

How To Use This Catalog

Welcome To The RSVP Tooling Interactive Catalog Section

Clickable & Touch Links

Within each page we have included a wide range of links that can be click when viewed on a computer or touched on a smart device (phones and pads).

The side tabs to the left when click will return you to the section index.

On the master index and section indexes the line items also contain links to the indicated pages.

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Downloading this catalog to a smart device - phones or pads

This catalog can be viewed on smart devices such as phones and pads. Most free PDF viewers will allow you to flip from page to page.

However, if you would like to take advantage of the built in interactive features you will need to download an app.



We have reviewed many apps and have found that "ezPDF Reader" seems to work the best on both the Apple and Droid product lines. It is available in two forms - one for the pads and one for the phones.

Icon Links



Click this icon to follow and like RSVP Tooling on FaceBook. Get the most up-to-date information on products, training, videos and products for your smart devices.



Click this icon to follow our short RSVP tweets. Quick tips and helpful links to increase your threading quality and productivity.



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Click this icon to visit our video channel. When this icon is next to a product you can directly link to a demonstration video.



Click this icon to quickly access our extensive knowledge base within the RSVP Tooling website.



This icon is not active within this PDF.



Click this icon to return to the section index for that product or page.

Start by going to your apps download center on your device. Search for "ezPDF Reader" and look for the above icon. Purchase the app that matches your device (at the time this catalog was created ezPDF reader was selling for \$2.99). Download and activate the app.

To download the RSVP Tooling Catalog follow the "ezPDF Reader" instructions to download a file from the internet to the app. On the home screen of "ezPDF Reader" select "URL Download" and enter the following URL - "http://www.rsvptooling.com/RSVPcatalog.pdf". Once the catalog is loaded to "ezPDF Reader" you can start using the interactive features.

Specialty Tools Index

Specialty Tools

RSVP Tooling offers a comprehensive selection of support and second operation tooling includes quick change holders, internal recessing heads, external knurl, and marking and marking holders as well as external high capacity turning and broaching heads. This complement of specialty tools in conjunction with our standard products afford us the ability to provide our customers with complete tooling solutions to virtually any component design.

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Rollerbox



Form Knurling



Flow-Thru Tap Driver



Spline Rolling



Marking



Accu-Screw



Broaching



Cut Knurling

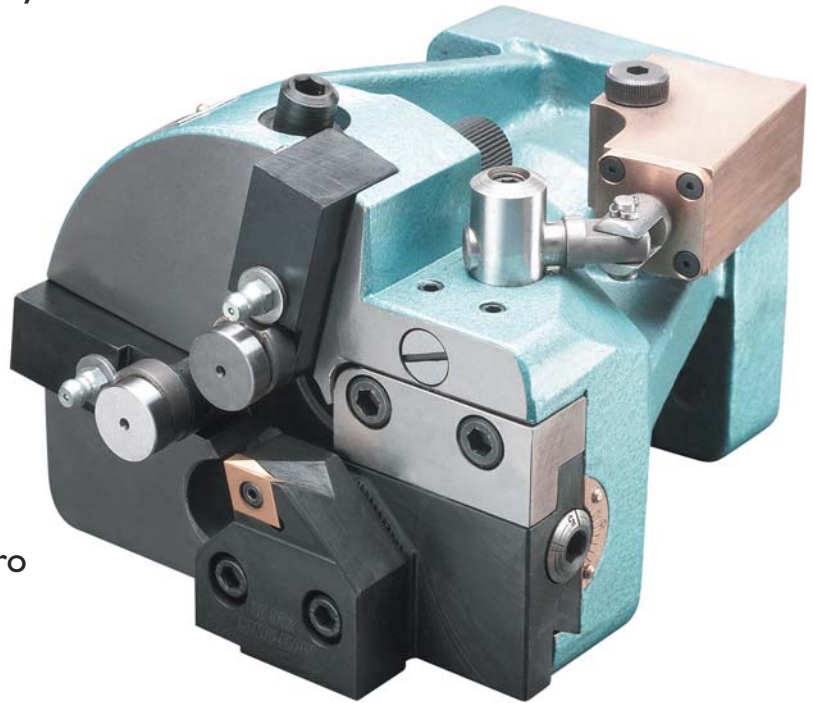


Broaching



Rollerbox

- Our Rollerbox tooling has a capacity from .0625 to 2.0 over 5 different style heads.
- All our Rollerbox tools feature an auto-retraction which leaves the machined part burnished by the supporting rollers.
- Integral tipholders can hold a variety of cutting geometry's for virtually any material making the tools extremely versatile. The micro adjustment of the cutting insert makes it easy to setup and 100% repeatable.
- We carry in stock a wide range of metric and inch shanks.
- An ideal tool for pre-turning your blank diameter prior to thread rolling to a 2 micron finish.
- Turns long parts down quickly and accurately in one pass.



Most Popular Rollerbox Head Specifications

Our Rollerbox turning system is the most effective means of producing accurate, true and parallel diameters with maximum repeatability.

AR/00M Rollerbox:

The smallest Rollerbox in the range, but with all the functions as the bigger heads; auto-retraction, integral tipholder capable of holding indexable inserts with a variety cutting geometrics, micro adjustment of size and a range of metric and imperial shank sizes.

Suitable for a variety of single and multi-spindle autos and small C.N.C lathes.

Capacity: Metric: 1.5mm-10mm
Imperial: 1/16" - 3/8"

Shank Diameters: 16 mm, 20mm, 25mm and
5/8", 3/4" and 1"

AR/T0 Rollerbox:

Slightly larger Rollerbox with more capacity, but offering the same facilities of auto-retraction integral tipholder taking triangular or rhomboidal inserts with a variety of cutting geometrics, micro-adjustment of size and a range of metric and imperial shank sizes.

Suitable of small diameter turning CNC lathes. Mainly used a single and multi-spindle autos and CNC.

Capacity: Metric: 3mm-14.5mm
Imperial: 1/8" - 9/16"

Shank Diameters: 16mm, 20mm, 25mm and
5/8", 3/4", 1"

AR/T9 Rollerbox:

The most popular and versatile mid-range Rollerbox offering integral tipholders to suit both the triangular or rhomboidal shaped indexable inserts, along with auto-retraction, micro adjustment of size and a range of metric and imperial shank sizes.

Extensively used on a variety of small automated and conventional capstan lathes and small CNC machines also single and multi-spindle autos including:

Capacity: Metric: 4mm - 19mm
Imperial: 13/64" - 15/16"

Shank Diameters: 20.25.32.40.50 mm and 3/4",
1", 1-1/4", 1-1/2", 1-3/4", 2",
and 2-1/8"

Other Rollerbox styles and sizes available

Various styles of inserts are available to suit different cutting conditions including a range of grades. Check our web page for set-up and trouble shooting guides.

Rollerbox Trouble Shooting Guide

Problem	Possible Cures
Insert “Rubs Away” Low quantity of components	Check grade for material spindle speed to high — feed rate to low.
Insert Breaks	Check grade for material spindle speed to low — feed rate to high.
Insert Craters	Check grade for material combination of either spindle speed to high or feed rate to low.
Chipstream style will not produce coil turning	Spindle speed to high — feed rate to low
Tool withdraw marks with auto retract set correctly	Insert set below centerline
Rollerbox will not repeat turned diameters	Side roller incorrectly set (side roller controls side more than top roller) Insufficient pressure on roller. Check heel of retraction arm is seated in cutting position. Support screw “J” has not been adjusted (heel of retraction arm and support screw should be adjusted correctly) particles of swarf trapped under retraction arm heel (regularly strip and clean by removing hinge pin when turning nonferrous material).
Lump or false cut on start of turned diameter	Bar stock was not pre-chamfered (30-45 degrees) down to minimum finished turned diameter prior to roller boxing to provide a lead on for the turn — this operation is usually preformed at the part-off stage of the previous component or before the roller box operation <u>THIS PRE-OP IS MOST CRITICAL.</u>
Chatter marks at end of cut or under head of turn	Too long a “Dwell” at end of cut.

Rollerbox Auto-Retract Setup Guide

1. Auto Retract Rollerbox Only

Before setting - tighten by hand knurled retraction adjusting screw so that there is no movement of the retraction arm. After setting to size required release knurled retraction adjusting screw to give no more than .010" movement of tool block and lock.

Do not adjust retraction arm support set screw located at rear of retraction arm.

Do not allow auto-retract boxes to dwell at the end of the cut when used on hand operated capstans. Automatic traverse must be used for full length of turn until cutting tool has retracted.

2. The integral tip holder allows the indexable throwaway tip to be accurately set on the headstock spindle center line.

3. When the setting datum edges of both tip holder and toolblock are flush, the cutting edge of the tip is on box tool center line.

4. Certify the true relationship of the turret bore center line to head-stock spindle center line on machine or machines to be used by measuring from machine bed over a pair of test bars.

5. To establish tip cutting edge on headstock spindle center line, simply separate datum edges in the appropriate direction by the amount calculated above using a depth micrometer (usually tip holder moves in an upwards direction).

6. The tip can be indexed without having to disturb the carrier assembly when cutting minimum diameters.

7. The cutting edge of the tip is always set at a pre-determined distance in front of the rollers and it is necessary only to adjust the roller carriers and toolblock to cut the required diameter.

8. These tools are intended to remove the maximum amount of metal quickly. Use speeds below with .004" to .012" feed.

Tangiloy Grade	Alloy Steel	Austinitic Steel	Cast STL Free Cut St.	Mal Iron Cast	Bronze Cast Brass
BT30	180-400	130-220	240-480		
BT60	120-150	90-130	130-270		
BT2		90-180		165-220	350-500

Spline Rolling Head - “RS” Series

Synchronized Spline Rolling Head

The “E”Series heads operate in a way similar to a three jaw chuck, but use an adjustment mechanism that is much more precise and repeatable. The three dies are adjusted with a single adjustment, and locked in position (the die slides do not open during the rolling cycle). If required, the slides can easily be adjusted individually.

To prevent mis-tracking, a springloaded shaft holds a synchronizing gear in position between the dies. When rolling, the gear is pushed ahead of the part and into the rolling head. When the correct depth is reached, the part is retracted and the gear follows the part (under spring pressure) back into position, to re-synchronize the rolls

Available In Two Sizes:

- The 150E measure 4” diameter, and extends 3” from the turret mounting face.
- The 200E measures 4.5” diameter, and extends 3” from the turret mounting face.
- Standard mounting shanks run from 3/4” to 1-1/2” diameter, in 1/4” increments, and measure 3” long.



Broaching Heads

Broaching Head Code 265

Capacity 1.5mm - 6mm (.50" - 1/4")

A broaching head designed primarily to produce hexagonal holes without stopping the spindle.

This is the smallest of the range designed to suit the smaller auto or CNC lathe - available in 5/8" or 16mm shanks.



Broaching Head Code 275

Capacity 2mm - 10mm (5/64" - 3/8")

This head is designed primarily for producing hexagonal holes. A micro screw is provided to set the cutting bit on the machine center line. The inner shaft is mounted on sealed ball races for precision and long life. Right hand and left hand rotation is possible to produce a component. The cutting bits can be rapidly replaced and are available in a range of both metric and imperial sizes. Various shank sizes are available.

Metric: 16 - 20 - 25

Imperial: 5/8" - 3/4" - 1"



Broaching Head Code 295

Capacity 8mm - 19mm (5/16" - 3/4")

A larger version of Code 275 but with increased capacity. All technical features remain the same. Various shank sizes are available.

Metric: 20 - 25 - 32

Imperial: 3/4" - 1" - 1-1/4"



Broaching Head Code 1500

The external broaching head has been developed to produce primarily hexagonal forms on turned parts during the turning cycle on capstans, autos, CNC lathes, etc.

Recommended feed rate 0.0015"-0.002" per revolution. Spindle speeds 885-1500 rpm pre-turn bar by 0.010"-0.015" below A/C dimension minimum. Chamfer to A/F diameter minimum.

At present for use on mechanical feed type machines only. Depending on material and work holding facilities, designed to produce 3mm-16mm (1/8"-5/8") A/F hexagon with length of flats 1.5 X A/F max. It is also possible to produce squares with limited application. The external broaching head complements the internal head and is available with various shank diameters, including VDI.



For further information please contact our sales office.

Broaching Heads

Broaching Head Code 1600

External Broach Diameter 20mm

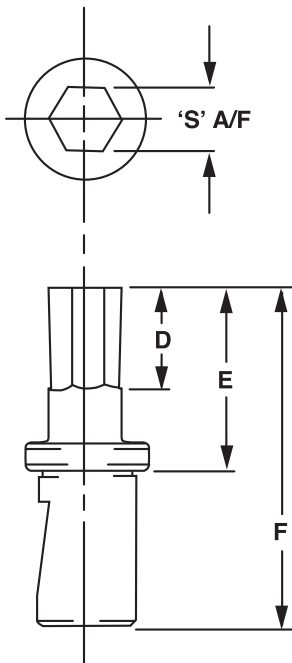
Internal Capacity 1.5mm - 10mm (0.05 - 3/8")

This universal model offers the versatility of being both an internal and external head, easily converted from one to the other with the exchange of operating shafts code 1602 and 1612. Various shank sizes available.

Metric: 16 - 20 - 25

Imperial: 5/8" - 3/4" - 1"

Standard Broach Bit Dimensions



8mm Shank

Code No.	NOM. AF. Size	To Cut AF. Size	'S' AF.	'D'
283-2	2	2.02/2.11	2.06/2.11	3.0/4.0
283-2.5	2.5	2.52/2.61	2.56/2.61	3.8/4.8
283-3	3	3.02/3.77	3.06/3.11	4.5/5.5
283-4	4	4.03/4.15	4.09/4.15	6.0/7.0
283-5	5	5.01/5.15	5.09/5.15	7.5/8.5
283-6	6	6.03/6.15	6.09/6.15	9.0/10.0
283-8	8	8.04/8.19	8.12/8.19	12.0/13.0
284-5/64	5/64	.0781/.0791	.0783/.0790	3.0/4.0
284-3/32	3/32	.0937/.0952	.0940/.0950	3.8/4.8
284-1/8	1/8	.1250/.1270	.1258/1268	4.8/5.8
284-5/32	5/32	.1562/.1587	.1572/.1586	6.0/7.0
284-3/16	3/16	.1875/.1900	.1885/1898	7.2/8.2
284-7/32	7/32	.2187/.2217	.2197/.2213	8.3/9.3
284-1/4	1/4	.2500/.2530	.2512/.2526	9.5/10.5
284-9/32	9/32	.2812/.2840	.2822/.2836	10.7/11.7
284-5/16	5/16	.3125/.3160	.3138/.3156	12.0/13.0

12mm Shank

Code No.	NOM. AF. Size	To Cut AF. Size	'S' AF.	'D'	'E'	'F'
296-8	8	8.19/8.04	8.18/8.11	12.5/13.5	25.25/25.0	42.5/42.0
296-10	10	10.19/10.04	10.18/10.11	15.5/16.5	25.25/25.0	42.5/42.0
296-12	12	12.23/12.05	12.21/12.14	18.5/19.5	25.25/25.0	42.5/42.0
296-14	14	14.23/14.05	14.21/14.14	21.5/22.5	25.25/25.0	42.5/42.0
296-17	17	17.23/17.05	17.21/17.14	21.5/22.5	32.25/32.0	52.5/52.0
296-19	19	19.27/19.07	19.25/19.16	21.5/22.5	32.25/32.0	52.5/52.0
297-5/16	5/16	.3160/.3125	.3156/.3138	12.5/13.5	25.25/25.0	42.5/42.0
297-3/8	3/8	.3790/.3750	.3786/.3768	15.0/16.0	25.25/25.0	42.5/42.0
297-1/2	1/2	.5050/.5000	.5042/.5020	19.5/20.5	25.25/25.0	42.5/42.0
297-9/16	9/16	.5680/.5625	.5672/.5650	22.0/23.0	25.25/25.0	42.5/42.0
297-5/8	5/8	.6310/.6250	.6302/.6275	22.0/23.0	32.25/32.0	52.5/52.0
297-3/4	3/4	.7570/.7500	.7562/.7525	22.0/23.0	32.25/32.0	52.5/52.0

We also produce square broaches and special dimensions to customer requirements.



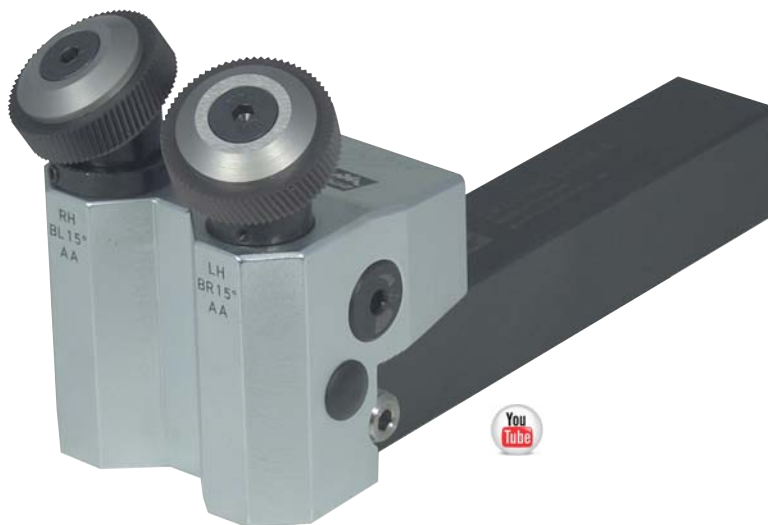
Zeus Cut Knurling Tools

Knurling without pressure and force.



Unbeatable benefits:

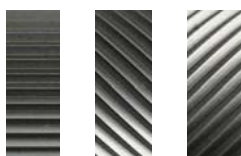
- **Flexible use** for shanks 20 and 25 through vertical adjustment mechanism.
- **High precision** for excellent knurling profiles
- **Modular tool system** for left and right hand orientation with easy tool conversion.
- **Fast and easy head orientation** reduces setting time.
- **Easy tool handling** and adjustment of work piece diameter.
- **Rigid tool design** offers high process safety and excellent knurling quality. Gear tooth system between tool holder and cut knurling head for a steady vibration free process
- **Knurling wheel options:** PVD coatings for increased wheel life
- **Special surface hardening** of the tool shank for increased tool life (nitriding)



**Best Example:
Zeus RF2-A**

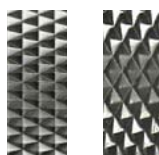
Tool Series:

RF1



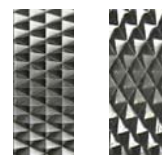
Knurling profiles:
RAA / RBL / RBR

RF2



Knurling profiles:
RGE30° / RGE45°

RF3



Knurling profiles:
RGE30° / RGE45°

Zeus Cut Knurling Tools

Zeus Cut Knurling Wheels guarantee an optimal tool life, high precision & absolute process safety:

- **Teeth fine milled, front and bore ground:** high quality of knurling pattern
- **Vacuum hardened**
- **Knurling wheel options:** PVD coatings for increased wheel life (✓)
- **Exclusive product range**



Form AA



BL 15°



BR 15°



BL 30°



BR 30°

Variations	Type	Ø x width x bore	Pitch p - Profile angle a
No.15 / milled, without chamfer, HSS ✓	AA	8,9 x 2,5 x 4 ✓	0,3 - 90°
No.16 / milled, without chamfer, PM ✓	BL 15°	10 x 3 x 6 ✓	0,4 - 90°
No.17 / milled, with chamfer, HSS ✓	BR15°	14,5 x 3 x 5 ✓	0,5 - 90°
No.18 / milled, with chamfer, PM ✓	BL30°	15 x 4 x 8 ✓	0,6 - 90°
No.35 / ground, without chamfer, PM ✓	BR30°	21,5 x 5 x 8 ✓	0,7
No.37 / ground, with chamfer, PM ✓		25 x 6 x 8 ✓	0,8
No.55 / ground, without chamfer, HM ✓		32 x 13 x 16 ✓	0,9
No.57 / ground, with chamfer, HM ✓		42 x 13 x 16 ✓	1,0
			1,2
			1,5
			1,6
			1,8
			2,0 - 90°

Please choose your options by combining the four columns accordingly.

HSS = High Speed Cutting Steel

PM = Powder metallurgy Steel

HM = Carbide



Zeus Form Knurling Tools

Optimal solutions for knurling applications.



Unbeatable benefits:

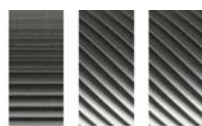
- **High precision** for excellent knurling profiles.
Low radial pressure on the work piece
- **Easy tool handling** and adjustment of work piece diameter. With scale for setting the work piece Ø
- **Rigid tool design** offers high process safety and excellent knurling quality.
- **Knurling wheel options:** PVD coatings for increased wheel life
- **Special surface hardening** of the tool shank for increased tool life (nitriding)
- **Application oriented** tool solutions. Suitable for small machines and small work piece diameters.



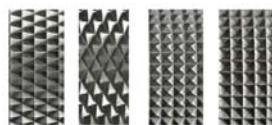
Best Example:
Zeus RD2

Tool Series:

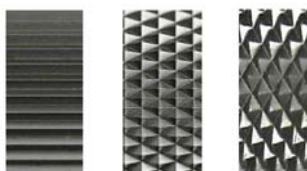
RD1



All knurling
profiles possible

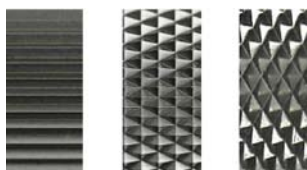


RD2



RAA
RGE30°
RGE45°

RD3



RAA
RGE30°
RGE45°



Specialty Tools

Zeus Form Knurling Wheels guarantee an optimal tool life, high precision and absolute process safety:



- **Teeth fine milled, front and bore ground:** high quality of knurling pattern
- **Vacuum hardened:** increase in tool life
- **Knurling wheel options:** PVD coatings for increased wheel life (✓)
- **Exclusive product range**



Form AA



BL 30°



BR 30°



BL 45°



BR 45°



GE 30°



GE 45°



KE

Variations	Type	Ø x width x bore			Pitch p - Profile angle a
No. 10 / milled, with chamfer, HSS ✓	AA	10	3	6	0,3 - 90°
No. 11 / milled, with chamfer, PM ✓	BL30	10	4	4 ✓	0,4 - 90°
No. 12 / milled, without chamfer, HSS ✓	BL45	15	4	4 ✓	0,5
No. 13 / milled, without chamfer, PM ✓	BR30	15	4	8	0,6
No. 30 / ground, with chamfer, PM ✓	BR45	15	6	4 ✓	0,7 - 90°
No. 32 / ground, without chamfer, PM ✓	GE30	15	6	6/8 ✓	0,8
No. 50 / ground, with chamfer, HM ✓	KE	15	6	6/11 *	0,9
No. 52 / ground, without chamfer, HM ✓		20	6	6 ✓	1,0
		20	8	6 ✓	1,2
		20	8	6/13 ✓	1,5
		20	8	10/12 ✓	1,6
		20	10	6 ✓	1,8
		25	6	6 ✓	2,0 - 90°
		25	6	8 *	cp 8 - 90°
		25	8	6 ✓	cp 10
		25	10	6 ✓	cp 12
		5/16	5/32	1/8 ✓	cp 14 - 90°
		1/2	3/16	3/16 ✓	cp 16
		1/2	1/4	3/16 ✓	cp 18
		5/8	5/16	7/32 ✓	cp 19
		5/8	1/4	1/4 ✓	cp 20 - 90°
		3/4	3/8	1/4 ✓	cp 21
		3/4	1/2	1/4 ✓	cp 24
		7/8	3/8	1/4 ✓	cp 25
		1	3/8	5/16 ✓	cp 29
		1 1/4	1/2	1/2 ✓	cp 30
					cp 32
					cp 33
					cp 35 - 70° / 90°
					cp 40 - 70° / 90°
					cp 41 - 90°
					cp 47 - 90°
					cp 50 - 70°
					cp 60 - 70°
					cp 70 - 70°
					cp 80 - 70°
					cp 90 - 70°
					cp 100 - 70°
					dp 64 - 80°
					dp 96 - 80°
					dp 128 - 80°
					dp 160 - 80°

Please choose your options by combining the four columns accordingly.

* With chanks 60° for knurling tool RD2

HSS = High Speed Cutting Steel
PM = Powder metallurgy Steel
HM = Carbide



Zeus Marking Tools - Turned Part Marking On (Auto) Lathe

Leave your mark with Zeus marking tools.



Unbeatable benefits:

- **Application oriented** tool solutions. Marking of work pieces on the (auto) lathe directly.
- **Customized tool** solutions. Each tool is designed according to the applications specific requirements.
- **Cost reduction.** No additional manual processing step or additional setting time required.
- **Individuality.** Branding of turned-parts with company name or logo.

Turned part marking application benefits:

- **Unique product allocation and traceability** through product identification
- **Unique supplier allocation**
- **Improved production data**
- **Branding possibilities**



**Best Example:
Zeus MRSI**

Tool Series:



Zeus Marking Tools - Turned Part Marking On (Auto) Lathe

Leave your mark with Zeus marking tools.



Marking Rolls:

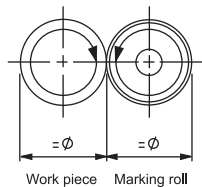
- **Customer oriented tool solutions.** Individual tool design for your specific application
- **Individual design.** Each marking roll is designed to the customer's specific requirements
- **Cost effective.** Customized solutions for standard price.

Continuous Roll Marking System:



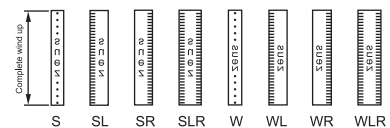
No. 40

Marking roll continuously rotating



Marking types
on work piece

For marking tools:
MCI - Series
MCCI - Series

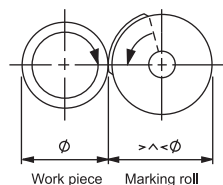


Spring Return Marking System:



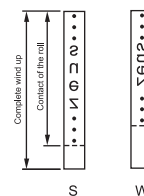
No. 41

Marking roll partially rotating



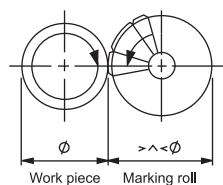
Marking types
on work piece

For marking tools:
MRI - Series



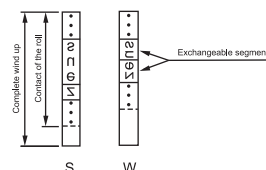
No. 41

Marking roll partially rotating



Marking types
on work piece

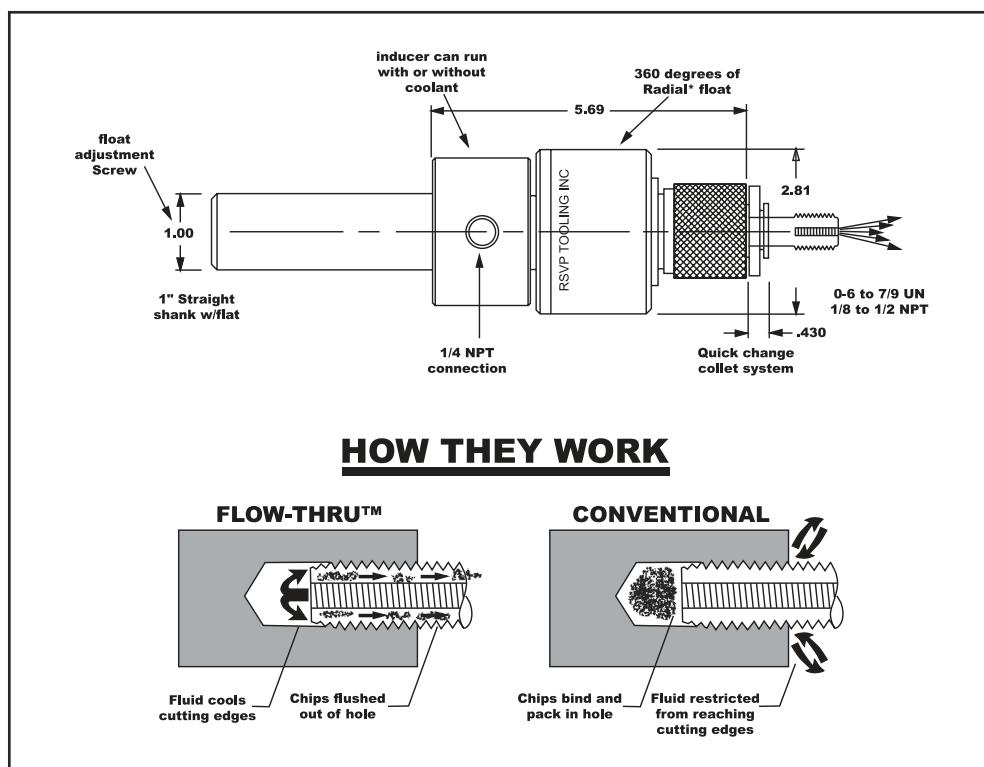
For marking tools:
MRSI - Series



Coolant Induced Tap Driver

Increases Your Tap Life Over 100X

A tap cuts with the first couple of threads and no matter how much you flood the tap, it is cutting dry causing premature wear and breakage of the tap in the work piece. By introducing coolant under pressure through an oil hole tap the swarf is evacuated out the flutes of the tap before it can do any damage. This system will increase your tap life over 100 times its normal life, while improving your thread quality.



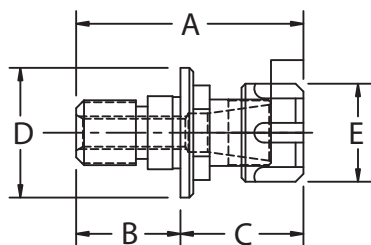
*RSVP radial floating system provides for a true 360 degrees of unrestricted radial float of 0.040. The float cage is sealed to eliminate any coolant contamination that can cause oxidation and gummy residue build up that will restrict or impede the floating system.

Accu-Screw™ - Holders & Receivers

For Davenports, Brown & Sharp or Swiss Style Machines

Quick-Change Drilling For Screw Machines

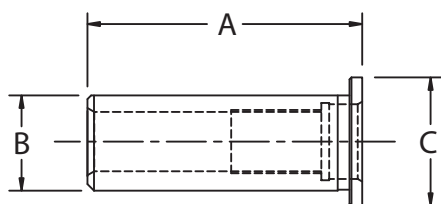
- Designed for use on Davenport , Brown & Sharpe and Swiss Style Machines
- 5-10 Second tool change with no tools needed for insertion
- Preset drills offline for maximum accuracy and minimum downtime
- Uses ER single angle collets - dramatic improvement over double angle collets
- Repeatable - .0005 TIR at 4"
- Set tool block or receiver one time and change tools with no additional setup time
- Your first part is a good part! – reduce scrap, eliminate setups, save time & money



Quik-Screw™ Drill Holder

Part #	Collet	A	B	C	D	E	Collet Nut
A-6985-000	ER 11	1.772	0.800	0.972	0.875	0.748	A-4139-211
A-6986-000	ER 16	2.237	0.800	1.437	0.875	0.748	A-4141-400
A-6989-000	ER 11	1.772	0.800	0.972	1.000	0.748	A-4139-211
A-6990-000	ER 16	2.237	0.800	1.437	1.000	1.103	A-4141-400
A-6993-000	ER 16	2.562	1.125	1.437	1.250	1.103	A-4141-400
A-6995-000	ER 25	2.750	1.125	1.625	1.250	1.600	A-4143-325

- Holder has a positive stop screw and is coolant thru capable.
- Preset offline and insert into receiver (see below) using no tools for insertion, and flat wrench on hex for removal.
- ER single angle collets are far more accurate than double angle collets, producing better parts and longer tool life.



Quik-Screw™ Receiver

Part #	Quik-Screw#	A	B	C
A-6970-000	A-6985-000	2.100	0.625	0.875
	A-6986-000	2.100	0.625	0.875
A-6975-000	A-6989-000	2.100	0.750	1.000
	A-6990-000	2.100	0.750	1.000
A-6980-000	A-6993-000	3.100	1.000	1.250
	A-6995-000	3.100	1.000	1.250

- Receiver is positioned and centered in machine tool block for initial tool setup
- Holders are preset offline eliminating additional downtime

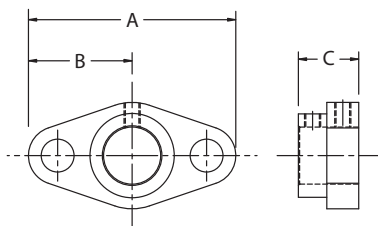
Accu-Screw™ - Flange Mounts

For Davenports, Brown & Sharp or Swiss Style Machines

Quick-Change Drilling For Screw Machines

Quik Screw™ Adjustable Flange Receiver

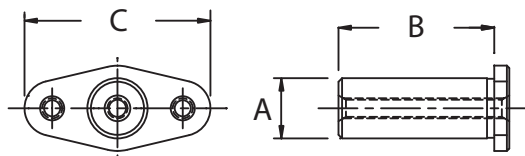
- Designed for use on Davenport , Brown & Sharpe and Swiss Style Machines using the Quik-Screw™ Drill Holder
- Allows for precision correction on misalignment between spindle and turret centerlines by adjusting face to face alignment with set screws
- Set it once and periodically recheck - no need to reset with every tool change
- Coolant thru capability
- Ideal system for turret lathes and most automatics



Quik-Screw™ Adjustable Flange(AF)

Part #	Quik-Screw#	Range	A	B	C
A-6950-000	A-6985-000	1/32-17/64	2.000	1.000	0.710
	A-6986-000	1/32-3/8	2.000	1.000	0.710
A-6955-000	A-6989-000	1/32-17/64	2.312	1.157	1.000
	A-6990-000	1/32-3/8	2.312	1.157	1.000
A-6960-000	A-6993-000	1/32-3/8	3.125	1.563	1.250
	A-6995-000	1/16-5/8	3.125	1.563	1.250

Will mount to Somma Adjustable Flange Holder - Page 83 Somma 2000



Quik-Screw™ Adjustable Flange Mount (AF)

Part #	AF Part #	A	B	C
A-6950-625	A-6950-000	0.625	1.125	2.000
A-6950-750	A-6950-000	0.750	2.000	2.000
A-6955-750	A-6855-000	0.750	1.937	2.312
A-6960-750	A-6960-000	0.750	1.406	3.125
A-6960-100	A-6960-000	1.000	2.937	3.125

ACCURATE, REPEATABLE AND COST EFFECTIVE!

Accu-Screw™ - Receivers & Holders

For Acme-Gridley, New Britain & Large Block Machines

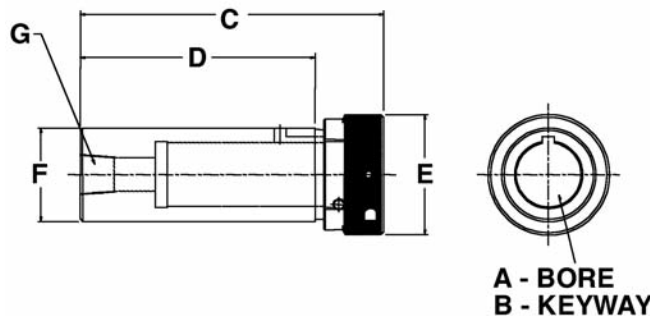
Quick-Change Drilling For Screw Machines

Accu-Screw™ Receivers & Holders

- Designed for use on Acme-Gridley, New Britain and other Large Block Machines
- 5-10 second tool change with no tools needed for insertion
- Preset drills offline for maximum accuracy and minimum downtime
- Set Receiver in tool block one time and quick-change tools with no additional setup time
- Repeatable - .0005 TIR at 4"

Accu-Screw™ Receivers

- Insert Accu-Screw holder with 1/4 turn of quick-change locking adapter
- Coolant capable with 1/4 -18 or 1/2 -14 NPT connection

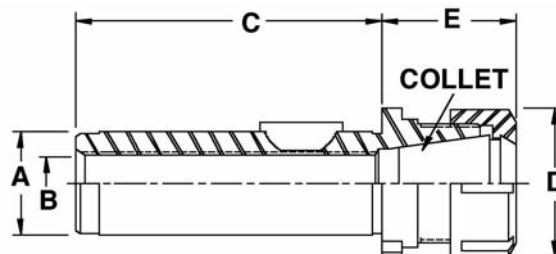


Part #	A	B	C	D	E	F	G
A-6920-000	5/8	5/32	5.43	4.00	1.562	1.00	1/4-18 NPT
A-6925-000	3/4	5/32	5.43	4.00	1.770	1.25	1/2-14-NPT
A-6930-000	3/4	5/32	5.43	4.00	1.770	1.50	1/2-14-NPT
A-6935-000	1-1/16	3/16	5.43	4.00	2.190	1.50	1/2-14-NPT
A-6940-000	1-3/8	1/4	6.43	5.00	2.565	2.00	1/2-14-NPT

*Additional shank O.D. and I.D.'s available upon request

Accu-Screw™ Holders

- Uses ER Single Angle Collets for Increased Accuracy vs. Double Angle Collets
- Your First Part is a good part! – reduce scrap, eliminate setups, save time & money
- Internal pre set stop screw standard, Posi-Drive assembly available upon request



Part #	Shank Dia. A	Collet Series	Collet Range	Adjustment Screw	Max Dia. Thru Shank B	Shank Length C	Collet NutNose D		PRJCTN E
							Max O.D.	Hex Size	
A-6900-000	5/8	ER-11	.0019 to .276	5/16-24 LH	.250	1.125	.630	.433	1.35
A-6905-000	3/4	ER-16	.019 to .394	7/16-20 LH	.375	1.500	1.10	N/A	1.80
A-6910-000	1-1/16	ER-32	.079 to .787	3/4-16 LH	.656	1.812	1.97	N/A	1.75
A-6915-000	1-3/8	ER-32	.079 to .787	13/16-20 LH	.750	2.000	1.97	N/A	1.75

***ADDITIONAL SHANK O.D.AND COLLET SIZES AVAILABLE UPON REQUEST**

Collet Quick-Change Precision Drill Holder

Patented Single Angle (ER)

- Uses standard ER collets - ER16, ER25, ER32 & ER40.
- Quick-change design requires no tools for insertion and easy removal w/spanner.
- Expanding bore collet provides minimal runout. It is as true as the spindle!
- Coolant thru capable with sealed collets or sealed disc system.
- Positive stop screw for offline presetting.
- Shank is precision ground and hardened for added tool life.
- Special sizes available upon request.



Shank Size	Collet Size	Minimum Projection	Nut Diam.
3/4	ER16	2.00	1.26
7/8	ER16	2.00	1.26
7/8	ER25	2.44	1.65
1-1/16	ER16	2.00	1.26
1-1/16	ER25	2.44	1.65
1-1/16	ER32	3.02	1.97
1-3/8	ER25	2.44	1.65
1-3/8	ER32	3.02	1.97
1-3/8	ER40	3.55	2.48