

M297 **CNC – UNIVERSAL PRECISION DRILL CHUCK for drills with combined coolant**

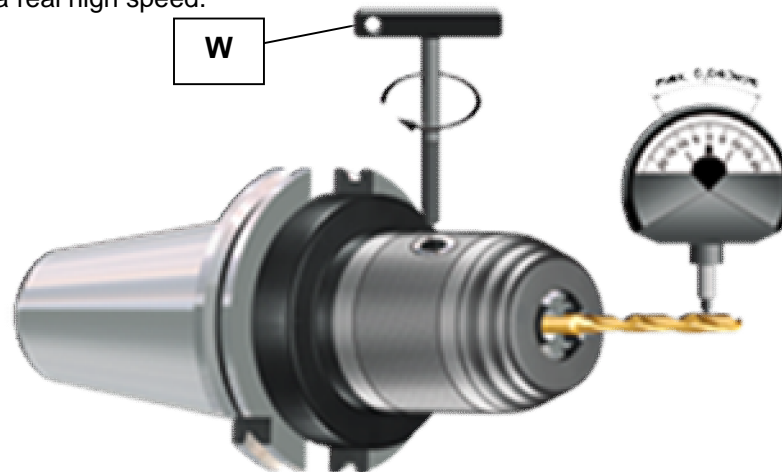
M297 is accurate fastening head for CNC machines with the most advanced technology. This technology serves to fastening HSS or hardmetal drills with cylindrical spindle. This head offers possibility of internal or combined tool coolant.



Advantages:

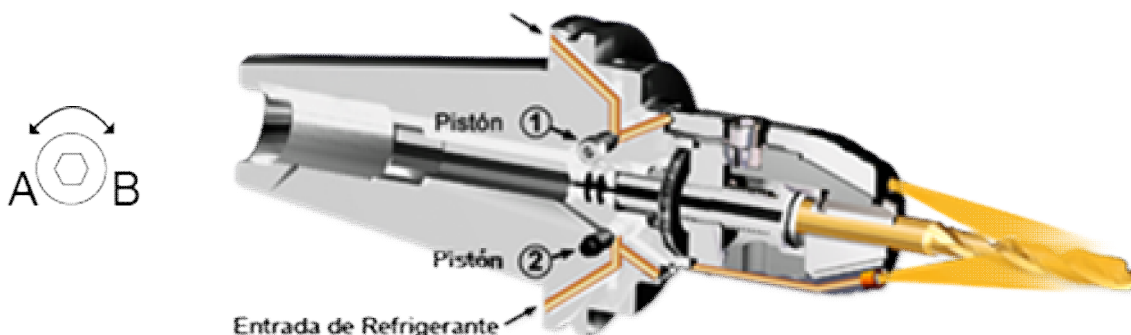
1. With small torque on key „W“ can be achieved very solid and accurate drill fastening – run out tolerance under 0,020 mm in distance 30mm from fixing
2. Perfect tool stability with higher revolutions because of the small head volume and its dynamic balancing.
3. Head provides internal cooling passing through in both AD+B forms.
4. Due to mechanical building as well as to its innovative design, the M297 Drill Chuck provides the distribution of the coolant in a voluntary way by using an hydraulic system consisting in two screws working over pistons. The coolant can be supplied through the coolant holes of the tool, through the front part of the chuck or both parts, simultaneously. These characteristics turn M297 Collet Chuck into something unique in the International Market.

Run out tolerance under 0,020mm, higher than the precision standard required by th Market. With tightening torque of 12Nm there`s obtained a tightening force of 70Nm. The tightening system provides to work left and right hand turning. The compact and the built-in construction of this drill chuck allowed us to reduce its volume, being also able to turn at a real high speed.

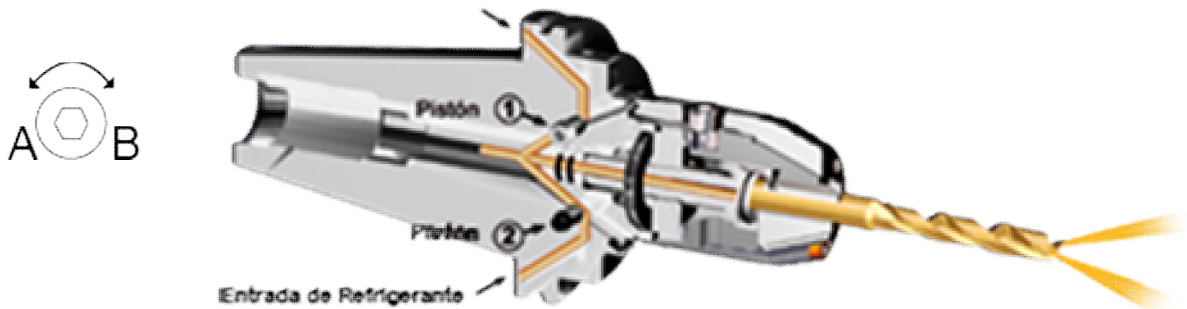


COOLANT – USAGE POSSIBILITIES:

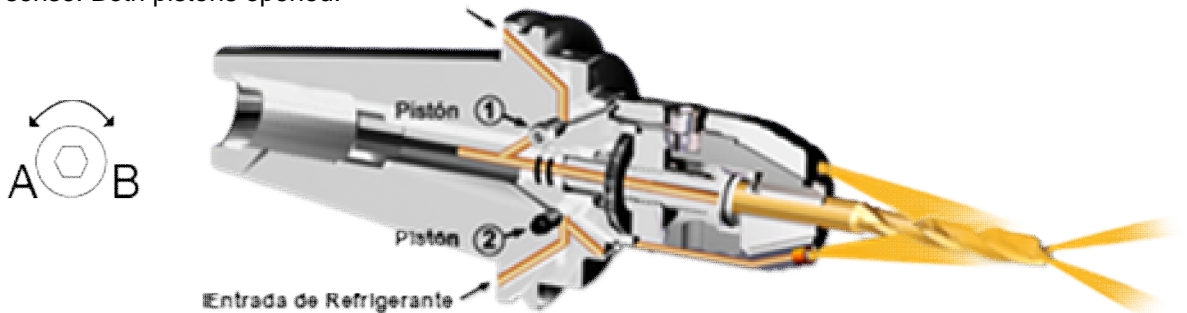
1. **Shall we cool through the frontal part** – turn pistons in the A sense. Piston 1 opened, Piston 2 closed.



2. **Shall we cool through the central part** – turn pistons in the B sense. Piston 1 closed, Piston 2 opened.



3. **Shall we cool through both parts simultaneously** – turn piston 2 in the A sense and piston 1 in the B sense. Both pistons opened.












Usage:

Head is for accurate drilling especially on NC and CNC machine tools. There are supposed quick, accurate and firm tool fastening with combined coolant possibility.

Delivery:

Heads are delivered with taper ISO40 and ISO50 according to DIN 69871 AD + B. Dimensions and technical parameters are in following table.

Ref. 13.297	K ISO	d1 mm	D mm	A mm	A1max mm		3 	
13.297.40.13	40	1-13	56	105	112	89.206.06	89.220.13	
13.297.40.16		3-16	56	112	119	89.206.06	89.220.13	
13.297.50.13	50	1-13	56	105	112	89.206.06	89.220.13	
13.297.50.16		3-16	56	112	119	89.206.06	89.220.13	

PŘEDVYVÁŽENO PRE-BALANCED		8.000 rpm	G 6.3
		6.000 rpm	

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