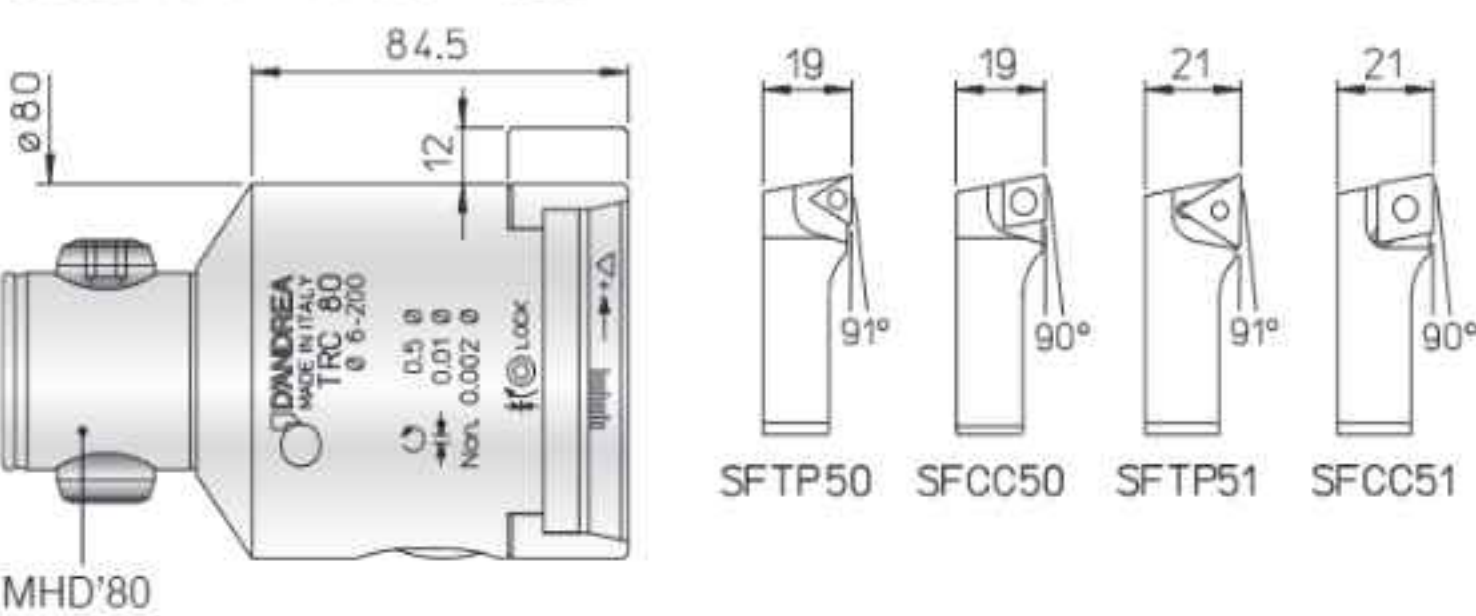
TRC 63 Ø 72 ~ 110



TRC 32 Ø 35.5 ~ 53.5



TRC 80 Ø 88 ~ 132

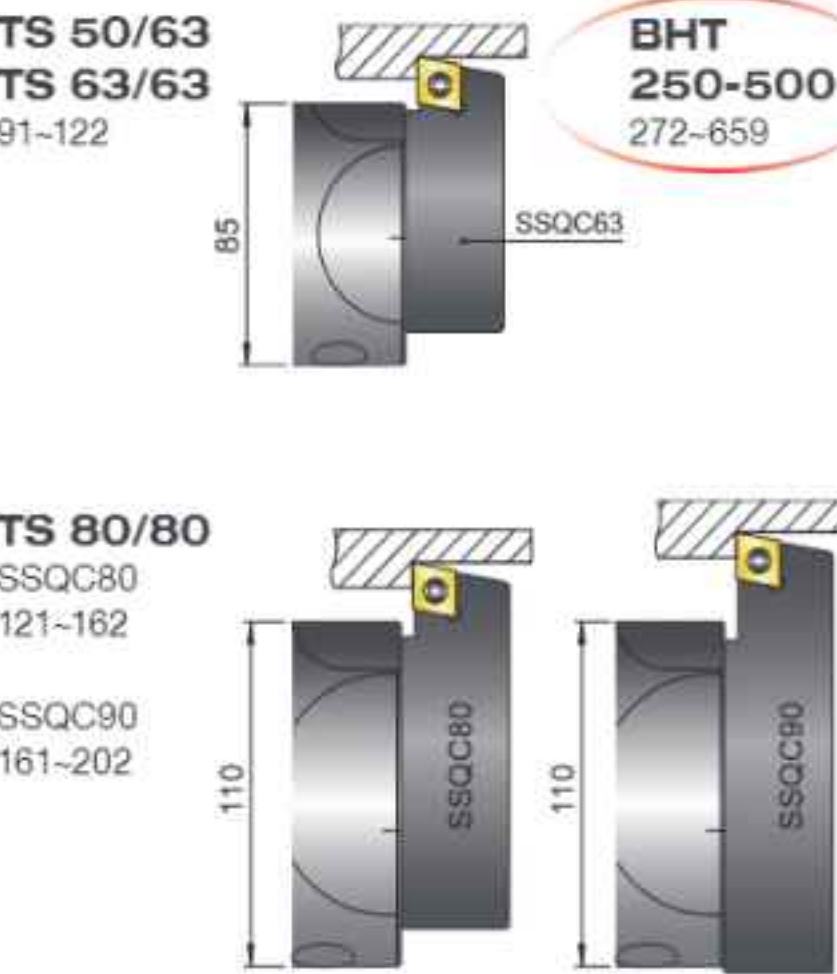
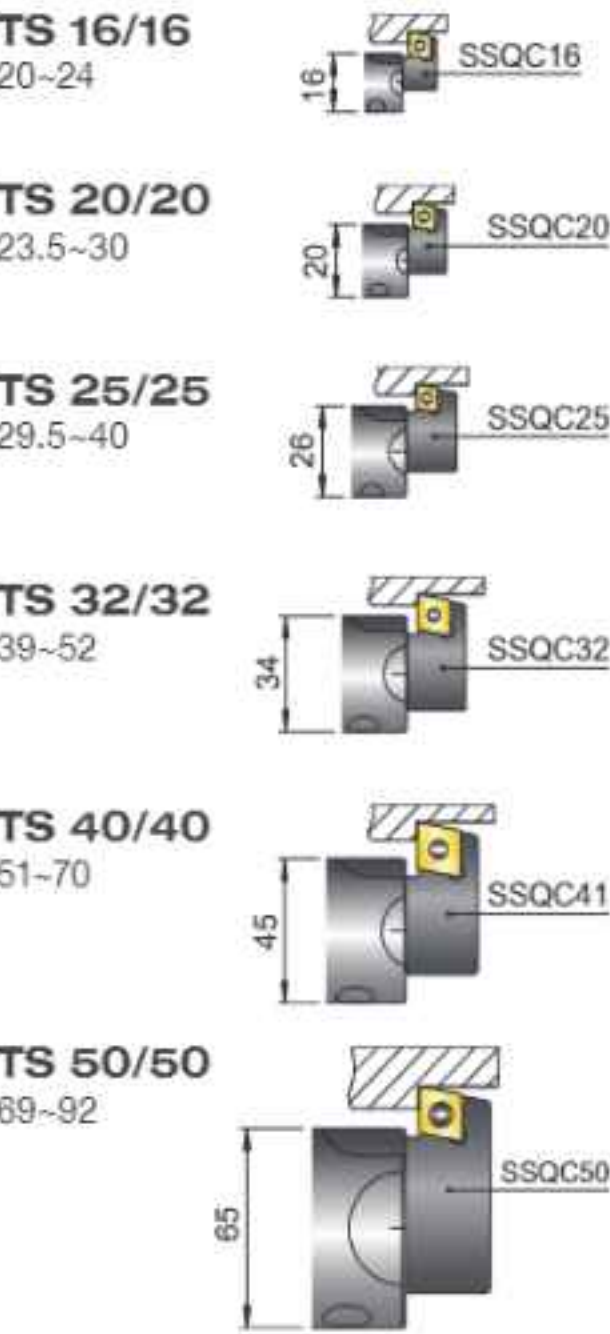


REF.	CODE	kg	
TRC 16	455011600341	0.05	
TRC 20	455012000401	0.1	
TRC 25	455012500501	0.2	
TRC 32	455013200631	0.35	
TRC 40	455014000801	0.7	
TRC 50	455015000801	1	
TRC 63	455016301001	2	
TRC 80	455018001201	3.8	

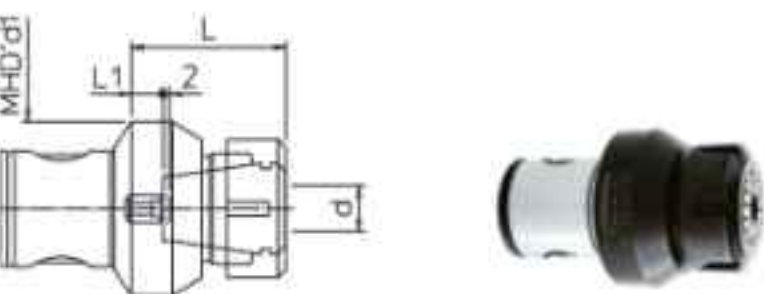
• For back-facing machining see p.26

REF.	CODE		TORX T	kg	
SFCC16	470500516002	CCGT 0602..	TS 25	08	0.003
SFCC20	470500520002	CCGT 0602..	TS 25	08	0.005
SFCC25	470500525002	CCGT 0602..	TS 25	08	0.01
SFCC32	470500532002	CCGT 0602..	TS 25	08	0.02
SFCC40	470500540002	CCGT 09T3..	TS 4	15	0.04
SFCC50	470500550002	CCGT 09T3..	TS 4	15	0.08
SFCC51	470500550004	CCMT 1204..	TS 5	25	0.09
SFTP25	470500525001	TPGX 0902..	CS 250T	08	0.01
SFTP32	470500532001	TPGX 0902..	CS 250T	08	0.02
SFTP40	470500540001	TPGX 1103..	CS300890T	08	0.04
SFTP50	470500550001	TPGX 1103..	CS300890T	08	0.08
SFTP51	470500550003	TCMT 16T3..	TS 4	15	0.09

MHD' TS / PSC TS



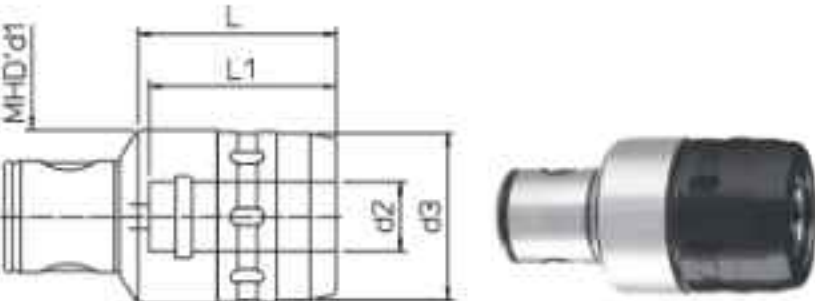
PE COLLETS CHUCKING TOOLS



Supplied without collets and clamping wrenches

REF.	CODE	MHD' d1	d	L	L1	kg			N·m		
PE 20 / ER16M	655702000160	20	0.5-10	32	1	0.06	ER-16M	E16M	40		
PE 32 / ER25M	655703200250	32	1-16	42	1.5	0.25	ER-25M	E25M	160		
PE 40 / ER25	655704000250	40	1-16	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	50	2-20	55	8	1	UM/ER32	E32	220		
PE 63 / ER32	655706300320	63	2-20	59	12	1.3	UM/ER32	E32	220		

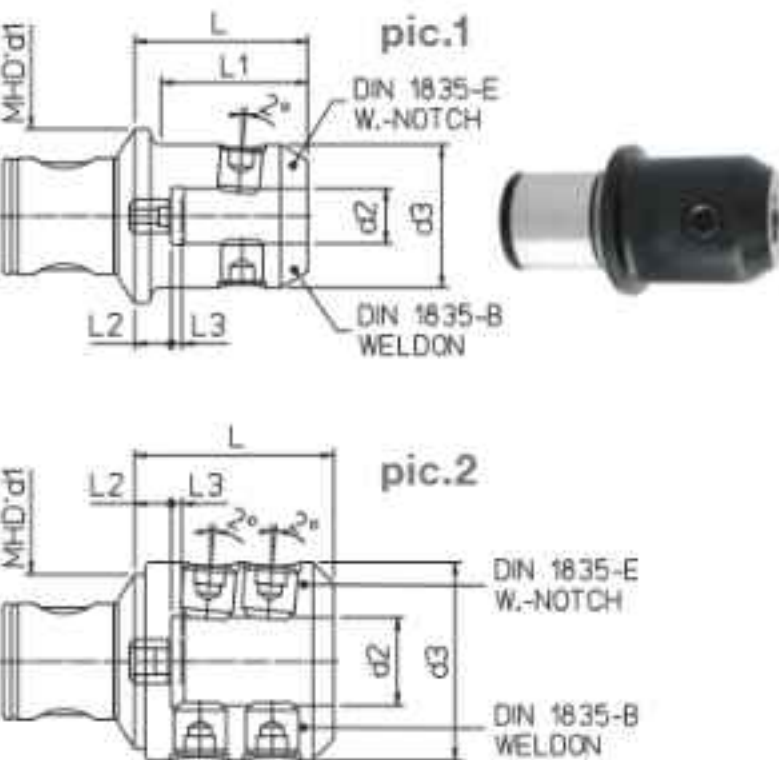
FORCE MILLING POWER CHUCK



Supplied without collets and clamping wrenches

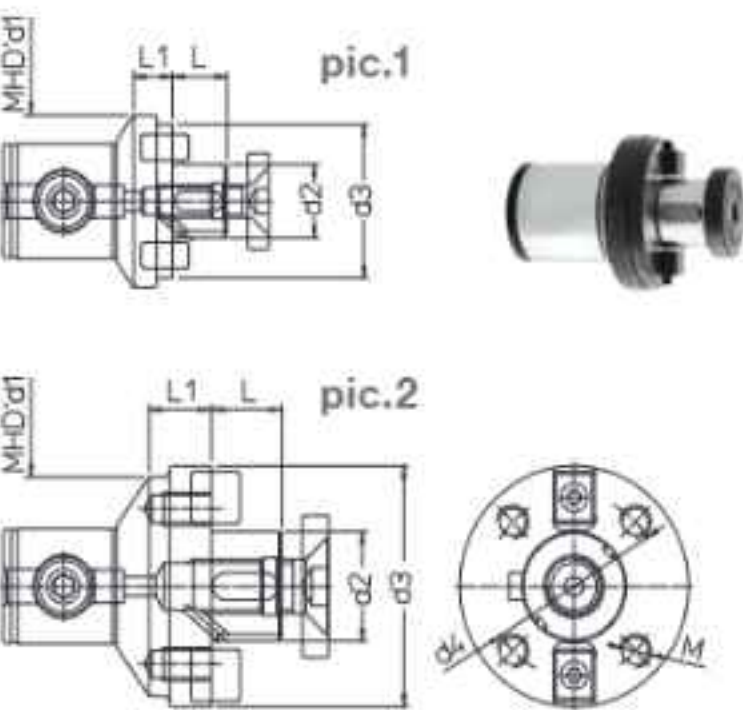
REF.	CODE	MHD' d1	d2	d3	L	L1	kg		
FORCE 50/20	656305000200	50	20	48	60	60	1		
FORCE 63/32	656306300320	63	32	66	80	80	2		

AW WELDON WHISTLE NOTCH CHUCKING TOOLS



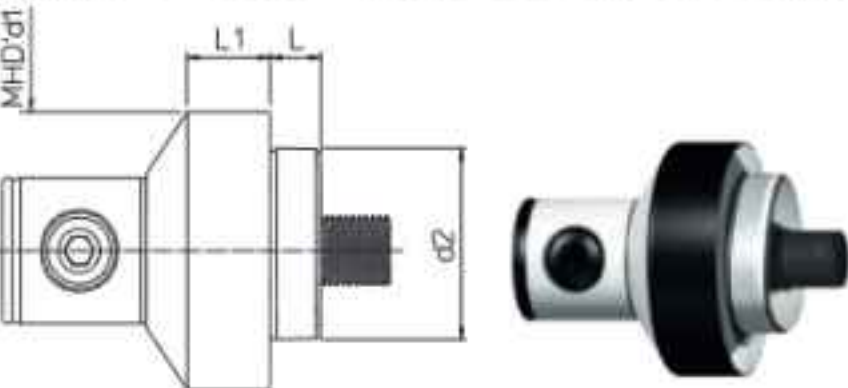
REF.	CODE	MHD' d1	d2 ^{HS}	d3	L	L1	L2	L3	kg	pic.		
AW 50/6	655805000060	50	6	25	44	32.5	7	2	0.5	1		
AW 50/8	655805000080	50	8	28	44	33	7	2	0.5	1		
AW 50/10	655805000100	50	10	35	52	42	11	3	0.7	1		
AW 50/12	655805000120	50	12	42	57	48	11	3	0.8	1		
AW 50/14	655805000140	50	14	42	57	48	11	3	0.8	1		
AW 50/16	655805000160	50	16	48	67	61	17	4	1.1	1		
AW 50/20	655805000200	50	20	51	67		16	4	1.2	1		
AW 50/25	655805000250	50	25	63	80		22	4	1.8	2		
AW 63/16	655806300160	63	16	48	64	53	14	4	1.4	1		
AW 63/20	655806300200	63	20	52	66	56	14	4	1.5	1		
AW 63/25	655806300250	63	25	64	74		16	4	2.1	2		
AW 63/32	655806300320	63	32	72	76		14	4	2.5	2		
AW 80/40	655808000400	80	40	80	83		12	4	3.2	2		

PF DISC AND FACING CUTTER HOLDERS



REF.	CODE	MHD' d1	d2	d3	d4	M	L	L1	kg	pic.		
PF 40/16	655904020165	40	16	32			17	15	0.3	1		
PF 40/22	655904020225	40	22	40			19	13	0.4	1		
PF 50/16	655905000160	50	16	32			17	15	0.5	1		
PF 50/22	655905000220	50	22	40			19	15	0.5	1		
PF 50/27	655905000270	50	27	50			21	15	0.6	1		
PF 50/32	655905000320	50	32	60			24	15	0.7	1		
PF 63/22	655906300220	63	22	60			19	15	0.9	1		
PF 63/27	655906300270	63	27	60			21	15	1.1	1		
PF 63/32	655906300320	63	32	63			24	15	1.2	1		
PF 80/32	655908000320	80	32	80			24	24	1.7	1		
PF 80/40	655908000400	80	40	84	66.7	M12	27	24	1.9	2		
PF 80/50	655908000500	80	50	90			30	24	2.0	2		
PF 80/60	655908000600	80	60	128.5	101.6	M16	40	31.5	3.5	2		

MHD' 80 - HT 8 CHUCKING TOOLS MHD' 80 - HT 8



REF.	CODE	MHD' d1	d2	L	L1	kg		
MHD'80-HT8	655108000080	80	HT8	15.5	25	2		

NS SEMIFINISHED CHUCK HOLDERS



ON REQUEST

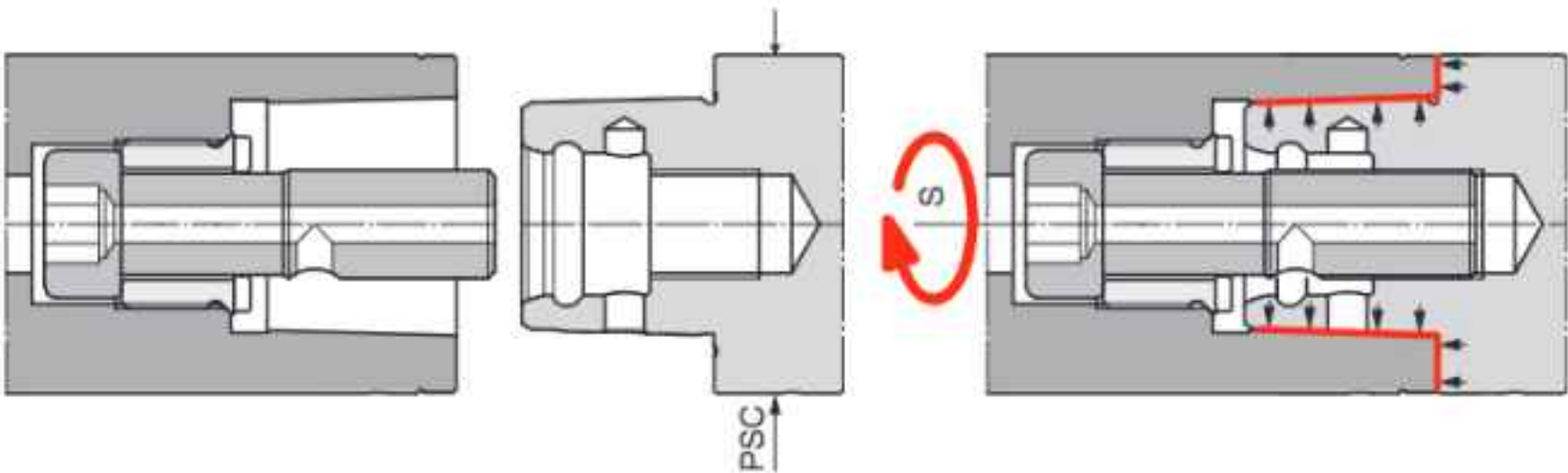
REF.	CODE	MHD' d1	d2	L	kg		
NS 50	657205001600	50	63	160	4.2		
NS 63	657206302000	63	80	200	8.7		
NS 80	657208002500	80	100	250	16		

Line of high-precision monolithic and modular tool holders that allows to perform different operations on the machine-tools.

The strong point of the **PSC** system is the ISO 26623 polygonal-conical connection which guarantees extreme rigidity even in the most demanding process.

The system allows the use of the entire **MHD'** line.

PSC COUPLING ISO 26623-1/2



PSC	S 	N·m
40	8	55
50	10	95
63-80	14	170

The **PSC coupling**, compliant with the ISO 26623 standard, is available in four sizes.

The system is complete with arbors, extensions, reductions, adapters, roughing and finishing heads. The range includes collet chuck ER and power chucks MONOFORCE holders.



PSC - TS complete line of double-bit boring heads for roughing from Ø 68 mm to Ø 200 mm.



PSC - TRM complete line of micrometric heads for finishing from Ø 2.5 mm to Ø 220 mm.



ARBORS, manufactured in 4 different sizes **PSC 40-50-63 and 80**, are made of case-hardened, tempered and subsequently ground steel.



PSC - PR e RD for each size of PSC, extensions and reductions are available in different lengths which allow to achieve the required working depths.



MONOforce line of high precision power milling chucks ideal for machining where precision and high clamping forces for the cutting tool are required.



PSC - ER collet holders made for the use of ER standard collets.



PF adapters for side and face milling cutters.



PSC - MHD' adapters to integrate the entire MHD' system boring line into the PSC program.

PSC - PR
Extensions
PSC - RD
Reductions

PSC50 - PR50



PSC50 - RD50

PSC63 - PR63



PSC63 - RD63

PSC80 - PR80



ARBORS
PSC

DIN - PSC



MAS BT - PSC



HSK - PSC



CAT - PSC



PSC - TS Roughing Heads



PSC50 - TS50
Ø 68 - 90



PSC63 - TS50
Ø 68 - 90



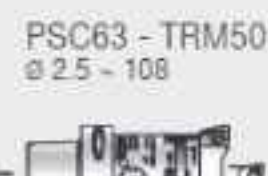
PSC63 - TS63
Ø 90 - 120



PSC80 - TS80
Ø 120 - 200



PSC50 - TRM50
Ø 2.5 - 108



PSC63 - TRM50
Ø 2.5 - 108



PSC63 - TRM63
Ø 2.5 - 125



PSC63 - TRM80
Ø 2.5 - 220

PSC - TRM Testarossa **2µm**

ADATTATORI

PSC - ER Collet chucks



PSC - MF Power Chucks



PSC - PF Portafrese



PSC - NS Blanks



modulhard'andrea

MHD' PR
Extensions

RD
Reductions

RAV
Vibration-damping
reductions

TS
Roughing Heads

TRM 2µm
Testarossa

TRC 10µm
Testarossa

16

PR 16 (25)



RD 32/16



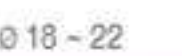
RD 40/16



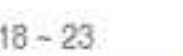
RD 50/16



RAV 50/16



TS 16/16 Ø 18 - 22



TRM 16 Ø 18 - 23



TRC 16 Ø 18 - 24

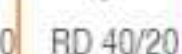


20

PR 20 (32)



RD 32/20



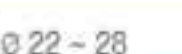
RD 40/20



RD 50/20



RAV 50/20



TS 20/20 Ø 22 - 28



TRM 20 Ø 22 - 29



TRC 20 Ø 22 - 30

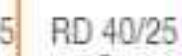


25

PR 25 (25-40)



RD 32/25



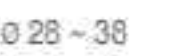
RD 40/25



RD 50/25



RAV 50/25



TS 25/25 Ø 28 - 38



TRM 25 Ø 28 - 38



TRC 25 Ø 28 - 40

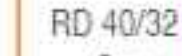


32

PR 32 (32-50)



RD 40/32



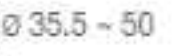
RD 50/32



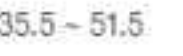
RAV 50/32



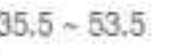
TS 32/32 Ø 35.5 - 50



TRM 32 Ø 35.5 - 51.5



TRC 32 Ø 35.5 - 53.5



TRC 32 Ø 35.5 - 53.5



40

PR 40 (40-63)



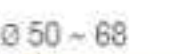
RD 50/40



RAV 50/40



TS 40/40 Ø 50 - 68



TRM 40 Ø 48 - 63



TRC 40 Ø 48 - 66



TRC 40 Ø 48 - 66



ARBORS
PSC-MHD'

PSC50 - MHD'



PSC63 - MHD'

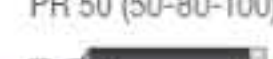


PSC80 - MHD'

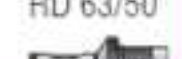


50

PR 50 (50-80-100)



RD 63/50



RD 80/50



RAV 63/50



TS 50/50 - 50/63
Ø 68 - 90



TRM 50
Ø 2.5 - 108



TRC 50 Ø 2.5 - 110



TRC 50 Ø 2.5 - 110



63

PR 63 (63-100-125)



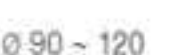
RD 80/63



RAV 80/63



TS 63/63 Ø 90 - 120



TRM 63/63 Ø 2.5 - 125



TRC 63 Ø 72 - 110



TRC 63 Ø 72 - 110



80

PR 80 (80-125-160)



RD 80/80



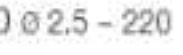
RAV 80/80



TS 80/80 Ø 120 - 200



TRM 80/80 Ø 2.5 - 220



TRC 80 Ø 88 - 132



TRC 80 Ø 88 - 132



TS 80/90 Ø 160 - 250



TRM 80/125 Ø 36 - 500



TRC 80 Ø 88 - 132



TRC 80 Ø 88 - 132



TRC 80 Ø 88 - 132



CHUCKING
TOOLS

Power Chucks



Collet chucks



Weldon



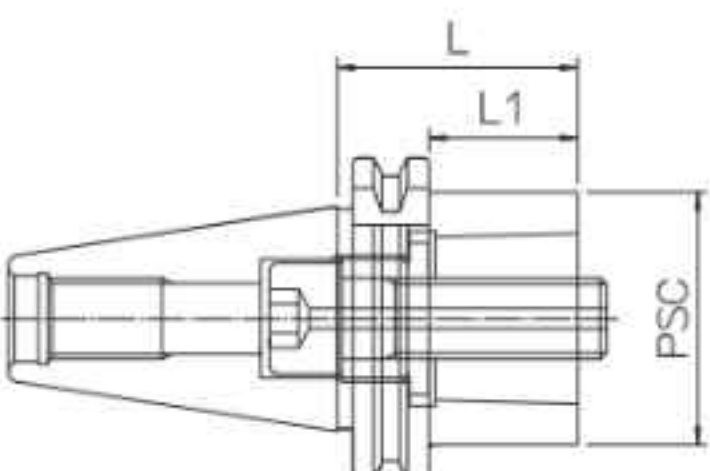
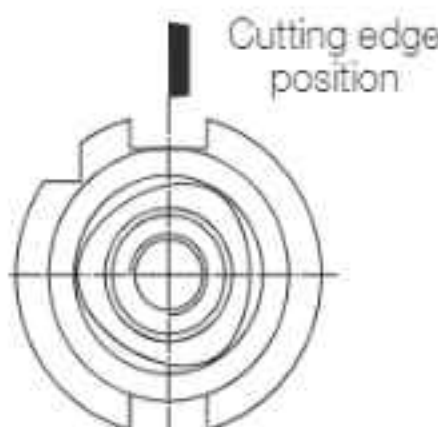
Shell mill holders



Blanks

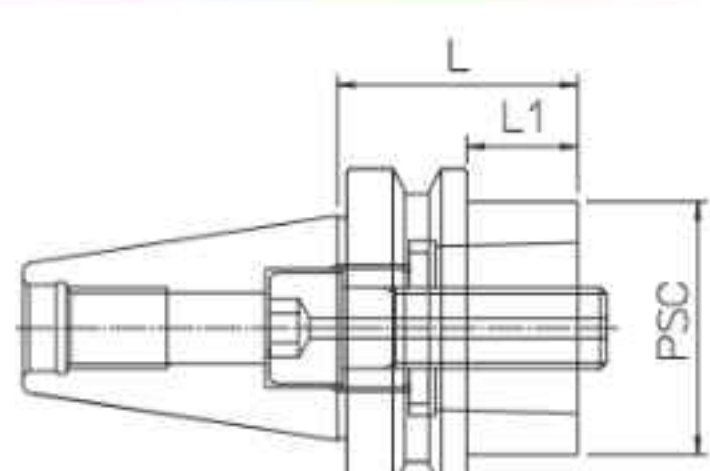
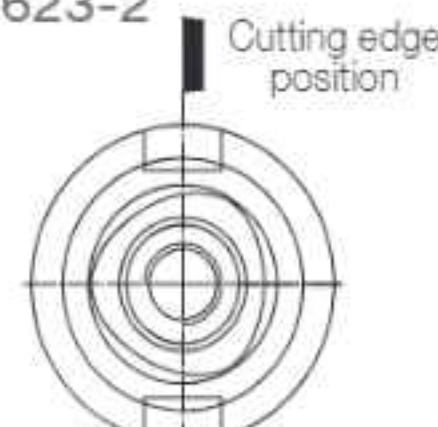


DIN-AD - PSC DIN 69871 / ISO 26623-2



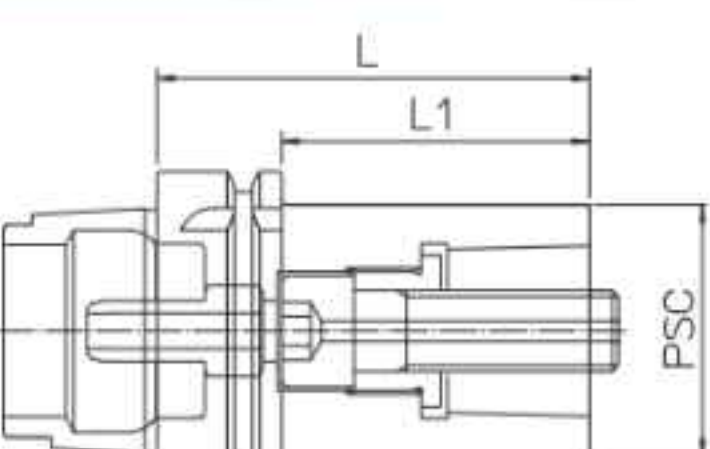
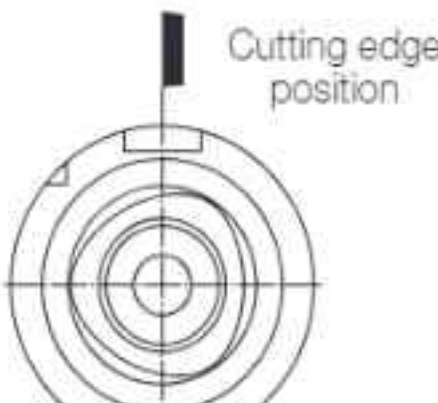
DIN	REF.	CODE	PSC	L	L1	kg		
40	DIN69871-AD40 PSC 50.40	41PS05014028	50	40	21	0.9		
50	DIN69871-AD50 PSC 50.30	41PS05015020	50	30	11	2.7		
50	DIN69871-AD50 PSC 63.30	41PS06315028	63	30	11	2.8		
50	DIN69871-AD50 PSC 80.70	41PS08015020	80	70	51	3.7		

MAS BT-AD - PSC MAS 403 BT / ISO 26623-2



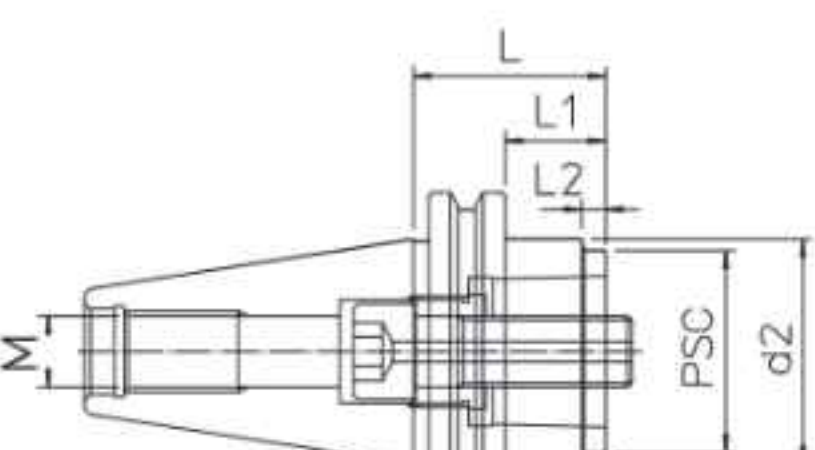
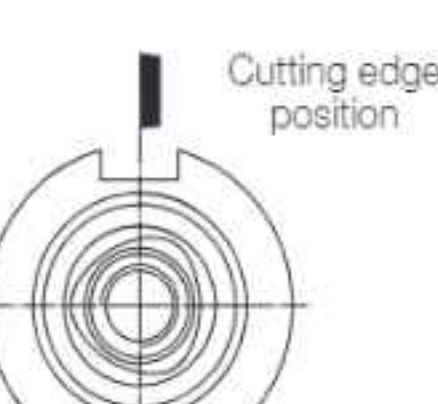
BT	REF.	CODE	PSC	L	L1	kg		
40	MAS403 BT40-AD PSC 50.50	41PS05014032	50	50	23	1.2		
50	MAS403 BT50-AD PSC 50.40	41PS05015030	50	40	2	3.4		
50	MAS403 BT50-AD PSC 63.50	41PS06315032	63	50	12	3.5		
50	MAS403 BT50-AD PSC 80.70	41PS08015030	80	70	32	4		

HSK-T - PSC DIN 69893 / ISO 26623-2



HSK-A	REF.	CODE	PSC	L	L1	kg	Supplied with coolant tube	
63	HSK-T63 PSC 40.80	41PS0405632T	40	80	54	1.1		
63	HSK-T63 PSC 50.90	41PS0505632T	50	90	64	1.5		
100	HSK-T100 PSC 50.100	41PS0505992T	50	100	71	3		
100	HSK-T100 PSC 63.110	41PS0635992T	63	110	81	3.6		
100	HSK-T100 PSC 80.120	41PS0805992T	80	120	91	4.7		

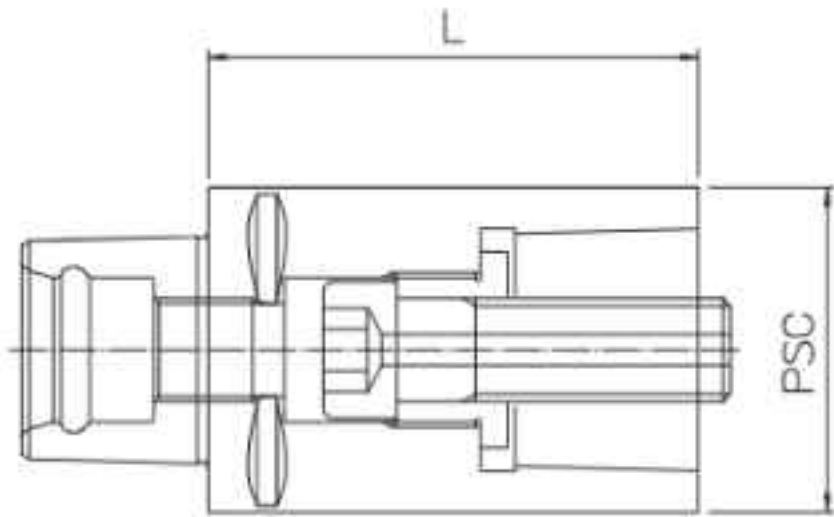
CAT-AD - PSC ANSI B5.50 / ISO 26623-2



CAT	REF.	CODE	PSC	d2	L	L1	L2	M	kg		
40	CAT40 AD PSC 50.50	41PS05014045	50		50	31		UNC 5/8-11	1		
50	CAT50 AD PSC 50.40	41PS05015045	50	69.9	40	21	5	UNC 1/8	2.5		
50	CAT50 AD PSC 63.50	41PS06315045	63	70	50	31	12.5	UNC 1/8	3		
50	CAT50 AD PSC 80.100	41PS08015045	80		100	81		UNC 1/8	4.6		

PSC - PR ISO 26623-1 / 2

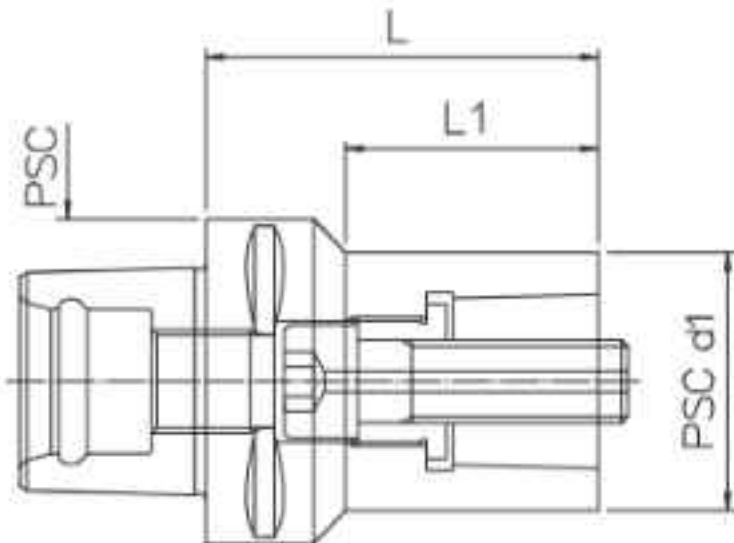
EXTENSIONS



PSC	REF.	CODE	L	kg		
40	PR PSC 40.60	656PS04006000	60	0.55		
50	PR PSC 50.80	656PS05008000	80	1.1		
63	PR PSC 63.100	656PS06310000	100	2.2		
80	PR PSC 80.100	656PS08010000	100	3.6		

PSC - RD ISO 26623-1 / 2

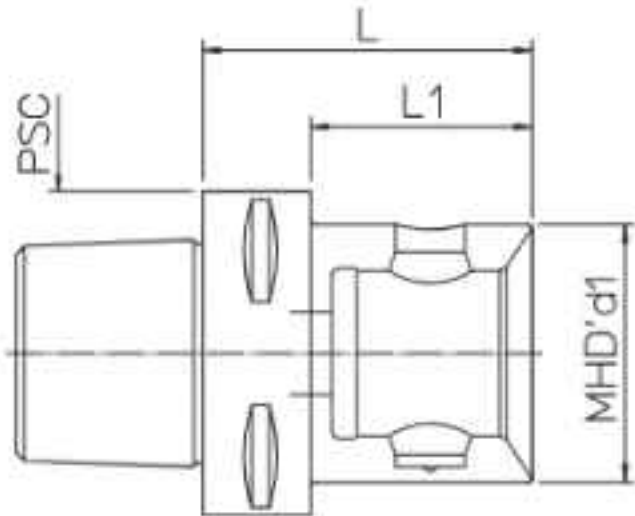
REDUCTIONS



PSC	REF.	CODE	PSCd1	L	L1	kg		
50	RD PSC 50/40.65	657PS05004000	40	65	45	0.7		
63	RD PSC 63/40.80	657PS06304000	40	80	51.4	1.3		
63	RD PSC 63/50.80	657PS06305000	50	80	51.5	1.5		
80	RD PSC 80/50.80	657PS08005000	50	80	49.3	2.2		
80	RD PSC 80/63.80	657PS08006300	63	80	53.1	2.5		

PSC - MHD' ISO 26623-1

REDUCTIONS TO MODULAR



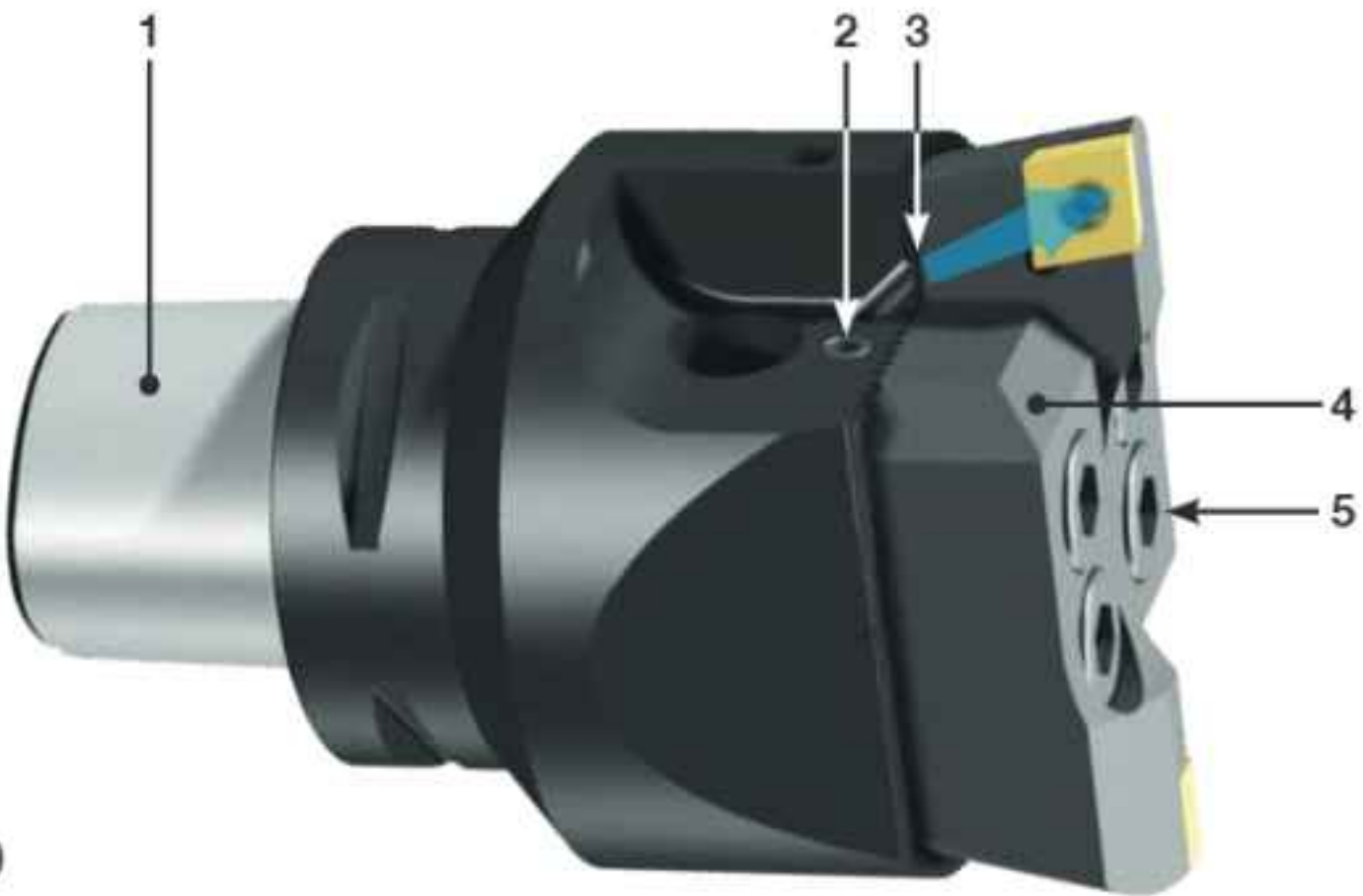
PSC	REF.	CODE	MHD' d1	L	L1	kg		
50	PSC 50 - MHD' 50.55	416502605005	50	55		0.8		
63	PSC 63 - MHD' 40.50	416402606305	40	50	28	0.9		
63	PSC 63 - MHD' 50.55	416502606305	50	55	33	0.8		
63	PSC 63 - MHD' 63.77	416632606307	63	77		1.8		
80	PSC 80 - MHD' 50.60	416502608006	50	60	30	2		
80	PSC 80 - MHD' 63.70	416632608007	63	70	40	2.3		
80	PSC 80 - MHD' 80.75	416802608007	80	75		2.6		

On request supplied with coolant tube **PSC**. See p.53

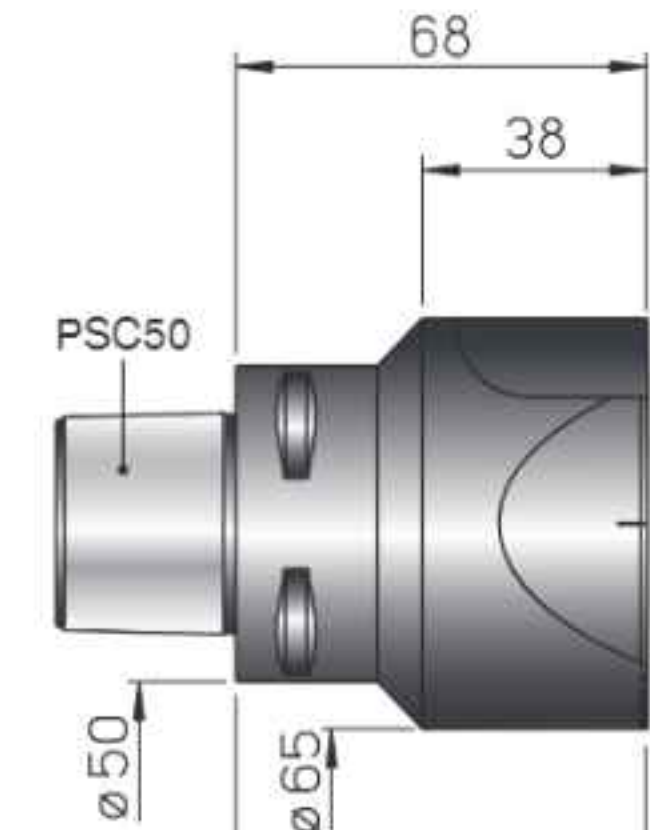


PSC - TS Ø 68 ~ 200

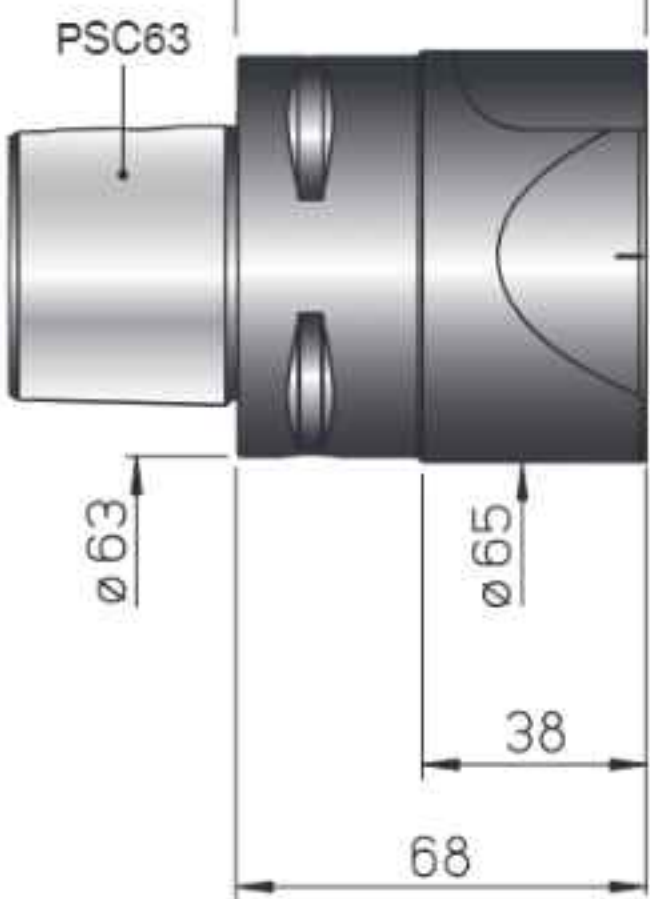
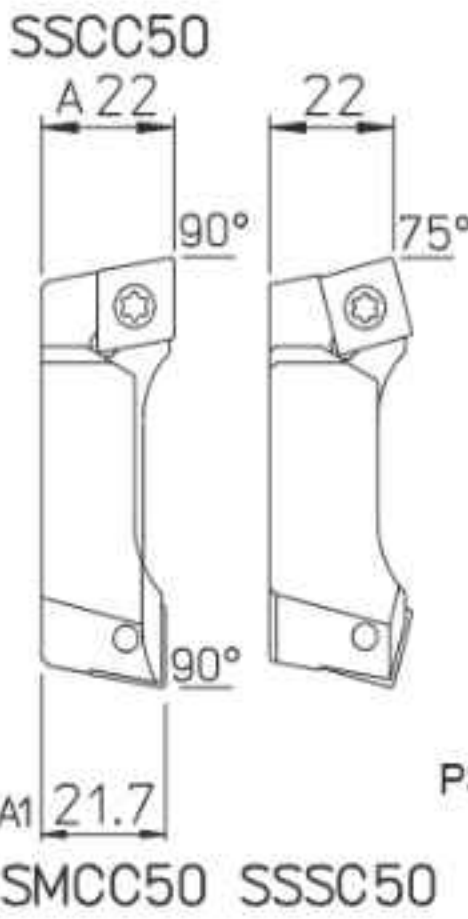
Simple and extremely rigid roughing heads, thanks to the serrated surfaces between the head body and the bit holders. The constant distance between the bit holder clamping screw and the cutting edge guarantees the stability of the system.



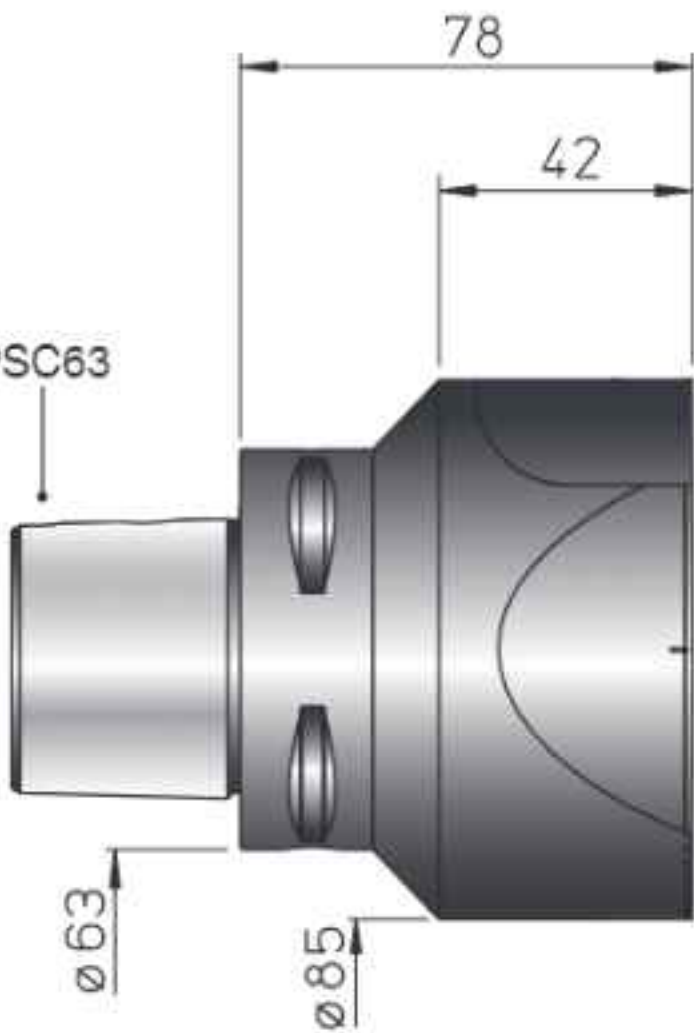
- 1. PSC 50 - 63 - 80
- 2. Setting screws
- 3. Coolant outlets Max BAR 40
- 4. Bit holders
- 5. Tools clamp screws



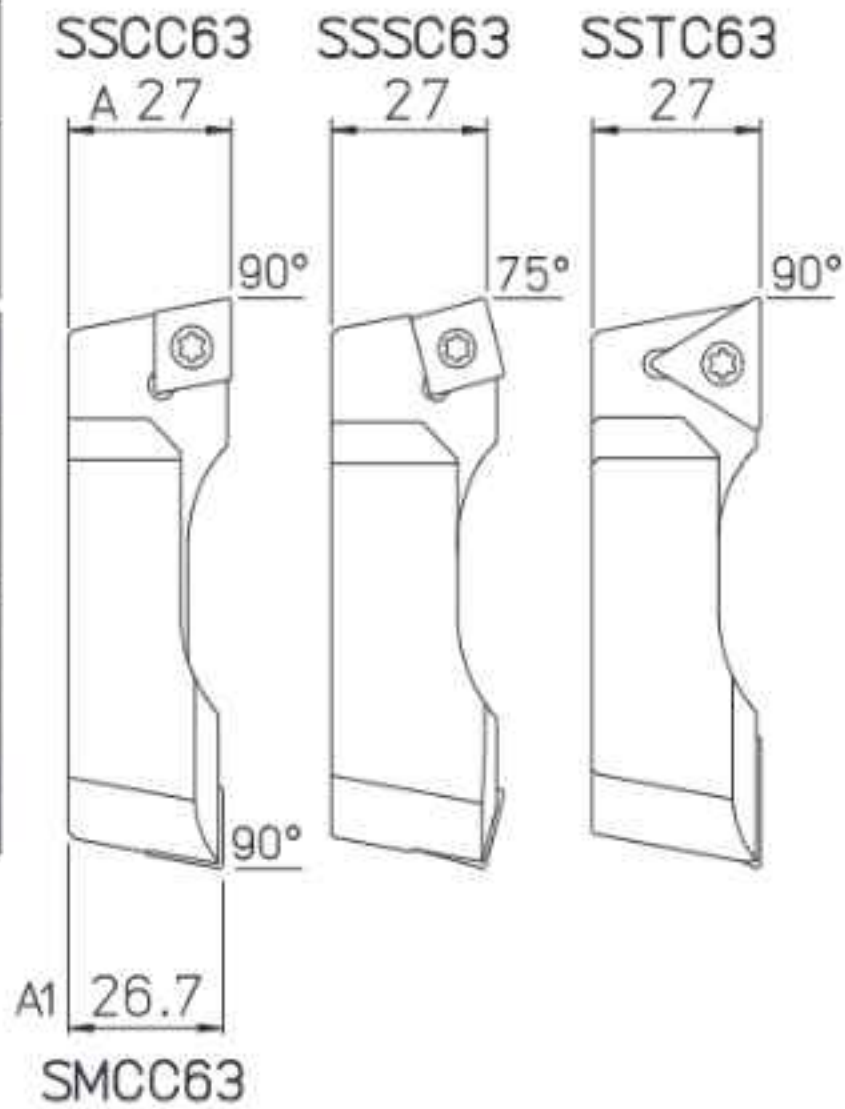
PSC50 - TS50
Ø 68 ~ 90



PSC63 - TS50
Ø 68 ~ 90



PSC63 - TS63
Ø 90 ~ 120



REF.	CODE	kg		
PSC50 - TS50	71PSC050TS50090	1.4		
PSC63 - TS50	71PSC063TS50090	1.8		

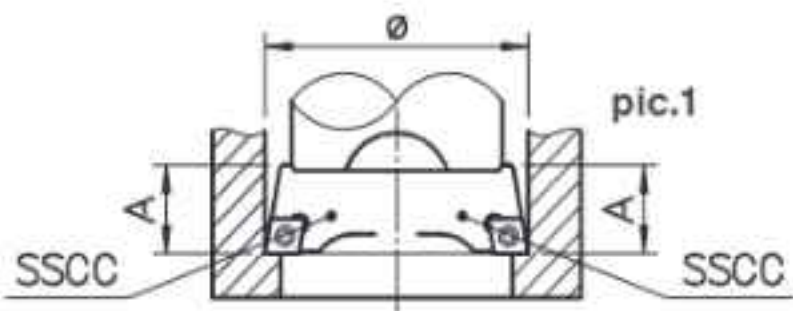
On request supplied with coolant tube **PSC**. See p.53

REF.	CODE	kg		
PSC63 - TS63	71PSC063TS63105	2.7		
PSC63 - TS80	71PSC063TS80115	3.8		

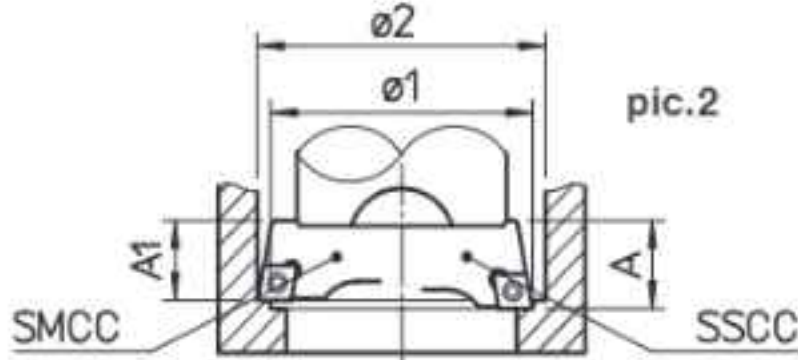


USE TS for ROUGHING end SEMI-FINISHING operations

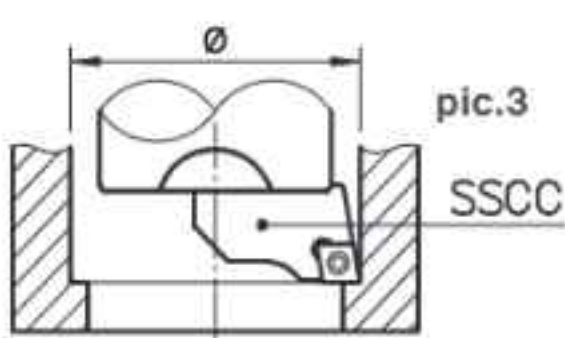
Roughing and semi-finishing operations. Cutting edges might be adjusted on a pre-setting bench and TS heads can be used in three different configurations, with a single cutting edge (pic. 3) or misaligned ones (pic.2) half the feed.



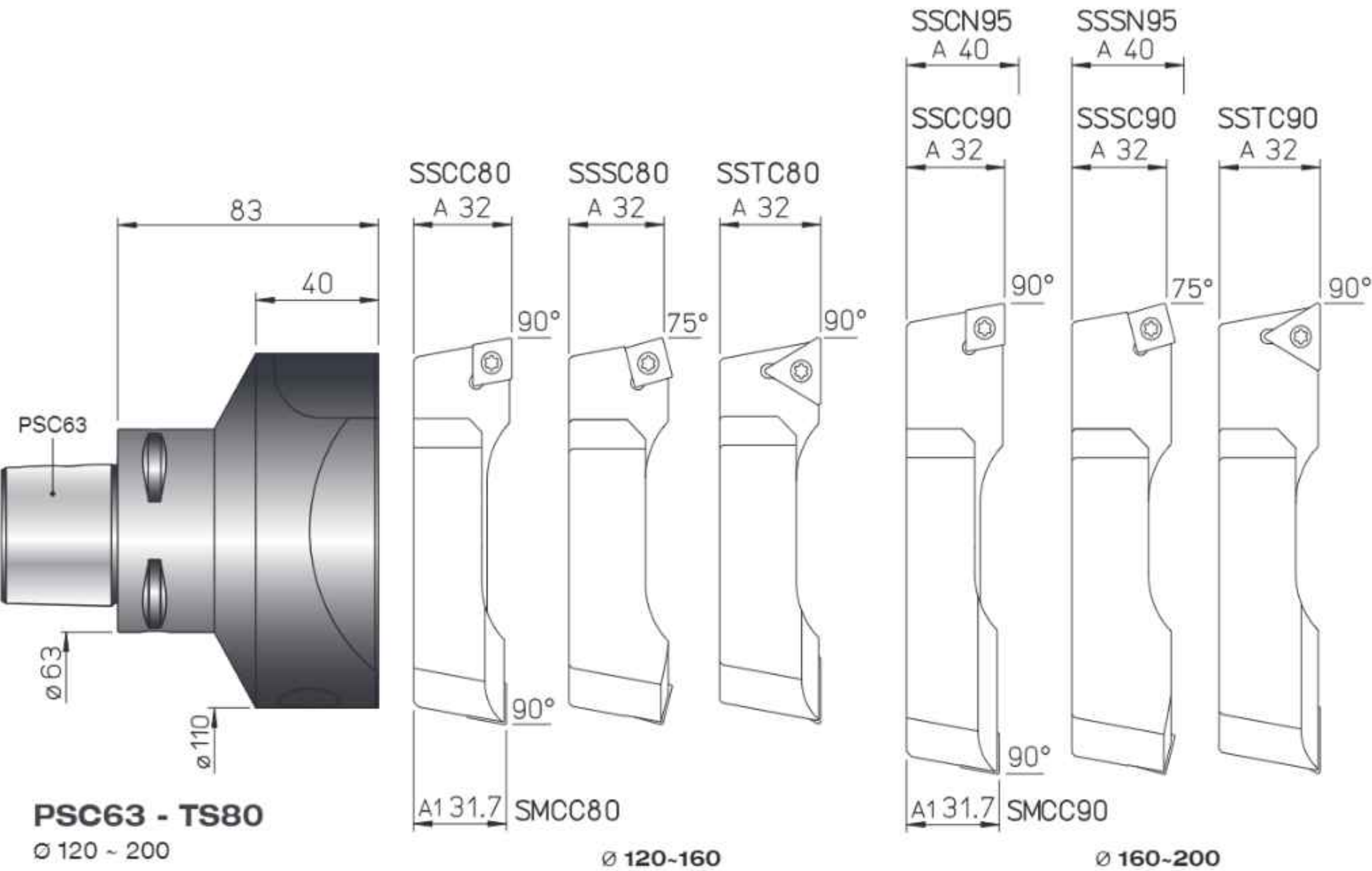
pic.1 with two SSCC bit holders aligned and on the same diameter for roughing operations with high feedrate.



pic. 2 with one SSCC bit holder and one SMCC bit holder staggered and on a different diameter for roughing operations with high depth of cut.



pic.3 with a single bit holder for roughing or semi-finishing operations.



REF.	CODE	TS TORX T	kg
SSCC 50	470500550204 CCMT 1204..	5 25	0.1
SSCC 63	470500563201 CCMT 1204..	5 25	0.2
SSCC 80	470500580201 CCMT 1204..	5 25	0.5
SSCC 90	470500590201 CCMT 1204..	5 25	0.7
SSCN 95	470500595201 CNM. 1906..		0.9
SSTC 63	470500563206 TCMT 2204..	5 25	0.2
SSTC 80	470500580206 TCMT 2204..	5 25	0.5
SSTC 90	470500590206 TCMT 2204..	5 25	0.7

• For back-facing machining see p.26

REF.	CODE	TS TORX T	kg
SMCC 50	470500550205 CCMT 1204..	5 25	0.1
SMCC 63	470500563203 CCMT 1204..	5 25	0.2
SMCC 80	470500580203 CCMT 1204..	5 25	0.5
SMCC 90	470500590203 CCMT 1204..	25 08	0.7
SSSC 50	470500550202 SCMT 1204..	5 25	0.1
SSSC 63	470500563202 SCMT 1204..	5 25	0.2
SSSC 80	470500580202 SCMT 1204..	5 25	0.5
SSSC 90	470500590202 SCMT 1204..	5 25	0.7
SSSN 95	470500595202 SNM. 1906..		0.9

PSC - ER



PSC - FORCE



PSC - PF

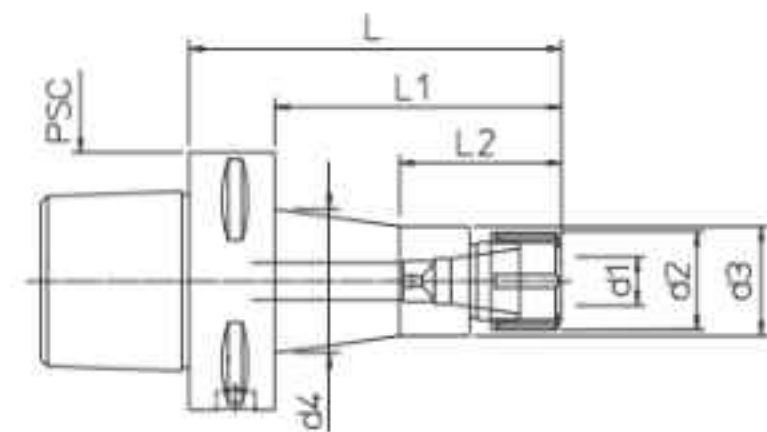


PSC - NS



PSC - ER

COLLETS CHUCKING TOOLS

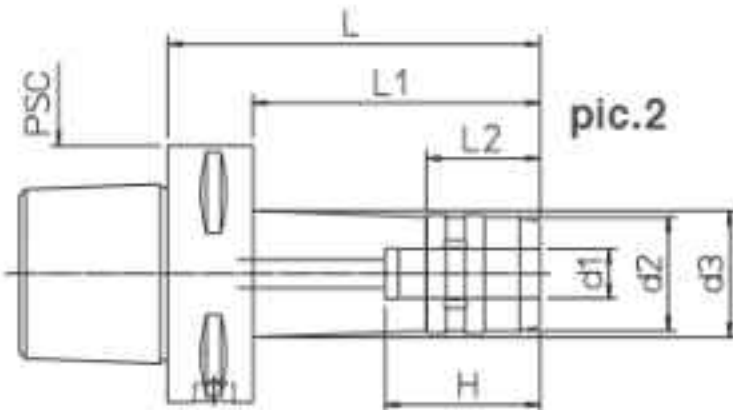
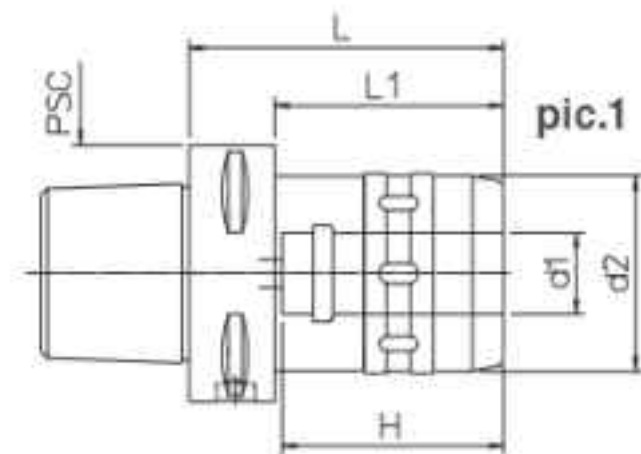


Supplied without collets and clamping wrenches - Chip prearrangement

PSC	REF.	CODE	ER	d1	d2	d3	d4	L	L1	L2	kg		
50	PSC50 - ER16.55	71PSC-050ER1605	16M	0.5-10	22	24		55	35	26	0.5		
50	PSC50 - ER25.65	71PSC-050ER2506	25	1-16	42			65	45		0.8		
63	PSC63 - ER16.60	71PSC-063ER1606	16M	0.5-10	22	24		60	38		0.85		
63	PSC63 - ER16.120	71PSC-063ER1612	16M	0.5-10	22	24	31	120	98	33	1.1		
63	PSC63 - ER25.65	71PSC-063ER2506	25	1-16	42			65	43	37	1.1		
63	PSC63 - ER25.140	71PSC-063ER2514	25	1-16	42		47.5	140	118	43.5	1.9		
63	PSC63 - ER32.75	71PSC-063ER3207	32	2-20	50			75	53		1.5		
63	PSC63 - ER32.160	71PSC-063ER3216	32	2-20	50			160	138		2.5		
80	PSC80 - ER25.70	71PSC-080ER2507	25	1-16	42			70	40		2.1		
80	PSC80 - ER32.75	71PSC-080ER3207	32	2-20	50			72	45		2.5		

PSC - FORCE

MILLING POWER CHUCKS

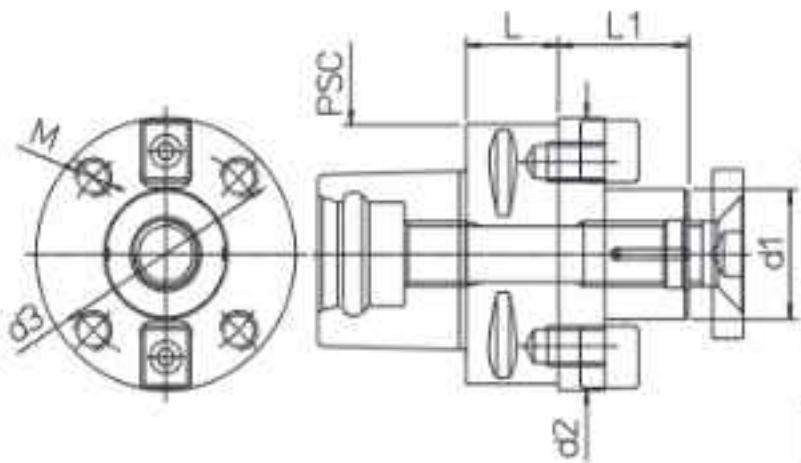


Without clamping wrench - Chip prearrangement

PSC	REF.	CODE	d1	d2	d3	H	L	L1	L2	kg	pic.		
63	PSC 63 - MF 12.100	71PSC-063MF1210	12	28	31.5	46	100	78	29.5	1.4	2		
63	PSC 63 - MF 20.80	71PSC-063MF2008	20	48		60	80	58		1.3	1		
63	PSC 63 - MF 32.100	71PSC-063MF3210	32	66		80	100			2.1	1		
80	PSC 80 - MF 20.80	71PSC-080MF2008	20	48		60	80	50		3.7	1		
80	PSC 80 - MF 32.100	71PSC-080MF3210	32	66		80	100	70		4.4	1		

PSC - PF

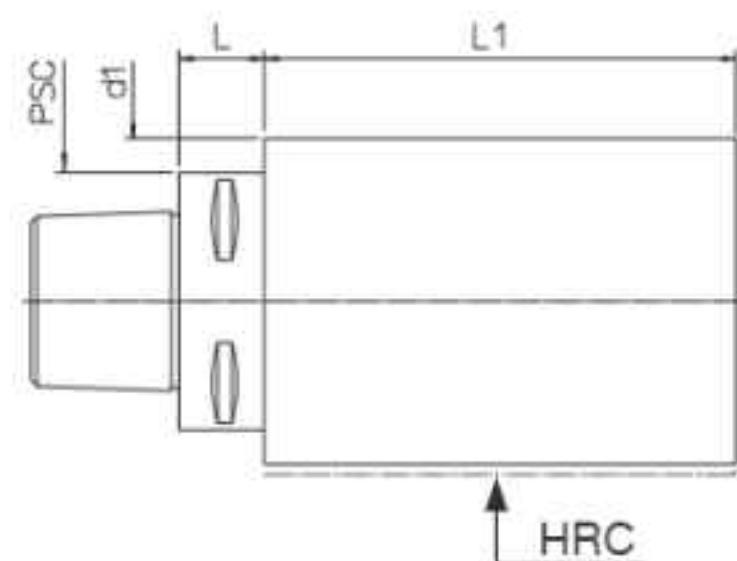
SHELL MILL HOLDERS



PSC	REF.	CODE	d1	d2	d3	M	L	L1	kg		
50	PSC 50 - PF22.25	71PSC-050PF2202	22				25	19	0.5		
50	PSC 50 - PF27.25	71PSC-050PF2702	27				25	21	0.6		
63	PSC 63 - PF27.25	71PSC-063PF2702	27				25	21	0.8		
63	PSC 63 - PF32.25	71PSC-063PF3202	32				25	24	0.9		
80	PSC 80 - PF32.30	71PSC-080PF3203	32				30	24	1.8		
80	PSC 80 - PF40.45	71PSC-080PF4004	40	84	66.7	M12	45	27	2.4		

PSC - NS

SEMIFINISHED CHUCK HOLDERS

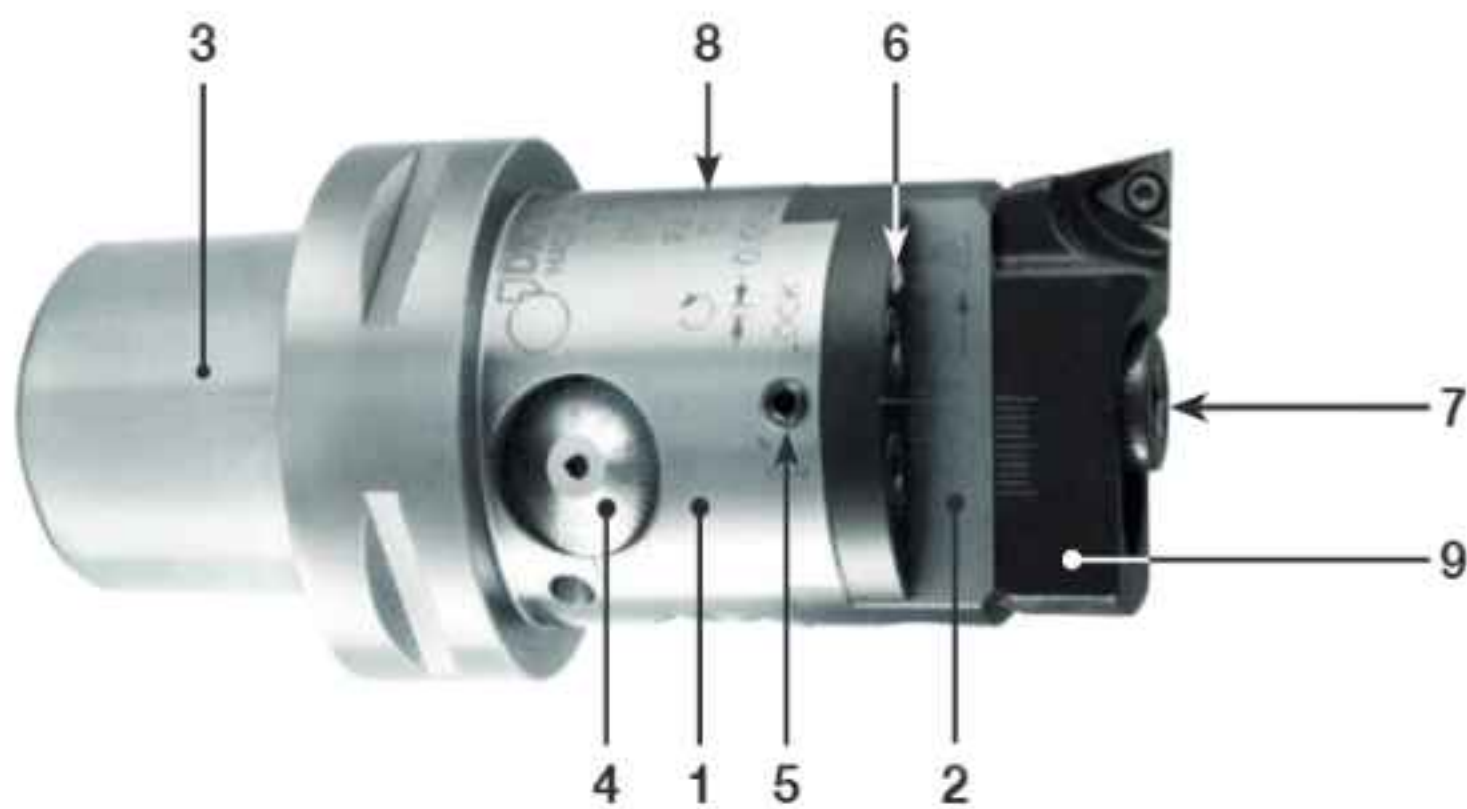


PSC	REF.	CODE	d1	L	L1	kg	HRC		
50	PSC 50 - NS 63.160/140 H.42	71PSC050Z406314	63	20	140	3.8	42		
50	PSC 50 - NS 80.160/140 H.42	71PSC050Z408014	80	20	140	10.2	42		
50	PSC 50 - NS 100.180/160 H.42	71PSC050Z410016	100	22	160	5.9	42		
63	PSC 63 - NS 80.162/140 H.42	71PSC063Z408014	80	22	140	6.2	42		
63	PSC 63 - NS 100.182/160 H.42	71PSC063Z410016	100	22	160	10.4	42		
63	PSC 63 - NS 120.202/180 H.42	71PSC063Z412018	120	22	180	17	42		
80	PSC 80 - NS 100.190/160 H.42	71PSC080Z410016	100	30	160	11.5	42		

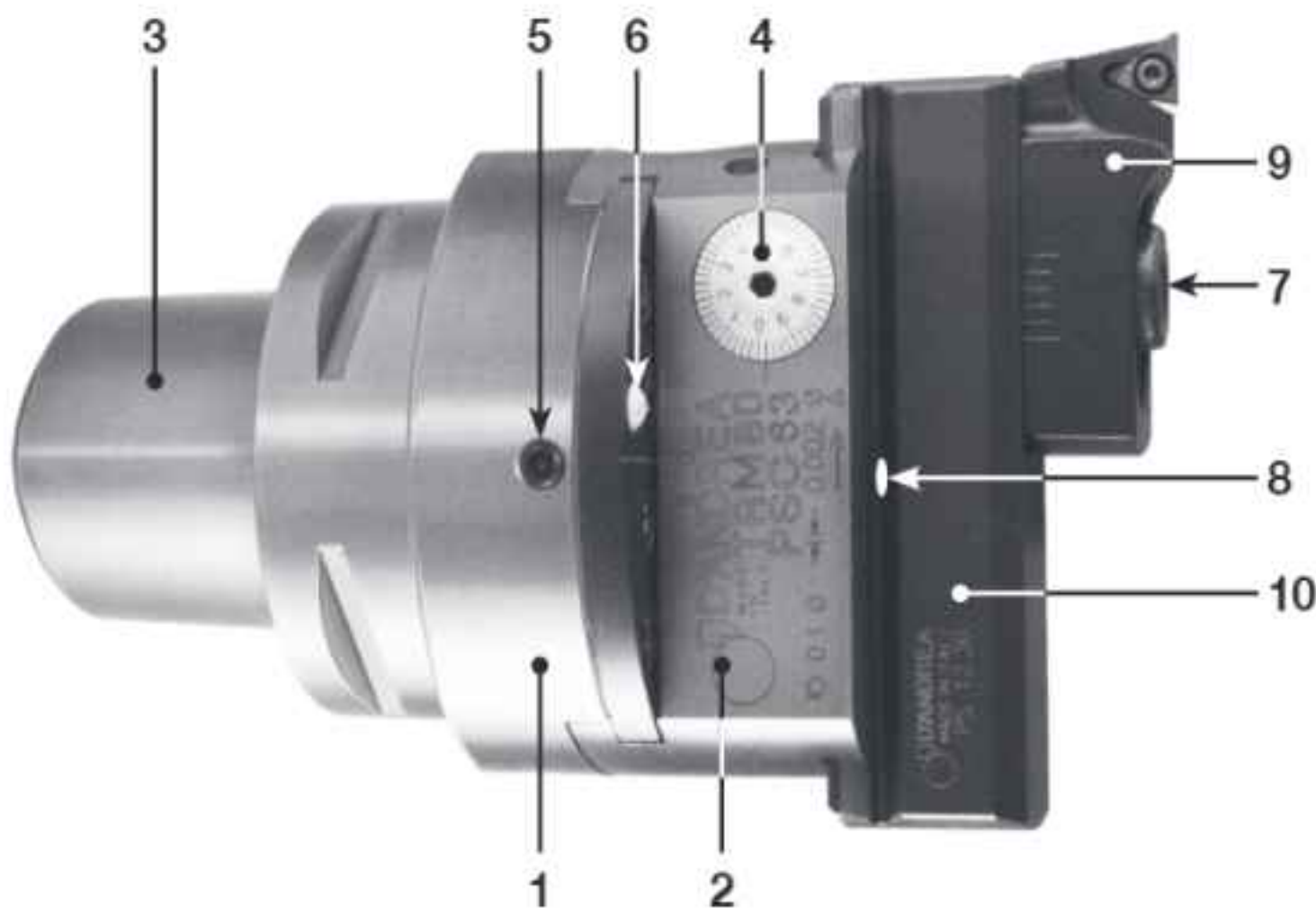
On request supplied with coolant tube **PSC**. See p.53



PSC - TRM Ø 2.5 ~ 220

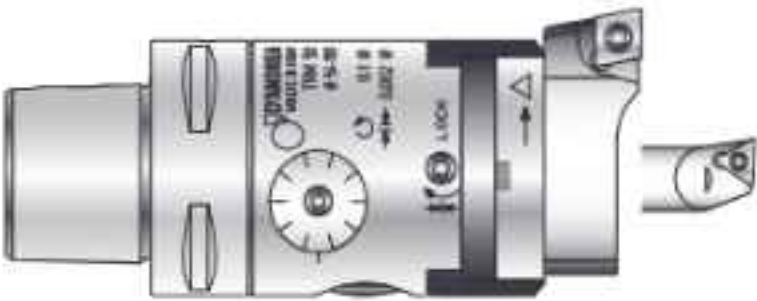


TRM heads allow high precision machining and excellent surface finish in **IT6** grade of tolerance. The adjustment sensitivity of **1 micron** on the radius is easily readable on the vernier scale and can also be performed in the machine.

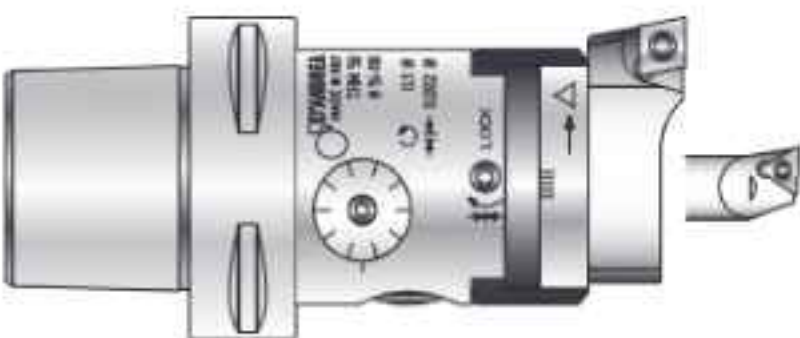


- 1. Body
- 2. Slide toolholder
- 3. **PSC 50-63-80**
- 4. Micrometric vernier scale
- 5. Slide clamp screw
- 6. Coolant outlet
- Max BAR 40**
- 7. Tools clamp screws
- 8. Oiler
- 9. Bit holder
- 10. Tool holder

PSC50 - TRM50
Ø 2.5 ~ 108



PSC63 - TRM50
Ø 2.5 ~ 108



PSC63 - TRM63
Ø 2.5 ~ 125



PSC63 - TRM80
Ø 2.5 ~ 220



PSC50 - TRM50

Ø 2.5 ~ 108



PSC63 - TRM50

Ø 2.5 ~ 108



2 µm

PSC50-TRM50
Ø 2.5-108

PSC63-TRM50
Ø 2.5-108

Tools

RDC D08.16

Vibration-damping

Carbide

B1.02 Ø2,5~4 B1.04 Ø4~6

Ø 28-42

Ø 36-54

Ø 54-84

Ø 80-108

REF.	CODE	kg
PSC50-TRM50	71PSC050TR50080	0.9
PSC63-TRM50	71PSC063TR50080	1.1
D08.16	200560116082	0.02
P25.63	435116250631	0.5
P25.105	435116251051	0.8
PS 31.24	433024140751	0.19
CW 32	392011003201	0.07

On request supplied with coolant tube **PSC**. See p.53

KIT K01 PSC50 - TRM50

Ø 6 ~ 108



- 1 PSC50-TRM50

1 B3.06

1 B3.08

1 B3.11

1 B3.16

1 B3.22

5 TPGX 090202L

1 TPGX 110302L

2 WCGT 020102L
- 1 SFTP 25

1 SFTP 32

1 SFTP 50

1 P 25.63

1 PS 31.24

1 CW 32

DC100

DC100

DC10

REF.	CODE	kg		
KIT K01 PSC50-TRM50	7KPSO050TR50080	3.5		

KIT K01 PSC63 - TRM50

Ø 6 ~ 108



- 1 PSC63-TRM50

1 B3.06

1 B3.08

1 B3.11

1 B3.16

1 B3.22

5 TPGX 090202L

1 TPGX 110302L

2 WCGT 020102L
- 1 SFTP 25

1 SFTP 32

1 SFTP 50

1 P 25.63

1 PS 31.24

1 CW 32

DC100

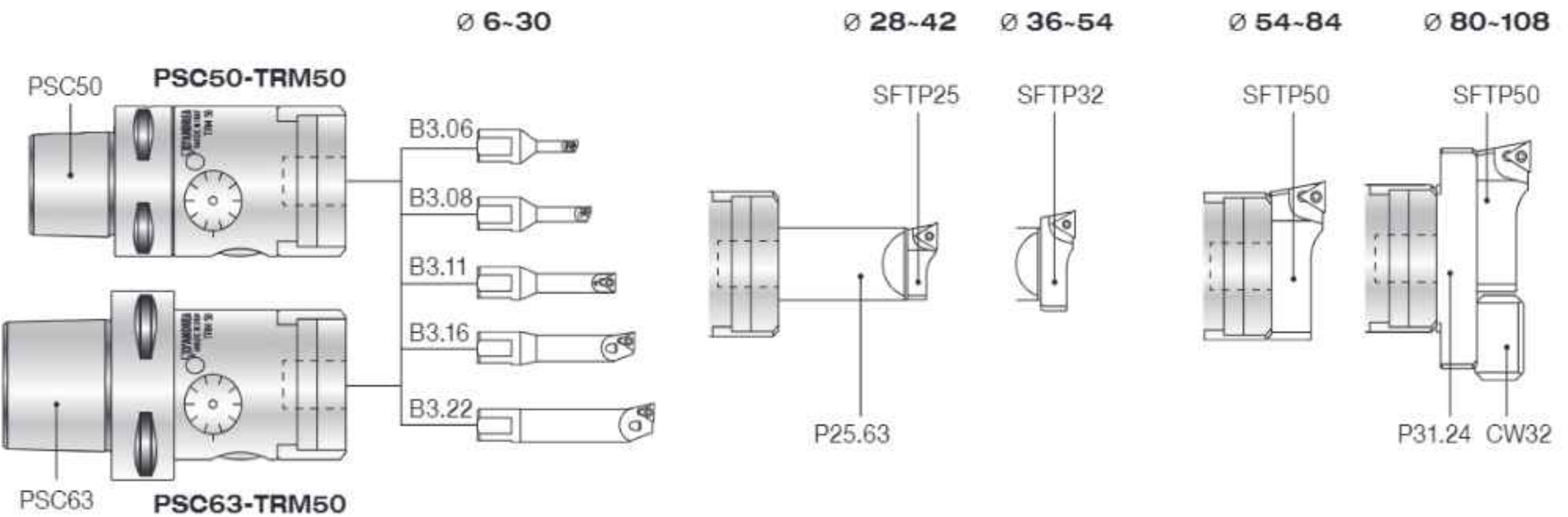
DC100

DC10

REF.	CODE	kg		
KIT K01 PSC63-TRM50	7KPSO063TR50080	4.2		

KIT K01 PSC50-TRM50 / PSC63-TRM50

Working Range



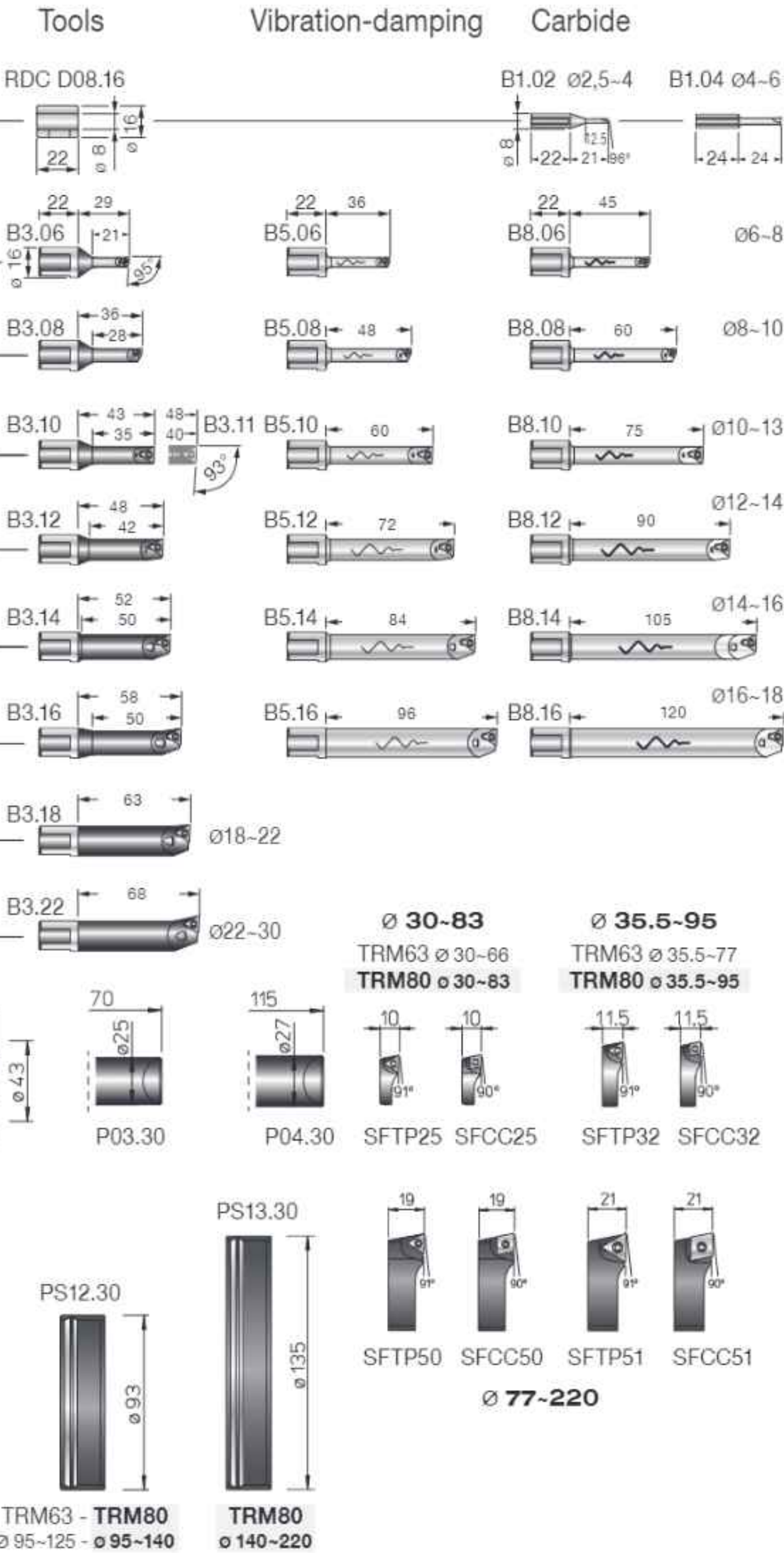
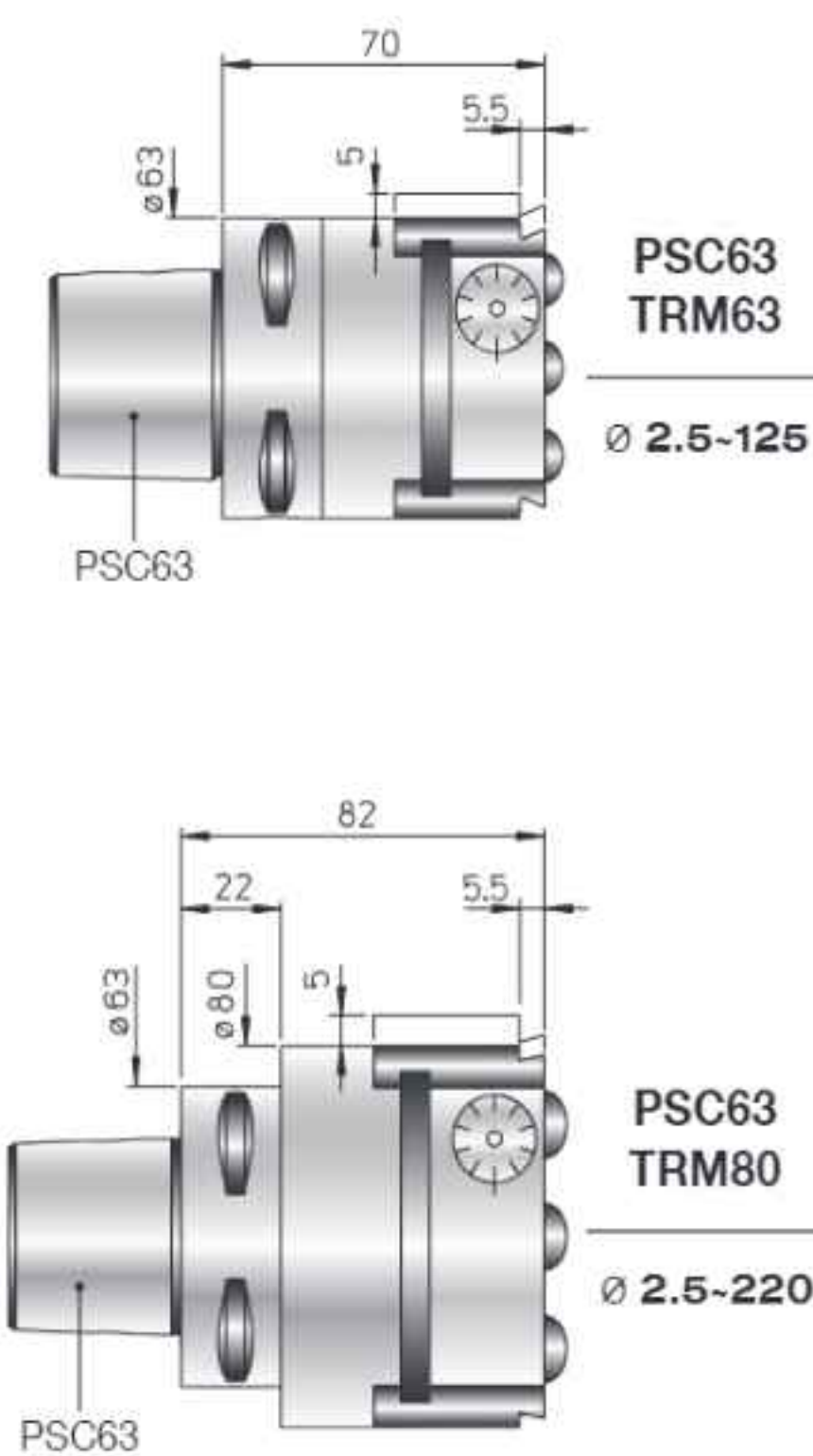
PSC63 - TRM63
Ø 2.5 ~ 125



PSC63 - TRM80
Ø 2.5 ~ 220



2 µm



REF.	CODE	kg
PSC63-TRM63	71PSC063TR63080	1.5
PSC63-TRM80	71PSC063TR80080	2
D08.16	200560116082	0.02
P20.30	431030160300	0.2
P02.30	431030250400	0.3
P03.30	431030250700	0.4
P04.30	431030251150	0.7
PS 11.30	433030260750	0.4
PS 12.30	433030260950	0.5
PS 13.30	433030261400	0.7

On request supplied with coolant tube **PSC**. See p.53

KIT K01 PSC63 - TRM63

Ø 6 ~ 125



- 1 PSC63 - TRM63
- 1 P20.30

1 PS11.30

1 P02.30

1 P03.30

1 B3.06

1 B3.08
- 1 B3.11

1 B3.16

1 B3.22

1 SFTP25

1 SFTP32

1 SFTP50
- 5 TPGX 090202L DC100

1 TPGX 110302L DC100

2 WCGT 020102L DC 10

REF.	CODE	kg		
KIT K01 PSC63-TRM63	7KPSC063TR63080	5.5		

KIT K01 PSC63 - TRM80

Ø 6 ~ 220



- 1 PSC63 - TRM80
- 1 P20.30

1 PS12.30

1 PS13.30

1 P02.30

1 P03.30

1 P04.30

1 B3.06
- 1 B3.08

1 B3.11

1 B3.16

1 B3.22

1 SFTP25

1 SFTP32

1 SFTP50
- 5 TPGX 090202L DC100

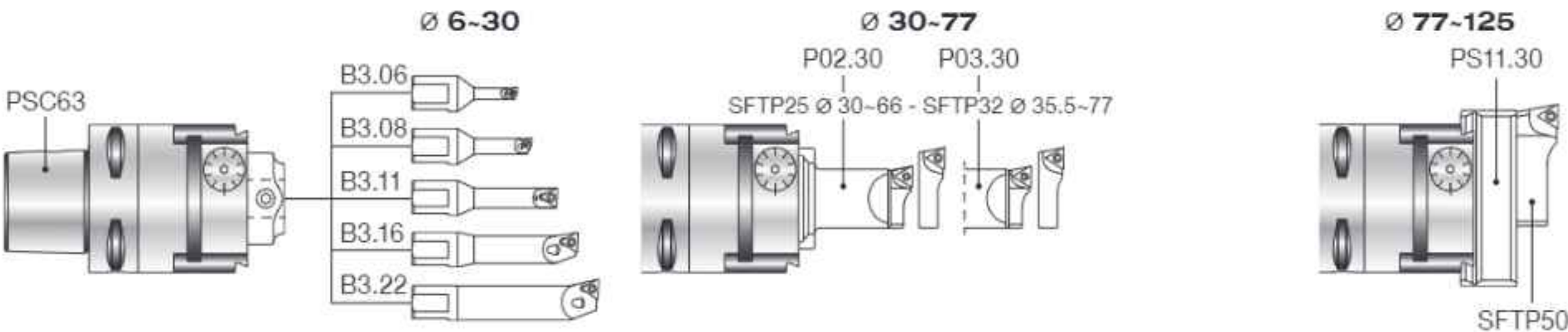
1 TPGX 110302L DC100

2 WCGT 020102L DC 10

REF.	CODE	kg		
KIT K01 PSC63-TRM80	7KPSC063TR80080	6.5		

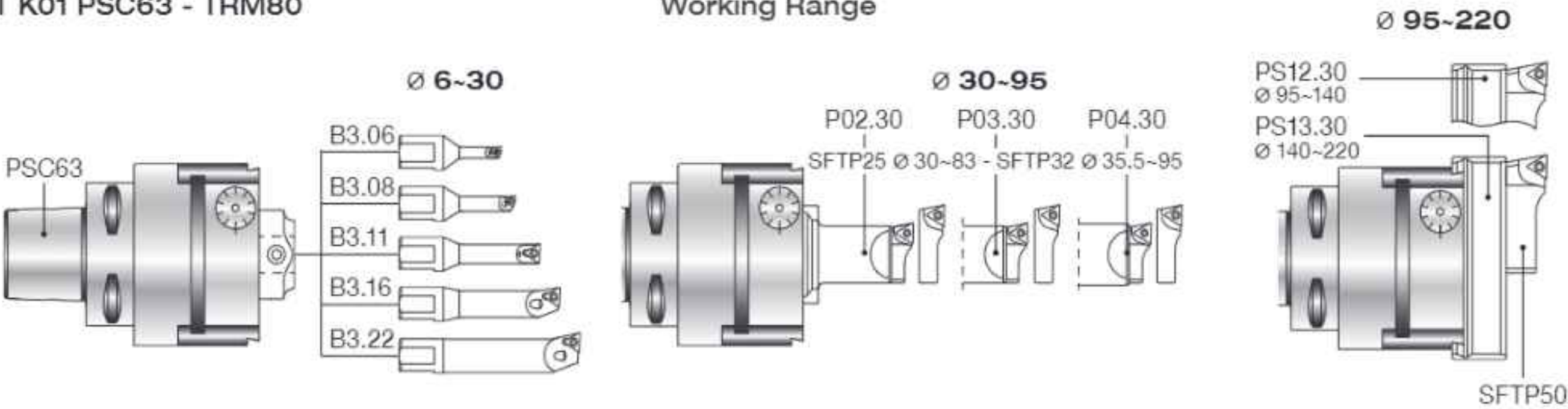
KIT K01 PSC63 - TRM63

Working Range



KIT K01 PSC63 - TRM80

Working Range



REF.	CODE		TORX T	kg
B1.02	572010502001			0.02
B1.04	572010504001			0.02
B3.06	572010506001	WCGT0201..	TS 21 06	0.035
B3.08	572010508001	WCGT0201..	TS 211 06	0.4
B3.10	572010510001	TPGX0902..	CS 250 T 08	0.05
B3.11	572010511001	TPGX0902..	CS 250 T 08	0.055
B3.12	572010512001	TPGX0902..	CS 250 T 08	0.06
B3.14	572010514001	TPGX0902..	CS 250 T 08	0.07
B3.16	572010516001	TPGX0902..	CS 250 T 08	0.07
B3.18	572010518001	TPGX0902..	CS 250 T 08	0.1
B3.22	572010522001	TPGX0902..	CS 250 T 08	0.1

REF.	CODE		TORX T	kg
SFTP25	470500525001	TPGX0902..	CS 250T 08	0.01
SFTP32	470500532001	TPGX0902..	CS 250T 08	0.02
SFTP50	470500550001	TPGX1103..	CS300890T 08	0.08
SFTP51	470500550003	TCMT16T3..	TS 4 15	0.09

• For back-facing machining see p.26

REF.	CODE		TORX T	kg
B5.06	572010506105	WCGT0201..	TS 21 06	0.075
B5.08	572010508105	WCGT0201..	TS 211 06	0.09
B5.10	572010510105	TPGX0902..	CS 250 T 08	0.1
B5.12	572010512105	TPGX0902..	CS 250 T 08	0.1
B5.14	572010514105	TPGX0902..	CS 250 T 08	0.2
B5.16	572010516105	TPGX0902..	CS 250 T 08	0.3
B8.06	572010506108	WCGT0201..	TS 21 06	0.065
B8.08	572010508108	WCGT0201..	TS 211 06	0.08
B8.10	572010510108	TPGX0902..	CS 250 T 08	0.1
B8.12	572010512108	TPGX0902..	CS 250 T 08	0.2
B8.14	572010514108	TPGX0902..	CS 250 T 08	0.2
B8.16	572010516108	TPGX0902..	CS 250 T 08	0.3

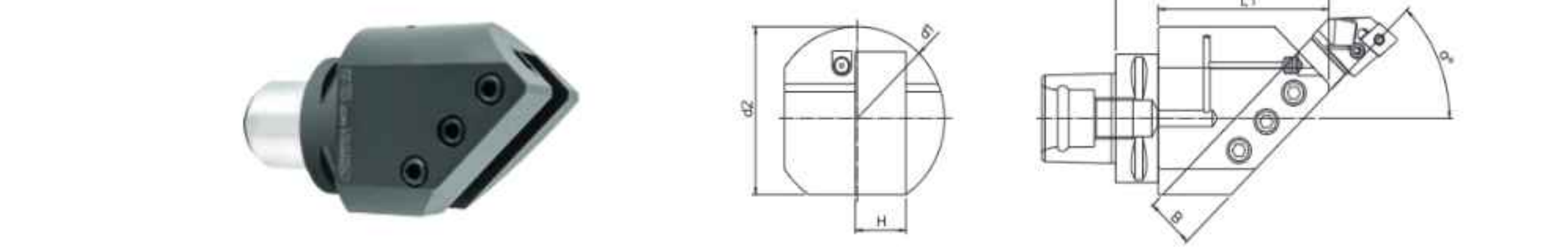
REF.	CODE		TORX T	kg
SFCC25	470500525002	CCGT0602..	TS 25 08	0.01
SFCC32	470500532002	CCGT0602..	TS 25 08	0.02
SFCC50	470500550002	CCGT09T3..	TS 4 15	0.08
SFCC51	470500550004	CCMT1204..	TS 5 25	0.09

PSC - TCD'

TURNING TOOLHOLDERS

TCD' is the turning tools line made according to the ISO 26623-1 **PSC** standards for Application on MULTI-TASK machines. The **TCD'** program consists of turning tools adapters. The **TCD'** line is prepared with the coolant way.

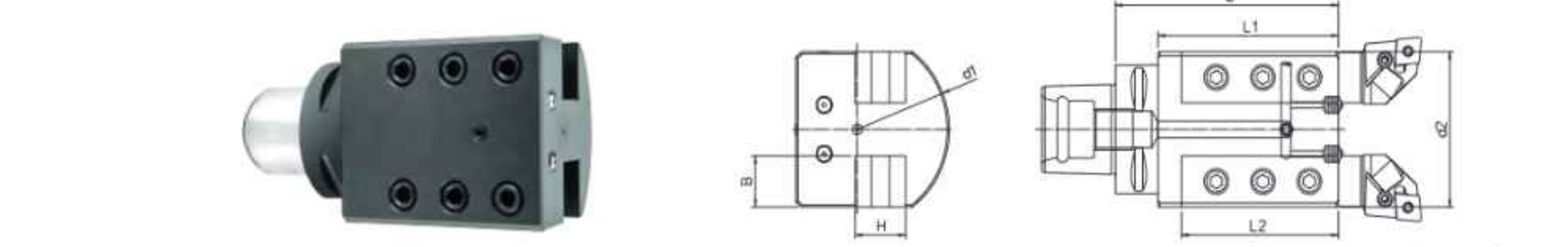
PSC - TU ISO 26623-1



Right hand tool holder shown. A standard Application requires left hand tools with right hand adapters.

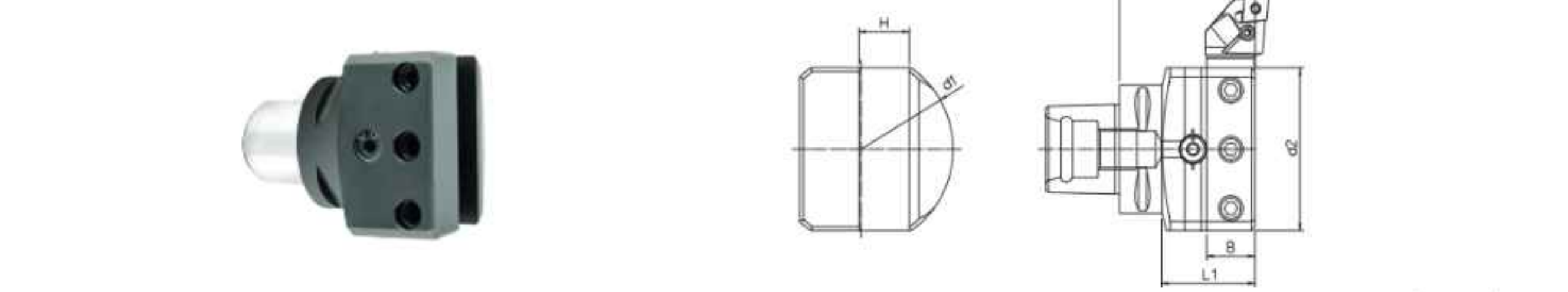
PSC	REF.	CODE	L	L1	d1	d2	a°	BxH	kg		
50	TCD' PSC50 - TU20.45R	71PSC050T2045R1	90	70	72	65	45°	20x20	1.8		
50	TCD' PSC50 - TU20.45L	71PSC050T2045L1	90	70	72	65	45°	20x20	1.8		
63	TCD' PSC63 - TU25.45R	71PSC063T2545R1	110	88	90	82.5	45°	25x25	3.5		
63	TCD' PSC63 - TU25.45L	71PSC063T2545L1	110	88	90	82.5	45°	25x25	3.5		
80	TCD' PSC80 - TU32.45R	71PSC080T3245R1	135	105	115	98.5	45°	32x32	6.4		
80	TCD' PSC80 - TU32.45L	71PSC080T3245L1	135	105	115	98.5	45°	32x32	6.4		

PSC - TU ISO 26623-1



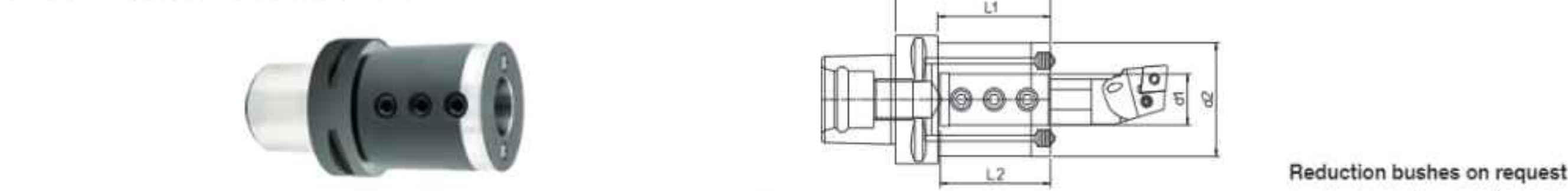
PSC	REF.	CODE	L	L1	L2	d1	d2	BxH	kg		
50	TCD' PSC50 - TU20.02	71PSC050T200201	100	80	64	80	63	20x20	2.5		
63	TCD' PSC63 - TU25.02	71PSC063T250201	115	93	80	95	76	25x25	4		
80	TCD' PSC80 - TU32.02	71PSC080T320201	125	95	80	115	86	32x32	6.2		

PSC - TU ISO 26623-1



PSC	REF.	CODE	L	L1	d1	d2	BxH	kg		
50	TCD' PSC50 - TU20.90	71PSC050T209001	60	40	80	64	20x20	1.4		
63	TCD' PSC63 - TU25.90	71PSC063T259001	70	48	95	80	25x25	2.6		
80	TCD' PSC80 - TU32.90	71PSC080T329001	85	55	133	105	32x32	5.2		

PSC - D... ISO 26623-1



Reduction bushes on request

PSC	REF.	CODE	d1H7	d2	L	L1	L2	kg		
50	TCD' PSC50 - D.25x80	71PSC050D250801	25	56	80	60	58	1.4		
63	TCD' PSC63 - D.25x80	71PSC063D250801	25	56	80	58	58	1.7		
63	TCD' PSC63 - D.40x125	71PSC063D401201	40	80	125	103	85	3.9		
80	TCD' PSC80 - D.25x85	71PSC080D250801	25	56	85	55	58	2.6		
63	TCD' PSC80 - D.40x125	71PSC080D401201	40	80	125	95	85	4.6		

On request supplied with coolant tube **PSC**. See p.53 

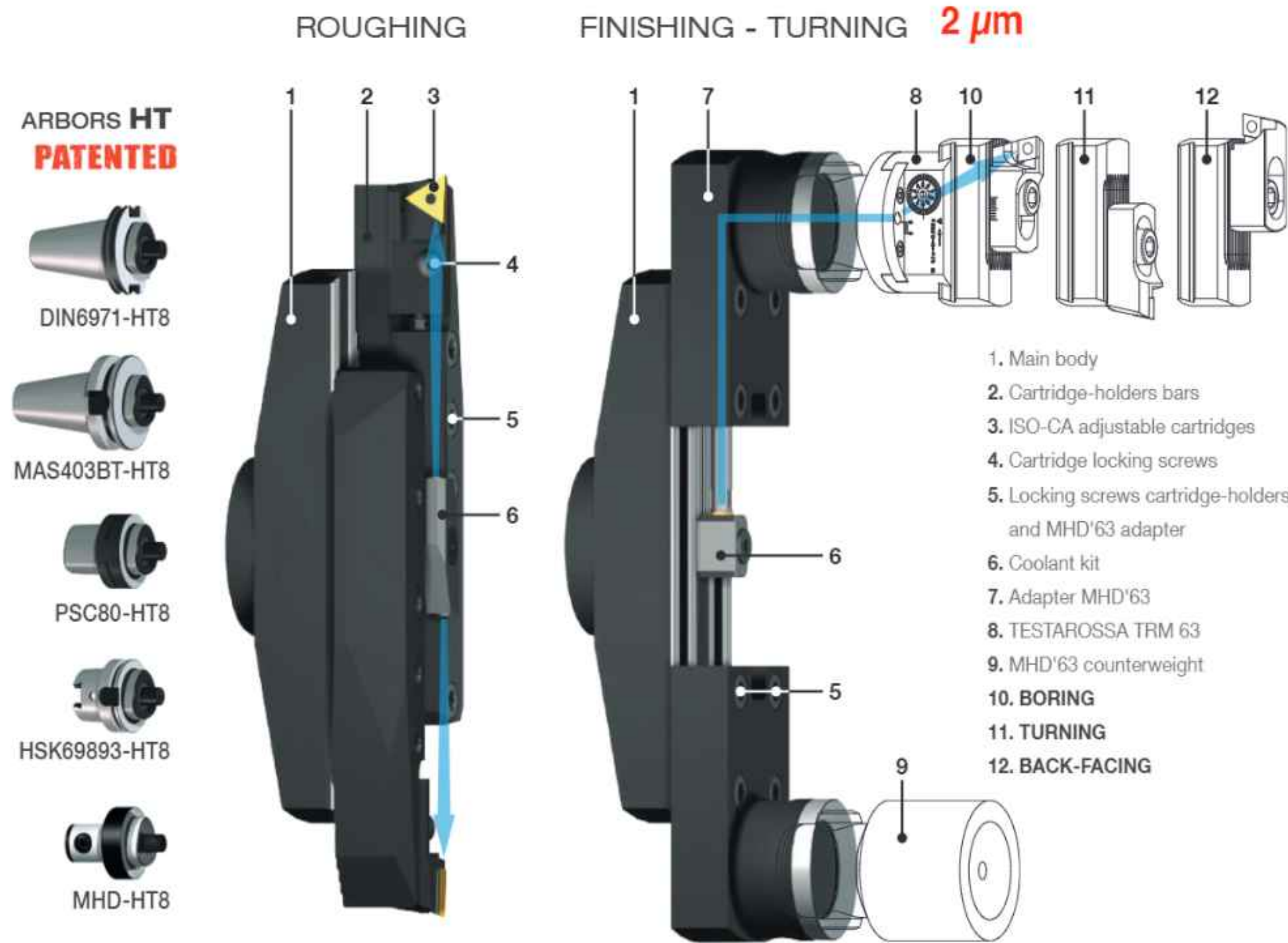


The new **BHT** boring system is characterized by the new **HT** coupling suitable for medium-heavy machining, characterized by strong torsional components with maximum concentricity.

BHT bars cover a working range from Ø 250 to Ø 750 mm, both in roughing and finishing.

The wide range of accessories includes adjustable ISO-CA roughing cartridges and a standard TRM 63 finishing micrometric head, suitable for boring, chamfering and back-facing operations.

The system in **FINISHING** configuration can be balanced by using counterweights.



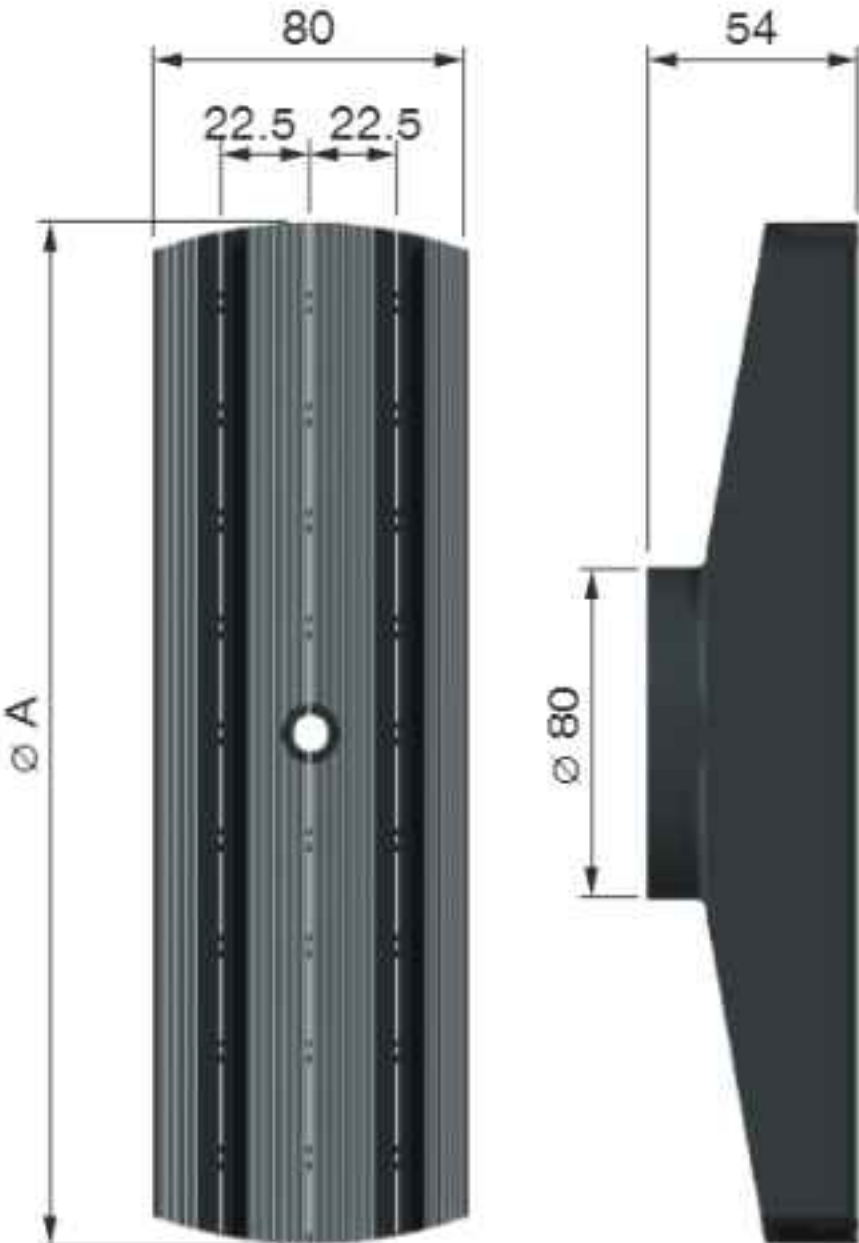
12. BACKWARD

For **ROUGHING** operations
use TS 63/63+SSQC 63 see page 26

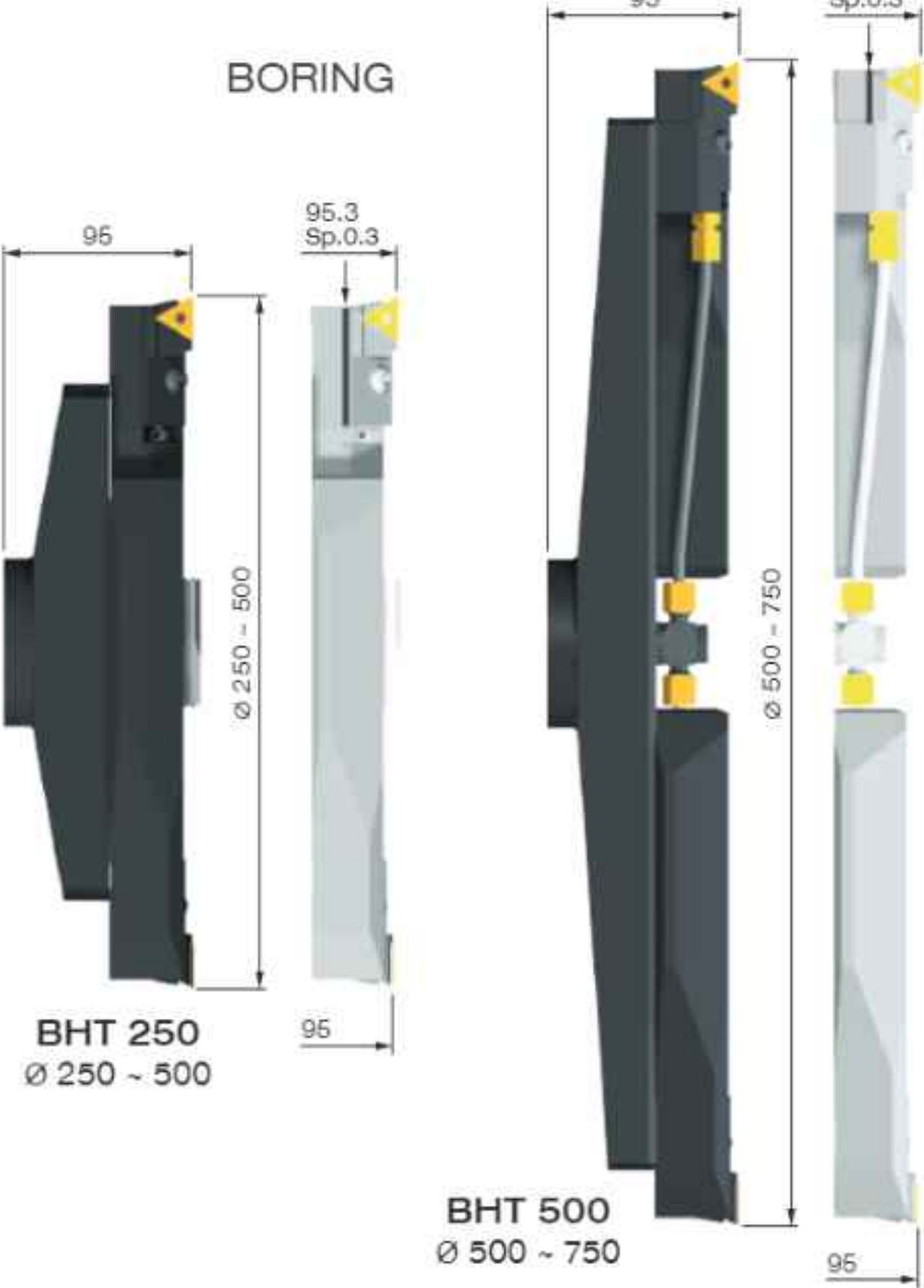
For **FINISHING** operations
use TRM 63+PS..+SFQC 50 see page 26

REF.	CODE	Ø	A	kg
BHT 250	435508882460	250 ~ 500	246	4.2
BHT 500	435508882960	500 ~ 750	496	7.8

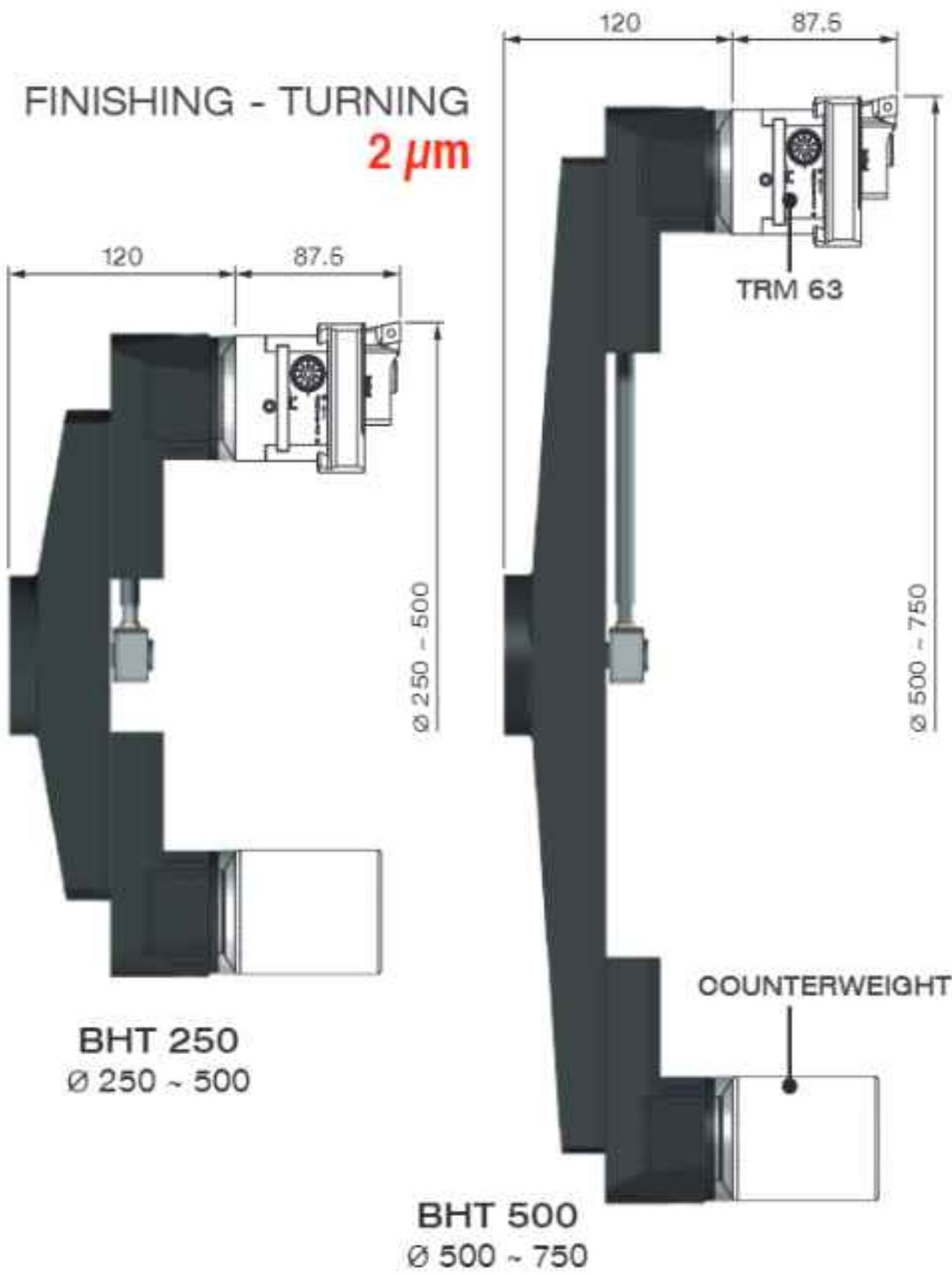
REF.	CODE	kg
DIN 69871-AD50 - HT8.36.5	41HT08025000	3.4
MAS403BT-AD50 - HT8.38.5	41HT08035000	3.7
PSC 80 - HT8.30	41HT08018000	2
HSK 100 - HT8.76.5	41HT08041000	4
MHD' 80 - HT8	655108000080	2



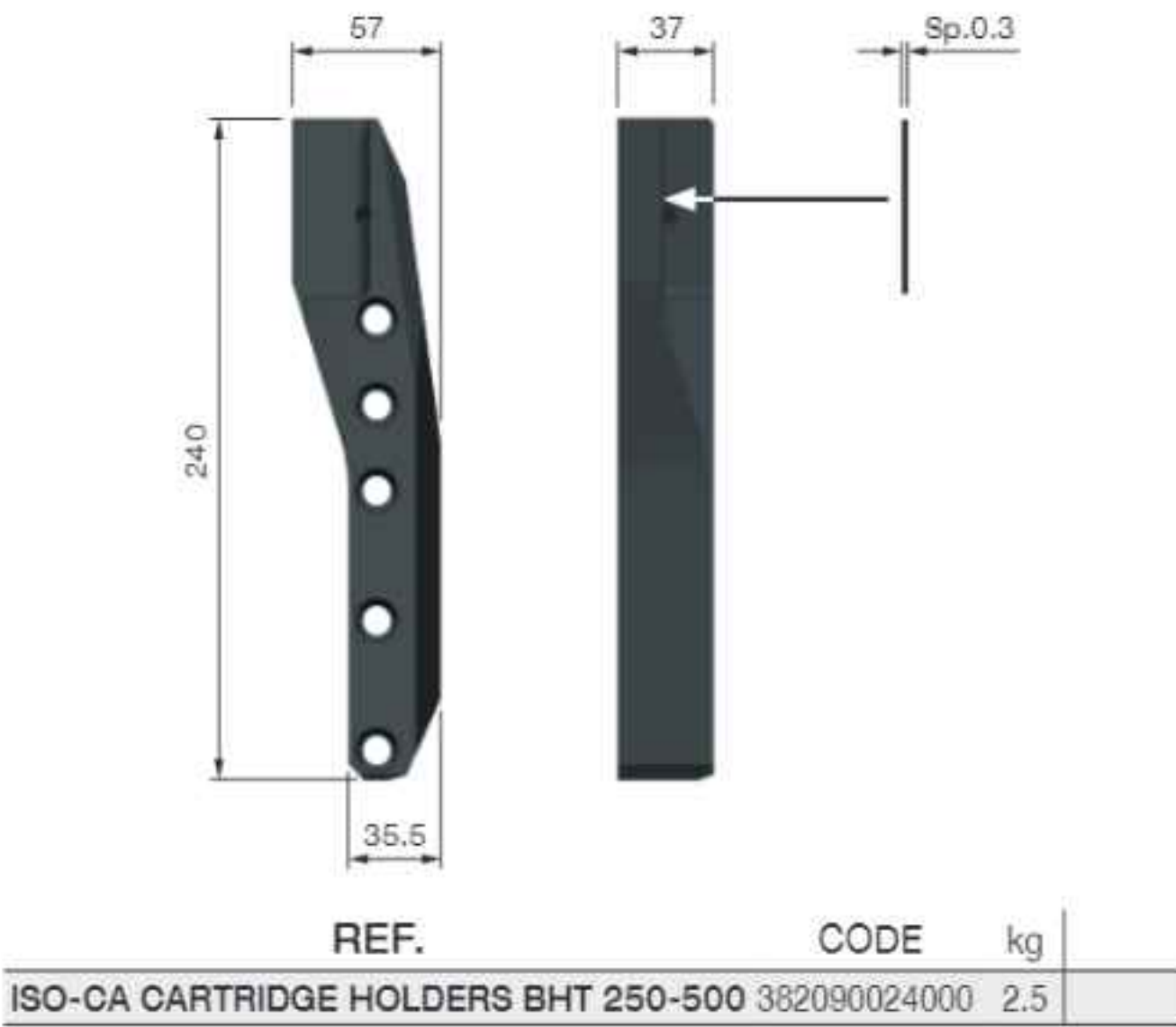
BHT Ø 250 ~ 750



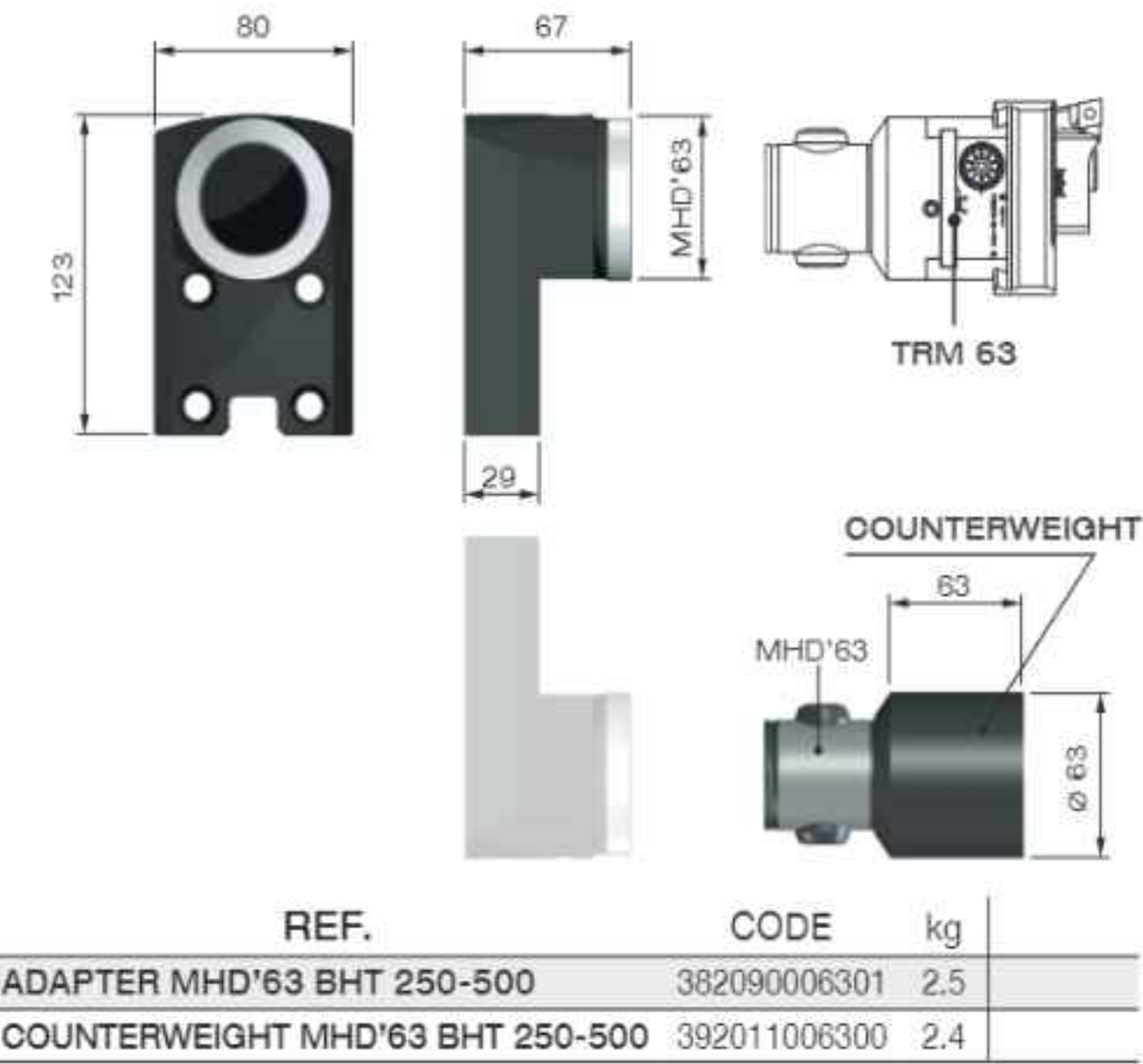
FINISHING - TURNING
2 µm



ISO-CA CARTRIDGE HOLDERS



ADAPTER MHD'63



COOLANT KIT



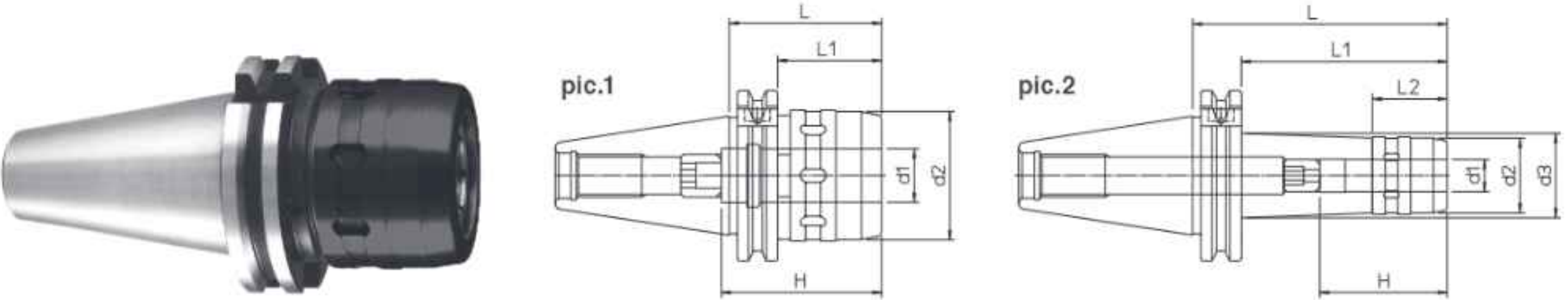
CARTRIDGES 20CA ISO 5611



MONOforce high precision ultra-tight toolholders, suitable for rough milling and precision finishing operations.
Produced in accordance with the most widespread standards of machine spindles, by using RC reduction bushes, it allows a range of use from Ø 3mm to Ø 25mm, RC sealed bushes are also available.
All MONOforce toolholders are balanced to class of tolerance G 6.3 at 15,000 rpm.

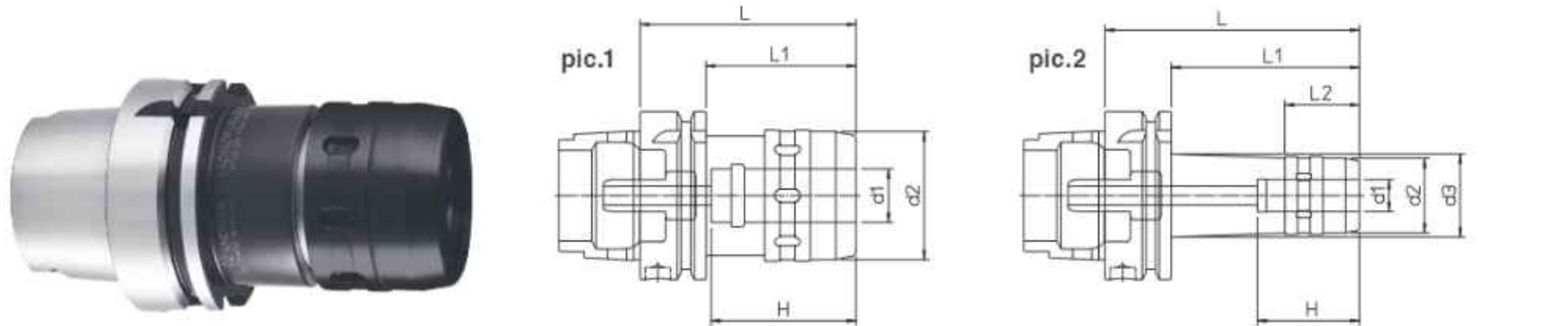


DIN 69871 AD



Without clamping wrench - Chip prearrangement												
DIN	REF.	CODE	d1	d2	d3	H	L	L1	L2	kg	pic.	
40	DIN69871-AD40 MF12.100	71DIN-A40MF1210	12	28	32	46	100	81	29.5	1.2	2	
40	DIN69871-AD40 MF20.60	71DIN-A40MF2006	20	48		63	60	41		1.1	1	
40	DIN69871-AD40 MF32.95	71DIN-A40MF3209	32	66		80	95			1.6	1	
50	DIN69871-AD50 MF20.80	71DIN-A50MF2008	20	48		63	80	61		2.3	1	
50	DIN69871-AD50 MF32.75	71DIN-A50MF3207	32	66		90	75	56		2.8	1	

DIN 69893 HSK-A



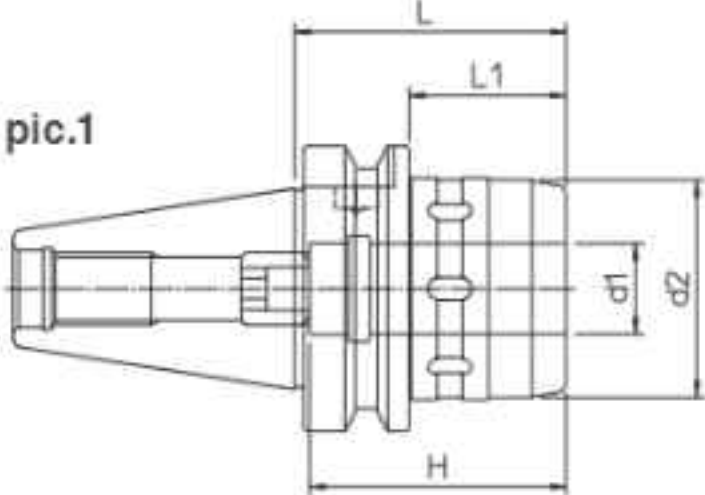
Supplied with coolant tube - Without clamping wrench - Chip prearrangement												
HSK-A	REF.	CODE	d1	d2	d3	H	L	L1	L2	kg	pic.	
63	HSK-A63 MF12.100	71HSK-A63MF1210	12	28	32	46	100	74	29.5	1.1	2	
63	HSK-A63 MF20.85	71HSK-A63MF2008	20	48		60	85	59		1.2	1	
63	HSK-A63 MF32.105	71HSK-A63MF3210	32	66		80	105			2	1	
100	HSK-A100 MF20.95	71HSKA100MF2009	20	48		60	95	66		2.8	1	
100	HSK-A100 MF32.110	71HSKA100MF3211	32	66		80	110	81		3.1	1	



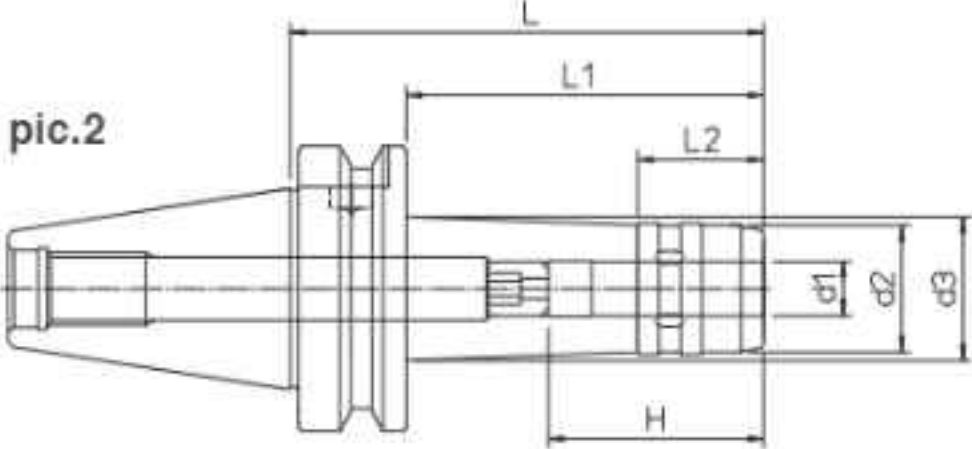
MAS 403 BT AD



pic.1



pic.2



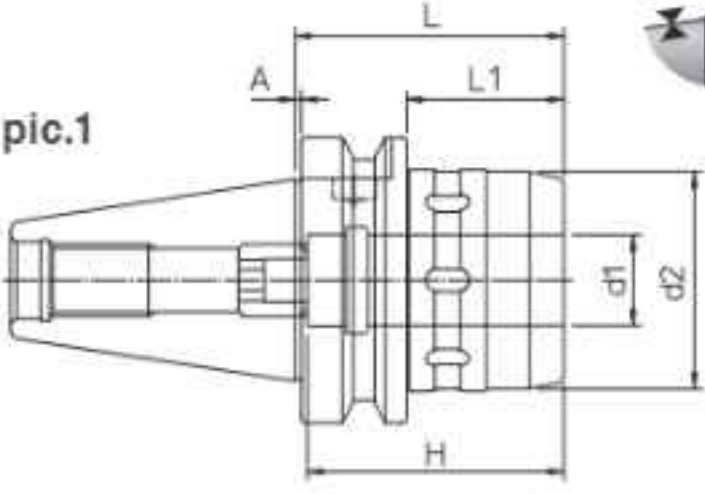
Without clamping wrench - Chip prearrangement

BT	REF.	CODE	d1	d2	d3	H	L	L1	L2	kg	pic.		
40	MAS403 BT40-AD MF12.100	71MBT-A40MF1210	12	28	32	46	100	73	29.5	1.4	2		
40	MAS403 BT40-AD MF20.65	71MBT-A40MF2007	20	48		63	65	38		1.3	1		
40	MAS403 BT40-AD MF32.90	71MBT-A40MF3209	32	66		80	90			2.1	1		
50	MAS403 BT50-AD MF20.85	71MBT-A50MF2008	20	48		63	85	47		3.7	1		
50	MAS403 BT50-AD MF32.95	71MBT-A50MF3209	32	66		90	95	57		4.4	1		

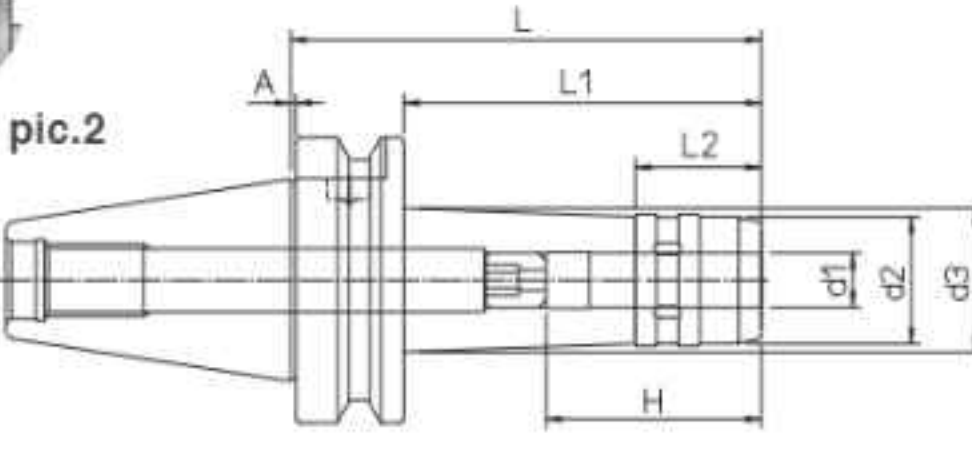
MAS 403 BT AD FACE CONTACT



pic.1



pic.2

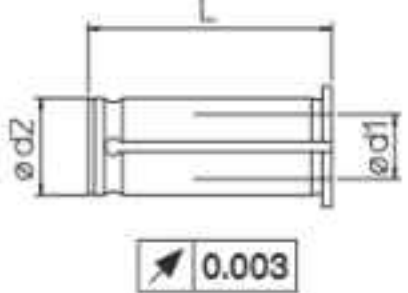


Without clamping wrench - Chip prearrangement

BT	REF.	CODE	d1	d2	d3	H	A	L	L1	L2	kg	pic.		
40	MAS403 BT40-AD FC MF12.100	71MBF-A40MF1210	12	28	32	46	1	100	73	29.5	1.4	2		
40	MAS403 BT40-AD FC MF20.65	71MBF-A40MF2007	20	48		63	1	65	38		1.3	1		
40	MAS403 BT40-AD FC MF32.90	71MBF-A40MF3209	32	66		80	1	90			2.1	1		
50	MAS403 BT50-AD FC MF20.85	71MBF-A50MF2008	20	48		63	1.5	85	47		3.7	1		
50	MAS403 BT50-AD FC MF32.95	71MBF-A50MF3209	32	66		90	1.5	95	57		4.4	1		

RC BUSHES ULTRA-TIGHT SPINDLE





RC SEALED bushes on request

ød2	REF.	CODE	d1	L		
32	RC32.03	497080032030	3	63		
32	RC32.04	497080032040	4	63		
32	RC32.05	497080032050	5	63		
32	RC32.06	497080032060	6	63		
32	RC32.08	497080032080	8	63		
32	RC32.10	497080032100	10	63		
32	RC32.12	497080032120	12	63		
32	RC32.14	497080032140	14	63		
32	RC32.16	497080032160	16	63		
32	RC32.18	497080032180	18	63		
32	RC32.20	497080032200	20	63		
32	RC32.25	497080032250	25	63		

ød2	REF.	CODE	d1	L		
20	RC20.03	497080020030	3	50		
20	RC20.04	497080020040	4	50		
20	RC20.05	497080020050	5	50		
20	RC20.06	497080020060	6	50		
20	RC20.08	497080020080	8	50		
20	RC20.10	497080020100	10	50		
20	RC20.12	497080020120	12	50		
20	RC20.14	497080020140	14	50		
20	RC20.16	497080020160	16	50		

ød2	REF.	CODE	d1	L		
12	RC12.03	497080012030	3	44		
12	RC12.04	497080012040	4	44		
12	RC12.06	497080012060	6	44		
12	RC12.08	497080012080	8	44		
12	RC12.10	497080012100	10	44		

PR CT R SHRINK FIT EXTENSIONS WITH AXIAL ADJUSTMENT





Supplied with the axial setting screw

REF.	CODE	d1	d2	d3	L	L1	kg		
PR.CT.R D20.06.130	49DC21320060	6	14	20	130	22 / 36	0.20		
PR.CT.R D20.06.160	49DC21620060	6	14	20	160	22 / 32	0.33		
PR.CT.R D20.08.130	49DC21320080	8	14	20	130	22 / 36	0.25		
PR.CT.R D32.16.160	49DC21632160	16	27	32	160	39 / 49	0.78		
PR.CT.R D32.16.200	49DC22032160	16	27	32	200	39 / 49	1.81		
PR.CT.R D32.18.160	49DC21632180	18	27	32	160	39 / 49	0.77		
PR.CT.R D32.20.160	49DC21632200	20	27	32	160	41 / 51	0.67		
PR.CT.R D32.20.200	49DC22032200	20	27	32	200	41 / 51	0.87		

MONOd'

MONOLITHIC TOOLHOLDERS

MONOd' monolithic collet chuck holders manufactured according to ISO Standards in DIN 69871, MAS 403 BT and DIN 69893 HSK machine tools.

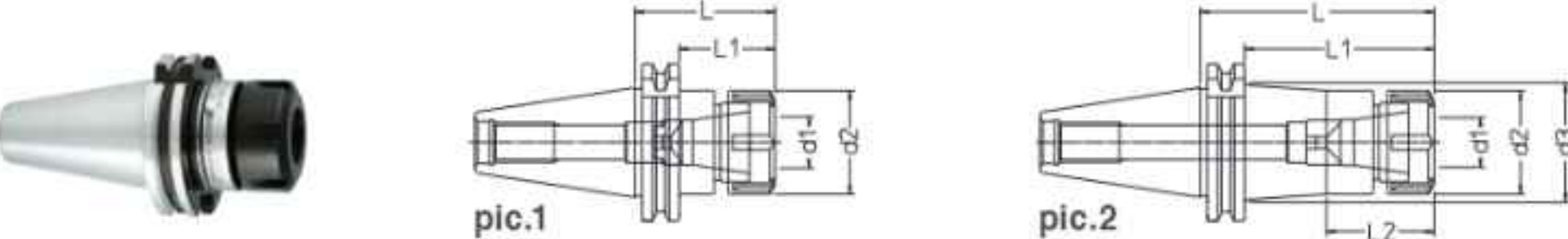
Produced in high quality, they guarantee a high level of precision. All ER toolholders are balanced to class G 6.3 at 15,000 rpm.



0.003

MAX. RPM 15.000

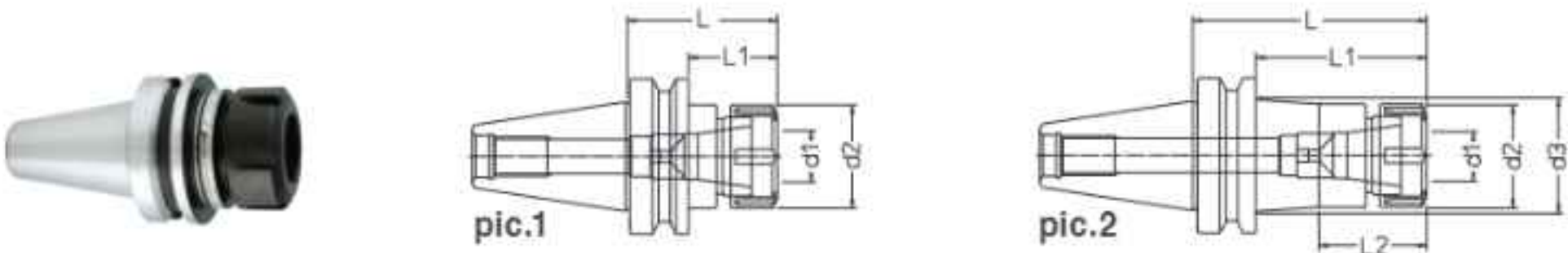
DIN 69871 AD COLLET CHUCK HOLDER - ER DIN 6499



Supplied without collets and clamping wrenches

DIN	REF.	CODE	ER	d1	d2	d3	L	L1	L2	kg	pic.		
40	DIN69871-AD40 ER16.60	71DIN-A40ER1606	16M	0.5-10	22		60	41		0.9	1		
40	DIN69871-AD40 ER16.100	71DIN-A40ER1610	16M	0.5-10	22	29.5	100	81	41	1	2		
40	DIN69871-AD40 ER25.60	71DIN-A40ER2506	25	1-16	42		60	41		1.1	1		
40	DIN69871-AD40 ER25.100	71DIN-A40ER2510	25	1-16	42	47	100	81	46	1.6	2		
40	DIN69871-AD40 ER32.70	71DIN-A40ER3207	32	2-20	50		70	51		1.2	1		
40	DIN69871-AD40 ER32.110	71DIN-A40ER3211	32	2-20	50		110	91		1.7	1		
50	DIN69871-AD50 ER16.100	71DIN-A50ER1610	16M	0.5-10	22	29.5	100	81	41	2.5	2		
50	DIN69871-AD50 ER16.160	71DIN-A50ER1616	16M	0.5-10	22	32.5	160	141	41	3.3	2		
50	DIN69871-AD50 ER25.110	71DIN-A50ER2511	25	1-16	42	48	110	91	46	2.8	2		
50	DIN69871-AD50 ER25.160	71DIN-A50ER2516	25	1-16	42	50	160	141	46	3.6	2		
50	DIN69871-AD50 ER32.70	71DIN-A50ER3207	32	2-20	50		70	51		2.9	1		
50	DIN69871-AD50 ER32.160	71DIN-A50ER3216	32	2-20	50	57.5	160	141	52	4	2		

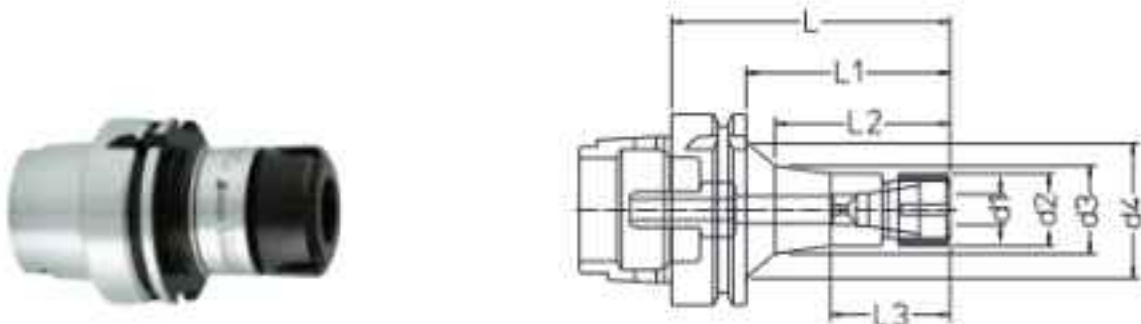
MAS 403 BT AD COLLET CHUCK HOLDER - ER DIN 6499



Supplied without collets and clamping wrenches

BT	REF.	CODE	ER	d1	d2	d3	L	L1	L2	kg	pic.		
40	MAS403 BT40-AD ER16.60	71MBT-A40ER1606	16M	0.5-10	22		60	33		1	1		
40	MAS403 BT40-AD ER16.100	71MBT-A40ER1610	16M	0.5-10	22	28	100	73	41	1.1	2		
40	MAS403 BT40-AD ER25.65	71MBT-A40ER2506	25	1-16	42		65	38		1.2	1		
40	MAS403 BT40-AD ER25.100	71MBT-A40ER2510	25	1-16	42	45.5	100	73	46	1.7	2		
40	MAS403 BT40-AD ER32.70	71MBT-A40ER3207	32	2-20	50		70	43		1.3	1		
40	MAS403 BT40-AD ER32.110	71MBT-A40ER3211	32	2-20	50		110	83		1.8	1		
50	MAS403 BT50-AD ER16.100	71MBT-A50ER1610	16M	0.5-10	22	26.5	100	62	41	3.6	2		
50	MAS403 BT50-AD ER16.160	71MBT-A50ER1616	16M	0.5-10	22	31	160	122	41	4.3	2		
50	MAS403 BT50-AD ER25.110	71MBT-A50ER2511	25	1-16	42	45.5	110	72	46	3.8	2		
50	MAS403 BT50-AD ER25.160	71MBT-A50ER2516	25	1-16	42	48.5	160	122	46	4.6	2		
50	MAS403 BT50-AD ER32.80	71MBT-A50ER3208	32	2-20	50		80	42		3.9	1		
50	MAS403 BT50-AD ER32.160	71MBT-A50ER3216	32	2-20	50	56	160	122	52	5	2		

DIN 69893 HSK-A COLLET CHUCK HOLDER - ER DIN 6499



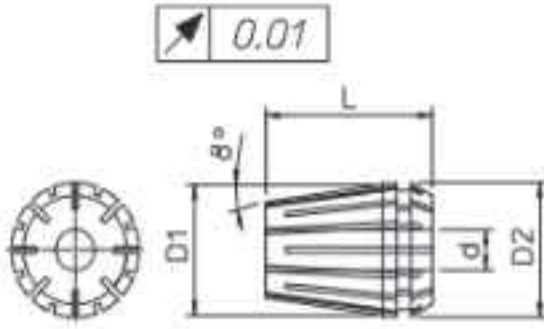
Supplied with coolant tube

HSK-A	REF.	CODE	ER	d1	d2	d3	d4	L	L1	L2	L3	kg		
63	HSK-A63 ER16.80	71HSKA063ER1608	16M	0.5-10	22	32		80	54	41		1.1		
63	HSK-A63 ER16.120	71HSKA063ER1612	16M	0.5-10	22	31		120	94			1.9		
63	HSK-A63 ER25.80	71HSKA063ER2508	25	1-16	42			80	54			1.3		
63	HSK-A63 ER25.140	71HSKA063ER2514	25	1-16	42	47.5		140	114	46		1.7		
63	HSK-A63 ER32.90	71HSKA063ER3209	32	2-20	50			90	64			1.6		
63	HSK-A63 ER32.160	71HSKA063ER3216	32	2-20	50			160	134			2.2		
100	HSK-A100 ER16.100	71HSKA100ER1610	16M	0.5-10	22	25	45	100	71	61	41.5	2.3		
100	HSK-A100 ER16.160	71HSKA100ER1616	16M	0.5-10	22	34.5	44	160	131	126		2.5		
100	HSK-A100 ER25.100	71HSKA100ER2510	25	1-16	42	45.5		100	71	47		2.6		
100	HSK-A100 ER25.160	71HSKA100ER2516	25	1-16	42	49.5		160	131	47		3.2		
100	HSK-A100 ER32.120	71HSKA100ER3212	32	2-20	50	55		120	91	52		3.1		
100	HSK-A100 ER32.160	71HSKA100ER3216	32	2-20	50	58.5		160	131	52		3.7		



PSC - PE see p.34

ER DIN 6499-B



REF.	d	D1	D2	L
ER 16	0.5 ~ 10	16	17	27.5
ER 25	1 ~ 16	25	26	34
ER 32	2 ~ 20	32	33	40

RANGE	CODE ER16		CODE ER25		CODE ER32
1 - 0.5	496080116010				
1.5 - 1	496080116015				
2 - 1					
2 - 1.5	496080116021		496080125020		
2.5 - 2	496080116025				
3 - 2	496080116030		496080125030		496080132030
4 - 3	496080116040		496080125040		496080132040
5 - 4	496080116050		496080125050		496080132050
6 - 5	496080116060		496080125060		496080132060
7 - 6	496080116070		496080125070		496080132070
8 - 7	496080116080		496080125080		496080132080
9 - 8	496080116090		496080125090		496080132090
10 - 9	496080116100		496080125100		496080132100
11 - 10			496080125110		496080132110
12 - 11			496080125120		496080132120
13 - 12			496080125130		496080132130
14 - 13			496080125140		496080132140
15 - 14			496080125150		496080132150
16 - 15			496080125160		496080132160
17 - 16					496080132170
18 - 17					496080132180
19 - 18					496080132190
20 - 19					496080132200

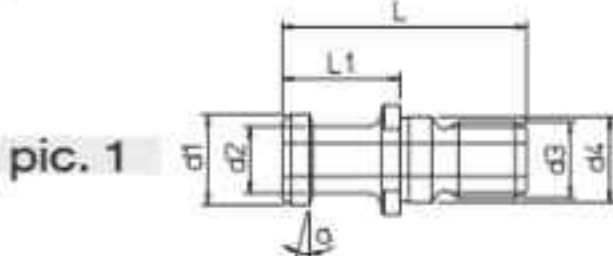
ER collets SEALED on request

SET ER



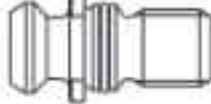
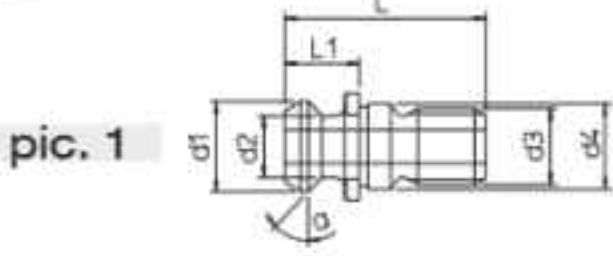
REF.	Ø	CODE
SET ER16/10	0.5 ~ 10	496080116000
SET ER25/15	1 ~ 16	496080125000
SET ER32/18	2 ~ 20	496080132000

ISO 7388/2 A - DIN 69872



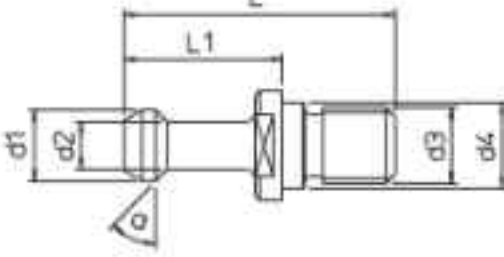
REF.	CODE	ISO	d1	d2	d3	d4	L	L1	a	pic.
TNT DIN69872-ISO7388/2A 40	201430250401	40	19	14	M16	17	54	26	15°	1
TNT DIN69872-ISO7388/2A 50	201430250501	50	28	21	M24	25	74	34	15°	1
TNT ISO7388/2A 40 WH	201430250400	40	19	14	M16	17	54	26	15°	2
TNT ISO7388/2A 50 WH	201430250500	50	28	21	M24	25	74	34	15°	2

ISO 7388/2 B - ANSI B.5 50



REF.	CODE	ISO	d1	d2	d3	d4	L	L1	a	pic.
TNT ISO7388/2B 40 ANSI B5.50	201430251401	40	18.95	12.95	M16	17	44.50	16.40	45°	1
TNT ISO7388/2B 50 ANSI B5.50	201430251501	50	29.10	19.60	M24	25	65.50	25.55	45°	1
TNT ISO7388/2B 40 WH	201430251400	40	18.95	12.95	M16	17	44.50	16.40	45°	2
TNT ISO7388/2B 50 WH	201430251500	50	29.10	19.60	M24	25	65.50	25.55	45°	2

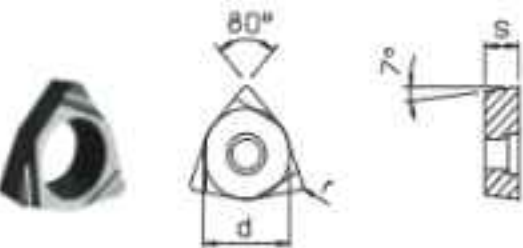
MAS 403 BT - 30° - 45°



REF.	CODE	ISO	d1	d2	d3	d4	L	L1	a
TNT MAS403 BT30 30°	201430252301	30	11	7	M12	12.5	43	23	30°
TNT MAS403 BT40 30°	201430252401	40	15	10	M16	17	60	35	30°
TNT MAS403 BT50 30°	201430252501	50	23	17	M24	25	85	45	30°
TNT MAS403 BT30 45°	201430252302	30	11	7	M12	12.5	43	23	45°
TNT MAS403 BT40 45°	201430252402	40	15	10	M16	17	60	35	45°
TNT MAS403 BT50 45°	201430252502	50	23	17	M24	25	85	45	45°

INSERTS

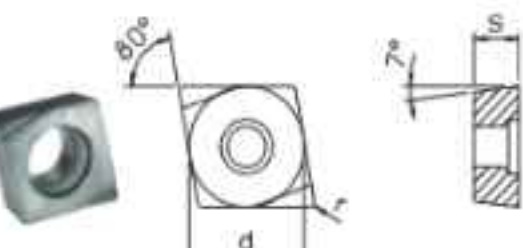
WCGT ○○○○○○L



REF.		CODE	d	s	r		
WCGT 020102L DC 100	CERMET	WCGT020102LC100	3.97	1.59	0.2	TS 21+ - TS 211+	TORX T06
WCGT 020102L DC 100T	COATED CERMET	WCGT020102LC10T	3.97	1.59	0.2	TS 21+ - TS 211+	TORX T06
WCGT 020102L DK 100	CARBIDE	WCGT020102LK100	3.97	1.59	0.2	TS 21+ - TS 211+	TORX T06
WCGT 020102L DP 300	CARBIDE	WCGT020102LP300	3.97	1.59	0.2	TS 21+ - TS 211+	TORX T06
WCGT 020104L DC 100	CERMET	WCGT020104LC100	3.97	1.59	0.4	TS 21+ - TS 211+	TORX T06
WCGT 020104L DC 100T	COATED CERMET	WCGT020104LC10T	3.97	1.59	0.4	TS 21+ - TS 211+	TORX T06
WCGT 020104L DK 100	CARBIDE	WCGT020104LK100	3.97	1.59	0.4	TS 21+ - TS 211+	TORX T06
WCGT 020104L DP 300	CARBIDE	WCGT020104LP300	3.97	1.59	0.4	TS 21+ - TS 211+	TORX T06

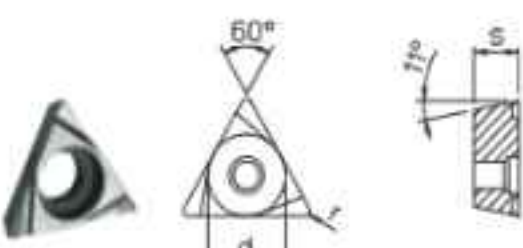
* TS21 : B...06 / * TS211 : B...08

CCGT ○○○○○○L



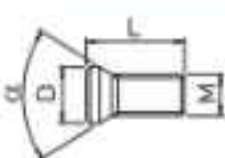
REF.		CODE	d	s	r		
CCGT 060200L DC 100	CERMET	CCGT060200LC100	6.35	2.38	0	TS 25	TORX T08
CCGT 060200L DC 100T	COATED CERMET	CCGT060200LC10T	6.35	2.38	0	TS 25	TORX T08
CCGT 060200L DK 100	CARBIDE	CCGT060200LK100	6.35	2.38	0	TS 25	TORX T08
CCGT 060200L DP 300	CARBIDE	CCGT060200LP300	6.35	2.38	0	TS 25	TORX T08
CCGT 060202L DC 100	CERMET	CCGT060202LC100	6.35	2.38	0.2	TS 25	TORX T08
CCGT 060202L DC 100T	COATED CERMET	CCGT060202LC10T	6.35	2.38	0.2	TS 25	TORX T08
CCGT 060202L DK 100	CARBIDE	CCGT060202LK100	6.35	2.38	0.2	TS 25	TORX T08
CCGT 060202L DP 300	CARBIDE	CCGT060202LP300	6.35	2.38	0.2	TS 25	TORX T08
CCGT 060204L DC 100	CERMET	CCGT060204LC100	6.35	2.38	0.4	TS 25	TORX T08
CCGT 060204L DC 100T	COATED CERMET	CCGT060204LC10T	6.35	2.38	0.4	TS 25	TORX T08
CCGT 060204L DK 100	CARBIDE	CCGT060204LK100	6.35	2.38	0.4	TS 25	TORX T08
CCGT 060204L DP 300	CARBIDE	CCGT060204LP300	6.35	2.38	0.4	TS 25	TORX T08
CCGT 09T302L DC 100	CERMET	CCGT09T302LC100	9.525	3.97	0.2	TS 4	TORX T15
CCGT 09T302L DC 100T	COATED CERMET	CCGT09T302LC10T	9.525	3.97	0.2	TS 4	TORX T15
CCGT 09T302L DK 100	CARBIDE	CCGT09T302LK100	9.525	3.97	0.2	TS 4	TORX T15
CCGT 09T302L DP 300	CARBIDE	CCGT09T302LP300	9.525	3.97	0.2	TS 4	TORX T15
CCGT 09T304L DC 100	CERMET	CCGT09T304LC100	9.525	3.97	0.4	TS 4	TORX T15
CCGT 09T304L DC 100T	COATED CERMET	CCGT09T304LC10T	9.525	3.97	0.4	TS 4	TORX T15
CCGT 09T304L DK 100	CARBIDE	CCGT09T304LK100	9.525	3.97	0.4	TS 4	TORX T15
CCGT 09T304L DP 300	CARBIDE	CCGT09T304LP300	9.525	3.97	0.4	TS 4	TORX T15

TPGX ○○○○○○L



REF.		CODE	d	s	r		
TPGX 090200L DC 100	CERMET	TPGX090200LC100	5.56	2.38	0	CS250T	TORX T08
TPGX 090200L DC 100T	COATED CERMET	TPGX090200LC10T	5.56	2.38	0	CS250T	TORX T08
TPGX 090200L DK 100	CARBIDE	TPGX090200LK100	5.56	2.38	0	CS250T	TORX T08
TPGX 090200L DP 300	CARBIDE	TPGX090200LP300	5.56	2.38	0	CS250T	TORX T08
TPGX 090202L DC 100	CERMET	TPGX090202LC100	5.56	2.38	0.2	CS250T	TORX T08
TPGX 090202L DC 100T	COATED CERMET	TPGX090202LC10T	5.56	2.38	0.2	CS250T	TORX T08
TPGX 090202L DK 100	CARBIDE	TPGX090202LK100	5.56	2.38	0.2	CS250T	TORX T08
TPGX 090202L DP 300	CARBIDE	TPGX090202LP300	5.56	2.38	0.2	CS250T	TORX T08
TPGX 090204L DC 100	CERMET	TPGX090204LC100	5.56	2.38	0.4	CS250T	TORX T08
TPGX 090204L DC 100T	COATED CERMET	TPGX090204LC10T	5.56	2.38	0.4	CS250T	TORX T08
TPGX 090204L DK 100	CARBIDE	TPGX090204LK100	5.56	2.38	0.4	CS250T	TORX T08
TPGX 090204L DP 300	CARBIDE	TPGX090204LP300	5.56	2.38	0.4	CS250T	TORX T08
TPGX 110300L DC 100	CERMET	TPGX110300LC100	6.35	3.18	0	CS300890T	TORX T08
TPGX 110300L DC 100T	COATED CERMET	TPGX110300LC10T	6.35	3.18	0	CS300890T	TORX T08
TPGX 110300L DK 100	CARBIDE	TPGX110300LK100	6.35	3.18	0	CS300890T	TORX T08
TPGX 110300L DP 300	CARBIDE	TPGX110300LP300	6.35	3.18	0	CS300890T	TORX T08
TPGX 110302L DC 100	CERMET	TPGX110302LC100	6.35	3.18	0.2	CS300890T	TORX T08
TPGX 110302L DC 100T	COATED CERMET	TPGX110302LC10T	6.35	3.18	0.2	CS300890T	TORX T08
TPGX 110302L DK 100	CARBIDE	TPGX110302LK100	6.35	3.18	0.2	CS300890T	TORX T08
TPGX 110302L DP 300	CARBIDE	TPGX110302LP300	6.35	3.18	0.2	CS300890T	TORX T08
TPGX 110304L DC 100	CERMET	TPGX110304LC100	6.35	3.18	0.4	CS300890T	TORX T08
TPGX 110304L DC 100T	COATED CERMET	TPGX110304LC10T	6.35	3.18	0.4	CS300890T	TORX T08
TPGX 110304L DK 100	CARBIDE	TPGX110304LK100	6.35	3.18	0.4	CS300890T	TORX T08
TPGX 110304L DP 300	CARBIDE	TPGX110304LP300	6.35	3.18	0.4	CS300890T	TORX T08

INSERT CLAMPING SCREWS



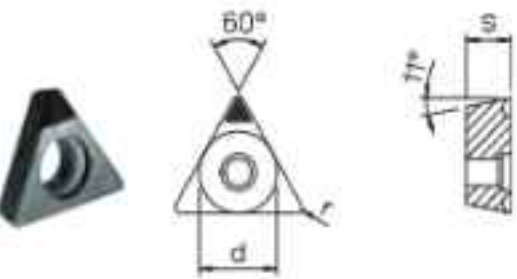
REF.		CODE	M	L	D	α	N·m
TS 21		494010002034	M 2x0.4	3.7	2.7	60°	0,5
TS 211		494010002040	M 2x0.4	4	2.7	60°	0,5
CS 250 T		494010002565	M 2.5x0.45	6	3.7	90°	1,0
CS 300890 T		494010003008	M 3x0.5	8	4.1	90°	1,0
TS 25		494010002555	M 2.5x0.45	5.7	3.45	60°	1,0
TS 4		494010004008	M 4x0.7	10	5.5	60°	3,0
TS 5		494010005009	M 5x0.8	11.5	7	60°	7,5



TORX WRENCH

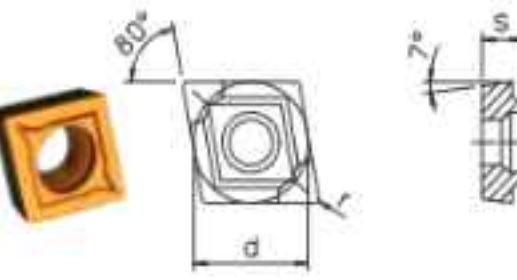
REF.		CODE
TORX T06		101500900600
TORX T06		101500900600
TORX T08		101500900800
TORX T08		101500900800
TORX T08		101500900800
TORX T15		101500901500
TORX T25		101500902500

TPGX ○○○○○○



REF.		CODE	d	s	r		
TPGX 090202 D20 MDC	SINTERED DIAMOND	TPGX090202MDC20	5.56	2.38	0.2	CS250T	TORX T08
TPGX 090204 D20 MDC		TPGX090204MDC20	5.56	2.38	0.4	CS250T	TORX T08
TPGX 110302 D20 MDC		TPGX110302MDC20	6.35	3.18	0.2	CS300890T	TORX T08
TPGX 110304 D20 MDC		TPGX110304MDC20	6.35	3.18	0.4	CS300890T	TORX T08
TPGX 090202 D20 CBN	CUBIC BORON NITRIDE	TPGX090202CBN20	5.56	2.38	0.2	CS250T	TORX T08
TPGX 090202 D25 CBN		TPGX090202CBN25	5.56	2.38	0.2	CS250T	TORX T08
TPGX 090204 D20 CBN		TPGX090204CBN20	5.56	2.38	0.4	CS250T	TORX T08
TPGX 090204 D25 CBN		TPGX090204CBN25	5.56	2.38	0.4	CS250T	TORX T08
TPGX 110302 D25 CBN		TPGX110302CBN25	6.35	3.18	0.2	CS300890T	TORX T08
TPGX 110304 D20 CBN		TPGX110304CBN20	6.35	3.18	0.4	CS300890T	TORX T08
TPGX 110304 D25 CBN		TPGX110304CBN25	6.35	3.18	0.4	CS300890T	TORX T08

CCMT ○○○○○○



REF.		CODE	d	s	r		
CCMT 060202 DP 100R	CVD COATED CARBIDE	CCMT060202P100R	6.35	2.38	0.2	TS 25	TORX T08
CCMT 060202 DP 300	CARBIDE	CCMT060202P300	6.35	2.38	0.2	TS 25	TORX T08
CCMT 060204 DP 100R	CVD COATED CARBIDE	CCMT060204P100R	6.35	2.38	0.4	TS 25	TORX T08
CCMT 060204 DP 300	CARBIDE	CCMT060204P300	6.35	2.38	0.4	TS 25	TORX T08
CCMT 09T304 DP 100R	CVD COATED CARBIDE	CCMT09T304P100R	9.525	3.97	0.4	TS 4	TORX T15
CCMT 09T304 DP 300	CARBIDE	CCMT09T304P300	9.525	3.97	0.4	TS 4	TORX T15
CCMT 09T308 DP 100R	CVD COATED CARBIDE	CCMT09T308P100R	9.525	3.97	0.8	TS 4	TORX T15
CCMT 09T308 DP 300	CARBIDE	CCMT09T308P300	9.525	3.97	0.8	TS 4	TORX T15
CCMT 120404 DP 100R	CVD COATED CARBIDE	CCMT120404P100R	12.7	4.76	0.4	TS 5	TORX T25
CCMT 120404 DP 300	CARBIDE	CCMT120404P300	12.7	4.76	0.4	TS 5	TORX T25
CCMT 120408 DP 100R	CVD COATED CARBIDE	CCMT120408P100R	12.7	4.76	0.8	TS 5	TORX T25
CCMT 120408 DP 300	CARBIDE	CCMT120408P300	12.7	4.76	0.8	TS 5	TORX T25

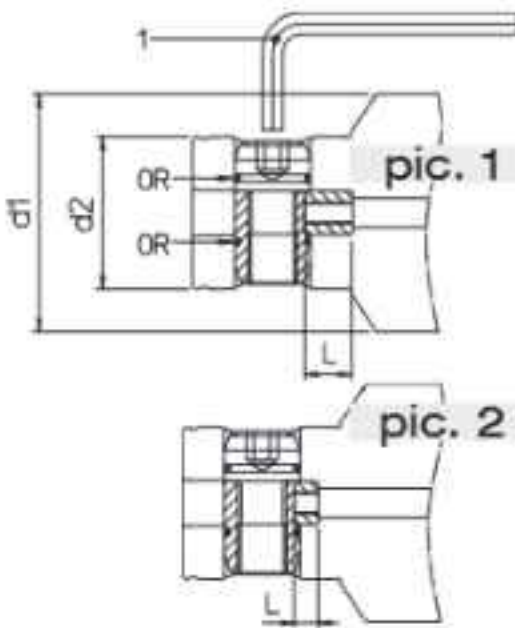
BORING GRADE

ISO	CARBIDE	CERMET	COATED CERMET	CVD COATED CARBIDE
P01				
P10		DO100	DO100T	DP100R
P20				
P30	DP300			
P40				
K01				
K10	DK100	DO100	DO100T	DP100R
K20	DP300			
K30				

DP300	Roughing and finishing. Low carbon steel - stainless steels
DK100	Roughing and finishing. Aluminium alloy cast iron
DP100R	Roughing. Steels, alloy steels and cast iron
DO100	Finishing. Alloy steels and cast iron
DO100T	Finishing. Alloy steels, stainless steels and cast iron
D20MDO	Finishing. Aluminium alloys, non-ferrous materials and non-metals
D20OBN	Finishing. High hardness steels (over 50 HRC) (it may replace the grinding)
D25OBN	Finishing. High hardness steels (over 50 HRC) and interrupted cutting (it may replace the grinding)

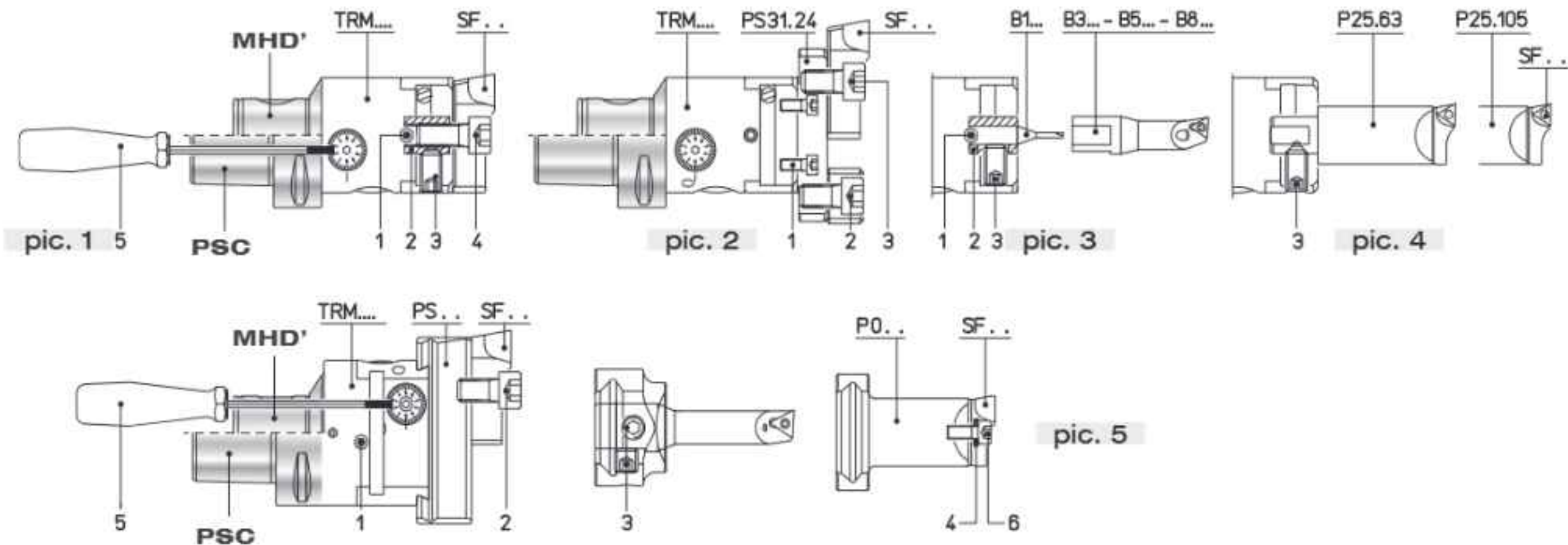
SPARE PARTS

SISTEM MHD'



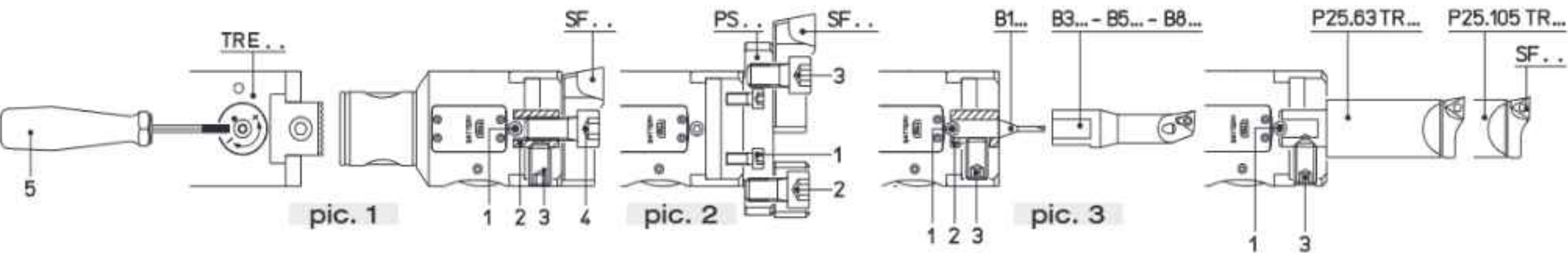
REF.	CODE	d1	d2	CODE 1	CODE OR	L	pic.
MHD' 16	381725001161	16	10	101500100250		2	2
MHD' 20	381725001201	20	13	101500100300		2.5	2
MHD' 25	381725001251	25	16	101500100300		3	2
MHD' 32	381725001321	32	20	101500100400	101254007510	3.55	2
MHD' 40	381725001401	40	25	101500100500	101254010010	4	2
MHD' 50 RD 50 / .. TRM - TRC - TR-E	381725001501	50	32	101500100600	101254013010	4.2	2
MHD' 50	381725001001	50	32	101500100600	101254013010	12.2	1
MHD' 63-80 RD 63 / .. TRM - TRC	381725001502	63-80	42	101500100800	101251002075	4.9	2
MHD' 63-80	381725001002	63-80	42	101500100800	101251002075	13.85	1

MHD' - PSC / TRM



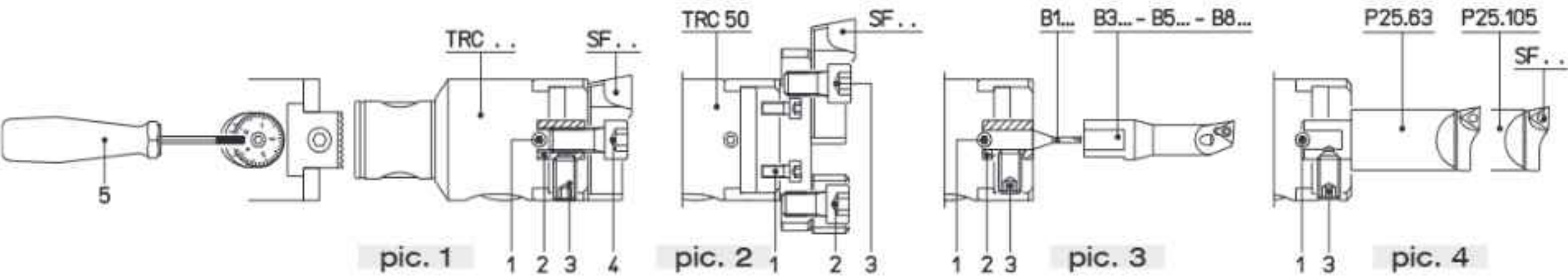
REF.	CODE 1	CODE 2	CODE 3	CODE 4	CODE 5	CODE 6	pic.
TRM 16 MHD'	200100190301			100051030006	101500800150		1
TRM 20 MHD'	200100190301			100051040008	101500800150		1
TRM 25 MHD'	100271040004			100051050010	101500800200		1
TRM 32 MHD'	100271040006			100051060012	101500800200		1
TRM 40 MHD'	100271050005			100051080014	101500800250		1
TRM 50 MHD' PSC50-TRM50 PSC63-TRM50	100271050008	201041015002	100231100016	100051100025	101500800250		1
TRM 50 MHD' PSC50-TRM50 PSC63-TRM50	200100150501	100051100020	100051100020		101500800250		2
TRM 50 MHD' PSC50-TRM50 PSC63-TRM50	100271050008	200560116082	100231100016		101500800250		3-4
TRM 63 MHD' PSC63-TRM63	100251060010	100051100018	100251080008	100051050012	101500800300	100800100530	5
TRM 80-MHD' PSC63-TRM80	100251060014	100051100018	100251080008	100051050012	101500800300	100800100530	5
TRM 125 MHD'	100251060020	100051100025		100051060018	101500800300	100800100640	5

TRE 50



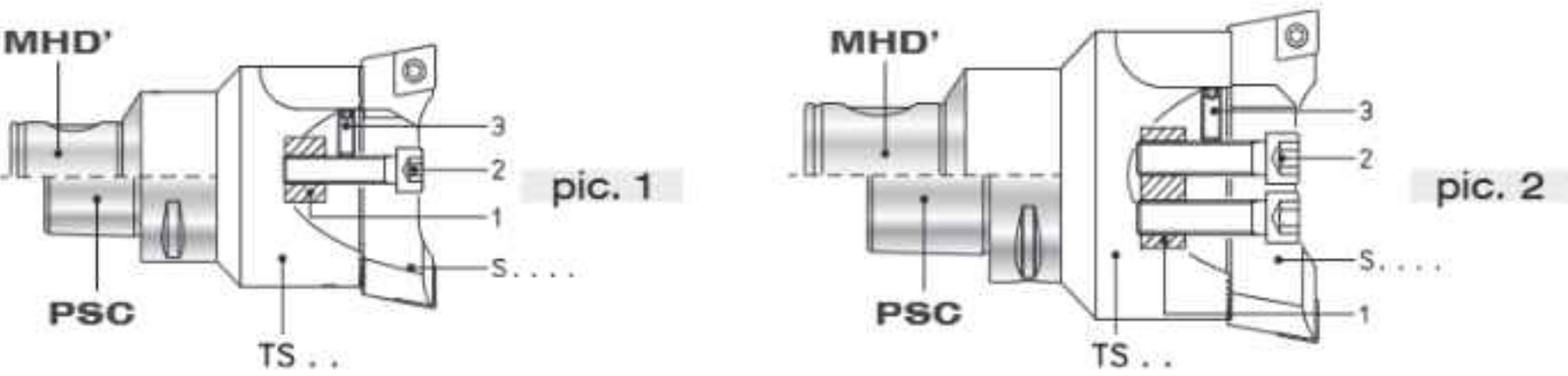
REF.	CODE 1	CODE 2	CODE 3	CODE 4	CODE 5	pic.
TRE 50	100238060010	201041015002	100231100016	100051100025	101500800250	1
TRE 50	200100150501	100051100020	100051100020			2
TRE 50	100238060010	200560116082	100231100016			3

TRC



REF.	CODE 1	CODE 2	CODE 3	CODE 4	CODE 5	pic.
TRC 16	200100190301			100051030006	101500800150	1
TRC 20	200100190301			100051040008	101500800150	1
TRC 25	100271040004			100051050010	101500800150	1
TRC 32	100271050005			100051060012	101500800250	1
TRC 40	100271060006			100051080014	101500800300	1
TRC 50	100271060008	201041015002	100231100016	100051100025	101500800300	1
TRC 50	200100150501	100051100020	100051100025			2
TRC 50	100271060008	200560116082	100231100010			3-4
TRC 63	100271060008			100051100020	101500800300	1
TRC 80	100271060012			100051100025	101500800300	1

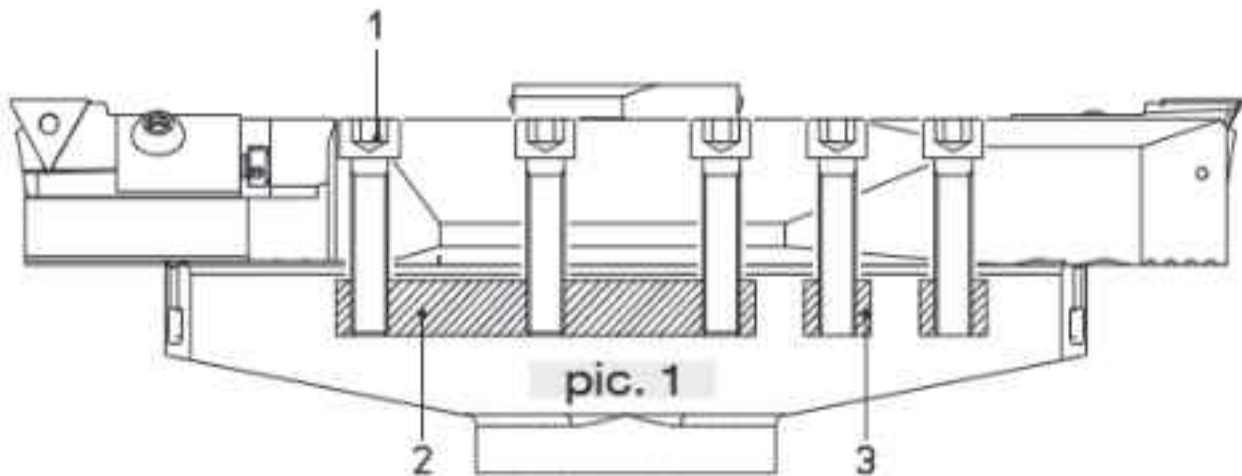
MHD' - PSC / TS



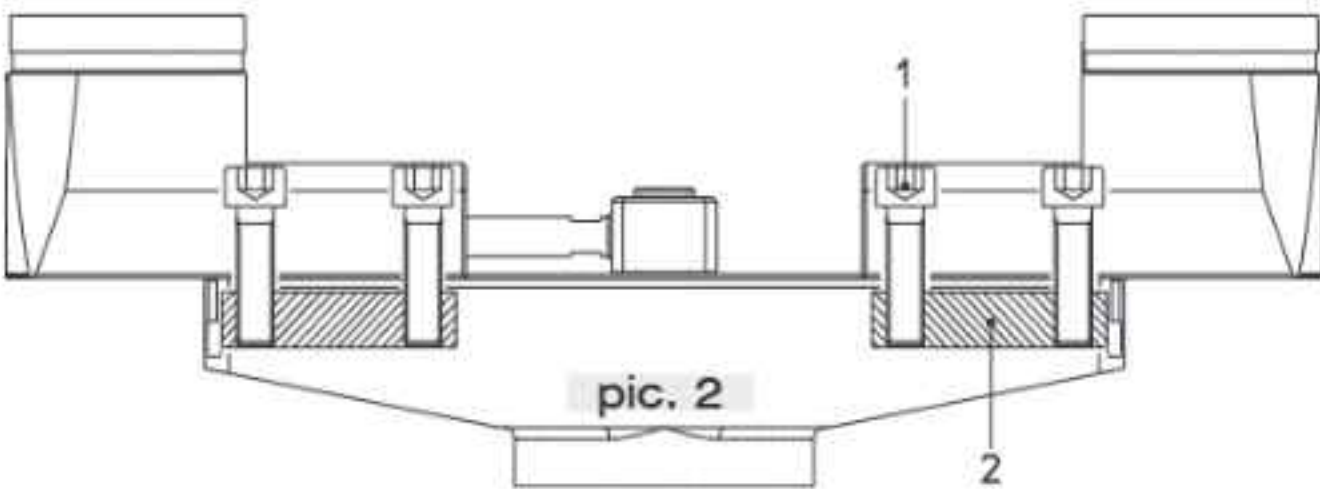
REF.	CODE 1	CODE 2	CODE 3	pic.
TS 16/16 MHD'	201430110008	100051030014	100231030004	1
TS 20/20 MHD'	201430110009	100051040015	100231030005	1
TS 25/25 MHD'	201430110032	100051040020	100231030008	1
TS 32/32 MHD'	201430110031	100051050025	100231040012	1
TS 40/40 MHD'	201430110029	100051060030	100231050014	1
TS 50/50 MHD' - PSC50-TS50 / PSC63-TS50	201430110013	100051080035	100231050012	1-2
TS 50/63 MHD'	201430110030	100051100040	100231060016	2
TS 63/63 MHD' - PSC63-TS63	201430110030	100051100040	100231060016	1-2
TS 80/80 MHD' - PSC63-TS80	201430110015	100051120045	100231080025	1-2
TS 80/90 MHD'	201430110015	100051120045	100231080025	1-2

BHT 250 - 500

ROUGHING BHT 250 SG - BHT 500 SG



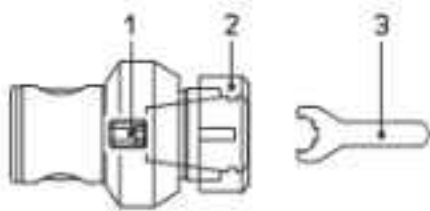
FINISHING BHT 250 FN - BHT 500 FN



REF.	CODE 1	CODE 2	CODE 3
ROUGHING pic. 1 BHT 250 SG - BHT 500 SG	100051100045	201430100065	201430100066
FINISHING pic.2 BHT 250 FN - BHT 500 FN	100051100035	201430100067	

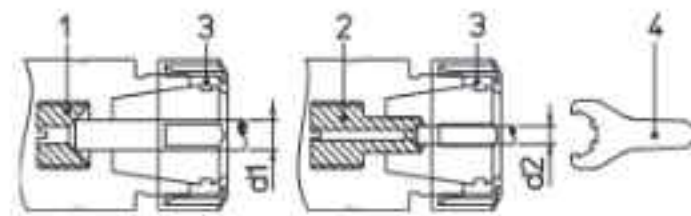
SPARE PARTS

PE - MHD' ER DIN 6499



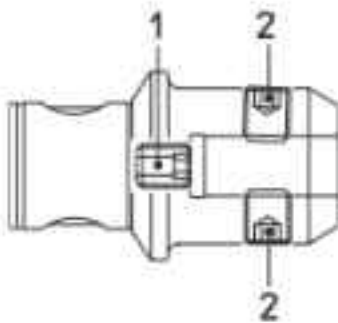
REF.	CODE 1	CODE 2	CODE 3
PE 20 / ER16M	200100190403	100451011600	101501001600
PE 32 / ER25M	200100190608	100451012500	101501002500
PE 40 / ER25	200100190808	100451032500	101501002501
PE 50 / ER25	200100190808	100451032500	101501002501
PE 50 / ER32	200100190808	100451033200	101501003201
PE 63 / ER32	200100191014	100451033200	101501003201

PE - PSC / MONOd ER DIN 6499



REF.	CODE 1	d1	CODE 2	d2	CODE 3	CODE 4
ER 16 M	201082010001	5 ~ 10	201082010002	1 ~ 4	100451011600	101501001600
ER 25	201082018001	8 ~ 16	201082018002	2 ~ 7	100451032500	101501002501
ER 32	201082022001	8 ~ 20	201082022002	3 ~ 7	100451033200	101501003201

AW DIN 1835 B-E



REF.	CODE 1	CODE 2
AW 50/6	200100190808	200100190610
AW 50/8	200100190808	200100190810
AW 50/10	200100190809	200100191012
AW 50/12	200100190809	200100191216
AW 50/14	200100190809	200100191216
AW 50/16	200100191215	200100191416
AW 50/20	200100191215	200100191616

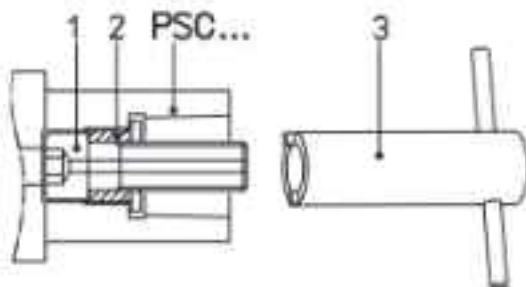
REF.	CODE 1	CODE 2
AW 50/25	200100191615	200100191820
AW 63/16	200100191215	200100191416
AW 63/20	200100191215	200100191616
AW 63/25	200100191615	200100191820
AW 63/32	200100191615	200100192020
AW 80/40	200100192019	200100192020

PF MHD' - PSC



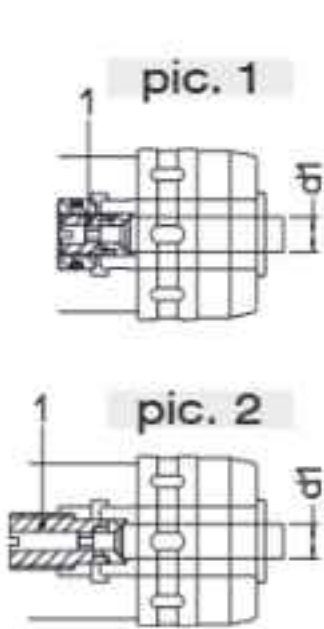
REF.	CODE 1	CODE 2	CODE 3	CODE 4	CODE 5
PF 40/16	201010085010	201101800801	101001040014	100101080025	100051030008
PF 40/22	201010105030	201101801002	101001060016	100101100025	100051040010
PF 50/16	201010085010	201101800801	101001040014	100101080025	100051030008
PF 50/22 MHD' / PSC50-PF22.25	201010105030	201101801002	101001060016	100101100025	100051040010
PF 50/27 MHD' / PSC50-PF27.25	201010125030	201101801202	101001070018	100101120030	100051050012
PF 50/32	201010165020	201101801402	101001080020	100101160035	100051060016
PF 63/22	201010105030	201101801002	101001060016	100101100025	100051040010
PF 63/27 MHD' / PSC63-PF27.25	201010125030	201101801202	101001070018	100101120030	100051050012
PF 63/32 MHD' / PSC63-PF32.25	201010165020	201101801402	101001080020	100101160035	100051060016
PF 80/32 MHD' / PSC80-PF32.30	201010165020	201101801402	101001080020	100101160035	100051060016
PF 80/40 MHD' / PSC80-PF40.45	201010210010	201101801603	101001100025	100101200045	100051060018
PF 80/50	201010260330	201101801802	101001120028	100101240050	100051060020
PF 80/60		201101802510	101001140036		100051120025

PSC



PSC	CODE 1	CODE 2	CODE 3
40	200101151448	201032215005	101501402101
50	200101151658	201032515005	101501402401
63	200101152071	201033015021	101501403001
80	200101152071	201033015021	101501403001

FORCE VCR SETTING SCREW FOR INTERNAL COOLANT SUPPLY



pic.	REF.	CODE 1	d1
1	VCR 20 MONOforce 20	382041020032	3 ~ 5
	HSK63-100 MHD'50	382041020062	6 ~ 12
	PSC 63-80	382041020142	14 ~ 20
1	VCR 32 MONOforce 32	382041032033	3 ~ 5
	HSK63-100 MHD'63	382041032063	6 ~ 12
	PSC 63-80	382041032143	14 ~ 20
		382041032253	25 ~ 32

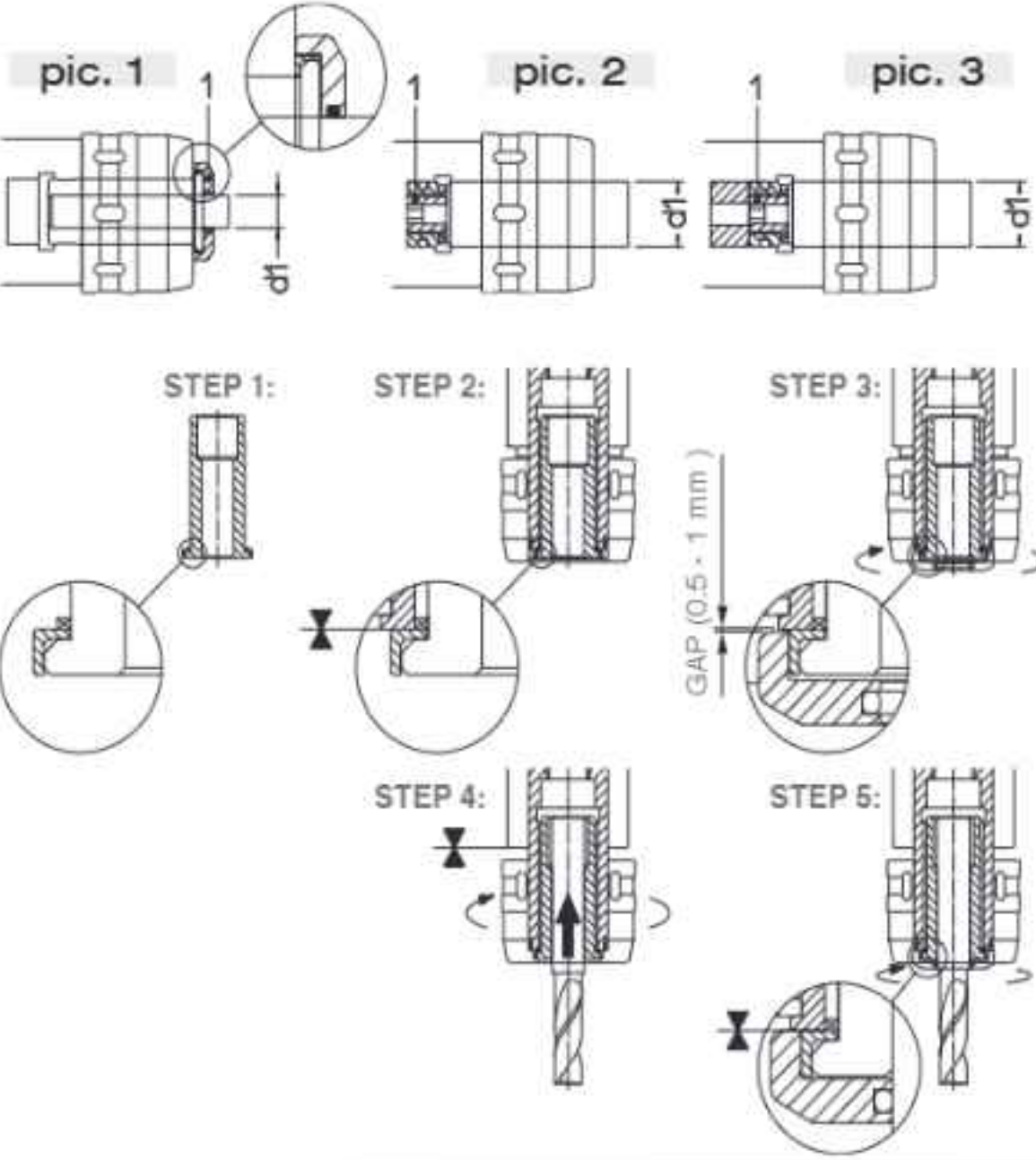
pic.	REF.	CODE 1	d1
2	VCR 20 MONOforce 20	382041020031	3 ~ 5
	DIN/BT-40-50	382041020061	6 ~ 12
		382041020141	14 ~ 20
2	VCR 32 MONOforce 32	382041032031	3 ~ 5
	DIN/BT-40	382041032061	6 ~ 12
		382041032141	14 ~ 20
2	VCR 32 MONOforce 32	382041032251	25 ~ 32
		382041032032	3 ~ 5
		382041032062	6 ~ 12
2	VCR 32 MONOforce 32	382041032142	14 ~ 20
	DIN/BT-50	382041032252	25 ~ 32

FORCE

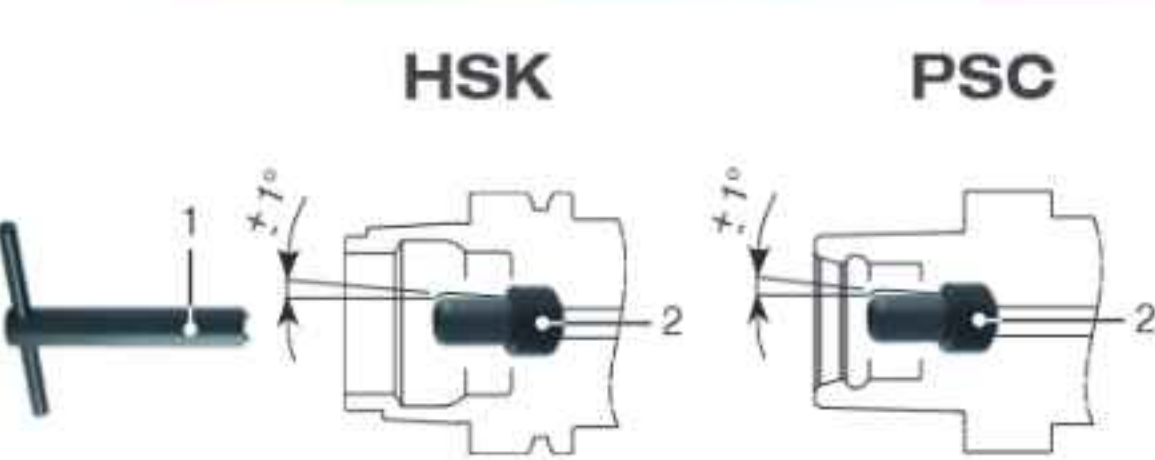


REF	CODE 1	CODE 2	CODE 3
FORCE 12	200100191014	101500400028	201271600400
FORCE 20	200100191615	101500400050	201271600400
FORCE 32	200100191615	101500400075	201271600400

FORCE GH - VT SEALING DEVICE FOR HIGH PRESSURE COOLANT SUPPLY

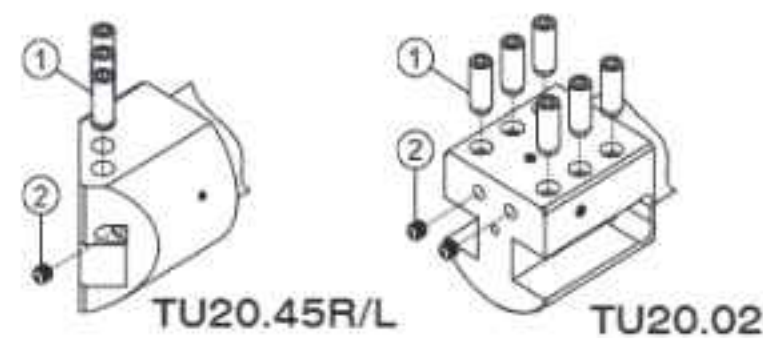


pic.	REF.	CODE 1	d1
1	GH 20 MONOforce 20 HSK63 MHD'50 / DIN/BT-40-50 PSC 63 - 80	382042020061	6
		382042020081	8
		382042020101	10
		382042020121	12
		382042020141	14
		382042020161	16
2	VT 20.20 MONOforce 20 DIN/BT-40-50 HSK63-100 PSC 63-80	382042020201	20
1	GH 32 MONOforce 32 DIN/BT-40-50 / HSK63-100 MHD'63 PSC 63-80	382042032061	6
		382042032081	8
		382042032101	10
		382042032121	12
		382042032141	14
		382042032161	16
		382042032181	18
		382042032201	20
		382042032251	25
2	VT 32.32 MONOforce 32 DIN/BT-40 HSK63-100 PSC 63-80	382042032321	32
3	VT 32.32.100 MONOforce 32 DIN/BT-50	382042032322	32



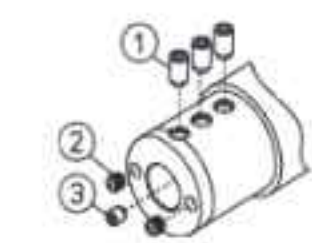
REF.	CODE 1	CODE 2
HSK-A50	101501101400	382019010001
HSK-A63	101501101600	382019012001
HSK-A80	101501101800	382019014001
HSK-A100	101501102200	382019016001
PSC 40	101501200700	382020006001
PSC 50	101501200800	382020007001
PSC 63	101501200900	382020008001
PSC 80	101501201100	382020010001

PSC - TU ISO 26623-1



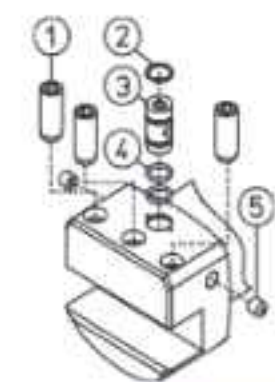
REF.	CODE 1	CODE 2
TCD' PSC 50 TU20.45R/L	100231120025	100585010800
TCD' PSC 63 TU25.45R/L	100231120025	100585010800
TCD' PSC 80 TU32.45R/L	100231120025	100585010800
TCD' PSC 50 TU20.02	100231120025	100585010800
TCD' PSC 63 TU25.02	100231120025	100585010800
TCD' PSC 80 TU32.02	100231120025	100585010800

PSC - D... ISO 26623-1



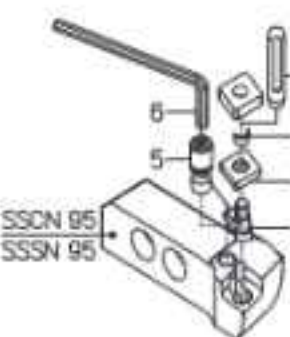
REF.	CODE 1	CODE 2	CODE 3
TCD' PSC 50 D.25x80	100231100016	100585010800	
TCD' PSC 63 D.25x80	100231100016	100585010800	
TCD' PSC 63 D.40x125	100231120020	100585010800	100231080008
TCD' PSC 80 D.25x85	100231100016	100585010800	
TCD' PSC 80 D.40x125	100231120020	100585010800	100231080008

PSC - TU ISO 26623-1



REF.	CODE 1	CODE 2	CODE 3	CODE 4	CODE 5
TCD' PSC 63 TU20.90	100231120025	100900301400	201462501400	101251002043	100580610180
TCD' PSC 63 TU25.90	100231120025	100900301400	201462501400	101251002043	100580610180
TCD' PSC 80 TU32.90	100231120025	100900301400	201462501400	101251002043	100580610180

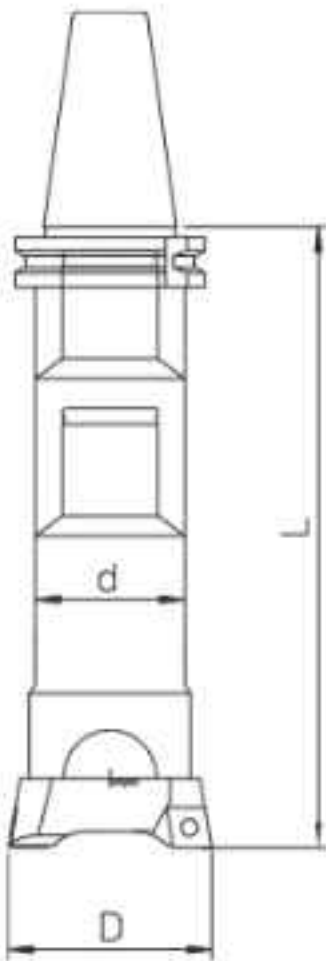
SS.. 95



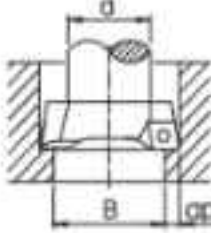
REF.	CODE 1	CODE 2	CODE 3	CODE 4	CODE 5	CODE 6
SSCN 95 491111190600	492031190600	100655095112	101501301408	494311190600	101500100400	
SSSN 95 491111190600	492035190600	100655095112	101501301408	494311190600	101500100400	

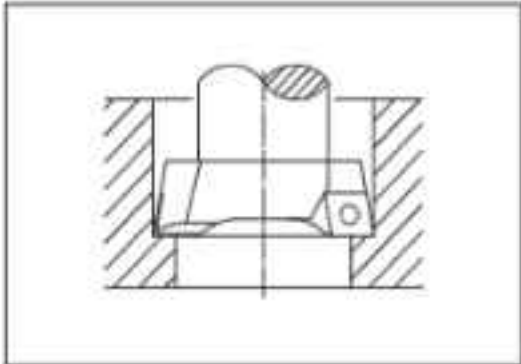
TECHNICAL DATA CUTTING DATA

RECOMMENDED CUTTING CONDITIONS FOR ROUGHING OPERATIONS WITH DOUBLE-BIT HEADS TS

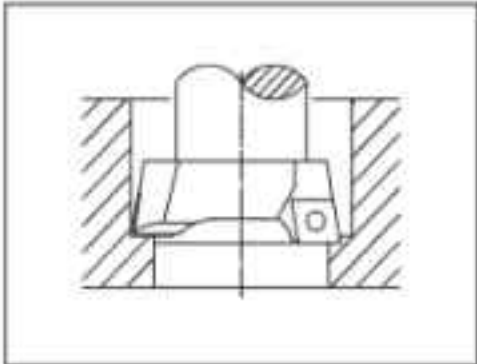


material	boring bar dimensions	working conditions	cutting speed Vc = m/min. diameter			feed fn = mm/rev (twin cutters) insert radius		
			D < 38	D = 38~120	D > 120	R = 0.2	R = 0.4	R = 0.8
carbon steel HB ≤ 200	L / d = 2.5	good	120 - 180	140 - 200	160 - 250		0.2 - 0.4	0.3 - 0.5
	L / d = 4	normal	100 - 160	120 - 180	140 - 200		0.2 - 0.4	0.3 - 0.5
	L / d = 6.3	difficult	70 - 100	70 - 100	70 - 100	0.15 - 0.3	0.2 - 0.4	
carbon steel HB > 200	L / d = 2.5	good	100 - 160	120 - 180	140 - 200		0.2 - 0.4	0.3 - 0.5
	L / d = 4	normal	80 - 140	100 - 160	120 - 180		0.2 - 0.4	0.3 - 0.5
	L / d = 6.3	difficult	60 - 90	70 - 100	70 - 100	0.15 - 0.3	0.2 - 0.4	
stainless steel AISI 304 - 316	L / d = 2.5	good	80 - 110	90 - 120	100 - 140		0.2 - 0.4	0.3 - 0.5
	L / d = 4	normal	70 - 100	80 - 110	90 - 120		0.2 - 0.4	0.3 - 0.5
	L / d = 6.3	difficult	60 - 90	60 - 90	60 - 90	0.15 - 0.3	0.2 - 0.4	
cast iron	L / d = 2.5	good	90 - 120	100 - 140	120 - 160		0.2 - 0.4	0.3 - 0.5
	L / d = 4	normal	70 - 100	90 - 120	100 - 140		0.2 - 0.4	0.3 - 0.5
	L / d = 6.3	difficult	60 - 90	60 - 90	60 - 90	0.15 - 0.3	0.2 - 0.4	
aluminium	L / d = 2.5	good	160 - 250	200 - 300	250 - 350		0.3 - 0.5	0.4 - 0.6
	L / d = 4	normal	140 - 200	160 - 250	200 - 300		0.3 - 0.5	0.4 - 0.6
	L / d = 6.3	difficult	100 - 150	100 - 150	100 - 150	0.2 - 0.4	0.3 - 0.5	

cutting depth ap = mm	working range Ø = mm	max. cutting depth	
		steel	cast iron, aluminium
	18 - 28	1.5 - 2	2 - 2.5
	28 - 50	2 - 3	2.5 - 3.5
	50 - 68	3 - 4	3.5 - 5
	68 - 200	4 - 5	5 - 7
	200 - 500	5 - 6	6 - 8



Twin cutters at the same cutting diameter

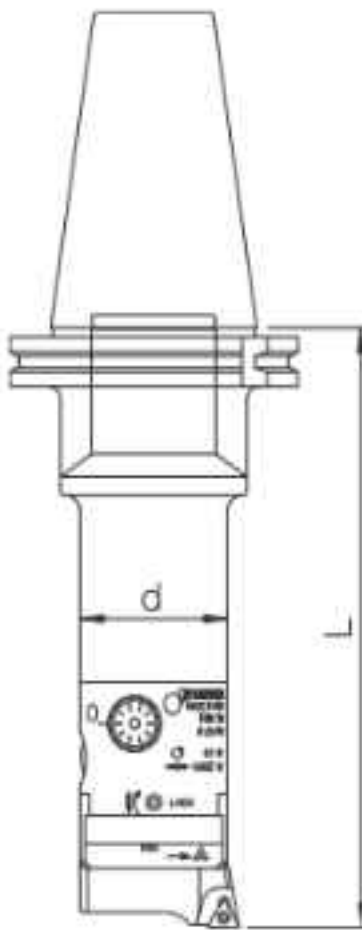


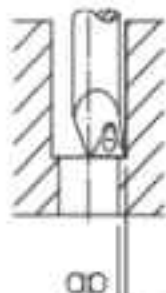
Twin cutters at different cutting diameters

It's advisable to start with B hole ≥ the boring bar diameter d.

ATTENTION: For boring operations at different diameters, reduce to a half the feed indicated on the above table.

RECOMMENDED CUTTING CONDITIONS FOR BORING OPERATIONS WITH TESTAROSSA TRM / TRC / TR-E



material	boring bar dimensions	working conditions	cutting speed Vc= m/min.	feed fn = mm/rev insert radius			quality insert	cutting depth
				R = 0.0	R = 0.2	R = 0.4		
carbon steel HB ≤ 200	L / d = 2.5	good	200 - 300		0.05 - 0.08	0.07 - 0.1	DC100 DP300	 0.1 - 0.25 mm
	L / d = 4	normal	160 - 250		0.05 - 0.08	0.07 - 0.1		
	L / d = 6.3	difficult	70 - 100	0.05 - 0.08	0.05 - 0.08			
carbon steel HB > 200	L / d = 2.5	good	160 - 250		0.05 - 0.08	0.07 - 0.1	DC100	
	L / d = 4	normal	150 - 200		0.05 - 0.08	0.07 - 0.1		
	L / d = 6.3	difficult	70 - 100	0.05 - 0.08	0.05 - 0.08			
stainless steel AISI 304 - 316	L / d = 2.5	good	120 - 160		0.05 - 0.08	0.07 - 0.1	DP300	
	L / d = 4	normal	100 - 140		0.05 - 0.08	0.07 - 0.1		
	L / d = 6.3	difficult	70 - 100	0.05 - 0.08	0.05 - 0.08			
cast iron	L / d = 2.5	good	120 - 160		0.05 - 0.08	0.07 - 0.1	DK100 DP100	
	L / d = 4	normal	100 - 140		0.05 - 0.08	0.07 - 0.1		
	L / d = 6.3	difficult	70 - 100	0.05 - 0.08	0.05 - 0.08			
aluminium	L / d = 2.5	good	300 - 400		0.05 - 0.08	0.07 - 0.1	DK100	
	L / d = 4	normal	250 - 350		0.05 - 0.08	0.07 - 0.1		
	L / d = 6.3	difficult	100 - 150	0.05 - 0.08	0.05 - 0.08			
steel HB > 200	L / d = 2.5	good	80 - 100		0.04 - 0.06	0.05 - 0.07	D20CBN	
	L / d = 4	normal	80 - 100		0.04 - 0.06	0.05 - 0.07		

CALCULATION FORMULAS FOR BORING

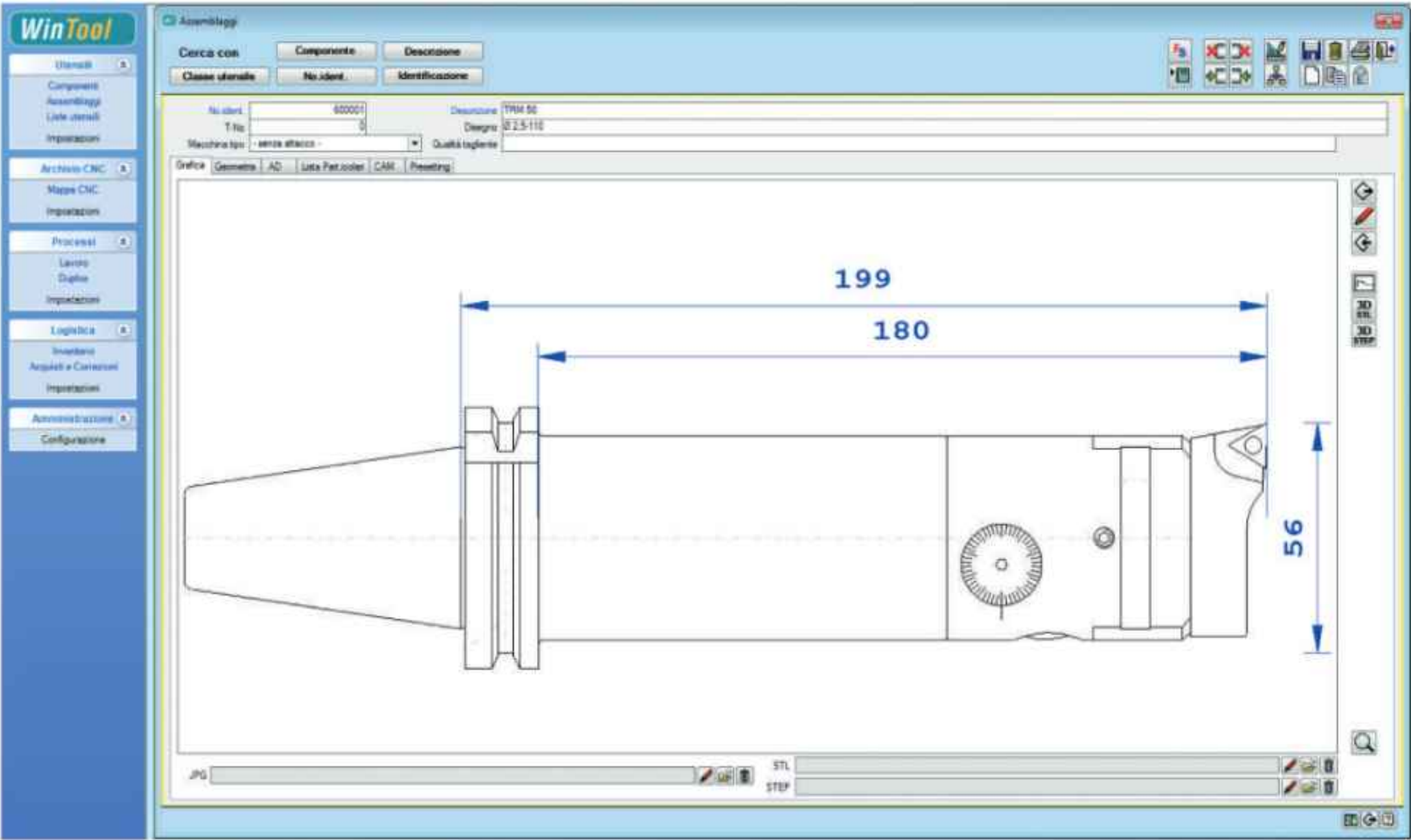
Vc cutting speed (m/min.)
D diameter of workpiece (mm)
n number of revolutions / min' (rev./min)
Vf feed rate (mm/min.)
fn feed / rev. (mm/rev)
π 3.14

$$Vc = \frac{\pi \cdot D \cdot n}{1000}$$

$$n = \frac{Vc \cdot 1000}{\pi \cdot D}$$

$$Vf = n \cdot fn$$

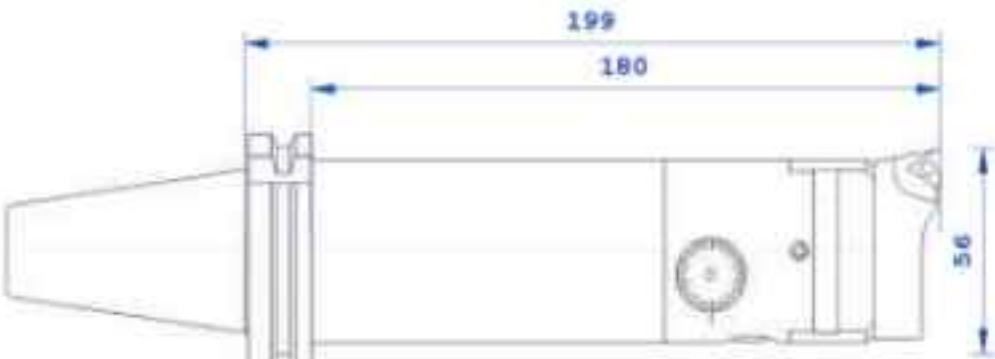
It allows to be graphically constructed in a short period of time, showing the complete composition of the Modulhard'Andrea tools, including dimensions, weight and the list of components.



Scheda Utensile

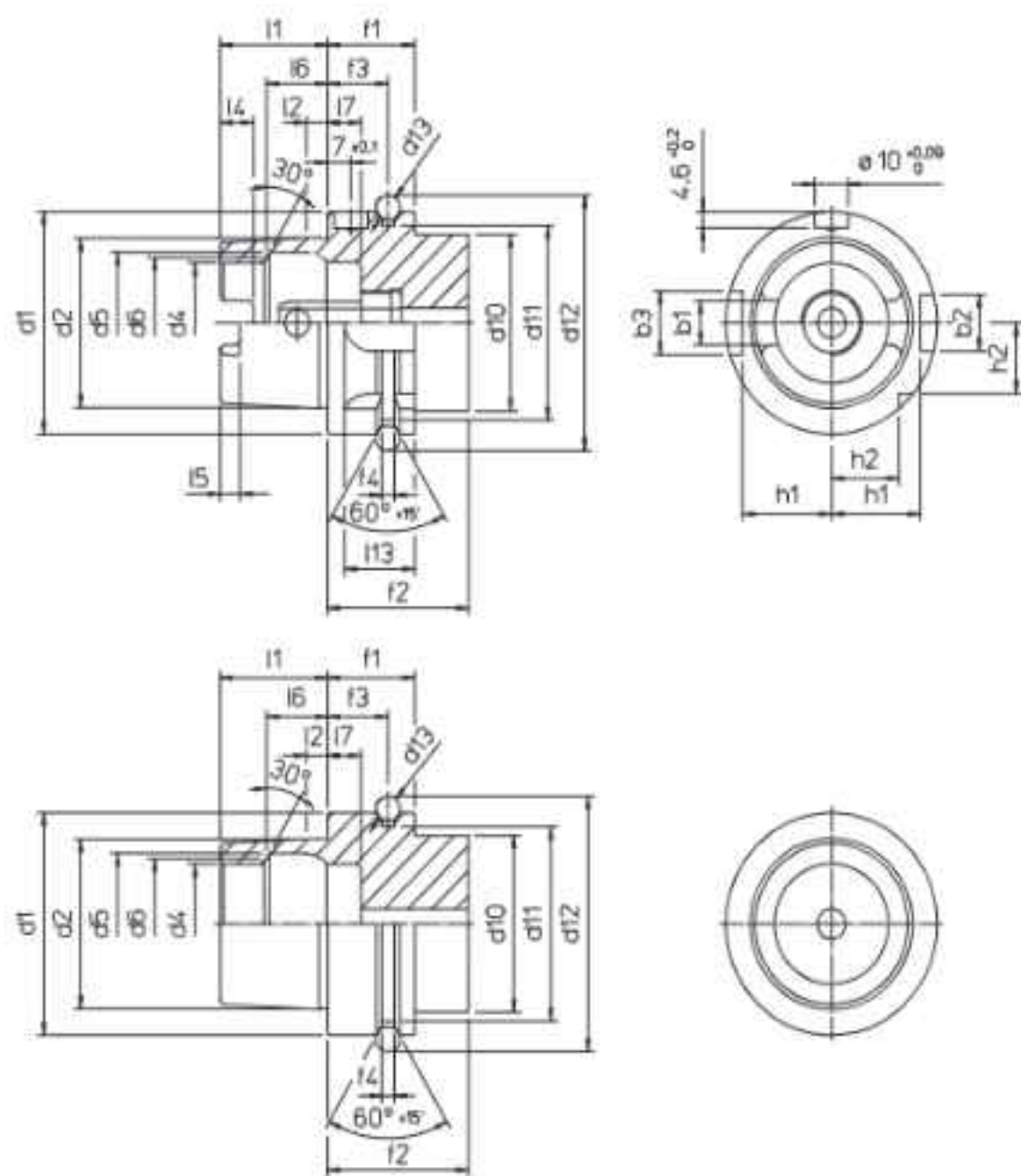
TRM 50 600001 Diametro parte pezzo 56,00

Ø 2,5-110



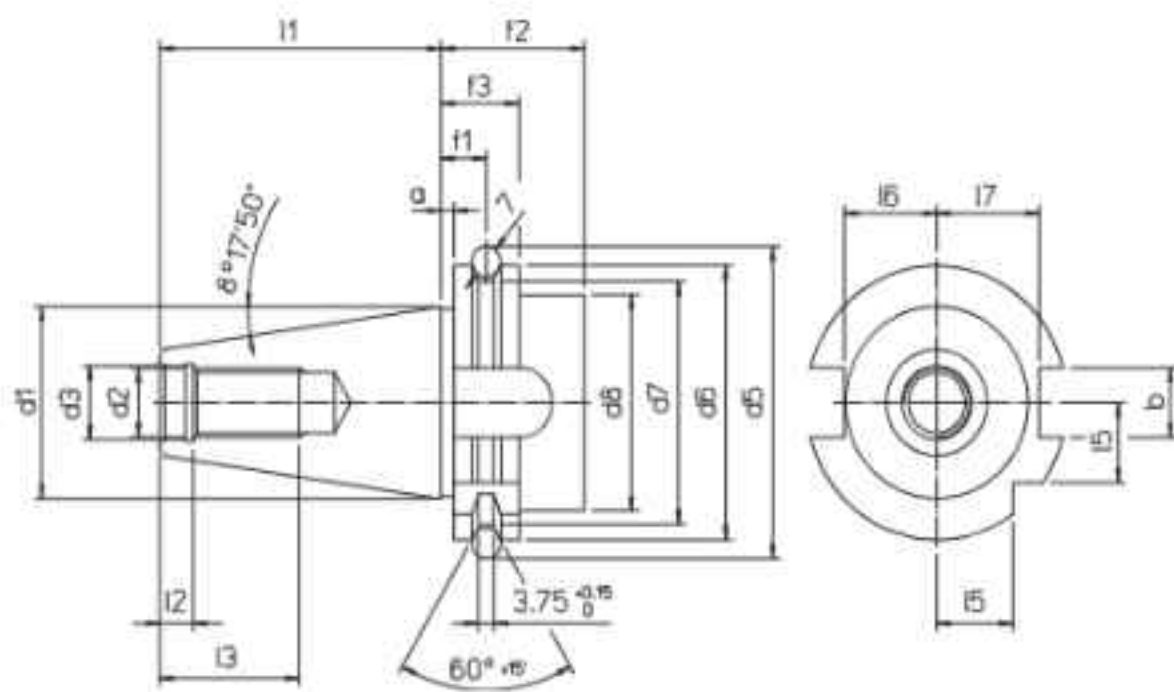
Descrizione / Tipo	Design / Item No. / Product Code / Storage Location	Peso
1 DWA9871-AD-B40 FC MHD50-120	MHD 50 41.8.30.01.040.28F	1,70
1 TRM 50	Ø 2,5-110 40.30.000.0050.0	1,00
1 SFTP 50	TPGX 1103 L 47.050.05.50.001	0,08
1 TPGX 110300L-10	DC 100T TPGX 110300L C10T	0,00
		2,78

HSK-A



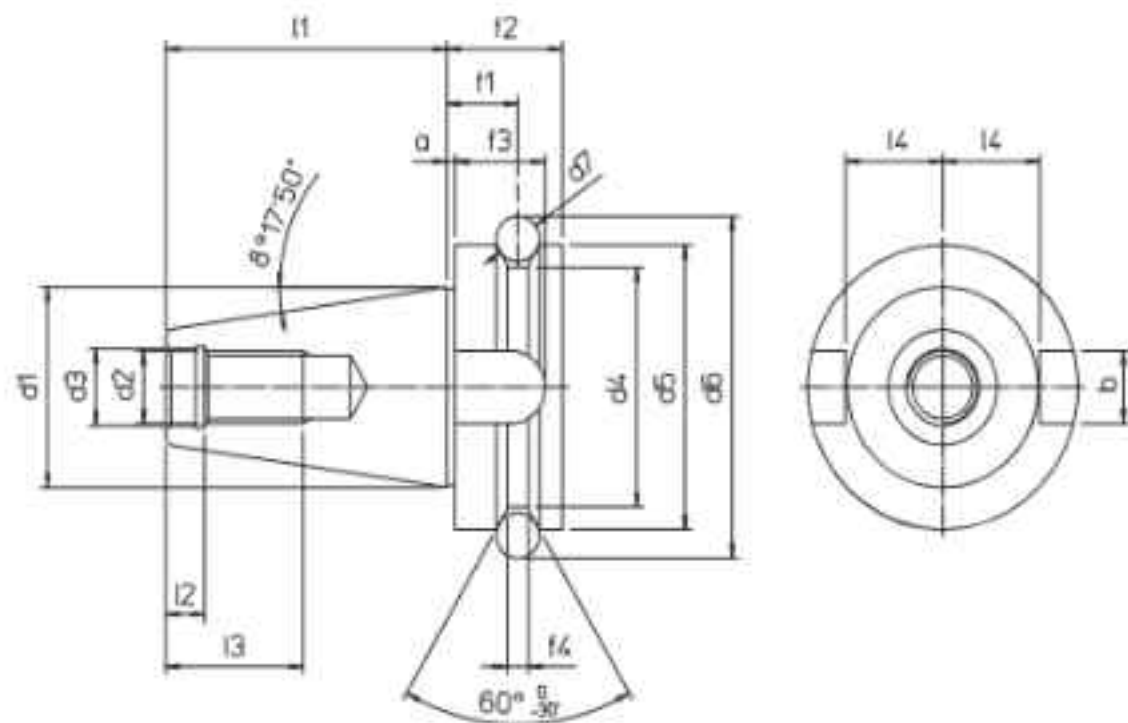
HSK	32	40	50	63	80	100
b1 ^{+0.04} / _{-0.04}	7.05	8.05	10.54	12.54	16.04	20.02
b2 H10	7	9	12	16	18	20
b3 H10	9	11	14	18	20	22
d1 h10	32	40	50	63	80	100
d2	24.007	30.007	38.009	48.010	60.012	75.013
d4 H10	17	21	26	34	42	53
d5 H11	20.5	25.5	32	40	50	63
d6	19	23	29	37	46	58
d10 max.	26	34	42	53	68	88
d11 ⁰ / _{-0.1}	26.5	34.8	43	55	70	92
d12 ⁰ / _{-0.1}	37	45	59.3	72.3	88.8	109.75
d13	4		7			
f1 ⁰ / _{-0.1}	20		26			29
f2 min.	35		42			45
f3 ± 0.1	16		18			20
f4 ^{+0.15} / ₀	2		3.75			
h1 ⁰ / _{-0.2}	13	17	21	26.5	34	44
h2 ⁰ / _{-0.3}	9.5	12	15.5	20	25	31.5
l1 ⁰ / _{-0.2}	16	20	25	32	40	50
l2	3.2	4	5	6.3	8	10
l4 ^{+0.2} / ₀	5	6	7.5	10	12	15
l5 ^{+0.2} / ₀	3	3.5	4.5	6	8	10
l6 JS10	8.92	11.42	14.13	18.13	22.85	28.56
l7 ⁰ / _{-0.1}	8		10	10	12.5	12.5
l13	12		19	21	22	24

DIN 69871 A (ISO 7388-1)



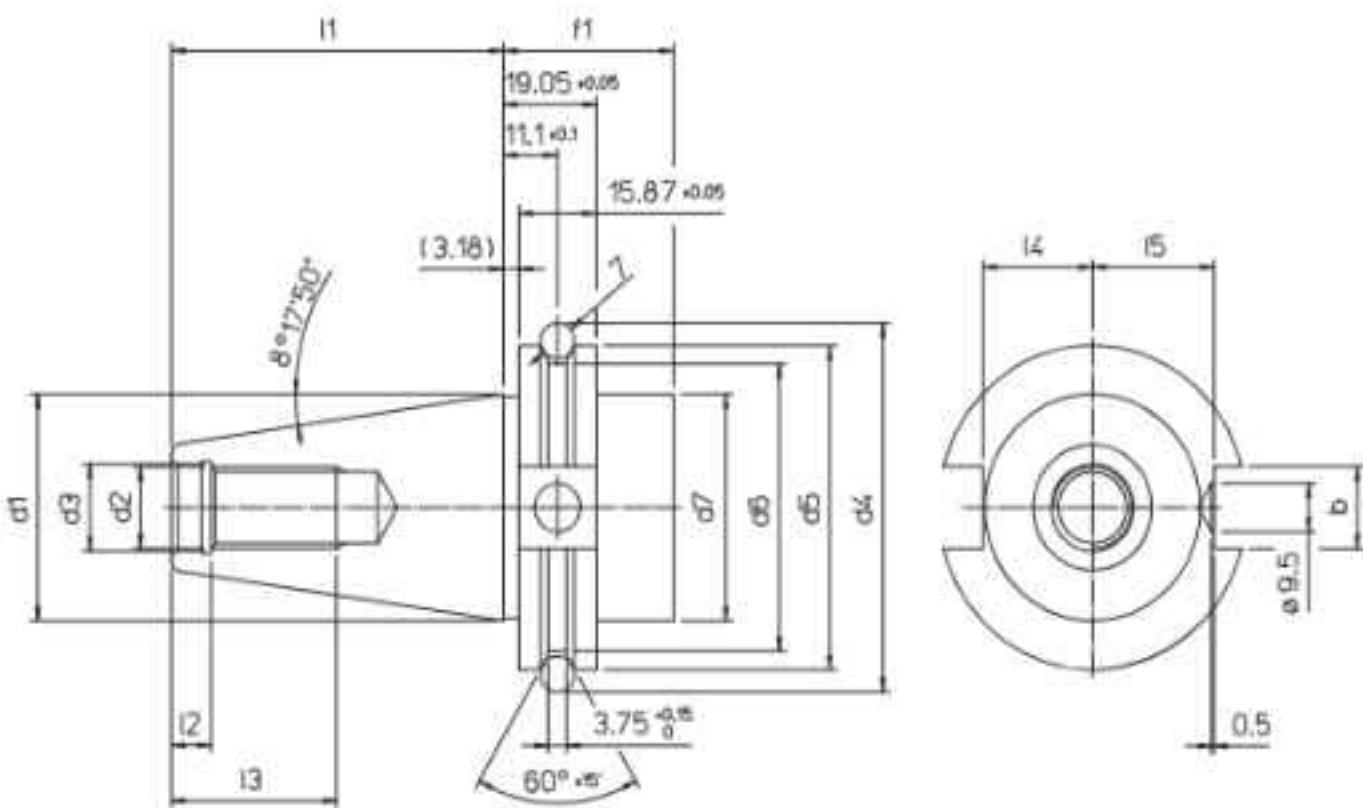
ISO	30	40	45	50	60
a ± 0.1	3.2				
b +0.5 / 0	16.1		19.3	25.7	
d1	31.75	44.45	57.15	69.85	107.95
d2 6H	M12	M16	M20	M24	M30
d3 H7	13	17	21	25	32
d5 ± 0.05	59.3	72.3	91.35	107.25	164.75
d6 0 / -0.1	50	63.55	82.55	97.50	155
d7 0 / -0.5	44.3	56.25	75.25	91.25	147.70
d8 max.	45	50	63	80	130
f1 ± 0.1	11.1				
f2 min.	35				38
f3 0 / -0.1	19.1				
l1 0 / -0.3	47.8	68.4	82.7	101.75	161.90
l2 +0.5 / 0	5.5	8.2	10	11.5	14
l3 min.	24	32	40	47	59
l5 0 / -0.3	15	18.5	24	30	49
l6 0 / -0.3	16.4	22.8	29.1	35.5	54.5
l7 0 / -0.3	19	25	31.3	37.7	59.3

MAS 403 BT A



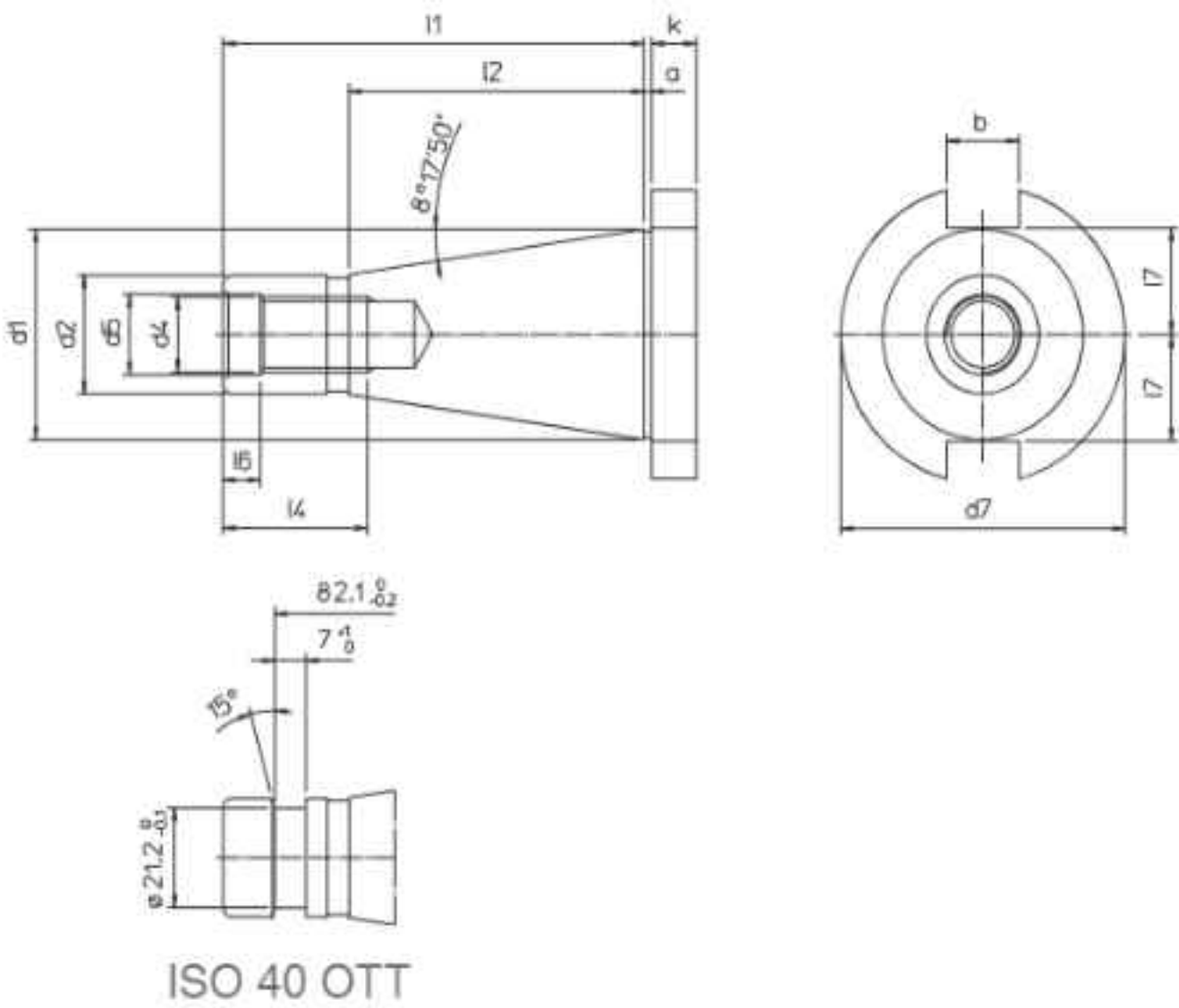
ISO	30	35	40	45	50	60
a ± 0.4	2			3		
b +0.2 / 0	16.1			19.3	25.7	25.7
d1	31.75	38.10	44.45	57.15	69.85	107.95
d2 6H	M 12		M 16	M 20	M 24	M30
d3 H8	12.5		17	21	25	31
d4 0 / -0.5	38	43	53	73	85	135
d5 h8	46	53	63	85	100	155
d6 ± 0.05	56.03	65.68	75.56	100.09	118.89	180.22
d7	8	10		12	15	20
f1 ± 0.1	13.6	14.6	16.6	21.2	23.2	28.2
f2	22	24	27	33	38	48
f3 min.	17	20	21	26	31	34
f4	4	5		6	7	11
l1 ± 0.2	48.4	56.4	65.4	82.8	101.8	161.8
l2 +0.5 / 0	7		9	11	13	16
l3 min.	24		30	36	45	56
l4 0 / -0.3	16.3	19.6	22.6	29.1	35.4	60.1

ANSI/CAT



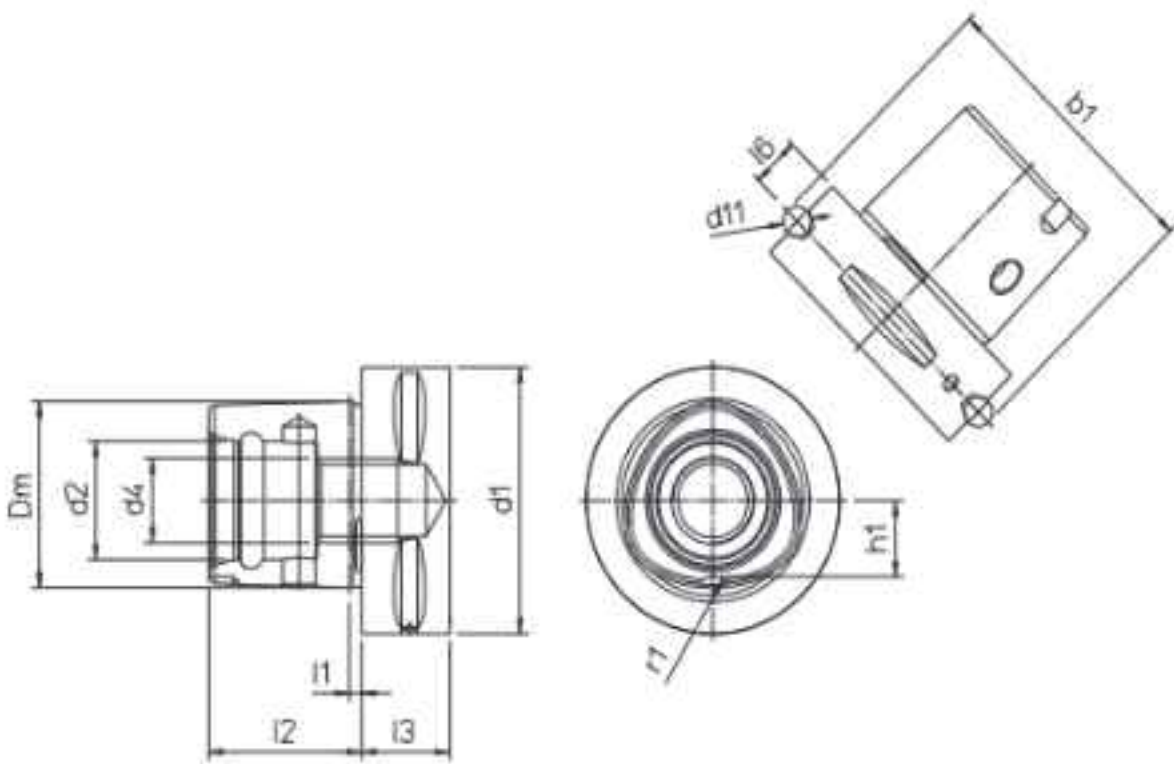
ISO	40	45	50
b +0.2 / 0	16.1	19.3	25.7
d1 6H	44.45	57.15	69.85
d2	M 16	M 20	M 24
d3 H7	17	21	25
d4 ±0.05	72.3	91.35	108.25
d5 0 / -0.1	63.55	82.55	98.5
d6 0 / -0.5	56.25	75.25	91.25
d7 ±0.15	44.45	57.15	69.95
f1 min	35		38
l1 0 / -0.3	68.4	82.7	101.75
l2 +0.5 / 0	8.2	10	11.5
l3 min	32	40	47
l4 0 / -0.3	22.8	29.10	35.50
l5 0 / -0.3	25	31.3	37.7

DIN 2080



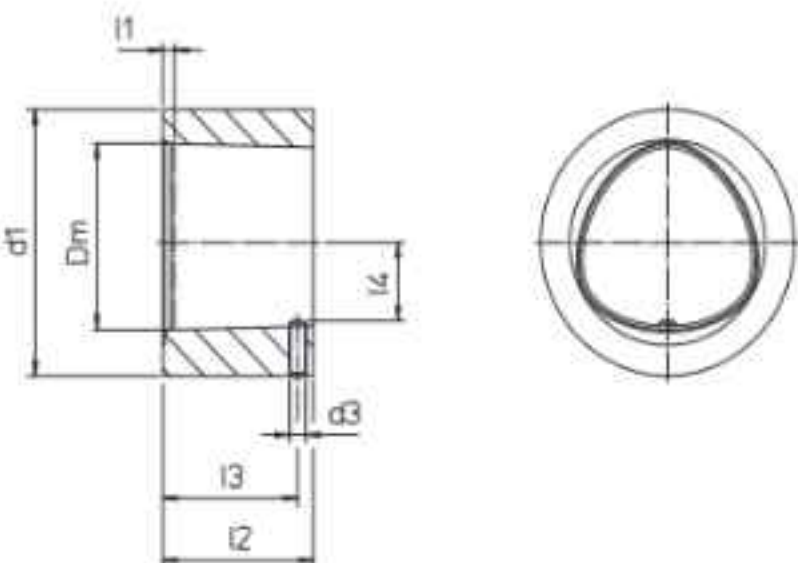
ISO	30	40	45	50
a ±0.2	1.6		3.2	
b H12	16.1		19.3	25.7
d1	31.75	44.45	57.15	69.85
d2 a10	17.4	25.3	32.4	39.6
d4 ±0.05	M 12	M 16	M 20	M 24
d5	13	17	21	26
d7 0 / -0.4	50	63	80	97.5
k ±0.15	8	10	12	12
l1	68.4	93.4	106.8	126.8
l2	48.4	65.4	82.8	101.8
l4	24	32	40	47
l6 +0.5 / 0	5.5	8.2	10	11.5
l7 max.	16.2	22.5	29	35.3

ISO 26623-1



PSC	40	50	63	80
b1 ±0.1	46	59.3	70.7	86
Dm	28	35	44	55
d1 ±0.1	40	50	63	80
d2 ^{+0.1} _{-0.05}	18	21	28	32
d4	M14x1.5	M16x1.5	M20x2	
d11	5	7		
l1	2.5	3		
l2 ±0.1	24	30	38	48
l3 min	20		22	30
l6 ±0.15	8	10	12	
h1 ±0.1	11	14	18	22.2
r1 ±0.3	4	5	6	7

ISO 26623-2



PSC	40	50	63	80
Dm	28	35	44	55
d1 min	40	50	63	80
d3	2.5	3	4	5
l1	2.3	2.8	2.8	2.8
l2 ±0.1	23.4	29.4	37.4	47.4
l3 ±0.2	21	26	33.5	43
l4	11.5±0.2	14.5±0.2	18.5±0.2	22.8±0.2

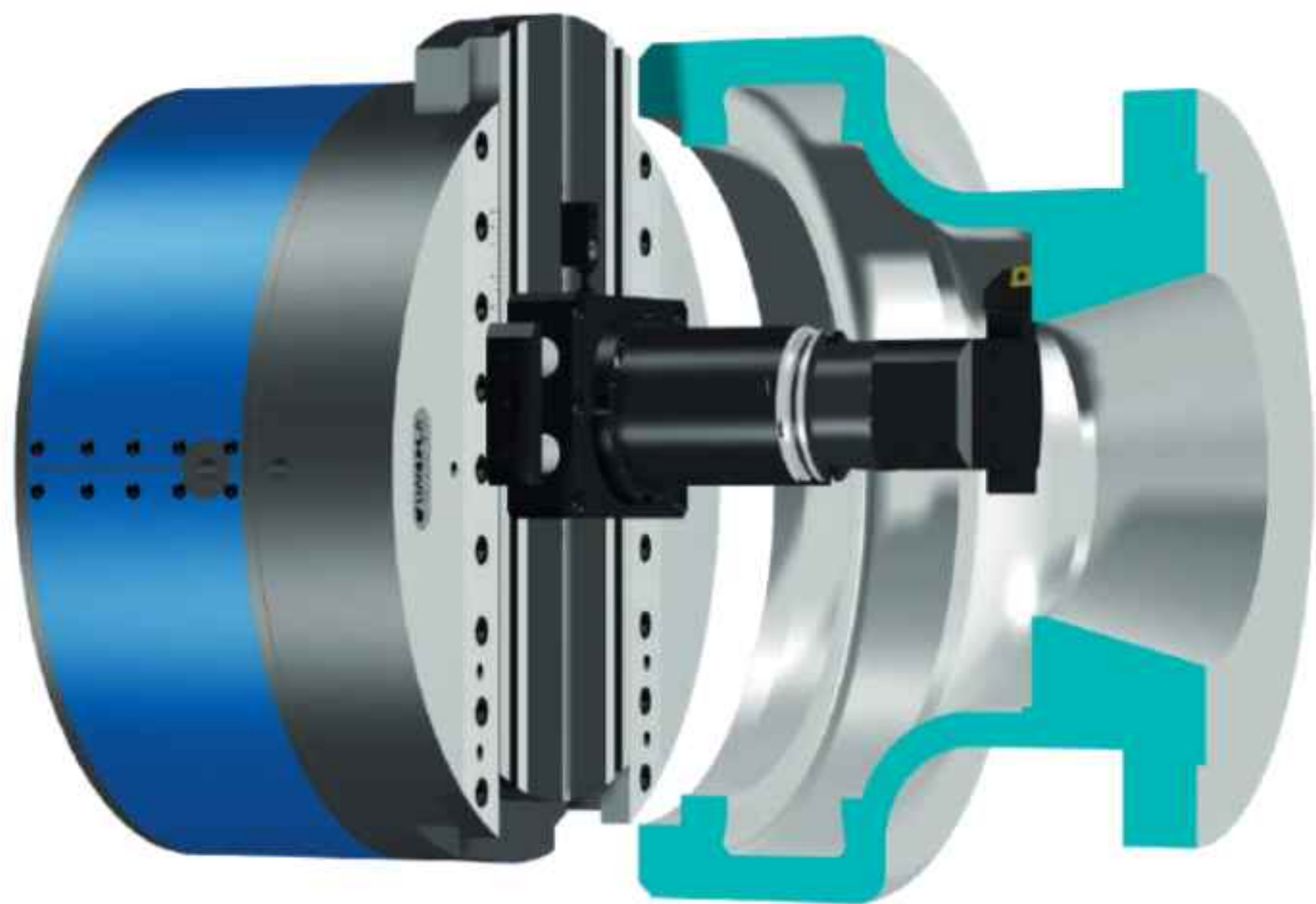
U-TRONIC

U-TRONIC -Medium and large Numerical Control heads, applicable on boring machines, machining centers and special machines.

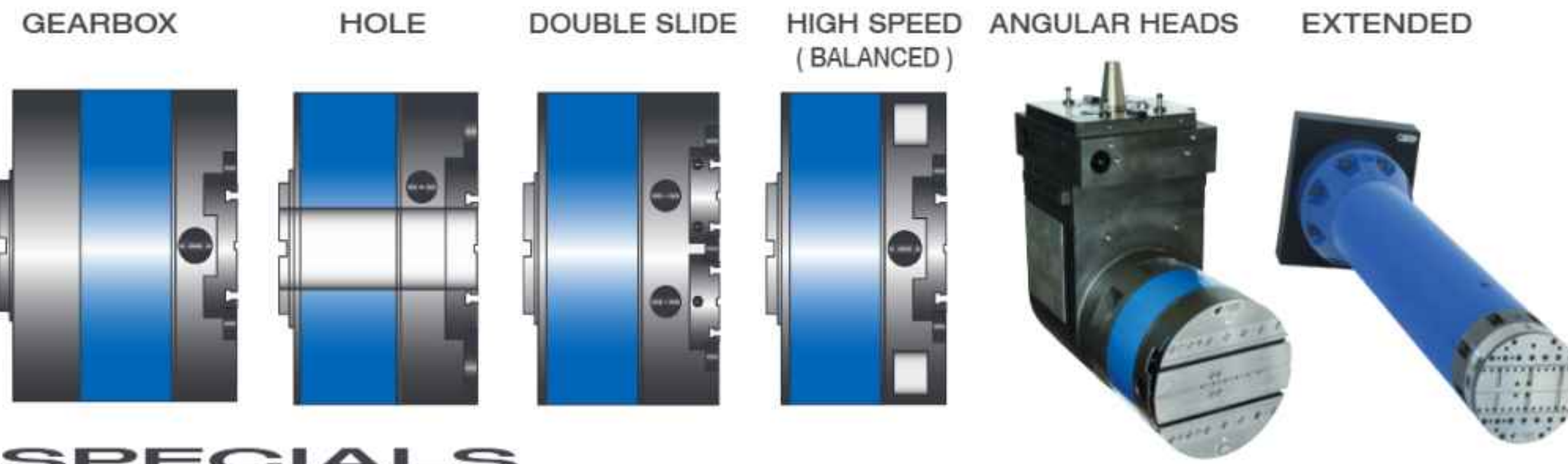
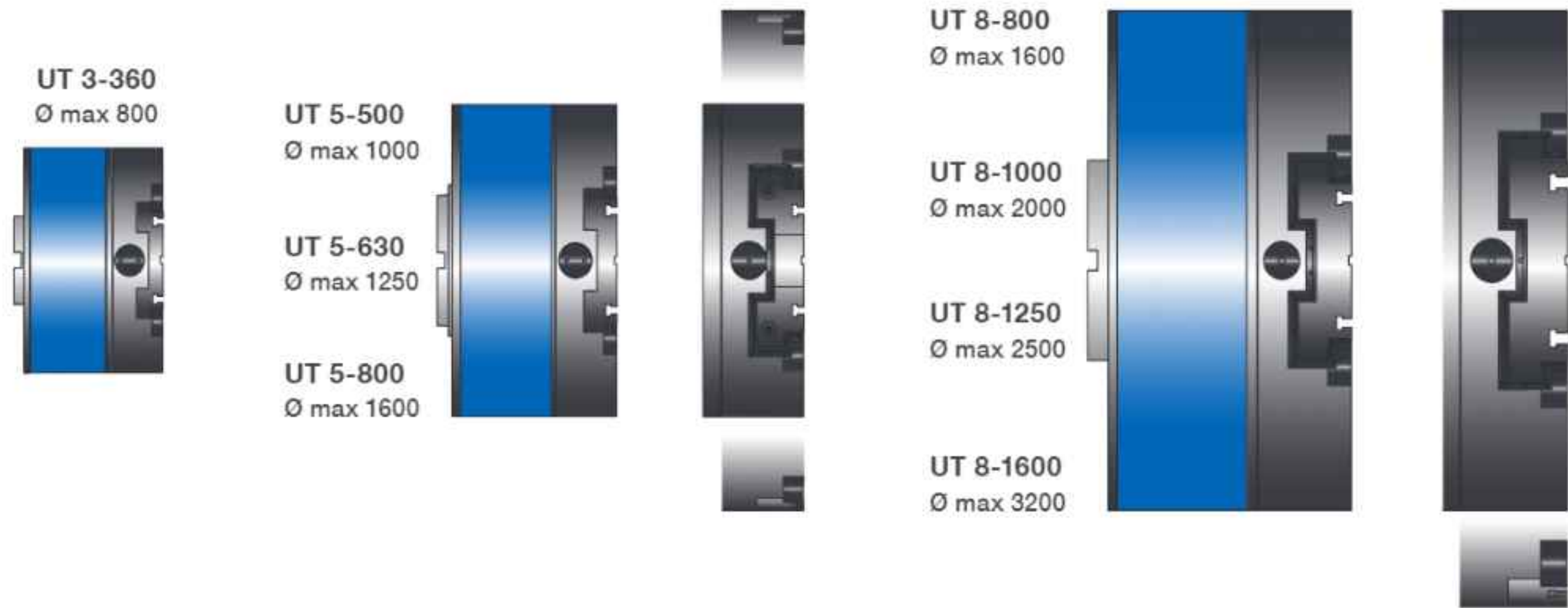
The slide movement is managed by an integrated servomotor and directly connected to the NC.

The application requires an interface flange that can be provided in manual, automatic, extended and angular versions.

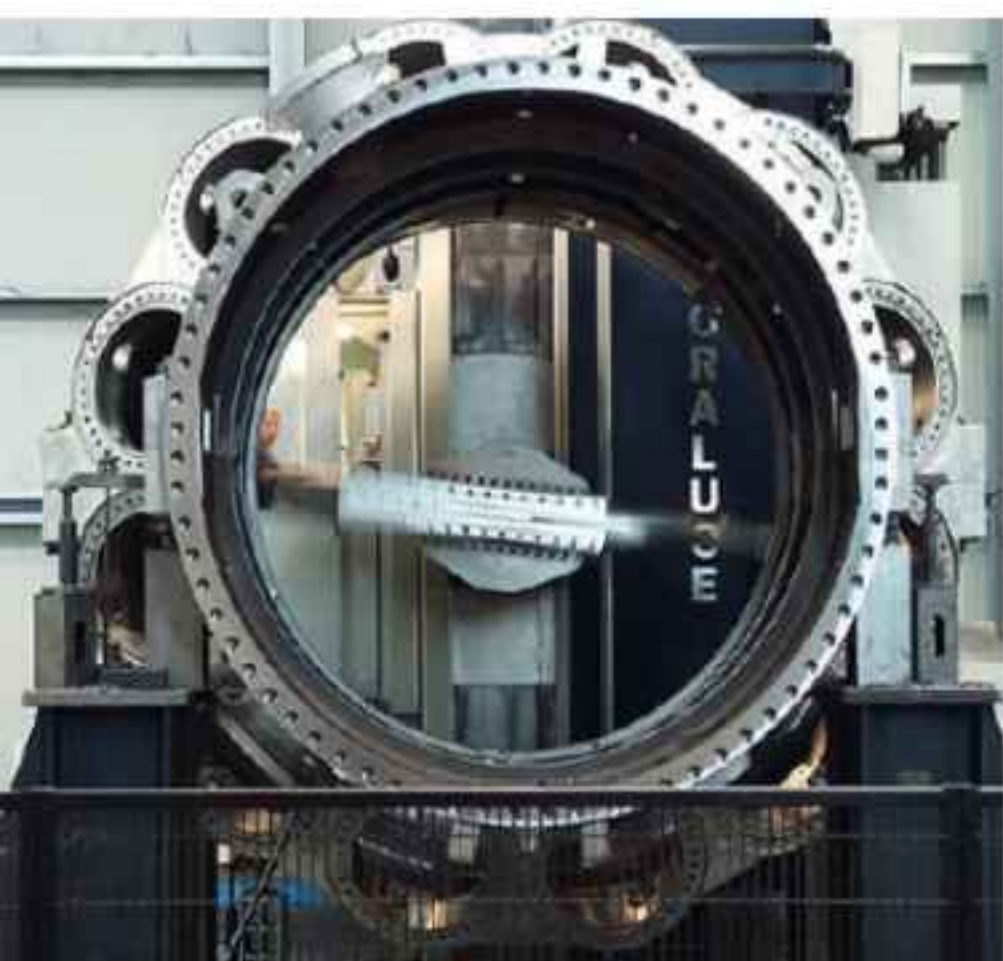
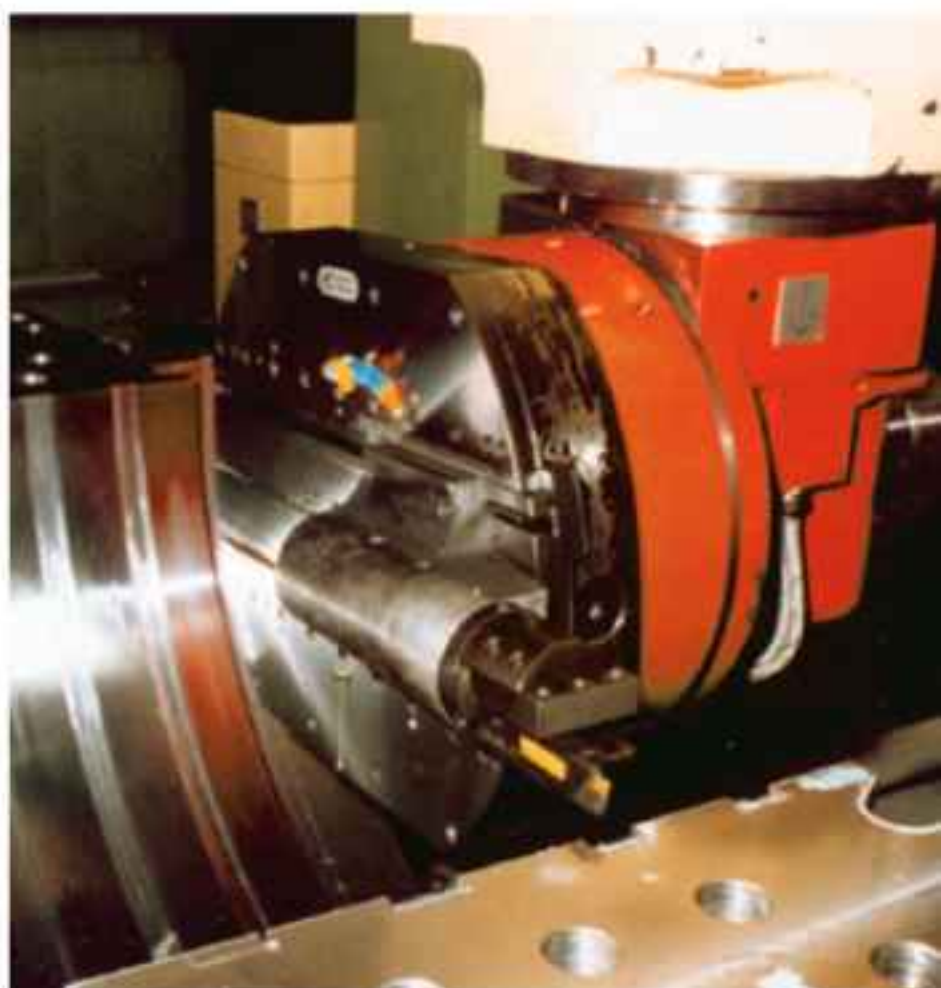
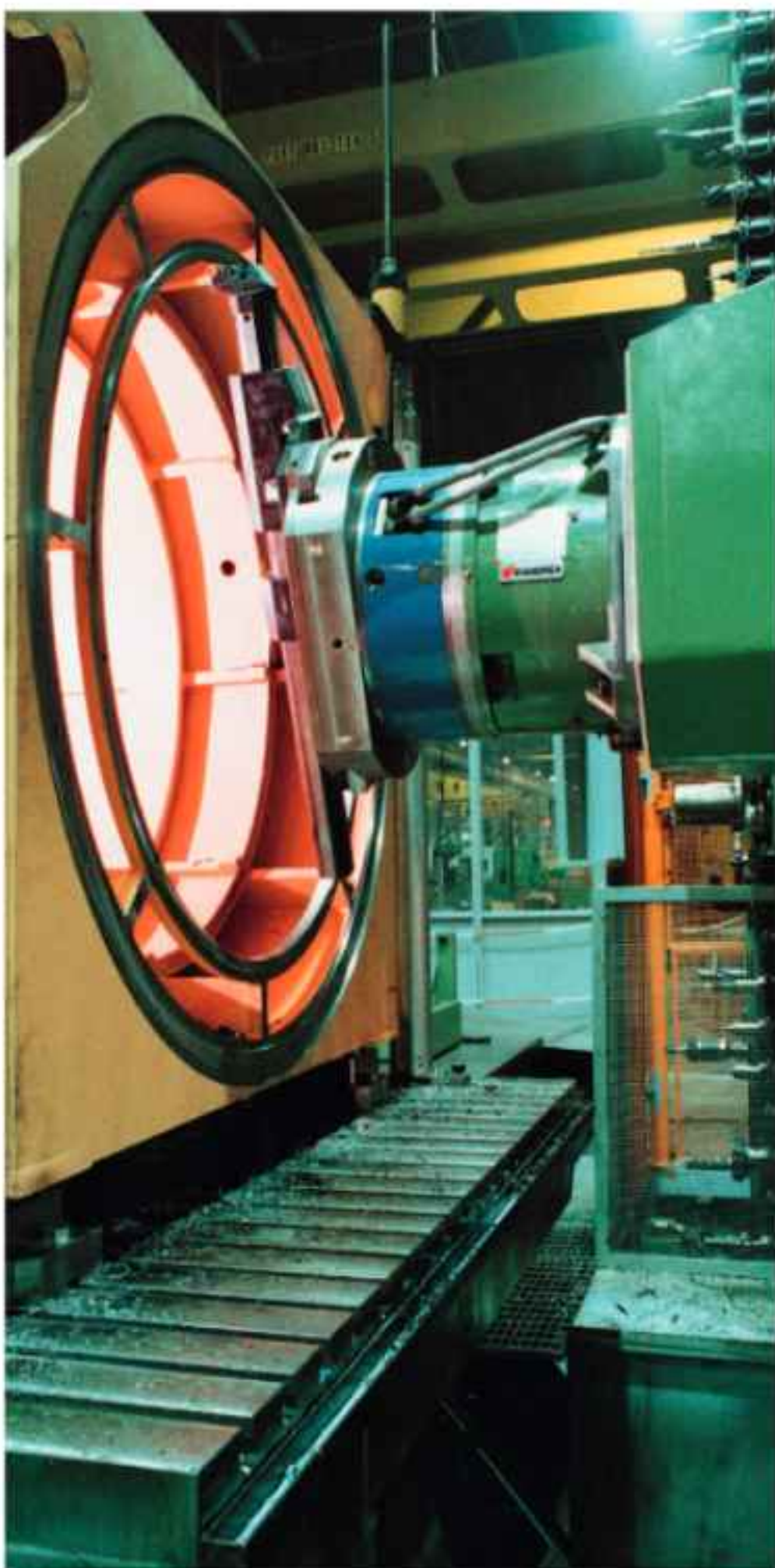
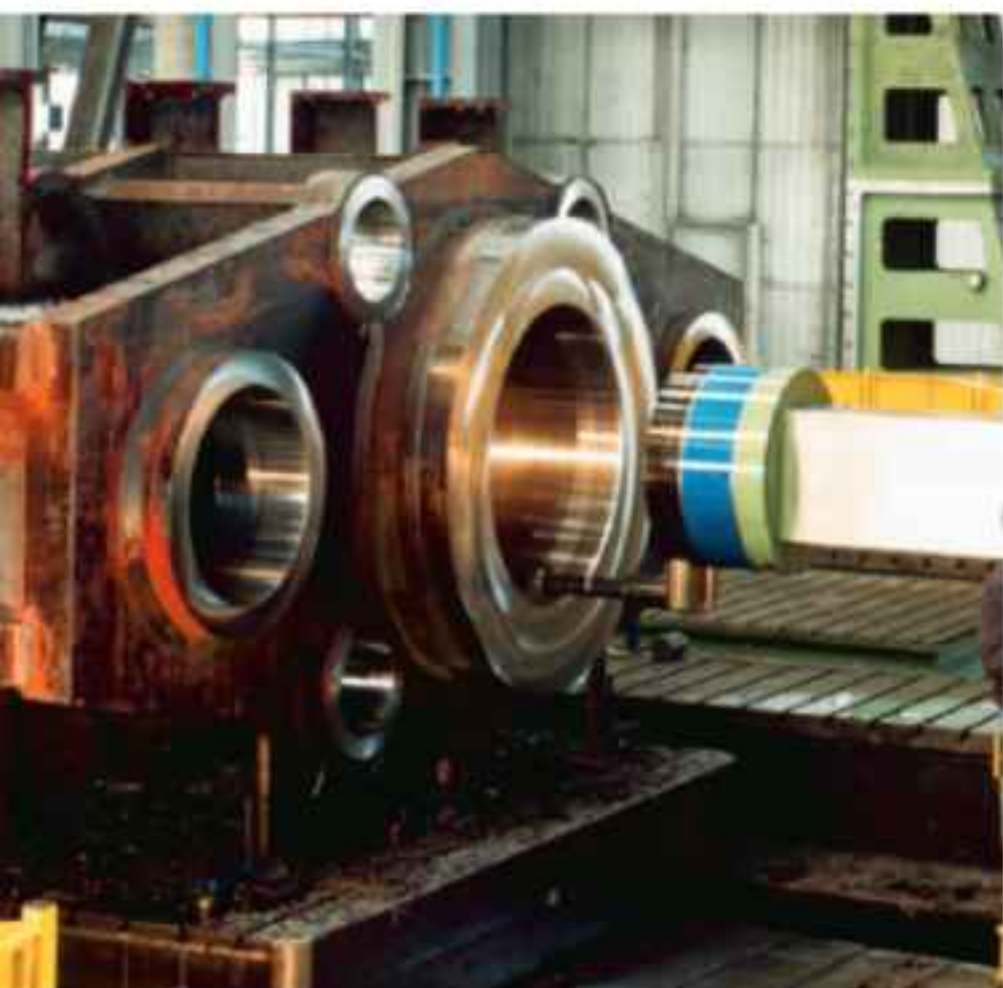
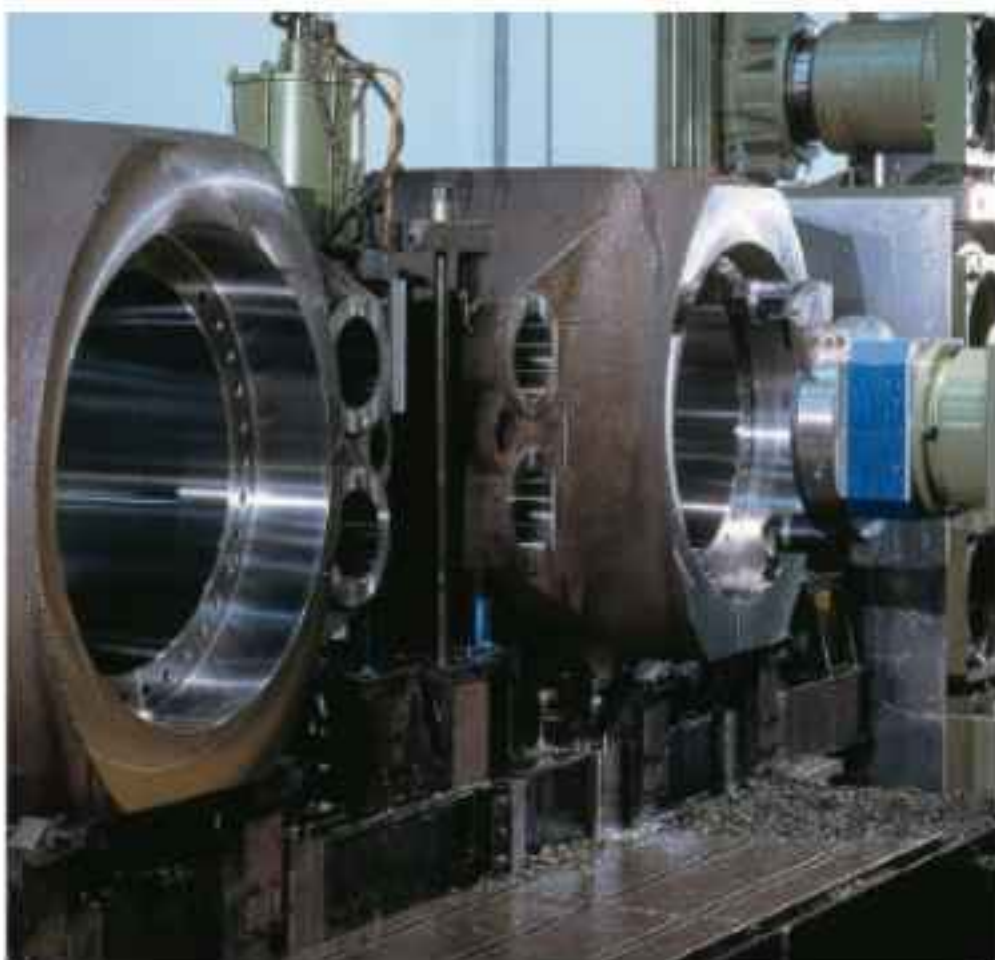
In addition to the standard range, the version with integrated reduction gear is available and, upon request, the special versions with hole, with double slide and with counterweights for self-balancing.



STANDARD

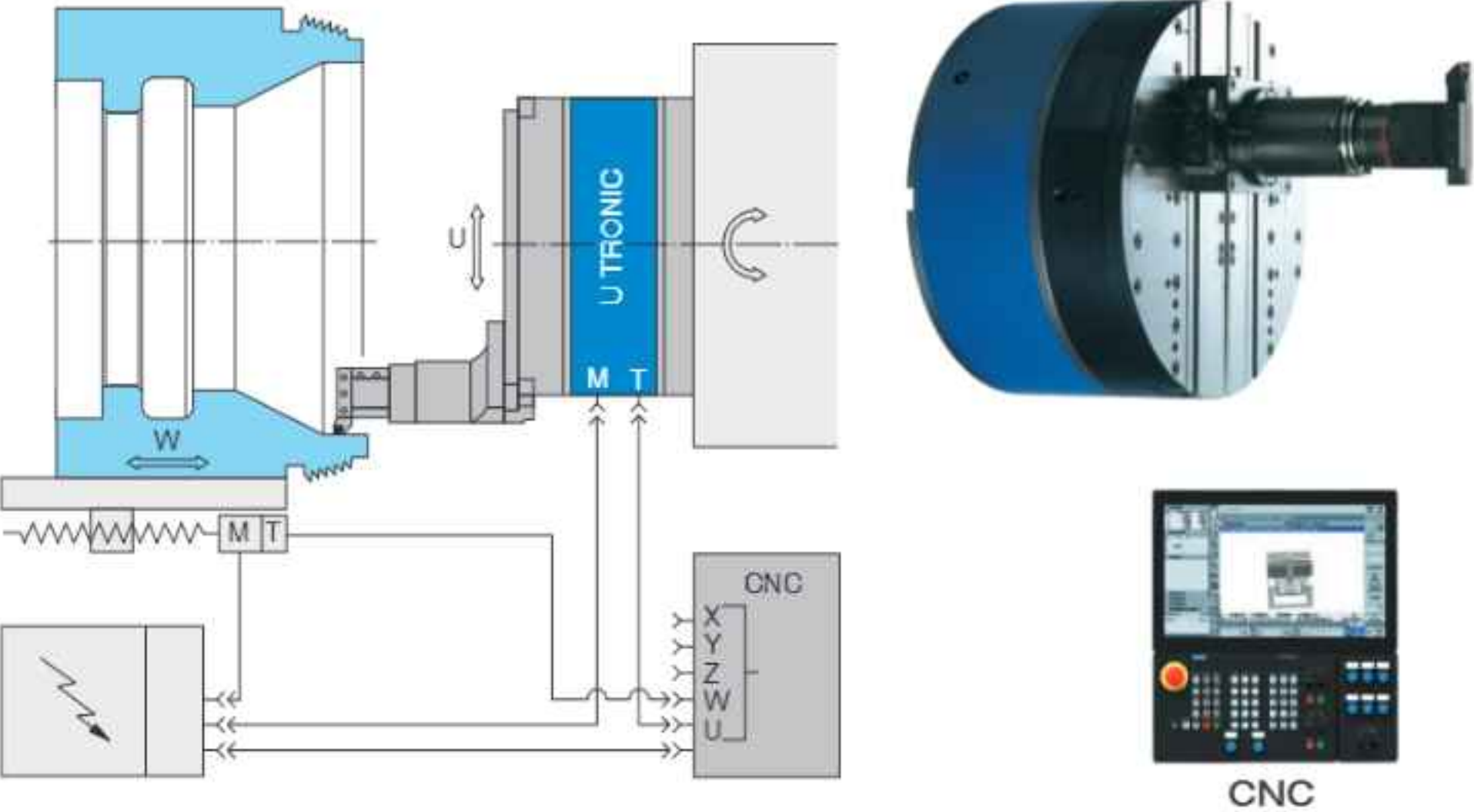


SPECIALS



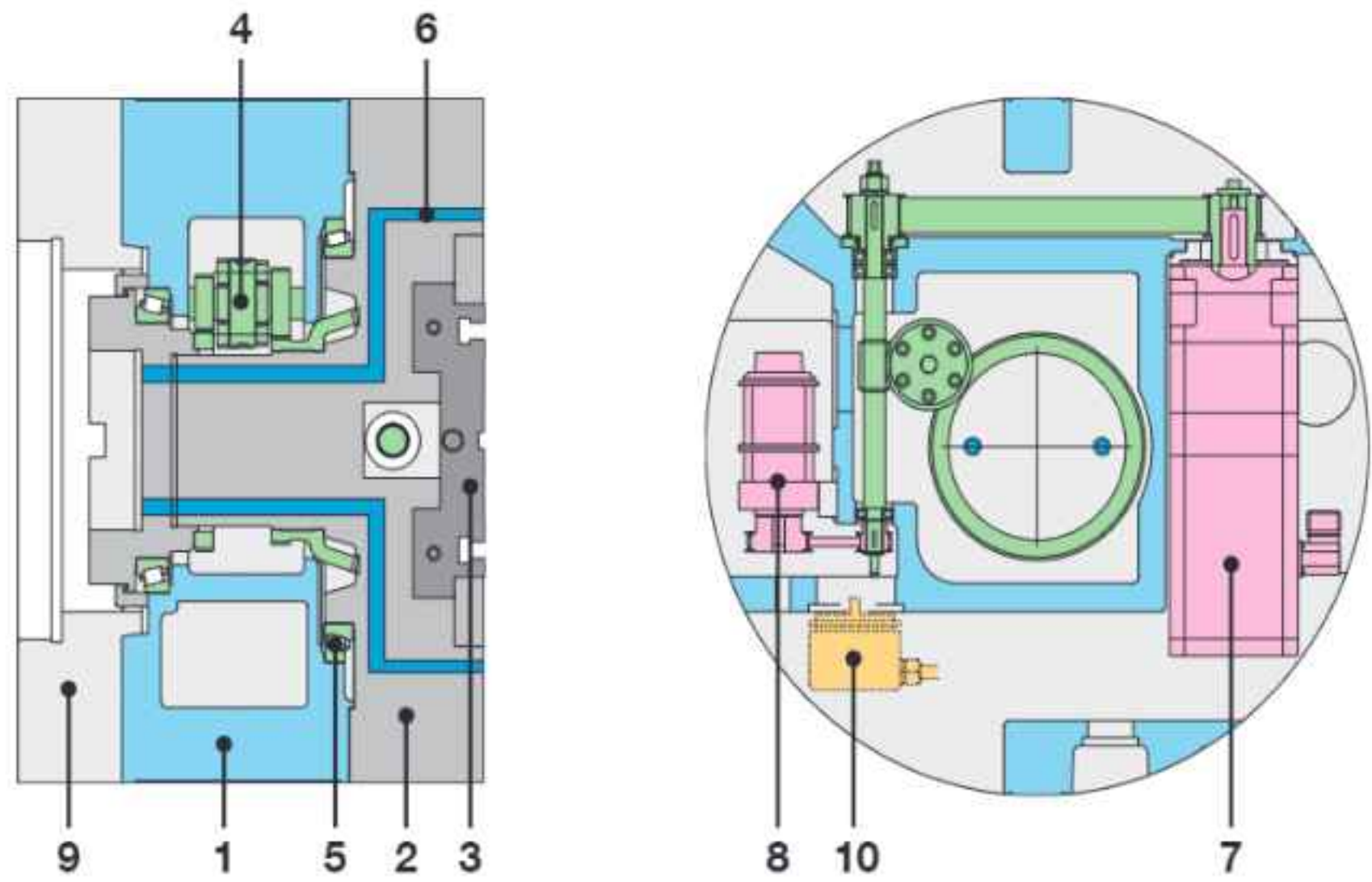
U-TRONIC

COMMAND



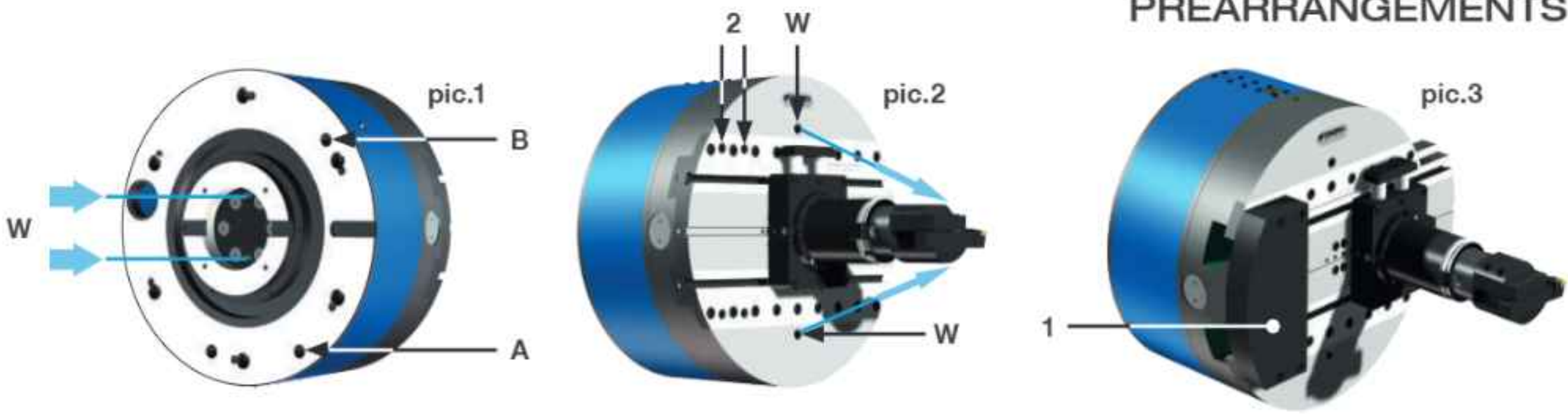
The control of the U-TRONIC HEADS takes place through the direct connection to the "U" axis of the machine numerical control. Through the interpolation of the axes, it allows to perform any type of turning, boring, radiusing and spherical operations.

COMPONENTS



- 1. Stationary body
- 2. Rotating body
- 3. Tool slide
- 4. Gears
- 5. Bearings
- 6. Coolant way
- 7. Servomotor
- 8. Limit switches
- 9. Flange
- 10. Encoder on request

PREARRANGEMENTS



A-Internal pressurization pic.1
To prevent liquid and dust from getting into the motor, transducer, and limit switch areas, an Ø 8,5 (A) hole is provided for internal pressurization of the fixed body with an air inlet at **0.5-1 BAR**.

B-Automatic greaser pic.1
A Ø 8,5 (B) hole is provided on the head so that grease can be automatically put in the U-TRONIC.

Coolant supply pic.1-2
Internal coolant channels (W) are provided inside the U-TRONIC head that allow coolants to pass through from the machine spindle until the two threaded holes located next to the slide (W). Hoses can be screwed on these holes to bring coolant directly to the tool. **Max pressure BAR 40.**

Balancing pic.3
To improve working conditions and balance the tool position when it appears shifted in relation to the U-TRONIC axis, counterweights (1) can be applied using the threaded holes (2) located on the rotating body.

APPLICATION

U-TRONIC is applied manually or automatically by using a flange for fastening to the machine tool and a driving plate for the rotary body rotation.

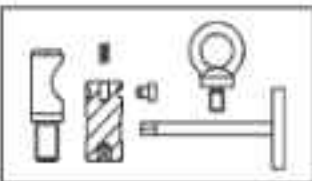
It is applied manually using a flange for fastening with a cam lock quick coupling, or automatically with a palletized system and special connectors.



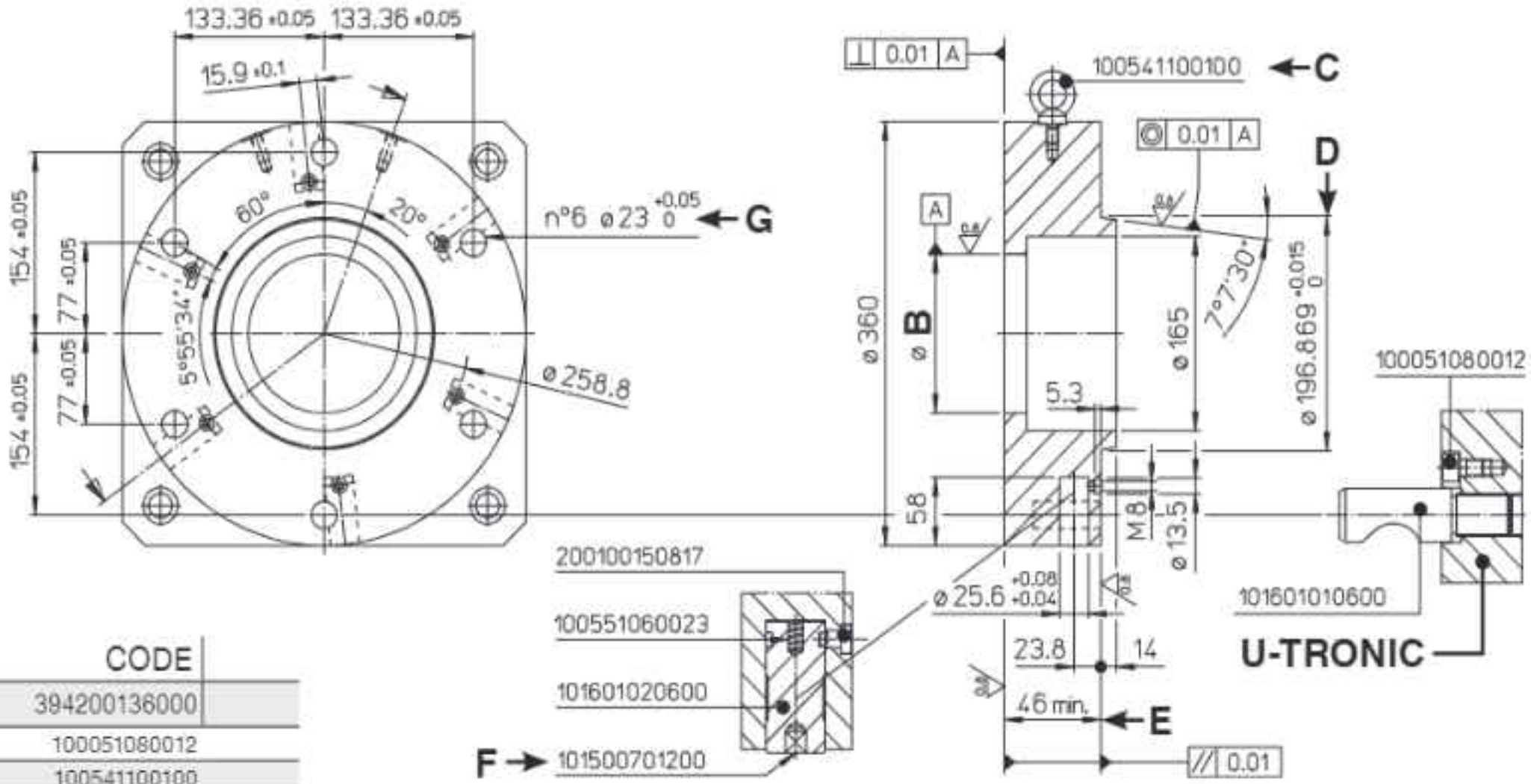
The following layout shows the basic information for the flange manufacturing with cam lock rapid coupling.

The U-TRONIC UT 8-800 S and UT 8-1000 S do not include the fastening with a cam lock quick coupling.

U-TRONIC 3-360 S



REF	CODE
KIT CAMLOCK UT 360	394200136000
n°6 VTC 8x12	100051080012
n°1 EYEBOLT M10 UT BASE 3	100541100100
n°6 SPRING UT BASE 3-5	100551060023
n°1 KEY FOR CAM 6 UT BASE 3	101500701200
n°6 CAMLOCK PIN 6 UT BASE 3	101601010600
n°6 CAMLOCK CAM 6 UT BASE 3	101601020600
n°6 PIN FOR CAM 6 UT BASE 3	200100150817

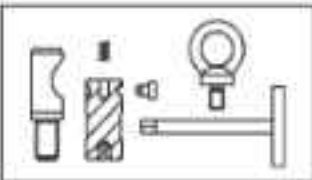


B Spindle centering C Eyebolt D Control with gauge E Measurement to control depending on spindle protrusion F Spanner G Bores min. depth 46

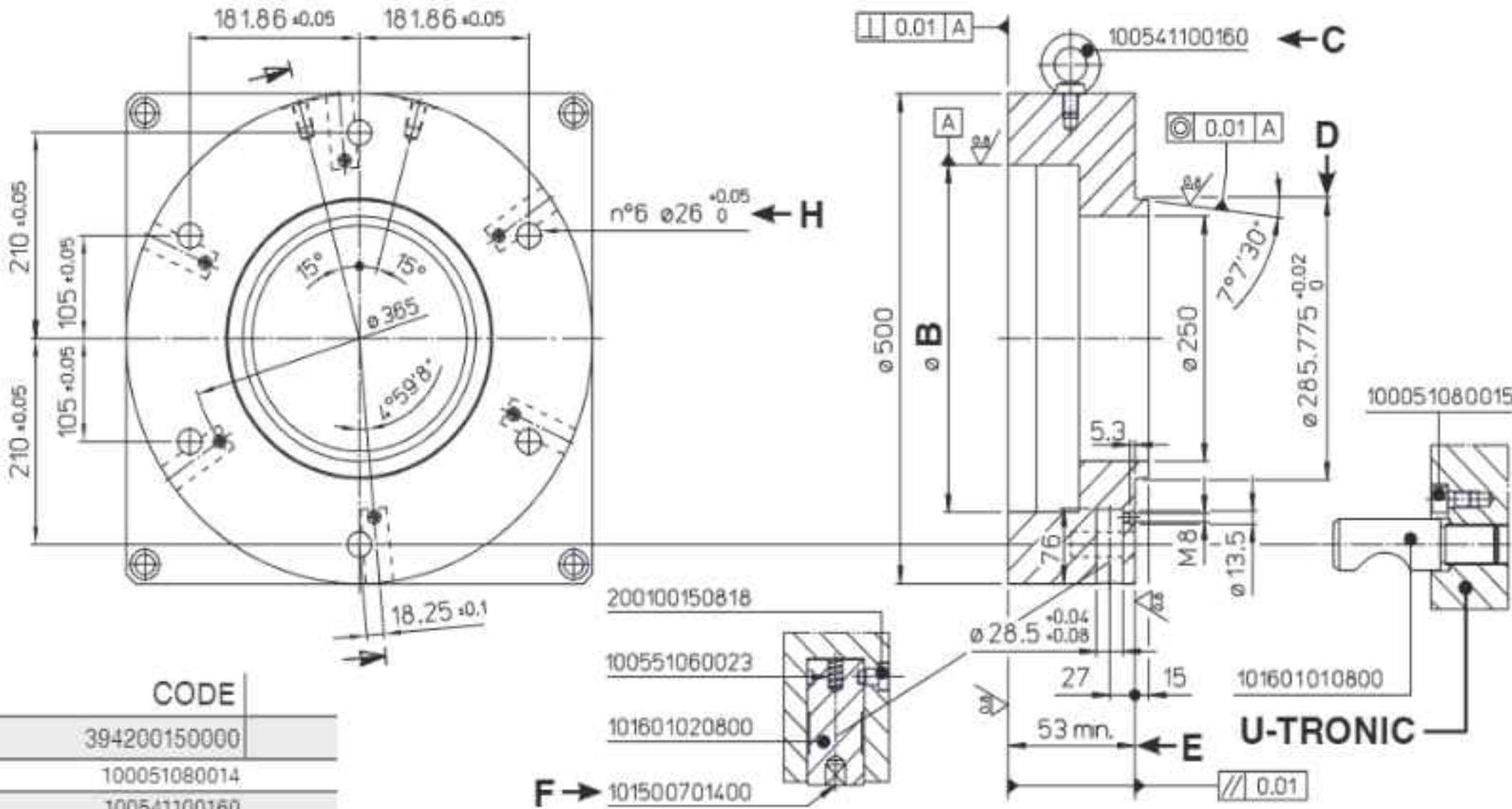
The following layout shows the basic information for the flange manufacturing with cam lock rapid coupling.

The U-TRONIC UT 8-800 S and UT 8-1000 S do not include the fastening with a cam lock quick coupling.

U-TRONIC 5-500 / 5-630 / 5-800 S



REF	CODE
KIT CAMLOCK UT 500	394200150000
n°6 VTC 8x14	100051080014
n°1 EYEBOLT M16 UT BASE 5	100541100160
n°6 SPRING UT BASE 3-5	100551060023
n°1 KEY FOR CAM 8 UT BASE 5	101500701400
n°6 CAMLOCK PIN 8 UT BASE 5	101601010800
n°6 CAMLOCK CAM 8 UT BASE 5	101601020800
n°6 PIN FOR CAM 8 UT BASE 5	200100150818



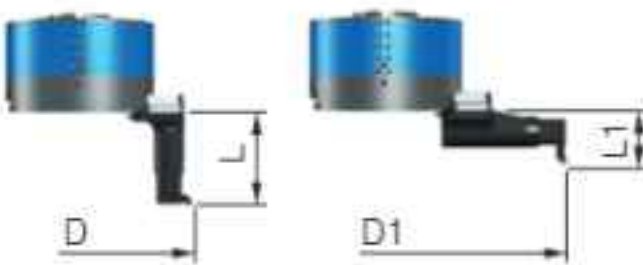
B Spindle centering C Eyebolt D Control with gauge E Measurement to control depending on spindle protrusion F Spanner H Bores min. depth 53

U-TRONIC

CHIP REMOVAL CAPACITY

The chip removals are indicative for normal working conditions on steels with hardness 160-200 HB, (average $K_s = 2000 \text{ N/mm}^2$) recommended $V_t 120/160 \text{ m/min}$. The optimal values and working times must be determined with trials.

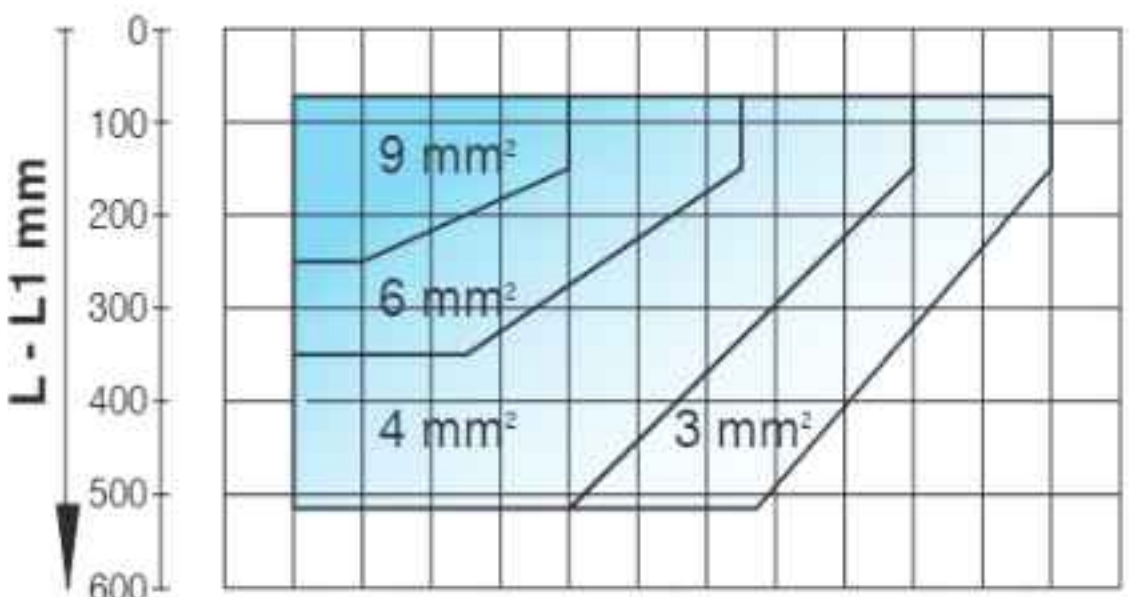
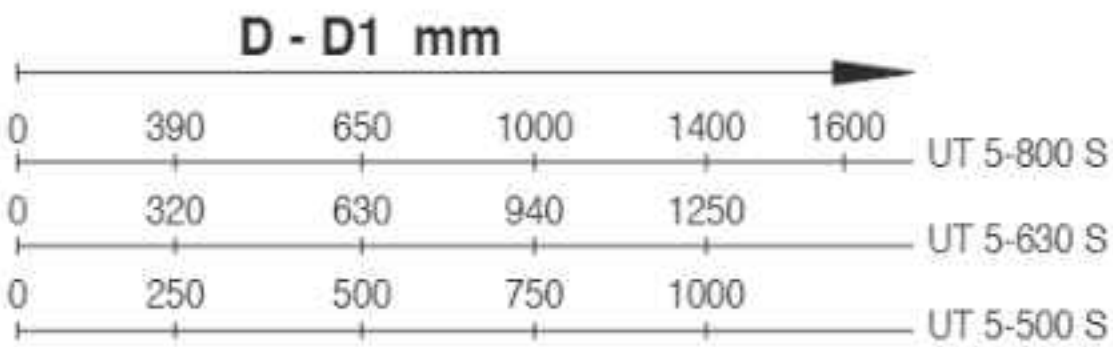
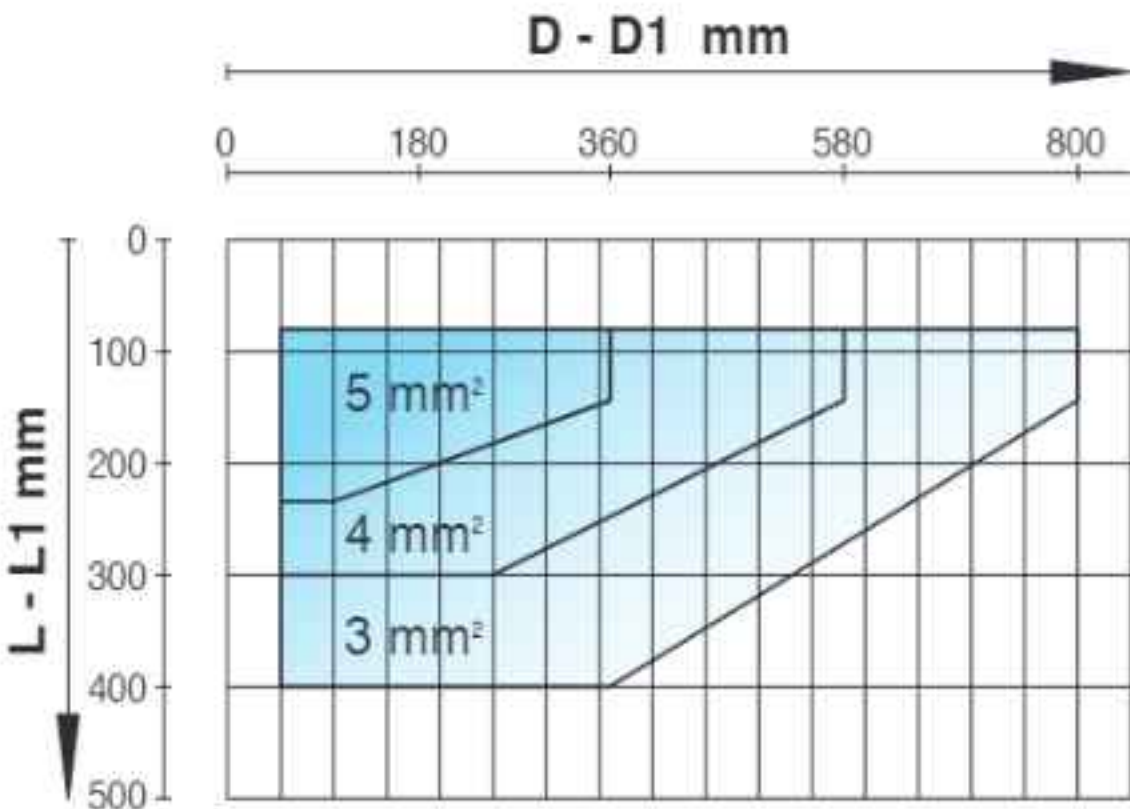
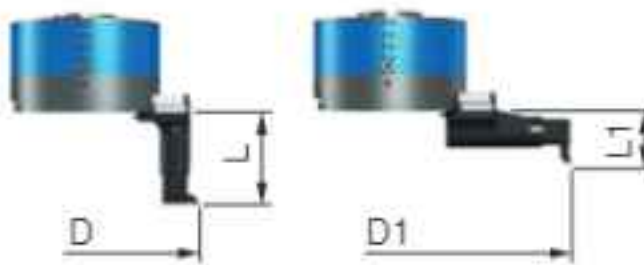
U-TRONIC 3-360 S



U-TRONIC 5-500 S

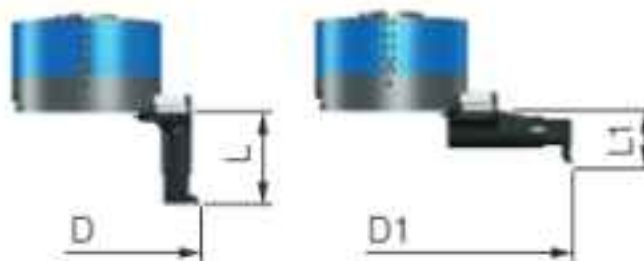
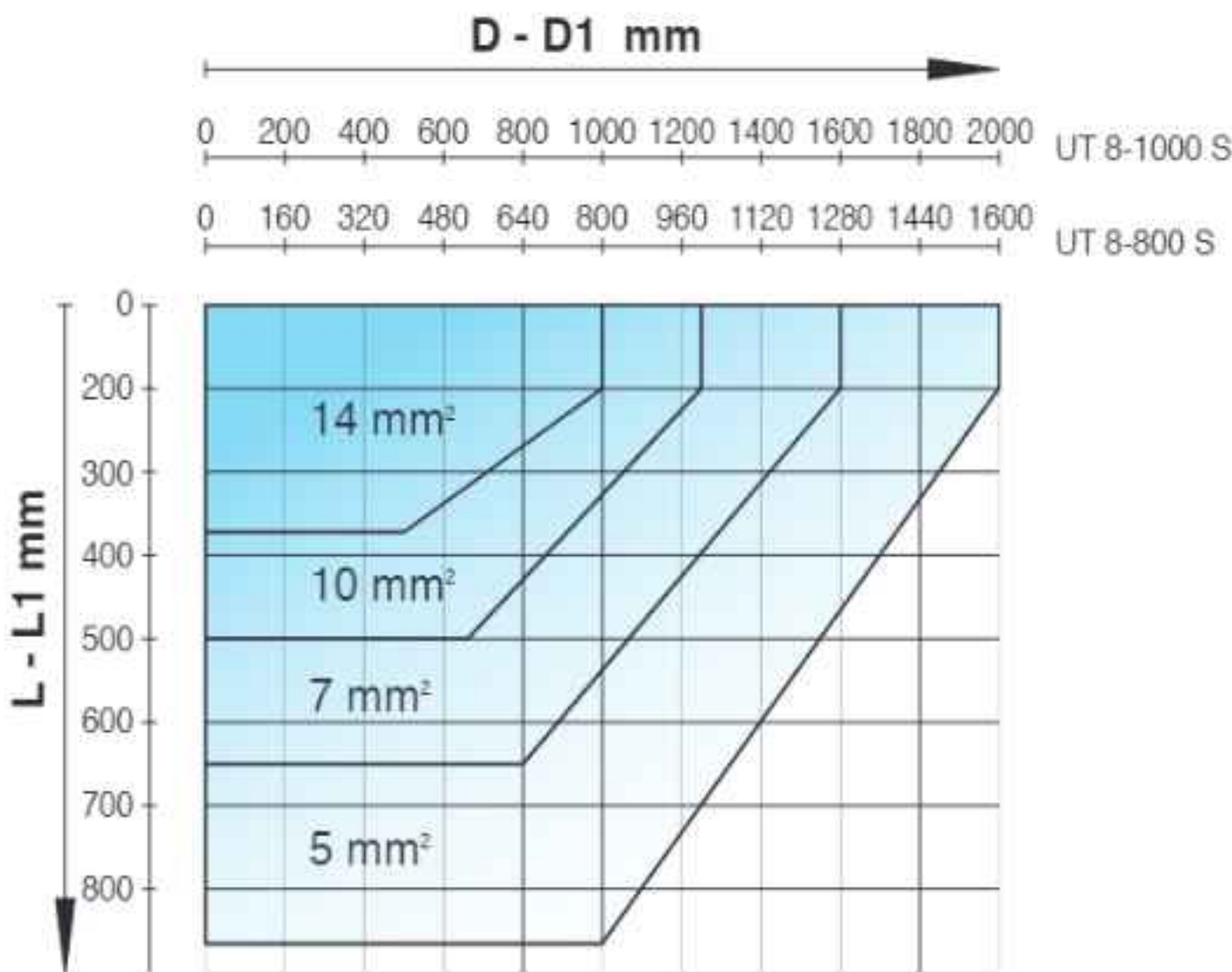
5-630 S

5-800 S



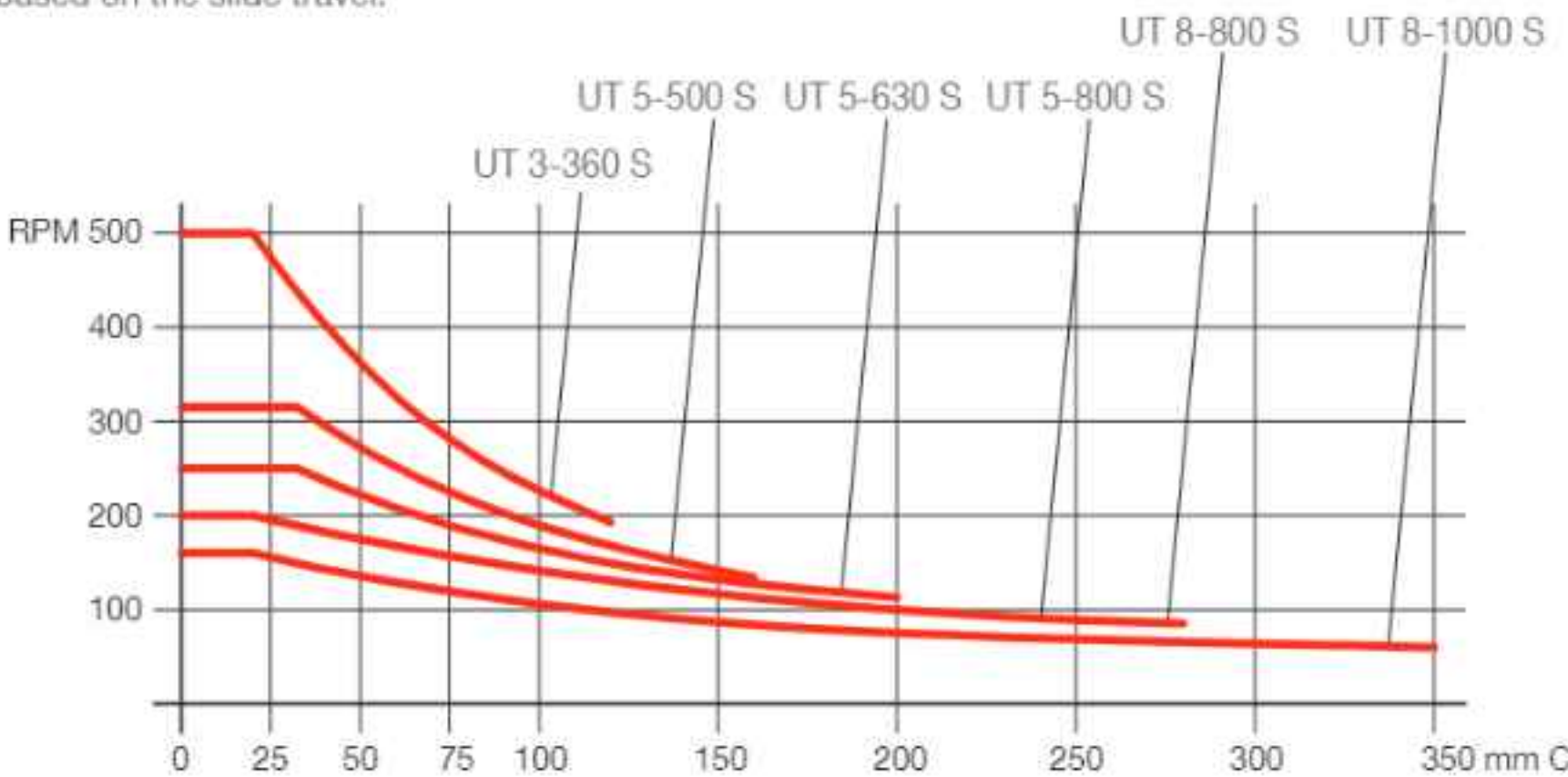
U-TRONIC 8-800 S

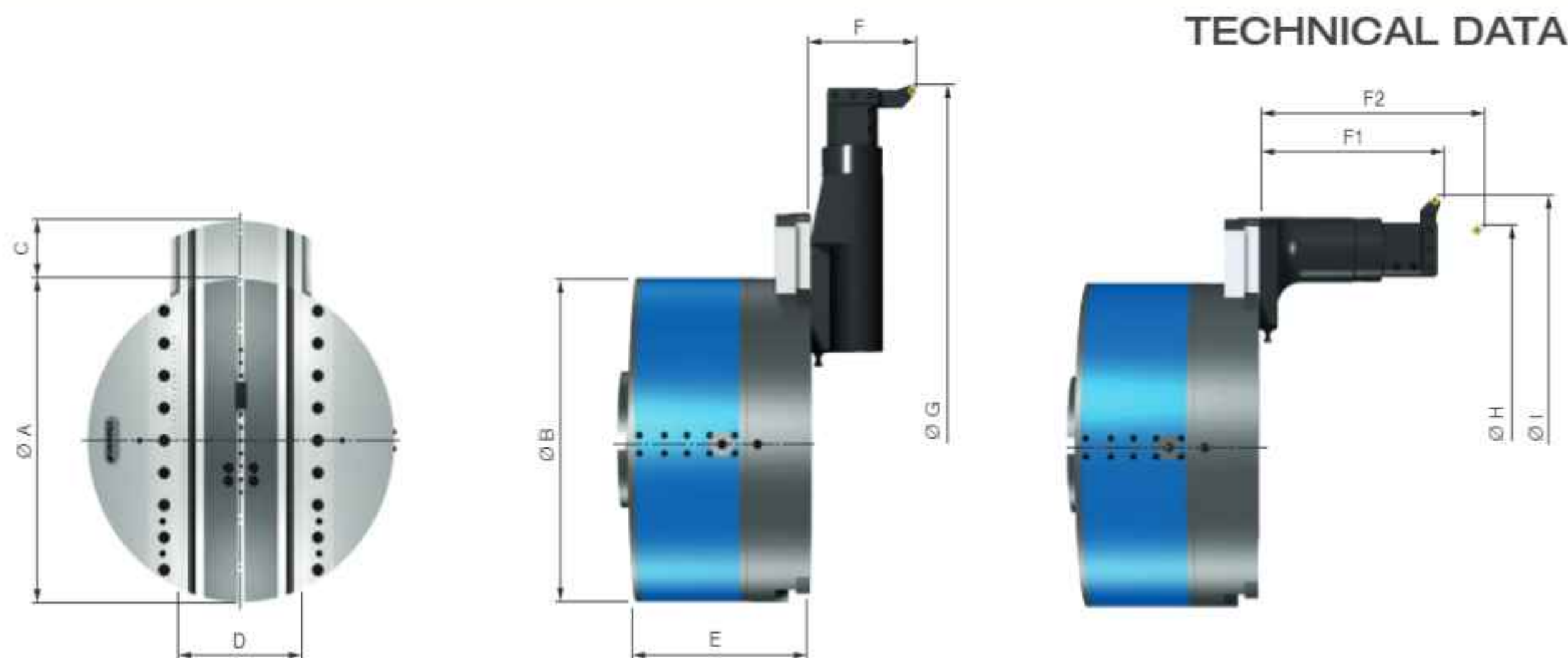
8-1000 S



For optimal U-TRONIC head operations and to protect it from damages, it is advisable to follow the chart below that indicates the **maximum rpm**, based on the slide travel.

MAX ROTATION SPEED





TECHNICAL DATA

TECHNICAL DATA		UT 3-360 S	UT 5-500 S	UT 5-630 S	UT 5-800 S	UT 8-800 S	UT 8-1000 S
Ø A	mm	360	500	630	800		1000
Ø B	mm	360	500			800	
C Radial traverse	mm	120	160	200	250	280	350
D	mm	154.6	199.6		230	250	260
E	mm	235	278.5	282	370	410	415
Ø G x F	mm	800 x 140	1000 x 150	1250 x 150	1600 x 150	1600 x 160	2500 x 160
Ø H x F2	mm	400 x 400	560 x 540	700 x 540	830 x 540	850 x 860	1050 x 860
Ø I x F1	mm	670 x 240	850 x 295	1050 x 295	1300 x 295	1250 x 370	1600 x 370
Max. mm/min	mm/min	1 ÷ 400				1 ÷ 500	
Max. U/min	RPM	500	315	250	200		160
Weight	Kg	130	230	310	530	1000	1200
Radial force	daN	400	500			1000	
Torque	daNm	400	800			1000	
Boring accuracy		H7					
Max chip removal	mm² C40	5	9			14	
Rapid trasverse	mm/min	400				500	
Roughness	Ra	0,8 ~ 1,2					

K02



UT 3-360 S

UT 5-500 S

UT 5-630 S

UT 5-800 S

UT 8-800 S

UT 8-1000 S

REF.

K02 UT 3-360 S

REF.

K02 UT 5-500 S

K02 UT 5-630 S

K02 UT 5-800 S

REF.

K02 UT 8-800 S

K02 UT 8-1000 S



Gearbox

Hole

Double slide

High Speed

Angular Heads

Extended

UT 3-360 / 5-500 / 5-630 / 5-800 / 8-800 / 8-1000 S

U-TRONIC

B 15

B 01

B 02

B50

MR

TU

TP

PC

Ø 25x25

16CA ISO5611

K03

1 B 01

1 B 02

1 B 15

1 MR

1 TU

FLANGE UT

REF.	CODE
KIT K03 UT 3-360 S	501703259300
KIT K03 UT 5-500/5-630/5-800 S	501705009300
KIT K03 UT 8-800/8-1000 S	501708009300

B01/B02

U-TRONIC	REF.	CODE	ØH7	A	B	C	D	E	kg		
UT 3-360 S	B01	443005001150	50	80	23	100	135	150	5.5		
	B02	443005002750	50	80	23	260	135	150	8.5		
UT 5-500 / 5-630 / 5-800 S	B01	443006301550	63	100	30	155	170	200	11		
	B02	443006303650	63	100	30	400	170	200	19		
UT 8-800 / 8-1000 S	B01	443008002300	80	130	30	230	200	250	25		
	B02	443008007200	80	130	30	720	250	250	60		

B15

U-TRONIC	REF.	CODE	ØH7	A	B	C	D	D1	E	kg		
UT 3-360 S	B15	445005001900	50	80	23	60	190	135	150	3.7		
UT 5-500 / 5-630 / 5-800 S	B15	445006302500	63	100	30	70	270	170	200	7.5		
UT 8-800 / 8-1000 S	B15	445008003001	80	130	30	85	300	200	250	34		

MR

U-TRONIC	REF.	CODE	MHD'	ØH7	Ø1	L	L1	L2	kg		
UT 3-360 S	MR 50/80.80	450208001060	80	50	80	95	50	45	1.6		
UT 5-500 / 5-630 / 5-800 S	MR 63/98.80	450209801060	80	63	98	105	60	45	3		
UT 8-800 / 8-1000 S	MR 80/130.80	450213001240	80	80	130	125	80	45	6		
	MR 80/130.110	450213001340	110	80	130	185	80	105	9		

TU

U-TRONIC	REF.	CODE	MHD'	Ø1	L	L1	L2	L3	kg		
UT 3 / 5 / 8 ... S ♦	TU 50/60.16	460505016001	50	60	60	44	16	16	1.2		
UT 3 / 5 / 8 ... S ♦	TU 63/75.20	460506320001	63	75	75	55	20	20	4		
UT 3 / 5 / 8 ... S	TU 80/95.25	460508025001	80	95	90	65	25	25	3.6		

♦ Use with RD 80/

TP

U-TRONIC	REF.	CODE	Ø	kg		
UT 3-360 S	TP 80/90.50	460408050001	90	2.3		
UT 5-500 / 5-630 / 5-800 S	TP 80/90.50	460408050001	90	2.3		
UT 8-800 / 8-1000 S	TP 80/125.50	460408050002	125	3.2		

PC

U-TRONIC	REF.	CODE	Ø	kg		
UT 3-360 S	PC 11.50	433050160950	95	1.3		
UT 5-500 / 5-630 / 5-800 S	PC 12.50	433050161350	135	2		
	PC 13.50	433050162000	200	3.2		
UT 8-800 / 8-1000 S	PC 14.50	433050163000	300	5		

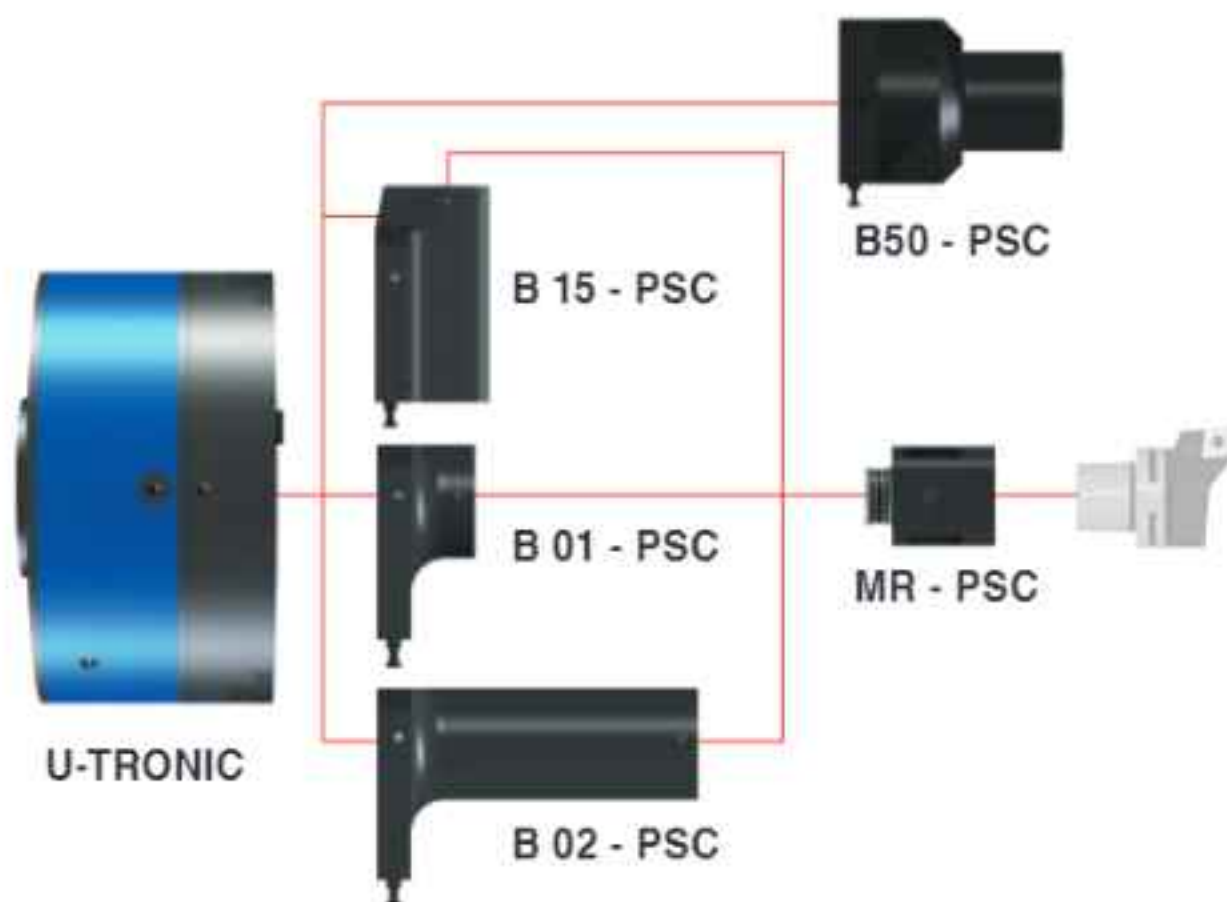
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CODE	483010161001
	TNM1604

	POLNL16OA-12
CODE	483010161002
	CNM1204

	PSSNL16OA-12
CODE	483010161003
	SNM1204

	PSRNL16OA-12
CODE	483010161004
	SNM1204

UT 3-360 / 5-500 / 5-630 / 5-800 / 8-800 / 8-1000 S



K03 - PSC



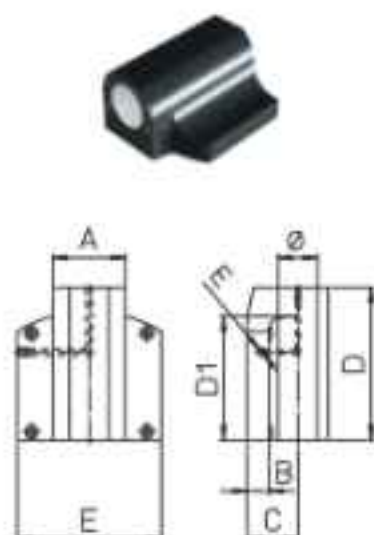
REF.	CODE
KIT K03 PSC 63 UT 3-360 S	501703259304
KIT K03 PSC 63 UT 5-500/5-630/5-800 S	501705009310
KIT K03 PSC 80 UT 5-500/5-630/5-800 S	501705009302
KIT K03 PSC 80 UT 8-800 / 8-1000 S	501708009301

B01 / B02 - PSC



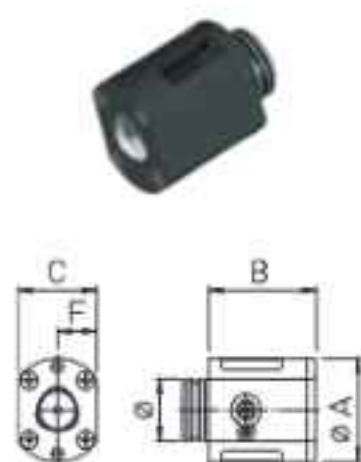
U-TRONIC	REF.	CODE	ØH7	A	B	C	D	E	F	G	kg
UT 3-360 S	B01 - PSC 63	443005000310	63	105	23	31	137	150	42	G1/8'	3.5
	B02 - PSC 63	443005001610	63	105	23	161	137	150	42	G1/8'	10
UT 5-500 / 5-630 / 5-800 S	B01 - PSC 63	443006302002	63	105	30	86	162	200	42	G1/8'	11
	B02 - PSC 63	443006304452	63	105	30	331	162	200	42	G1/8'	20
	B01 - PSC 80	443006302001	75	130	30	71	185	180	50	G1/8'	10.5
	B02 - PSC 80	443006304451	75	130	30	316	235	180	50	G1/8'	30
UT 8-800 / 8-1000 S	B01 - PSC 80	443008001460	75	130	30	146	182	250	50	G1/4'	16
	B02 - PSC 80	443008006360	75	130	30	636	182	250	50	G1/4'	53

B15 - PSC



U-TRONIC	REF.	CODE	ØH7	A	B	C	D	D1	E	F	G	kg
UT 3-360 S	B15 - PSC 63	445005001210	63	100	23	60	121		150	42	G1/8'	8
UT 5-500 / 5-630 / 5-800 S	B15 - PSC 63	445006303152	63	100	30	70	201	170	200	42	G1/8'	6.5
	B15 - PSC 80	445006303911	75	130	39	85	262	200	180	50	G1/8'	27.5
UT 8-800 / 8-1000 S	B15 - PSC 80	445008003005	75	130	30		300	200	250	50	G1/4'	33

MR - PSC



U-TRONIC	REF.	CODE	Øg6	A	B	C	F	kg
UT 3-360 S	MR - PSC 63	450206000630	63	105	114	84	42	6.5
UT 5-500 / 5-630 / 5-800 S	MR - PSC 63	450206000630	63	105	114	84	42	6.5
UT 5-500 / 5-630 / 5-800 S	MR - PSC 80	450208000800	75	130	129	100	50	11
UT 8-800 / 8-1000 S	MR - PSC 80	450208000800	75	130	129	100	50	11

TOOLHOLDER WITH AUTOMATIC TOOL CHANGE

B50 MECHANICAL



pic.1

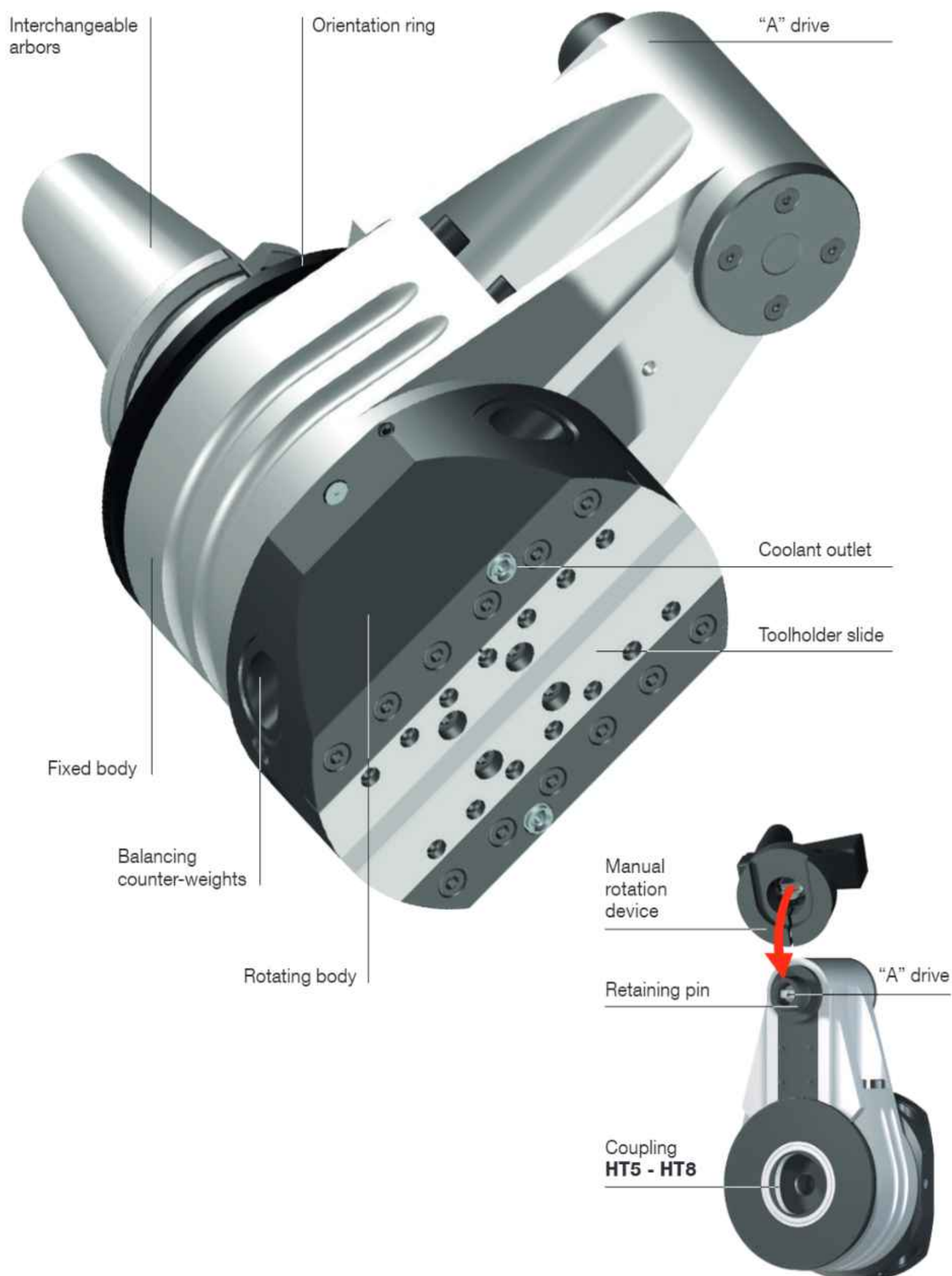


U-TRONIC	REF.
UT 3-360 S	- HSK
UT 5-500 / UT 5-630 / 5-800 S	B50 - DIN69871
UT 8-800 / 8-1000 S	- MAS BT

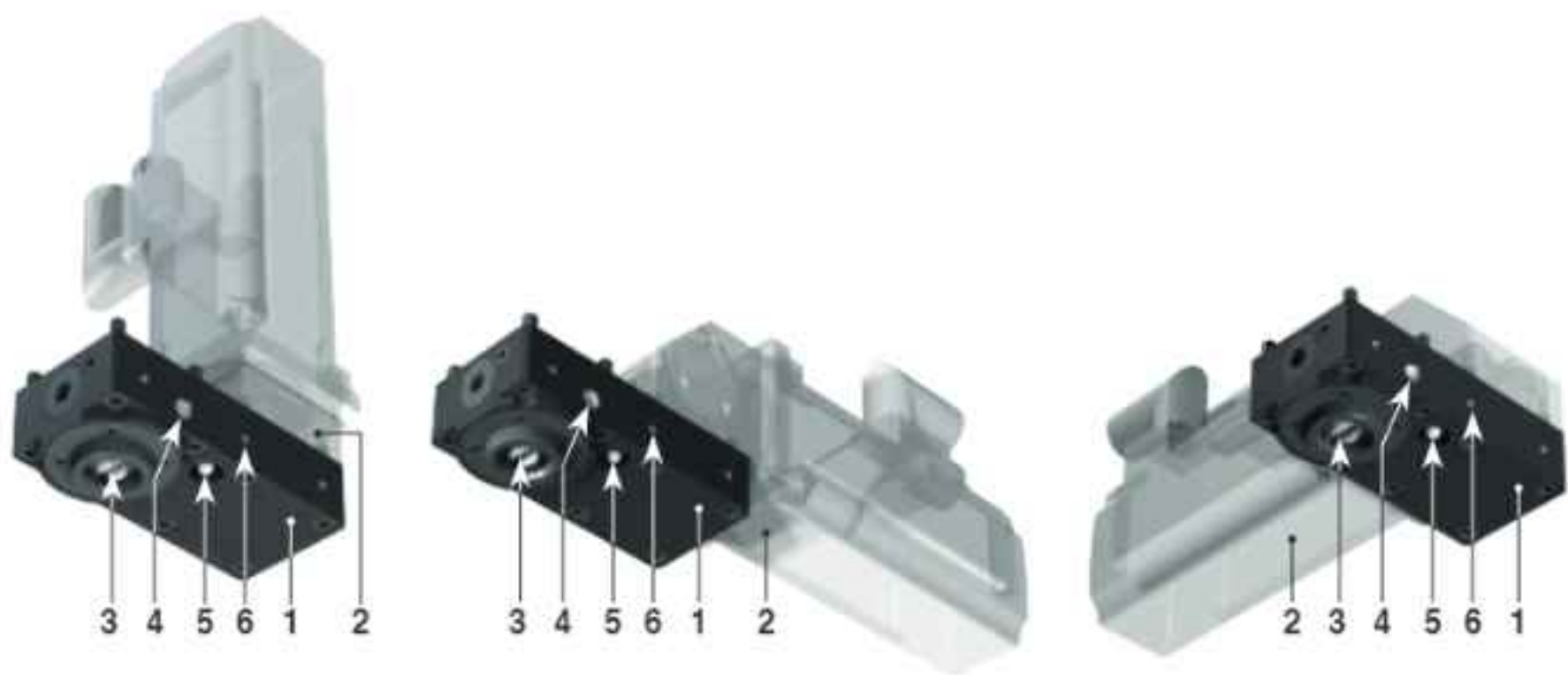
U-TRONIC	REF.
UT 3-360 S	- PSC / HSK
UT 5-500 / UT 5-630 / 5-800 S	B50 - DIN69871
UT 8-800 / 8-1000 S	- MAS BT

Special and HYDRAULICS B50 toolholders for automatic tool change, can be provided on request (pic.1).

TA-CENTER 2 - Boring and facing heads realized for machines with automatic tool change and applicable on every machining centers.
The toolholder slide movement is managed by a drive unit
External U-DRIVE fixed to the spindle flange.



COMPONENTS U-DRIVE



1. Base element
2. Servomotor
3. Mechanical unit for automatic hook-up to the TA-CENTER 2 drive
4. The unit comes with air inlet connection for cleaning the drive
5. Manual lubrication
6. n°6 M5x8 holes to be used for securing a possible protective casing

COMMAND



The TA-CENTER 2 boring and facing heads are designed to be used on machines with automatic tool change, therefore essentially on all machining centers. The control of the feed, the tool-holder slide and the tool position, also during rotation, are controlled by a U-DRIVE gearbox unit. This group is managed directly by an axis called "U" of the numerical control of the machining center. A machining center set up in this way allows to hit several different features such as internal and external turning, grooves, taper bores, concave and convex radius machining, cylindrical and conical threads and facing for serration.

PREARRANGEMENTS



Coolant supply pic.1

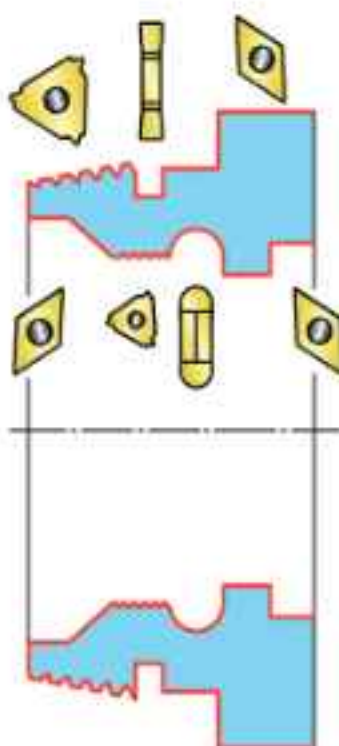
Coolant exits from the two adjustable nozzles in the TA-C2 located next to the slide after crossing the taper and the rotating body of the head. This noteworthy advantage ensures longer duration of the cutting edge, quicker cutting speed and for obtaining good surface finishes. The centralized supply of coolant does not harm the TA-C2 of which the internal labyrinth protected by an O-ring. It is advisable to not exceed **50 BAR** of pressure.



Balancing pic.2

TA-CENTER heads are designed with two counterweights (5) for automatic balancing, that move opposite to the slide (3) allowing to machine at a higher number of rpm without noticeable oscillations.

MACHINING



TA-CENTER 2

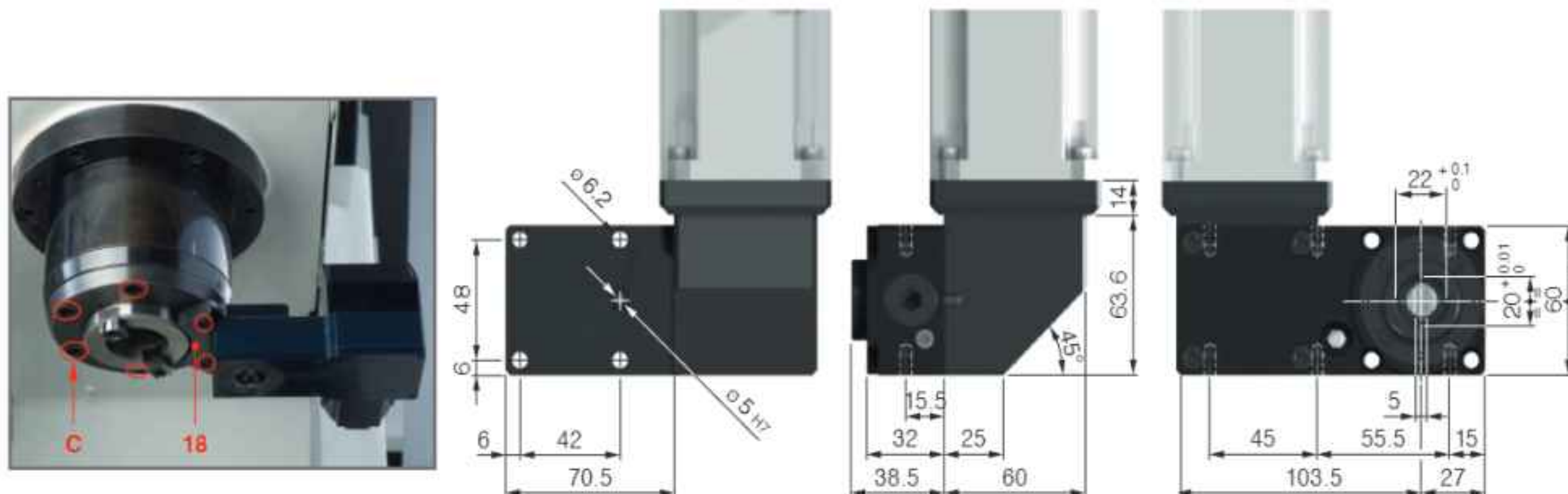
APPLICATION

U-Drive

D'ANDREA has developed a standard U-DRIVE unit (horizontal and vertical), on which different types of servomotors can be mounted.

The U-DRIVE can be easily positioned on the machine (see photo) with plate (18) adapted to the machine that is connected and fixed to the holes (C) on the front of the spindle flange.

Other special configurations can be provided on request



U-DRIVE assembly TA-CENTER

For a correct installation of the U-DRIVE and TA-CENTER 2, carefully follow these instructions:

1. Mount the cone on the TA-CENTER 2, detect the **B** distance between the gauge limit of the cone (4) and the retaining pin plane (9).

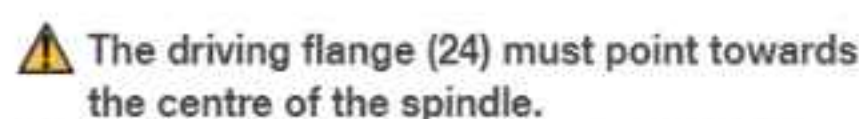
Calculate X height with the formula $X=B+4\text{ mm}$.

Warning, if more heads are employed on the same machine, calculate the X height by using the lower B value.

2. Mount the plate (18) and the U-DRIVE on the machine according to the Layout and detect the F distance between the spindle gauge limit and the U-DRIVE plane.

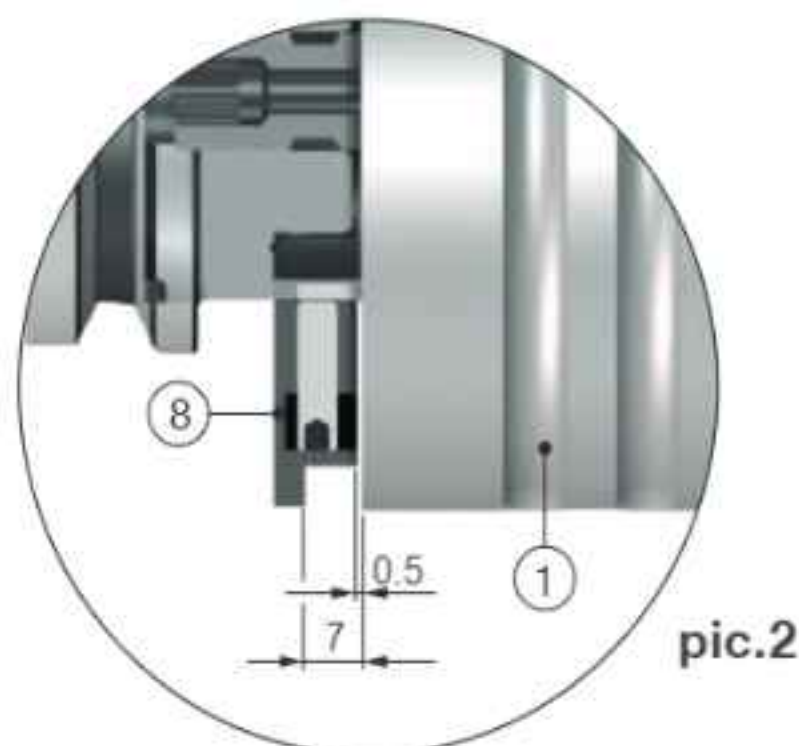
The F distance must be equal to the X height.

The plate **(18)** is thicker than indicated in the layout, to get the F and X distances alike, the plate thickness must be trimmed **(18)**. After adjusting the F height, remount the U-DRIVE by paying attention to its alignment, the position of the drive shaft **(22)** and distance **(23)** between the drive shaft axis **(22)** and the machine spindle centre.



3. To align the TA-CENTER 2 to the U-DRIVE, remove the two locking dowels (21) of the orientation ring (8) to the left and right of the white reference point, and replace them temporarily with two longer dowels, integrating the ring to the fixed body. Screw the 4 ring dowels until they lay slightly to the cone (4) (pic.1-2).

After checking that the head is in the **HOME POSITION**, that the slide stroke is 0 and that the transmission shaft (22) of the U-DRIVE is aligned with the retaining pin (9) of the head, spindle orientation (M19), manually mount the head in the machine. Insert the cone (4) in the spindle by rotating the fixed body (1) up to the U-DRIVE, once the TA-CENTER 2 and U-DRIVE are aligned, lock the TA-CENTER 2 in the machine and tighten all dowels (21) putting the two original dowels one at a time. During this operation, pay attention to the height between the ring (8) and the fixed body (1) (pic.3). Load and unload the TA-CENTER 2 manually a few times to check the alignment.

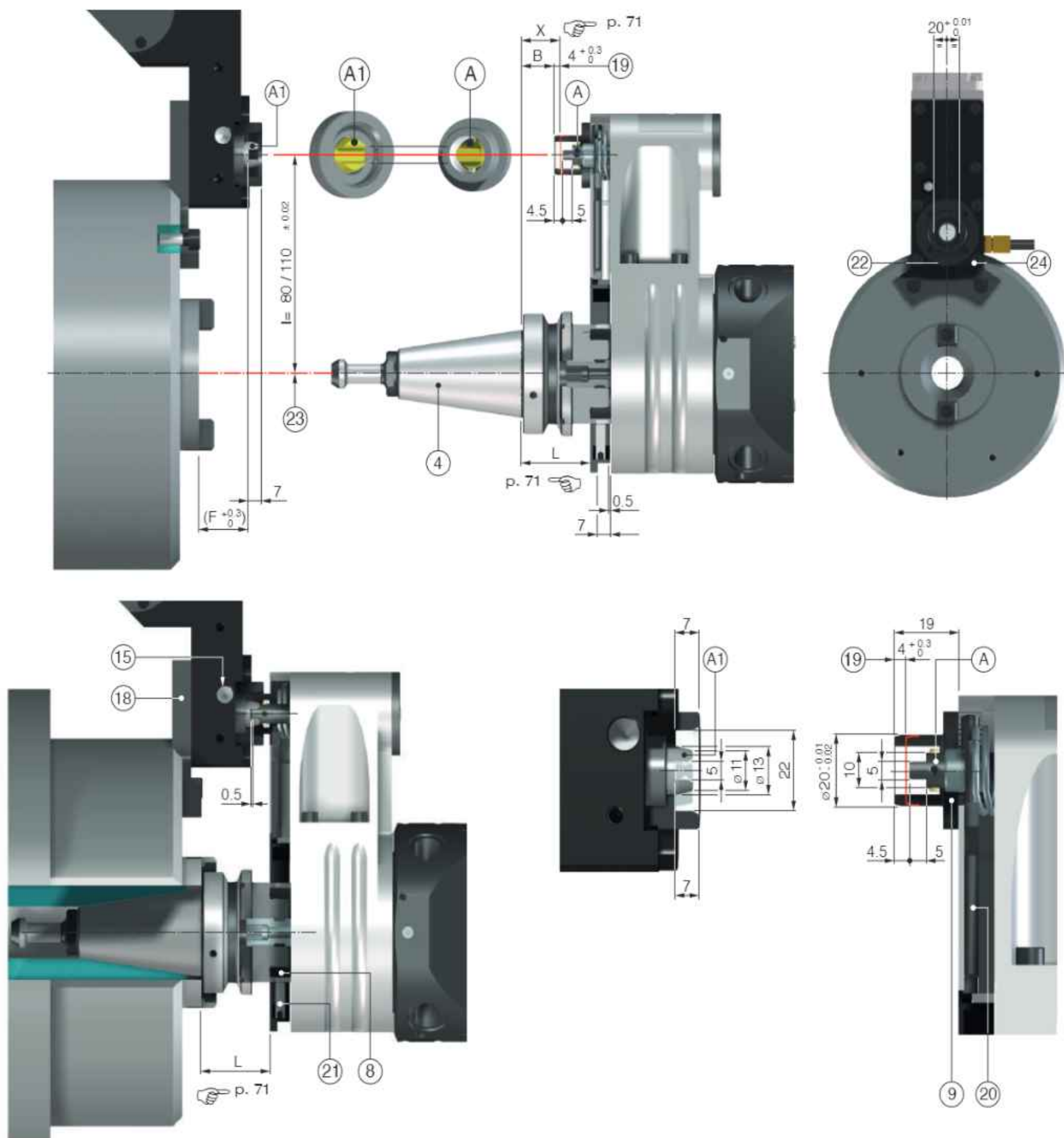


U-DRIVE assembly TA-CENTER

⚠ WARNING

During tool changes the "A" shafts of the TA-CENTER and "A1" U-DRIVE must comply with the correct "HOME POSITION" setting and must be always run in an unidirectional way to allow :

- the perfect coupling tooth "A" to "A1".
- can be properly attached, the rotating body can be properly coupled to the fixed body.
- to avoid exceeding runout and cause damage inside the head, recognition of the "0" position of the tool slide is required.



15. Air inlet connection for cleaning the drive 1/8 GAS.

18. Support plate for blocking and adapting the X dimension of the U-DRIVE ($X + 0.3/0$) mm.

19. Release rotation lock travel.

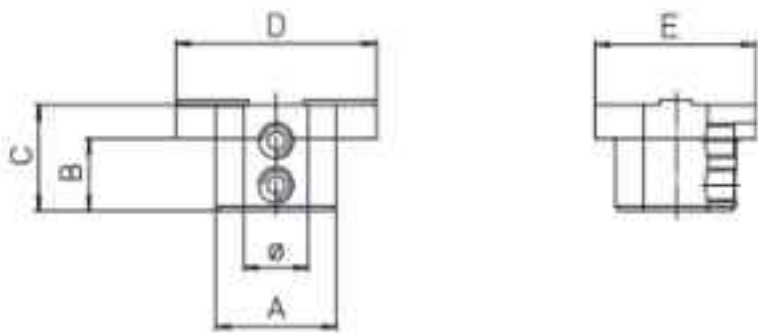
20. Locking-unlocking lever.

TA-CENTER 2

SUPPLY

P120

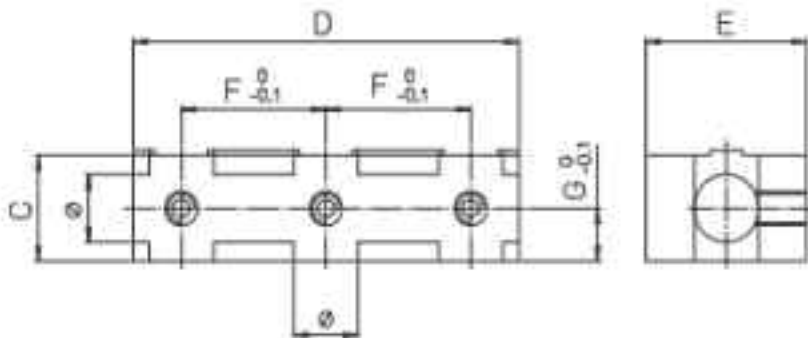
TA-C2 / TA-T2



REF.	CODE	ØH7	A	B	C	D	E	Kg.		
P 120 TA-C2.110 / TA-T2.110	431550160250	16	30	17	25	50	40	0.2		
P 120 TA-C2.170 / TA-T2.170	431550250380	25	47	27.5	38	76	54	0.55		

P130

TA-C2 / TA-T2



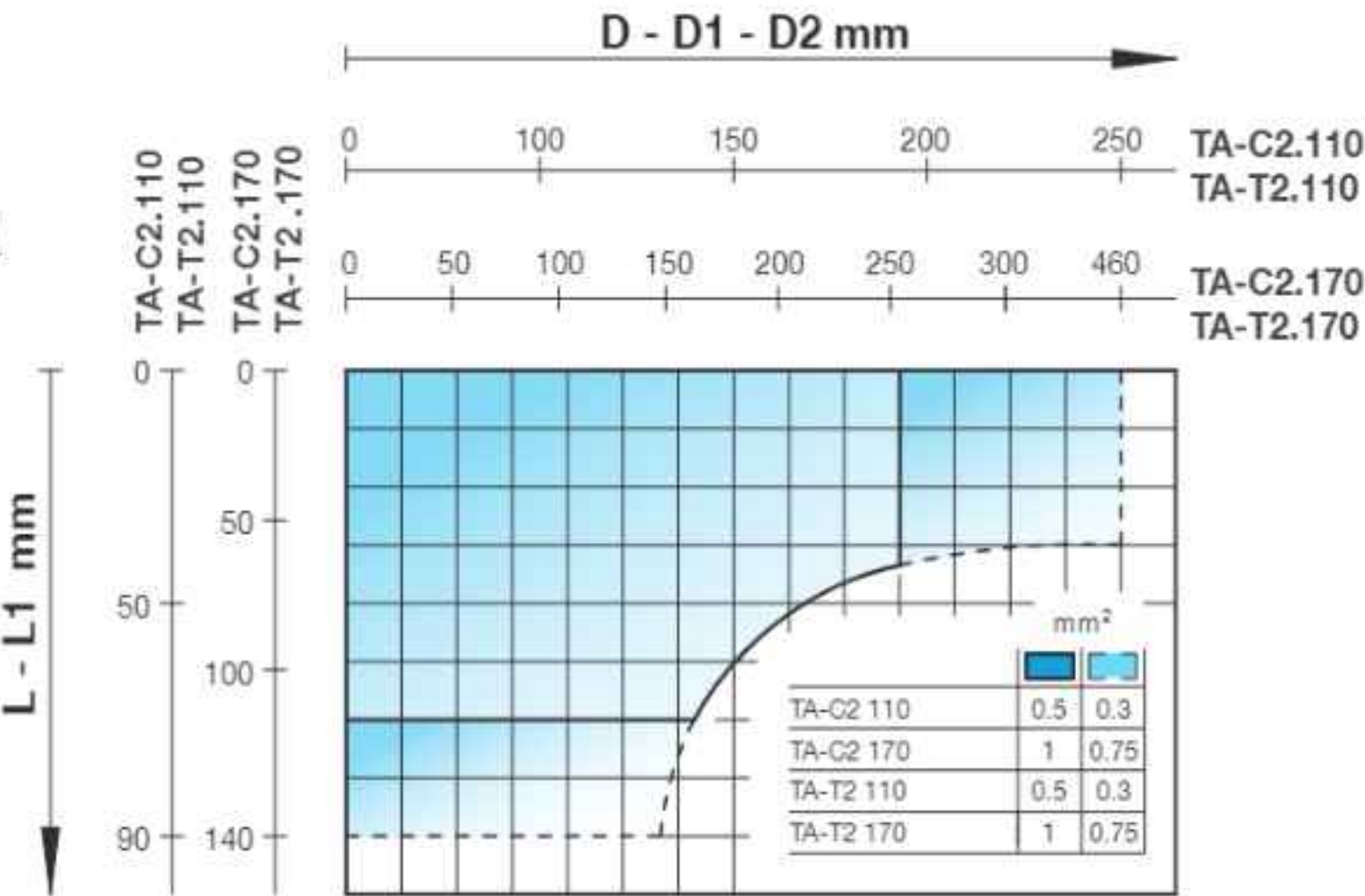
REF.	CODE	ØH7	C	D	E	F	G	Kg.		
P 130 TA-C2.110 / TA-T2.110	433040250950	16	25	95	40	37	10.5	0.5		
P 130 TA-C2.170 / TA-T2.170	433054381520	25	38	152	54	59.5	16.5	1.6		

The chip removals are indicative for normal working conditions on steels with hardness 160-200 HB, (average Ks = 2000 N/mm²) recommended Vt 120/160 m/min.
The optimal values and working times must be determined with trials.

CHIP REMOVAL CAPACITY TA-C2 / TA-T2

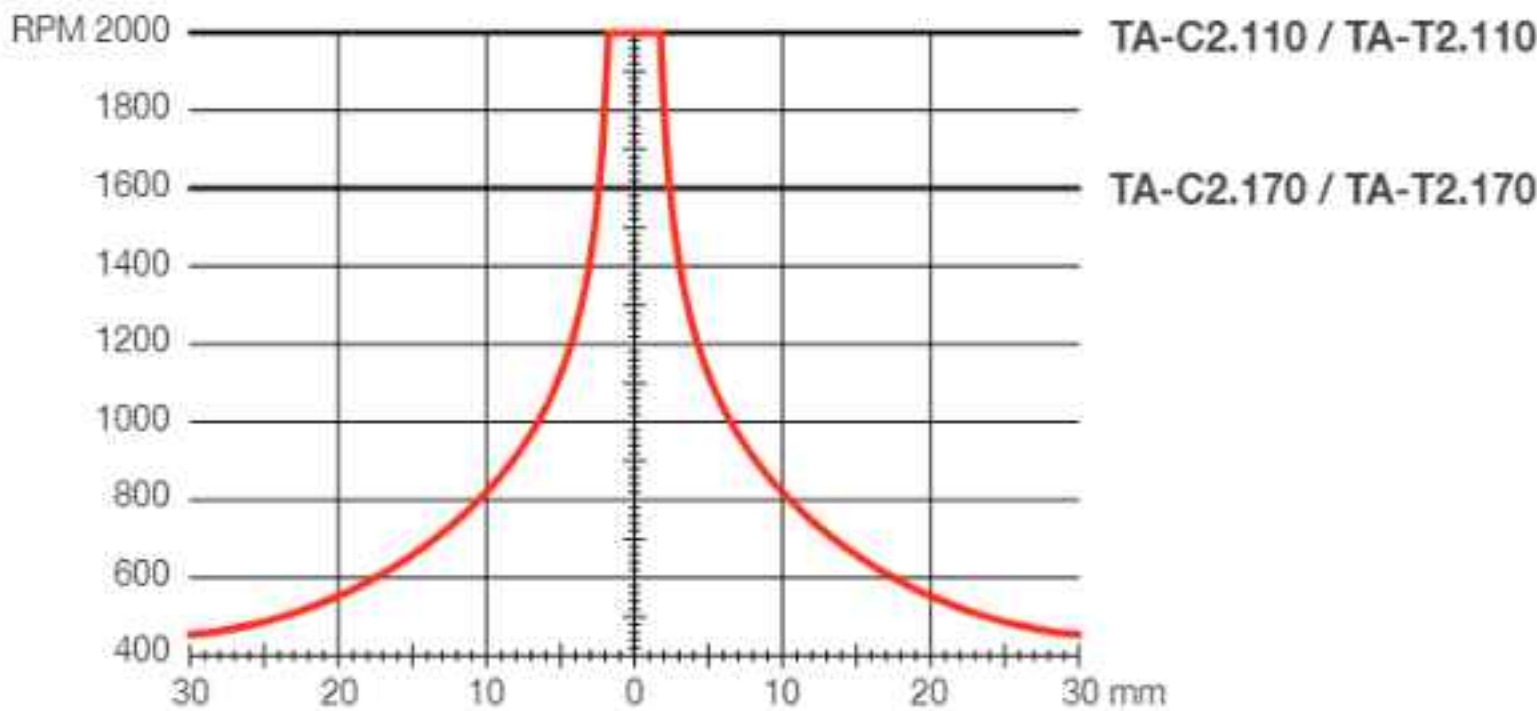


	TA-C2.110 TA-T2.110	TA-C2.170 TA-T2.170
D	10 ~ 102	20 ~ 194
L	65	100
D1	96 ~ 126	153 ~ 263
L1	90	140
D2	126 ~ 250	203 ~ 460
L2	25.5	38.5



For good TA-CENTER head operations and to protect it from damages, it is advisable to follow the chart below that indicates the **maximum rpm**, based on the slide travel.

MAX ROTATION SPEED TA-C2 / TA-T2



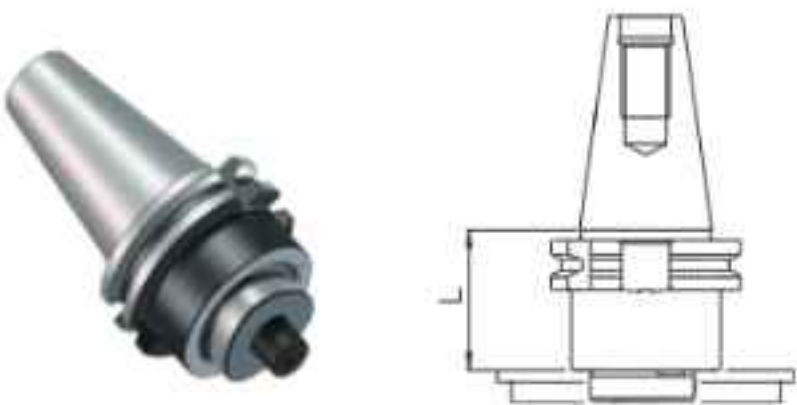
K02

For Interchangeability with previous version TA-CENTER, use **TA-C2** with mechanical ratio **R.0.5**.



REF.	CODE
K02 TA-C2.110 I.80 R. 0.25	501251100800
K02 TA-C2.110 I.80 R. 0.5	501251100801
K02 TA-C2.110 I.110 R. 0.25	501251101100
K02 TA-C2.110 I.110 R. 0.5	501251101101
K02 TA-C2.170 I.110 R. 0.25	501251701100
K02 TA-C2.170 I.110 R. 0.5	501251701101
U-DRIVE KB-KA1	

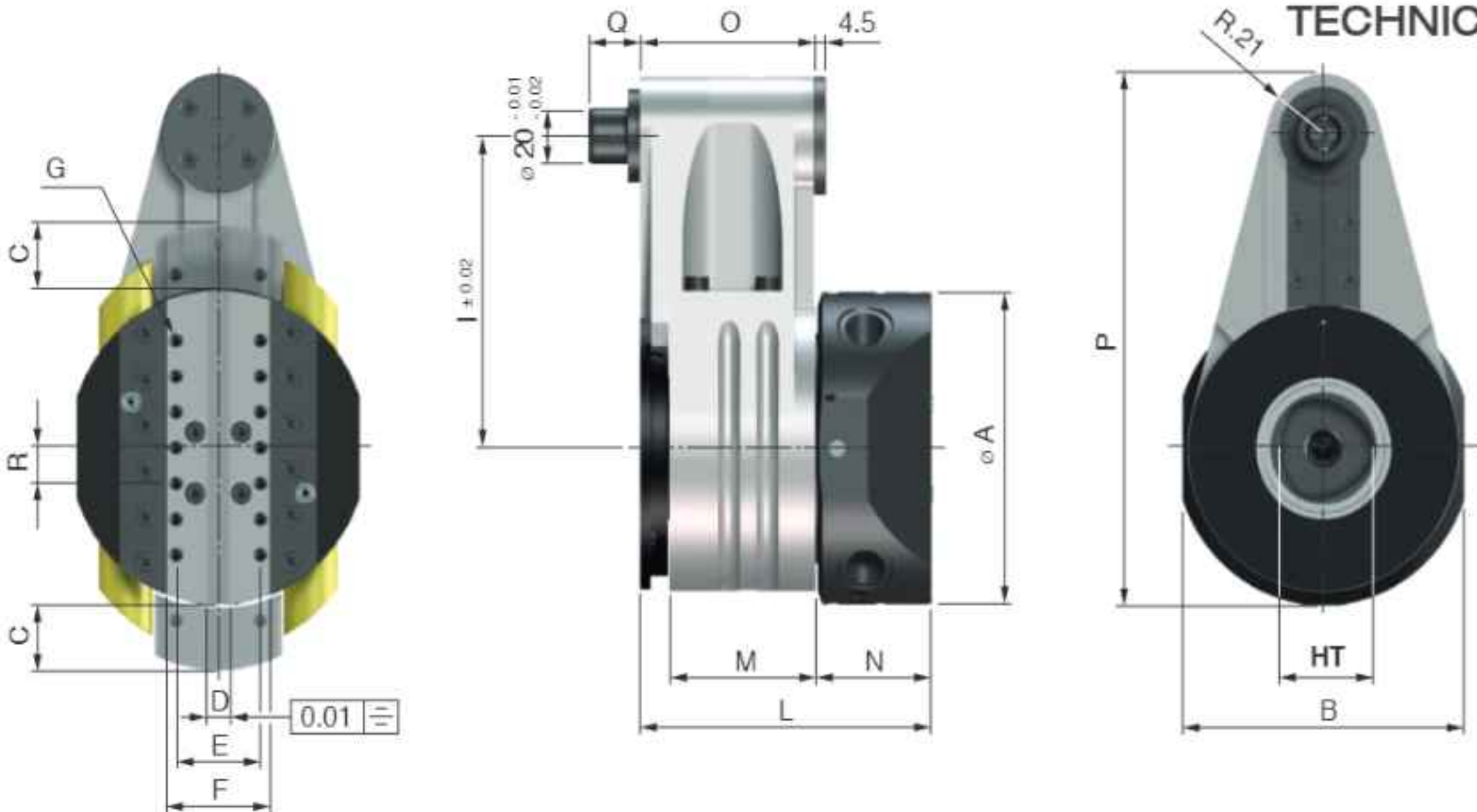
ARBORS HT



SUPPLY

TA-C2 / TA-T2

	REF.	CODE	L	X
TA-C2.110 TA-T2.110	DIN69871-A40-HT5.36.5	41HT05024000	36.5	21.5
	DIN69871-A40-HT5.44.5	41HT05024001	44.5	29.5
	MAS403 BT40-HT5.27	41HT05034000	27	12
	MAS403 BT40-HT5.36.5	41HT05034001	36.5	21.5
	MAS403 BT40-HT5.44.5	41HT05034002	44.5	29.5
	HSK-A63-HT5.54.5	41HT05046300	54.5	39.5
	ANSI/CAT40-HT5.54.5	41HT05054000	54.5	39.5
TA-C2.170 TA-T2.170	DIN69871-A50-HT8.36.5	41HT08025000	36.5	21.5
	MAS403 BT50-HT8.38.5	41HT08035000	38.5	23.5
	HSK-A100-HT8.76.5	41HT08041000	76.5	61.5
	ANSI/CAT40-HT8.50.5	41HT08055000	50.5	35.5

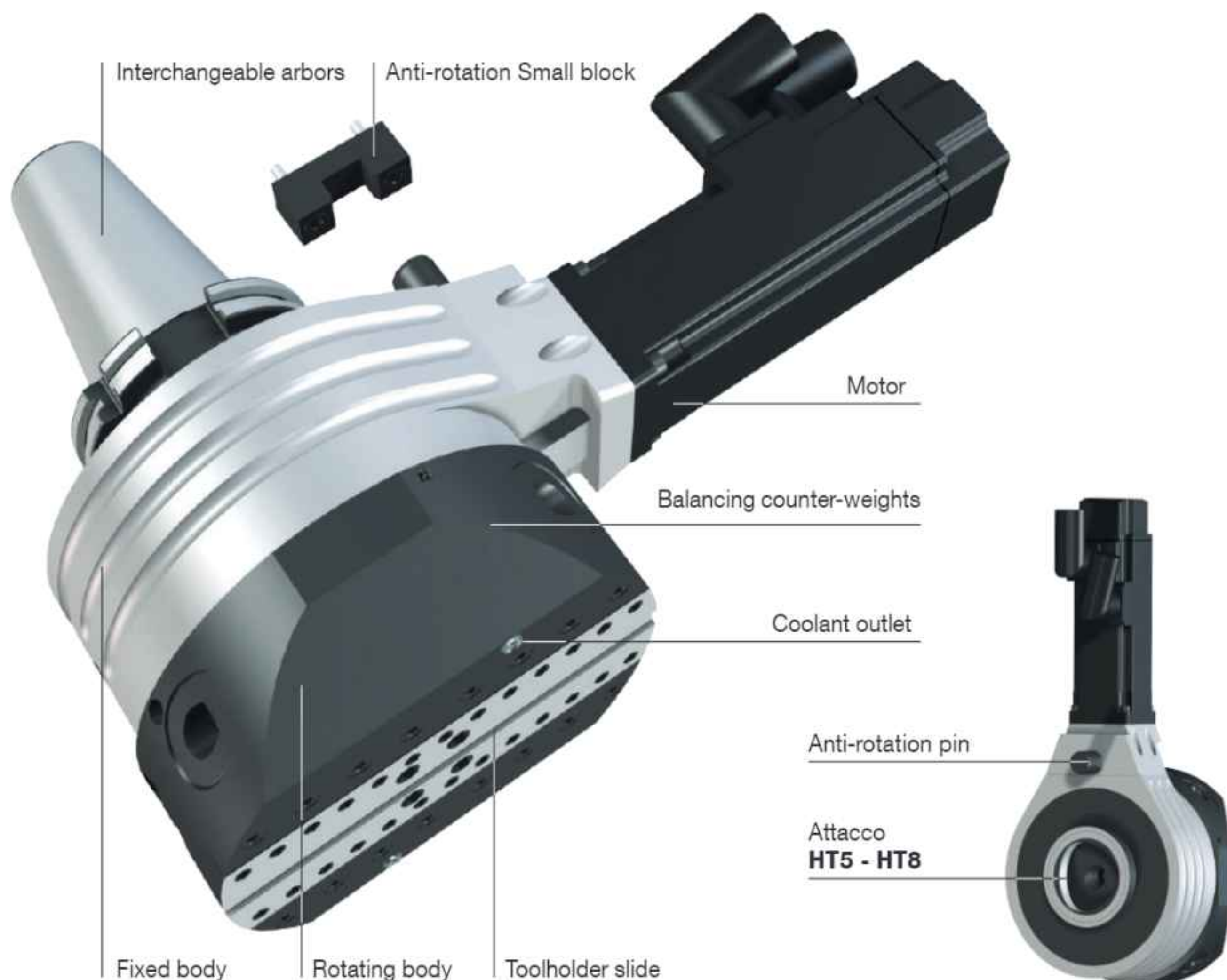


TECHNICAL DATA

TECHNICAL DATA		TA-C2.110	TA-C2.170
Ø A	mm	110	170
B	mm	104	164
C radial traverse	mm	± 15	± 30
D	mm	8 ± 0.04 ± 0.02	10 ± 0.04 ± 0.02
E	mm	31	40
F	mm	38	54
G	mm	M 4	M 5
HT	mm	HT5	HT8
I	mm	80/110	110
L	mm	108	136
M	mm	55	69
N	mm	42	56
O	mm	64.5	69
P	mm	156 / 186	216
Q	mm	19	19
R	mm	12.5	12.5
Feed	mm/min	1 ÷ 500	
Radial force	daN	150	250
Maximum speed	RPM	2000	1600
Torque	Nm	400	800
Weight without the cone	Kg	5.7	16.5
Boring accuracy		H7	
Max workable ø	mm	250	460
Max chip removal on C40 steel	mm²	0,5	1
Roughness	Ra	0.8 - 1.2	

TA-TRONIC 2 TA-T2

TA-TRONIC 2 - Boring and facing heads designed to be applied manually on small boring machines, machining centers and special machines. The integrated servomotor, connected to the CN, manages the toolholder slide movement. The stationary body is held in position by a flange or, for light operations, by a simple anti-rotation pin.



CNC

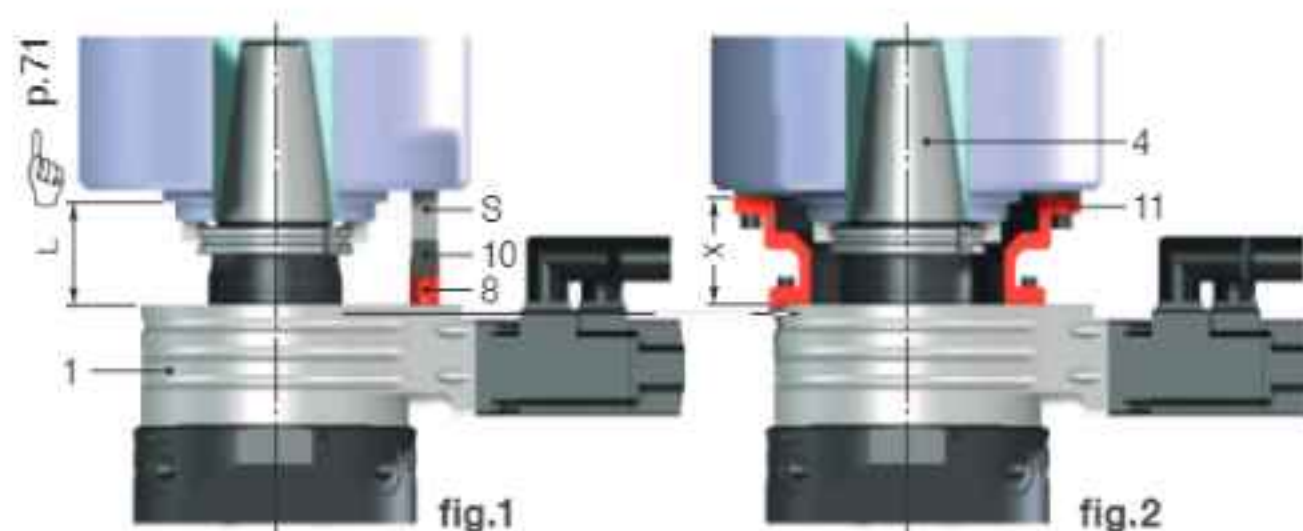
COMMAND

The control of the TA-T2 heads takes place through the direct connection to the "U" axis of the numerical control of the machine tool that allows boring, internal, external and back facing, internal and external turning, grooves, facing for serration, threads and taper bores, as well as concave and convex radius machining through interpolation with the other axes.

APPLICATION

TA-T2 is mounted on the machine using a taper (4). The anti-rotation pin (8) inserted in the stop block (10) locked on the head of the machine tool, preventing the fixed body of TA-T2 to rotate. The stop block (10) is applied on a fixed part around the spindle in relation to the dimensions of **pic.1**, adjusting the height indicated by way of a thickness **S**. For heavy machining it is advisable

to apply a flange (11) with a dimension **X** in tolerance ± 0.005 mm. To make the TA-T2 solidly connected with the head of the machine tool (**pic.2-3**) it is always advisable to use a flange with TA-T2 170. The type of flange required depends on the model of the machine and may be easily built by the Customer or supplied by D'Andrea. All data for flange application are available in the instruction manual.



Coolant supply pic.1

In the TA-T2, coolant exits from the two adjustable nozzles are located next to the slide after crossing the taper and the rotating body of the head. This noteworthy advantage ensures longer duration of the cutting edge, quicker

cutting speed and for obtaining good surface finishes. The centralized supply of coolant does not harm the TA-T2 of which the internal labyrinth protected by an O-ring. It is advisable not to exceed **50 BAR** of pressure.



Balancing pic.2

TA-TRONIC heads are designed with two counter-weights (5) for automatic balancing, that move opposite to the slide (3) allowing to machine at a higher number of rpms without noticeable oscillations.



PREARRANGEMENTS

K02



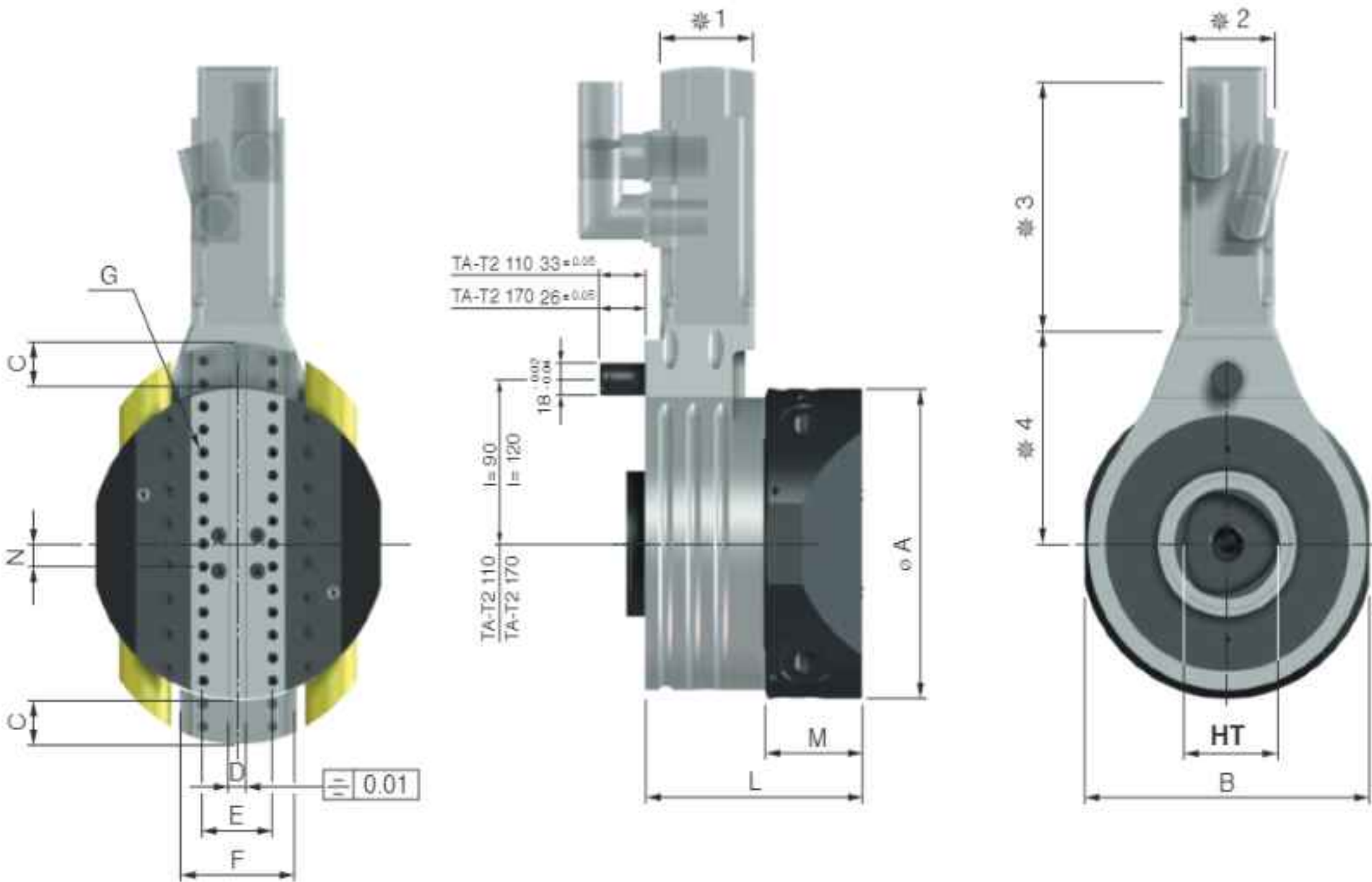
ARBORS HT / P120 - P130 see p.70-71



REF.	CODE		
K02 TA-T2.110 1FK7022-5AK74-1HA5	501201100400		
K02 TA-T2.110 FANUC β is 1/6000	501201100800		
K02 TA-T2.170 1FK7032-2AK74-1EA2	501201700400		
K02 TA-T2.170 FANUC β is 1/6000	501201700800		
FLANGE TA-T2.110 / TA-T2.170			

SUPPLY

TECHNICAL DATA



TECHNICAL DATA		TA-T2.110	TA-T2.170
Ø A	mm	110	170
B	mm	104	164
C radial traverse	mm	± 15	± 30
D	mm	8 +0.04 / -0.02	10 +0.04 / -0.02
E	mm	31	40
F	mm	M 4	M 5
G	mm	38	54
HT	mm	5	8
L	mm	108	136
M	mm	42	56
N	mm	12.5	
Feed	mm/min	1 ÷ 500	
Radial force	daN	150	250
Maximum speed	RPM	2000	1600

TECHNICAL DATA		TA-T2.110	TA-T2.170
Torque	Nm	400	800
Weight without the cone	Kg	5.3 without motor	15.8 without motor
Boring accuracy		H7	
Max workable ø	mm	200	320
Max chip removal on C40 steel	mm²	0,75	1
Roughness	Ra	0.8 - 1.2	
SIEMENS Motors Dimensions		Siemens 1FK7022	Siemens 1FK7032
✱ 1		55	72
✱ 2		55	72
✱ 3		178	173
✱ 4		90	120
FANUC Motors Dimensions		FANUC β is 1/6000	
✱ 1		60	
✱ 2		60	
✱ 3		111.5	
✱ 4		92/120	

✱ Rough measures that may vary on changing the motor

AUTORADIAL

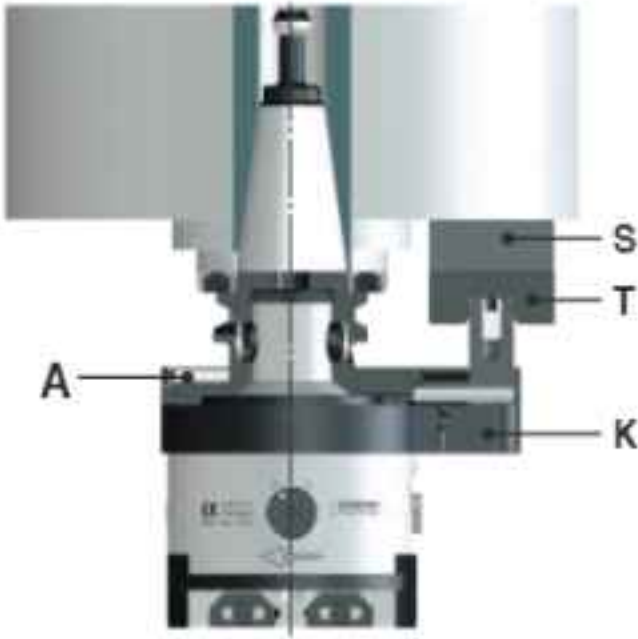
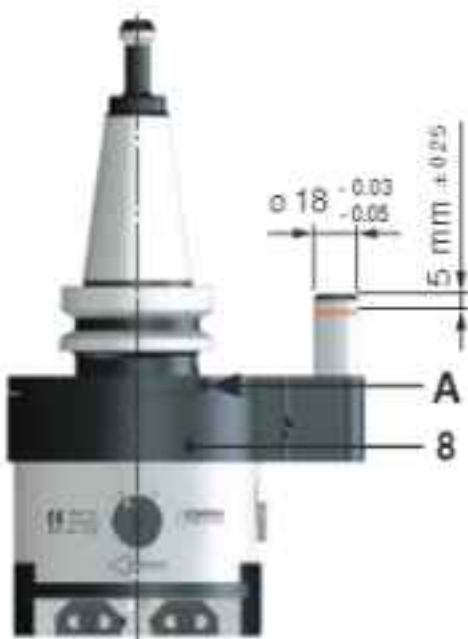
AUTORADIAL - Automatic facing heads that can be applied on machining centers and on NC machines without the need for an electronic interface or interlock.

They perform automatic working cycle without ever stopping the rotation of the spindle.
Particularly suitable for machining of seats for elastic rings and facing for serration.

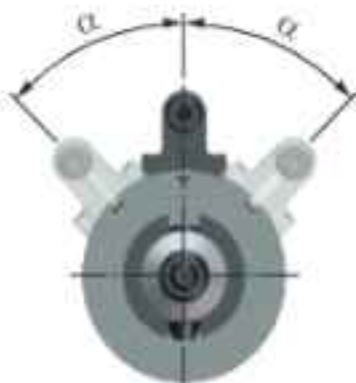


In the AUTORADIAL the slide is moved forward by holding back the drive flange (8) while the spindle is rotating.
The T-block supplied with the K-NC KIT (K) is to be applied to a fixed part around the spindle, observing the measurements indicated.

If the stroke of the check pin is not $5\text{ mm} \pm 0.25$, you must adjust the position of the T-block using the spacer S.
The angle α is freely adjustable by loosening the 3 screws (A), turning the flange (8) to the desired angle and tightening the screws (A).



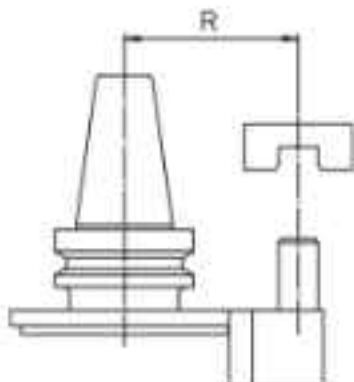
ASSEMBLY



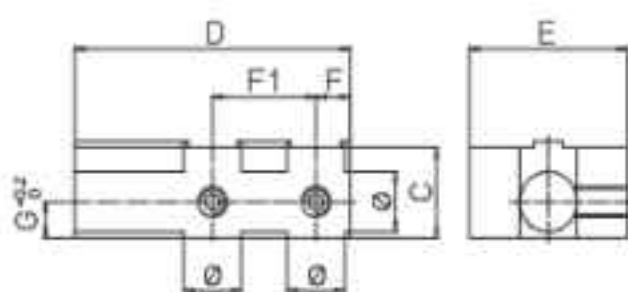
K02

SPECIAL AUTORADIALS ON REQUEST

REF.	Fmm/U	K02 AR 125 CODE	K02 AR 160 CODE
K02 AR...-F.0.05 ± 0.005	0.05	500612520050	500616020050
K02 AR...-F.0.1 ± 0.005	0.1	500612520100	500616020100
K02 AR...-F.0.2 ± 0.01	0.2	500612520200	500616020200
K02 AR...-F.0.3 ± 0.01	0.3	500612520300	500616020300
K02 AR...-F.0.4 ± 0.02	0.4	500612520400	500616020400
K02 AR...-F.0.5 ± 0.02	0.5	500612520500	500616020500
K02 AR...-F.0.6 ± 0.02	0.6	500612520600	500616020600



REF.	R.80 CODE	R.110 CODE
K-NC R...-AR125	394112508002	394112511002
K-NC R...-AR160	394116008002	394116011003



REF.	CODE	ØH7	C	D	E	F	F1	G	Kg.
AR 125 - P 110	433056381200	25	39	121	56	15	45.5	16	1.3
AR 160 - P 110	433063481600	32	49	164	63	19	63	21	2.5

MHD'



REF.	MHD' Gamma completa dei coni a pag.10
AR 125	63
AR 160	80

INTERCHANGEABLE FEEDS

F ...



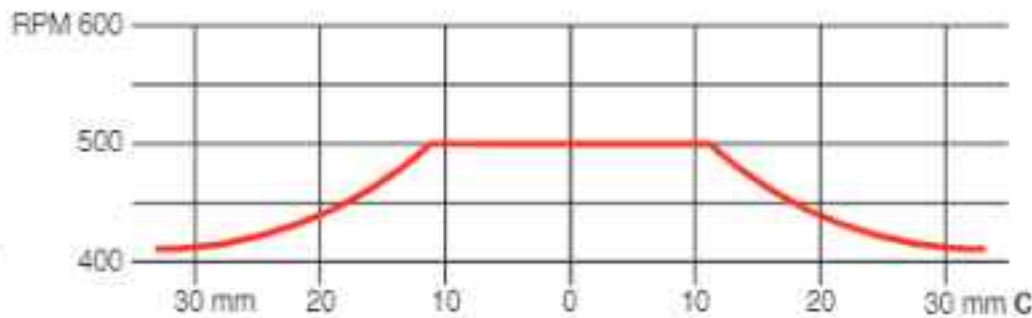
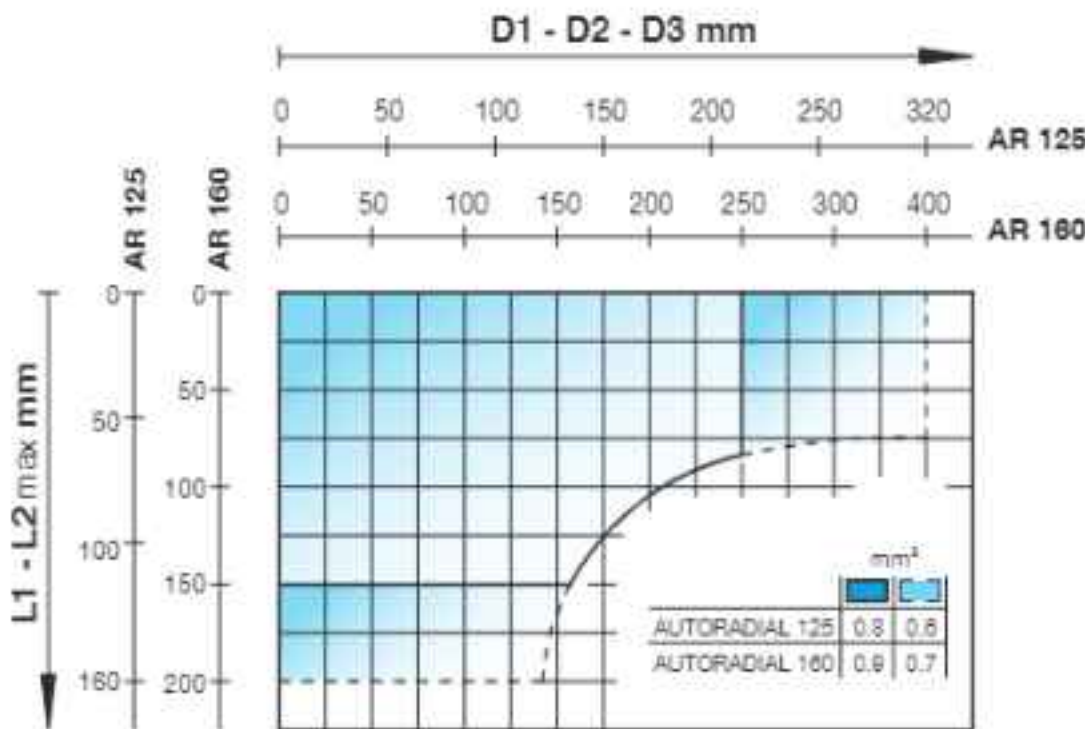
REF.	Fmm/°	K02 AR 125 CODE	K02 AR 160 CODE
F. 0.05 - AR... ± 0.005	0.05	382006105001	382006205001
F. 0.1 - AR... ± 0.005	0.1	382006110001	382006210001
F. 0.2 - AR... ± 0.01	0.2	382006120001	382006220001
F. 0.3 - AR... ± 0.01	0.3	382006130001	382006230001
F. 0.4 - AR... ± 0.02	0.4	382006140001	382006240001
F. 0.5 - AR... ± 0.02	0.5	382006150001	382006250001
F. 0.6 - AR... ± 0.02	0.6	382006160001	382006260001

CHIP REMOVAL CAPACITY - MAX ROTATION SPEED

The chip removals are indicative for normal working conditions on steels with hardness 160-200 HB, (average Ks = 2000 N/mm2) recommended Vt 120/160 m/min.
The optimal values and working times must be determined with trials.

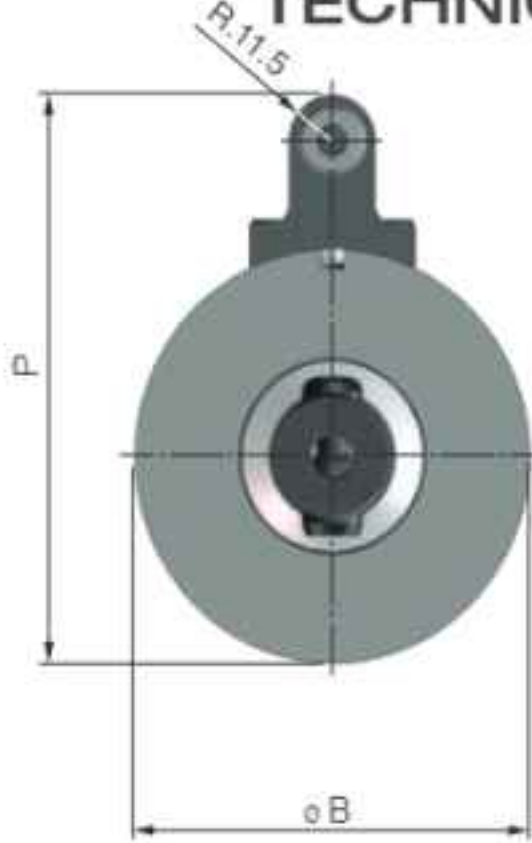
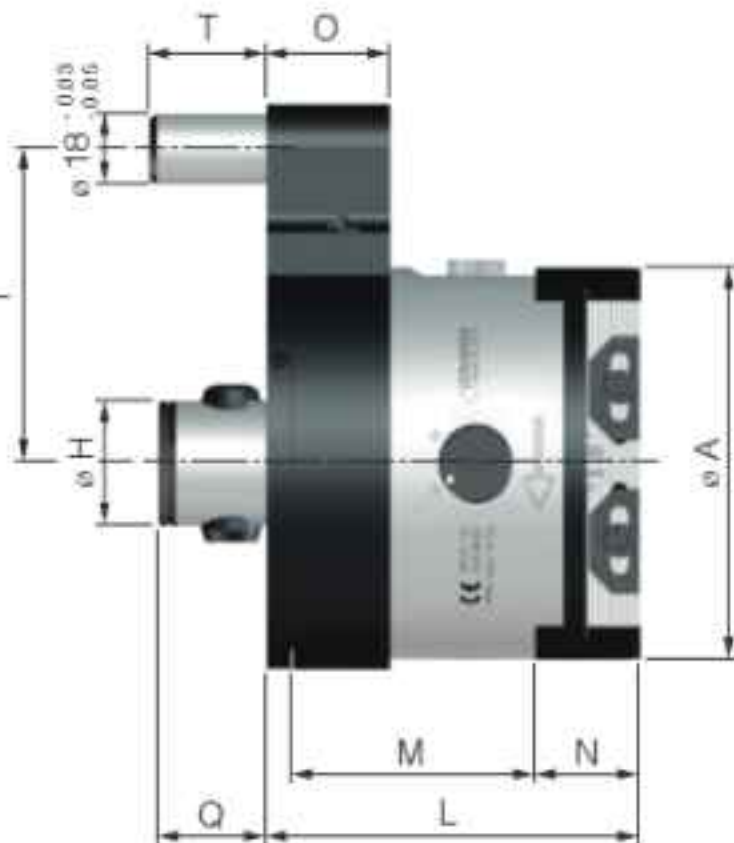
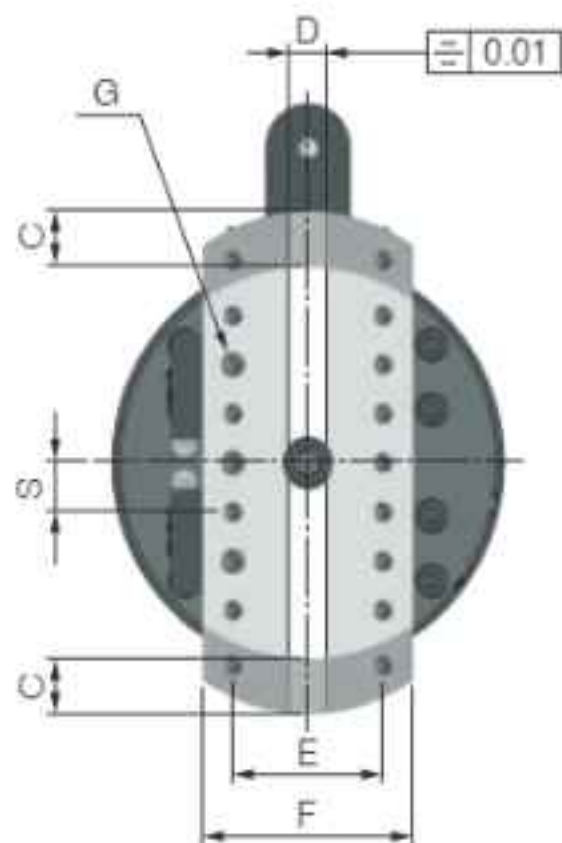


	AR 125	AR 160
F	25	32
D1 max	99	144
L1	160	200
D2 max	190	270
L2	160	200
D3 max	320	400
L3	40	50



For good AUTORADIAL head operations and to protect it from damages, it is advisable to follow the chart below that indicates the **maximum rpm**, based on the travel of the slide.

TECHNICAL DATA



TECHNICAL DATA	AR 125	AR 160
Ø A	mm 125	mm 160
Ø B	mm 130	mm 130
C radial traverse	mm ± 20	mm ± 35
D	mm 10 ^{+0.03} ₀	mm 12 ^{+0.03} ₀
E	mm 40	mm 50
F	mm 63 ^{-0.003} _{-0.007}	mm 80 ^{-0.003} _{-0.007}
G	mm M5	mm M6
Ø H	mm (MHD'63) 42 ^{-0.005} _{-0.008}	mm (MHD'63) 42 ^{-0.005} _{-0.008}
I	mm 80/110	mm 80/110
L	mm 110	mm 125

TECHNICAL DATA	AR 125	AR 160
M	mm 75	mm 83
N	mm 28	mm 35
O	mm 35	mm 35
P	mm 156.5 / 186.5	mm 171.5 / 201.5
Q	mm 38.5	mm 44.5
S	mm 12.5	mm 15
T	mm 39.5	mm 45.5
Maximum speed	RPM 500	RPM 400
Weight without the cone	Kg 9	Kg 14
Quick return	mm/° 0.8	mm/° 0.8

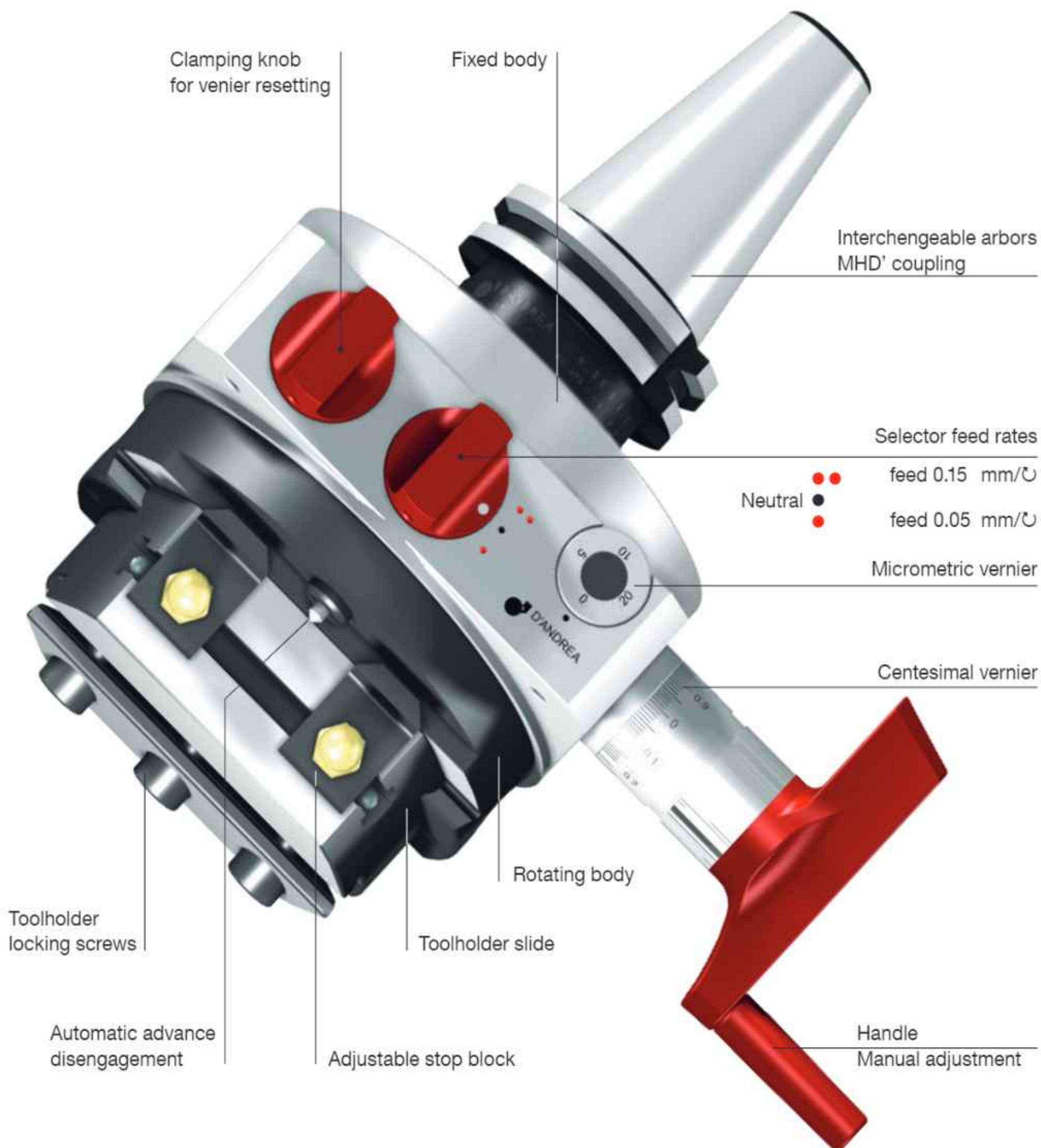
FACING AND BORING HEADS

TA-SENSITIV 2 - Boring and facing heads, applicable to milling, boring and radial drills with possibility of manual adjustments during **machine stops** and automatic feeds during the revolution of the machine spindle.

It's possible to carry out external and internal facing operations, backward operations, cylindrical and conical borings, internal and external grooves, turnings and chamfers.

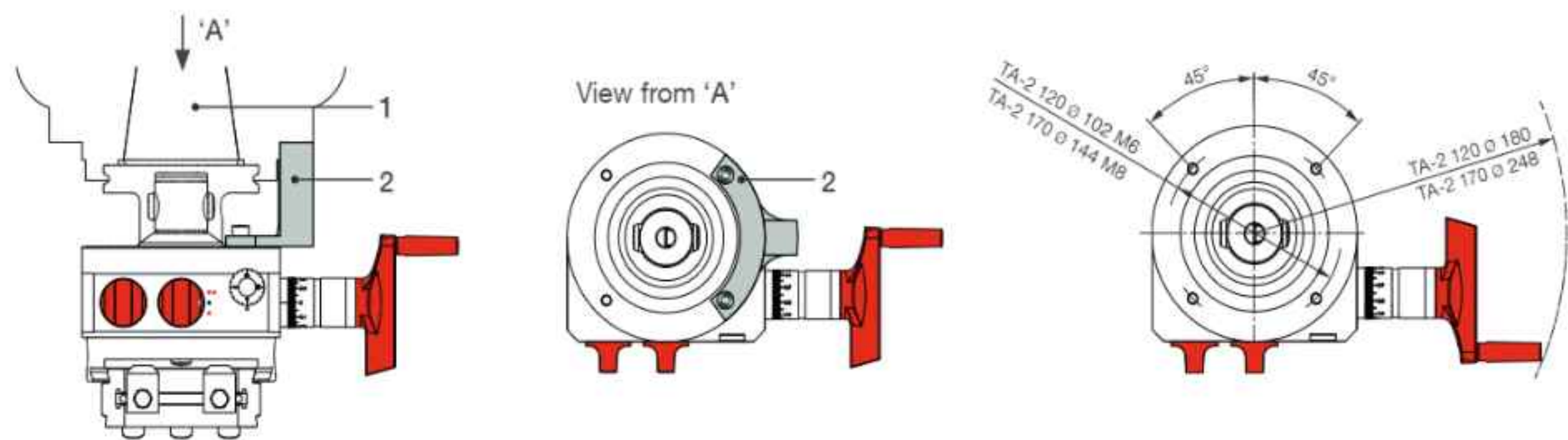
The arbor is interchangeable and, thanks to the MHD' adapter, it allows the use of all available arbors from the MHD' modular system.

TA-S2.120 max Ø 250 **TA-S2.170** max Ø 400



APPLICATION

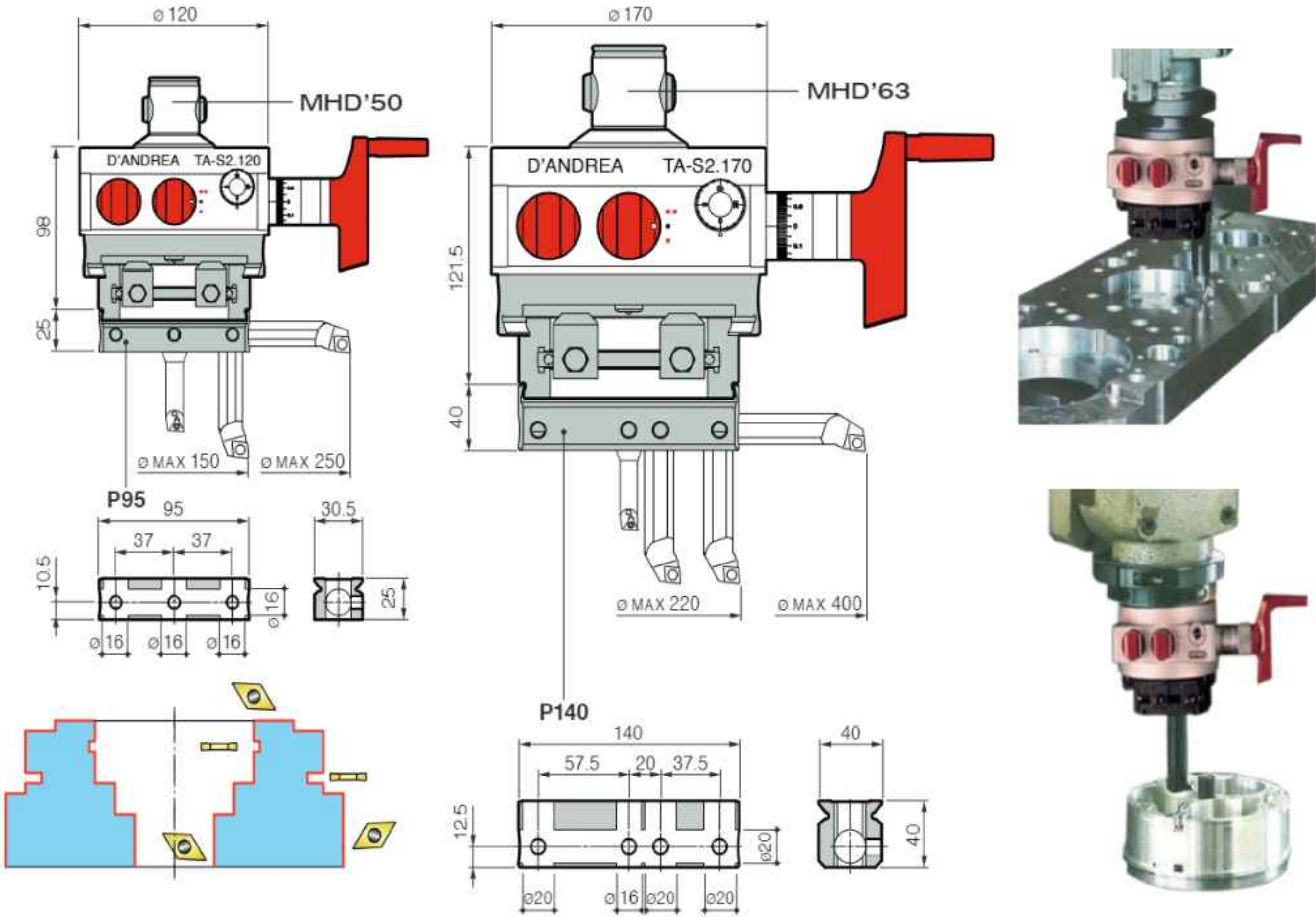
The TA-S2 heads can be applied to the machine tools through the driving arbor (1) and an anti-rotation stop block (2). For heavy machining it is recommended to apply a flange.



TECHNICAL DATA

TA-S2.120	TECHNICAL DATA			TA-S2.170
250	Max workable ø	mm		400
40	C radial traverse	mm		60
1000	Maximum speed	RPM		800
6.5	Net weight	Kg		19
400	Torque	Nm		800
2 - 6	Motor Power	Kw		3.5 - 11

REF.	CODE	Kg		
K02 TA-S2.120	500212031001	5,8		
P95 TA-S2.120	433030300951	0,4		
K02 TA-S2.170	500217031001	14		
P140 TA-S2.170	433040401401	1		



On the dovetail slide, in addition to the P95 - P140 universal toolholder for boring and facing, a wide range of toolholders of the Testarossa TRM 63/80 and TRM 80/125 heads are applicable.

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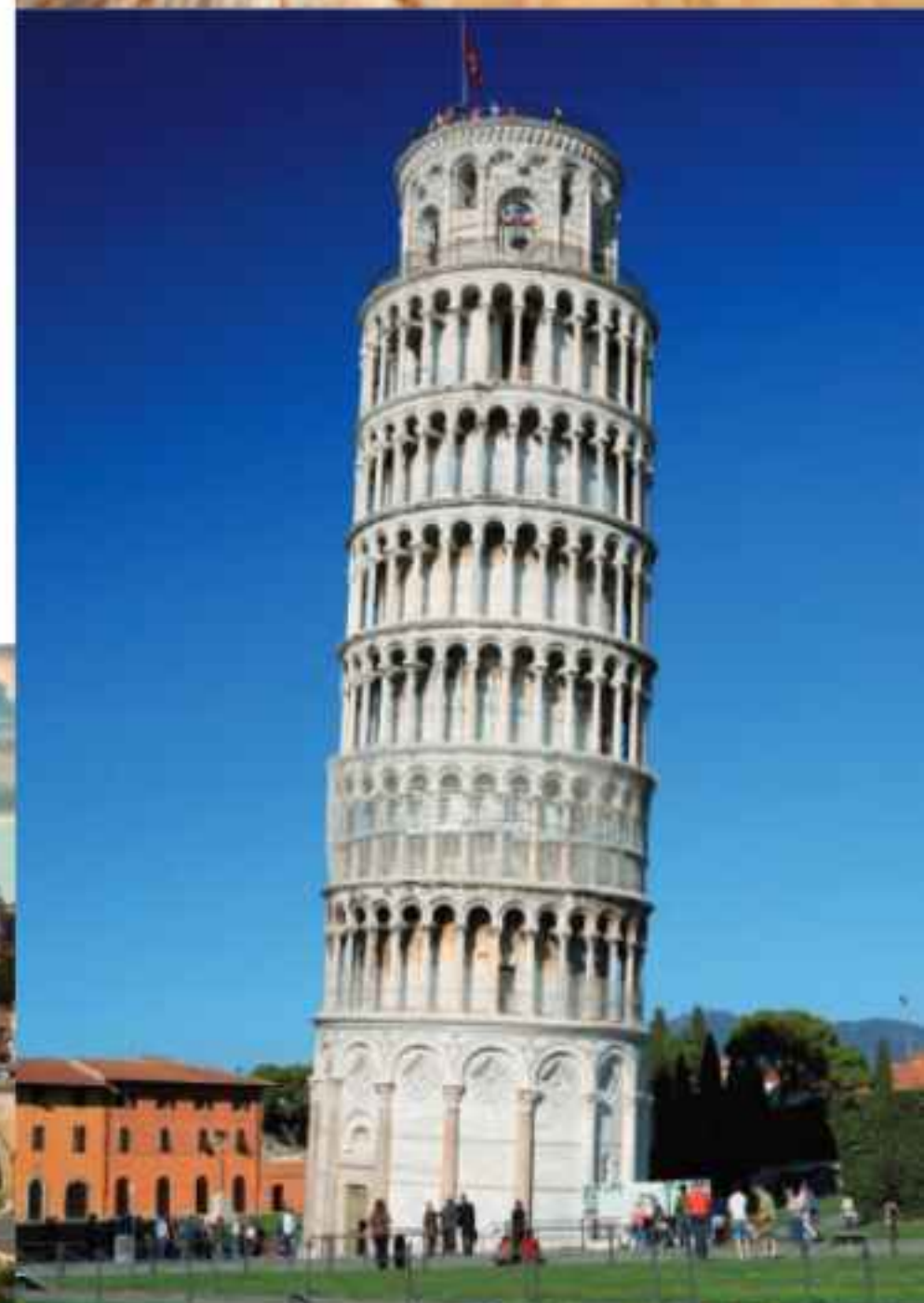
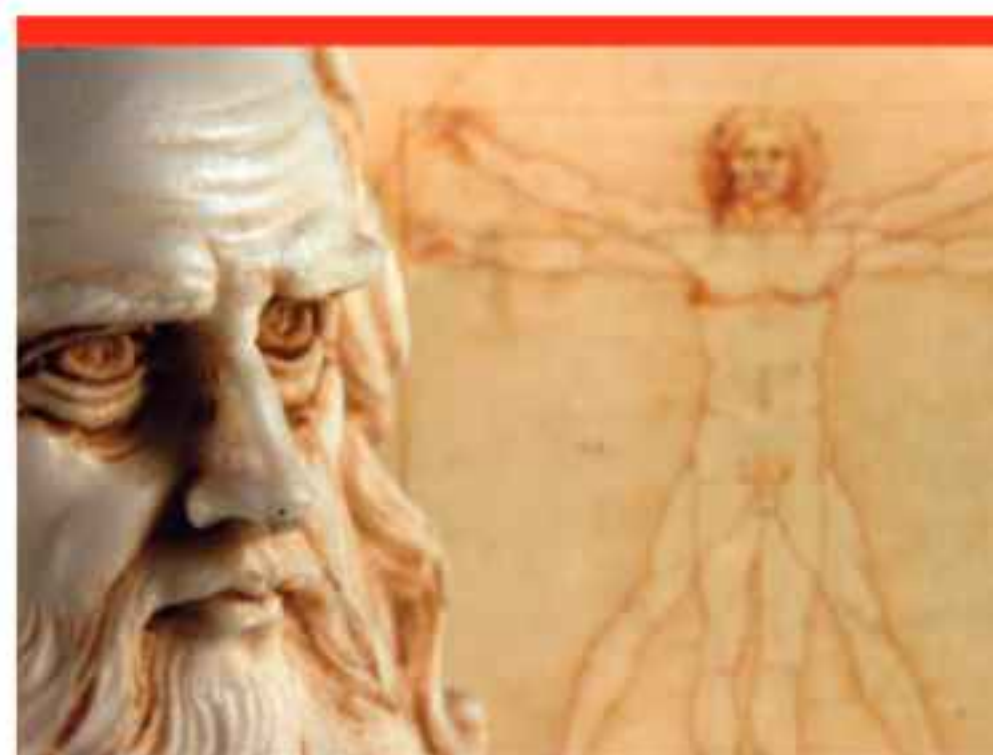
D'ANDREA Molise
Castel del Giudice - Isernia

 *made in italy*



You will be welcome in Italy
Wir warten auf euch in Italien
Os esperamos en Italia
Nous vous attendons en Italie
Vi aspettiamo in Italia

Ennio D'Andrea



D'ANDREA IN ITALY AND WORLDWIDE



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The technical data shown in this catalogue are not binding and they can be modified also without notice.

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