

M 307 COMBINED END MILL ADAPTOR FOR TOOLS

This combined adaptor has two tightening holes each one being 180° opposed from the other. One is right-angled for fixing Weldon End Mills and the other has a 2° acute angle for Whistle-Notch End Mills, with an integral regulation step.

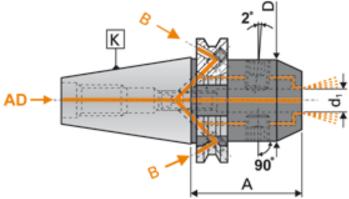
internal regulation stop.



Advantages:

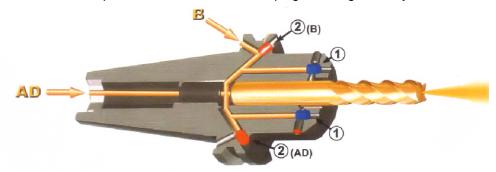
- 1. Couple of clamp bolts permits using of adaptor for whole tools assortment with shank WELDON. This offers internal cooling in both forms AD and B.
- 2. Here can be used internal cooling, external cooling or combined tool coolant.
- 3. Dynamic adaptor prebalancing higher tool stability during higher revolutions.

Into the adaptor is coolant inlet through central – form "AD" or through 2 holes in collar "form B". These two holes can be opened or closed by pistons "2" (figure on the second side). After pistons screwing out from the holes, there is opened coolant inlet. If these two pistons are closed, the inlet is reduced only on the central – form "AD".

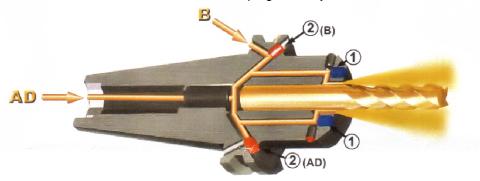


COOLANT:

INTERNAL COOLING – push inside the threaded "B" plugs, closing that way the coolant to go out

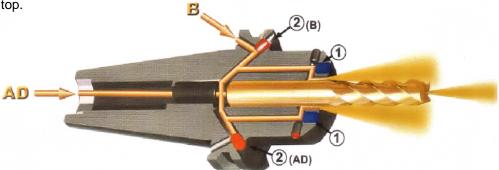


2. EXTERNAL COOLING - leave both threaded "B" plugs as they are delivered



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3. **INTERNAL + EXTERNAL COOLING** – the coolant gets out by pulling both threaded "B" plugs until the external top.



If adaptor is indicated only for one form of usage, more suitable is to paste both pistons in adjusted position by gum Loctite or Silicone. This way is assured their position and sealing.

Remark:

Adaptors are produced and delivered in model SK40 and SK50 in dimension row according to following table. Dynamic prebalancing is showed by one or two rings and they indicate the number of planes in which it was done.

Ref. 13.307	K ISO	d1 H4 mm	A mm	D mm		2 x	
13.307.40.06	40	6	50	25	89.190.15	89.122.20	
13.307.40.08		8	50	28	89.190.21	89.122.35	
13.307.40.10		10	50	35	89.190.37	89.122.40	
13.307.40.12		12	50	42	89.190.43	89.122.50	
13.307.40.14		14	50	44	89.190.43	89.122.50	
13.307.40.16		16	63	48	89.190.51	89.122.60	
13.307.40.18		18	63	50	89.190.51	89.122.60	
13.307.40.20		20	63	52	89.190.66	89.122.65	
13.307.40.25		25	100	65	89.190.82	89.122.75	
13.307.40.32		32	100	72	89.190.82	89.122.80	
13.307.50.06	50	6	63	25	89.190.15	89.122.20	
13.307.50.08		8	63	28	89.190.21	89.122.35	
13.307.50.10		10	63	35	89.190.37	89.122.40	
13.307.50.12		12	63	42	89.190.43	89.122.50	
13.307.50.14		14	63	44	89.190.43	89.122.50	
13.307.50.16		16	63	48	89.190.51	89.122.60	"พ"
13.307.50.18		18	63	50	89.190.51	89.122.60	
13.307.50.20		20	63	52	89.190.66	89.122.65	
13.307.50.25		25	80	65	89.190.82	89.122.75	
13.307.50.32		32	100	72	89.190.82	89.122.80	
13.307.50.40		40	120	90	89.190.82	89.122.80	

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