

ANGST – FLOATING REAMER HOLDERS

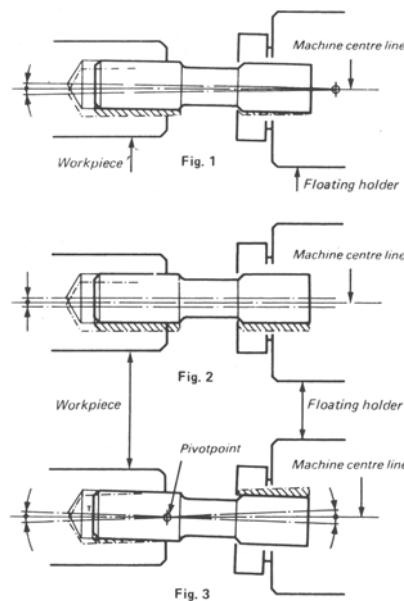


Getting poor results when reaming?

- * Conventional low cost rubber-band reamer holders are crude and inconsistent.
- * Solid reaming only works if the hole is straight, true, the machine positions exactly and the reamer is held with no run out. Not very likely.
- * Bell-mouthing at the front of a hole and ovality at the rear.
- * Poor surface finish and accuracy.
- * Chatter, Binding, high wear rate and breakage.

The Angst Floating Reamer Holder provides the solution.

Conventional designs of floating reamer holder provide only two modes of reamer displacement - Pendulum, as in fig. 1 and Parallel, as in fig. 2 where the reamer moves about a centre inside the holder body. The Angst design provides a third, pivoting mode of reamer deflection as shown in fig. 3.

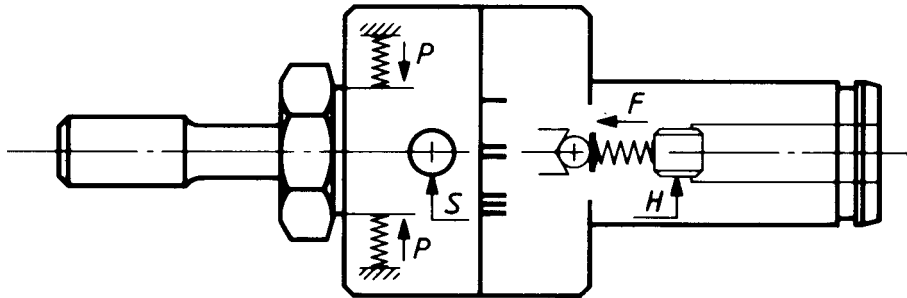


With this additional movement the reamer will accurately follow a correctly centred hole where the drill has subsequently wandered.

Radial and Axial spring pressures are adjustable to suit reamer size and conditions, A centralising device holds the reamer on centre.

Servicing facilities are available.

SETTING



The centralising spring pressure (P) within the front part of the toolholders can be pre-set, or adjusted, according to reaming conditions and size of reamer. Spring adjustments are made by turning the knurled ring and setting the locking screw (S) on Pos. I, II or III. Similarly, the back spring pressure (F) can be adjusted with the key provided by turning the screw (H).

Strong pendulum resistance:

Set screw S on III and fully tighten screw H

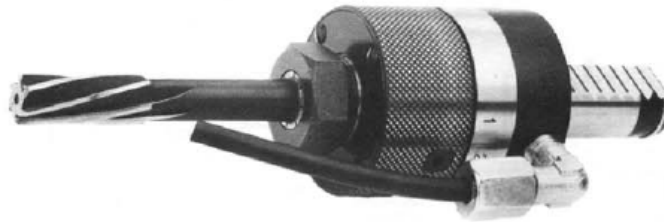
Medium pendulum resistance:

Set screw S on II and loosen screw H one turn

Weak pendulum resistance:

Set screw S on I and loosen screw H two turns

FLOATING REAMER HOLDERS – Cylindrical shanks



Gripping Capacity	Shank Ø	Order Code Flex Collets	Flex Collet Size	Order Code ER Collets	ER Collet Size	Length - Flex excl. shank	Length - ER excl. shank	Diameter
2-6.5 (7)	14 x 25	3601001	1	3601051	ER11	46	55	38
	5/8" x 30	3601002		3601052				
	20 x 50	3601006		3601056				
	25 x 50	3601007		3601057				
	1" x 50	3601008		3601058				
	20 x 50*	3601036		3601086		57	66	
	25 x 50*	3601037		3601087				
	VDI 16	3601013		3601063				
	VDI 20	3601014		3601064				
	VDI 30	3601015	3601065					
3-12 (13)	5/8" x 30	3602002	2	3602052	ER20	58	71	50
	20 x 50	3602006		3602056				
	25 x 50	3602007		3602057				
	1" x 50	3602008		3602058				
	20 x 50*	3602036		3602086				
	25 x 50*	3602037		3602087				
	VDI 16	3602013		3602063				
	VDI 20	3602014		3602064				
		VDI 30		3602015		3602065		
	VDI 40	3602016	3602066					
6-20	25 x 50	3604007	4	3604057	ER32	85	93	84
	1" x 50	3604008		3604058				
	25 x 50*	3604037		3604087				
	32 x 60*	3604038		3604088				
	40 x 70*	3604039		3604089				
	VDI 30	3604015		3604065				
	VDI 40	3604016		3604066				
	VDI 50	3604017		3604067				
		VDI 60		3604018		3604068		

FLOATING REAMER HOLDERS – Taper shanks



Gripping Capacity	Shank Ø	Order Code Flex Collets	Flex Collet Size	Order Code ER Collets	ER Collet Size	Gauge Length Flex	Gauge Length ER	Diameter
2-6.5 (7)	BT 40	3601216	1	3601266	ER11	73	82	38
	DIN 40	3601236		3601286		65	74	
	MT 1	3601401		3601451		46	55	
	MT 2	3601402		3601452				
	MT 3	3601403		3601453				
3-12 (13)	BT 40	3602216	2	3602266	ER20	85	98	50
	DIN 40	3602236		3602286		77	90	
	MT 2	3602402		3602452		58	71	
	MT 3	3602403		3602453				
6-20	BT 40	3604216	4	3604266	ER32	112	120	84
	BT 50	3604218		3604268		123	131	
	DIN 40	3604236		3604286		121	129	
	DIN 50	3604238		3604288				
	MT 3	3604403		3604453				
	MT 4	3604404		3604454				

DIN = DIN69871A

Flex - Collets



Collet Sets					
Size 1	Qty	Size 2	Qty	Size 4	N°
3301600	7	3302600	10	3304600	9
Collets - individual					
Size 1	Dia	Size 2	Dia	Size 4	Dia
3301625	2.5-2	3302635	3.5-3*	3304670	7-6*
3301630	3-2.5	3302640	4-3.5*	3304680	8-7*
3301635	3.5-3	3302650	5-4	3304690	9-8
3301640	4-3.5	3302670	6-5	3304700	10-9
3301650	5-4	3302680	7-6	3304720	12-10
3301660	6-5	3302680	8-7	3304740	14-12
3301665	6.5-5.5	3302690	9-8	3304760	16-14
		3302700	10-9	3304780	18-16
		3302710	11-10	3304800	20-18
		3302720	12-11		

Adaptor for Morse Taper shank reamers

Order Code	Flex Version	MT size	Order Code	ER Version	MT size
3602121/27	2	1	3602191/97	ER20	1
3604122/27	4	2	3604192/97	ER32	2
3604123/27	4	3	3604193/97	ER32	3

ER - Collets



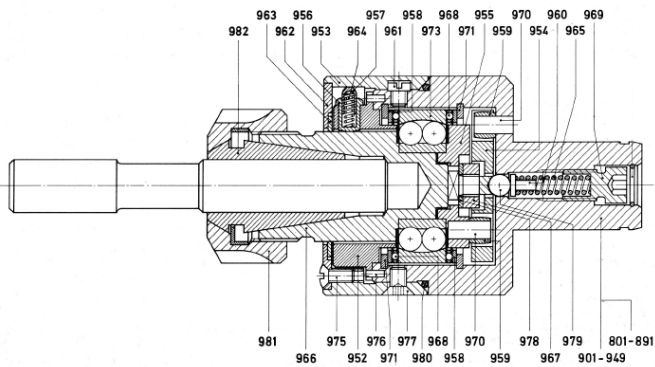
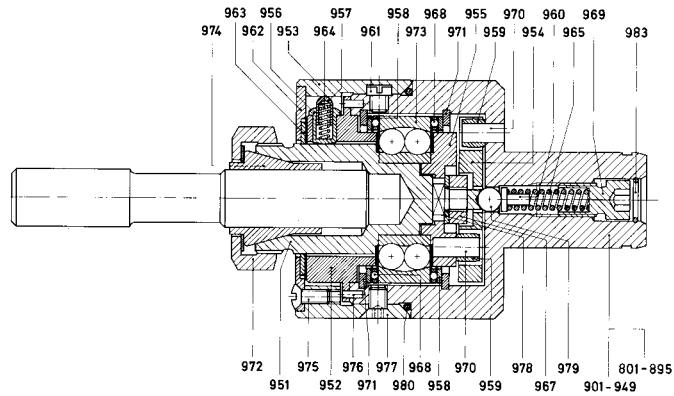
Collet Sets					
ER11	Qty	ER20	Qty	ER32	Qty
3801600	6	3802600	10	3304600	14
3801000	9	3802000	13	3804000	18
Collets - individual					
ER11	Dia	ER20	Dia	ER32	Dia
3801610	1-0.5*	3802610	1-0.5*	3804630	3-2*
3801615	1.5-1*	3802620	2-1*	3804640	4-3*
3801620	2-1.5*	3802630	3-2*	3804650	5-4*
3801625	2.5-2	3802640	4-3	3804660	6-5*
3801630	3-2.5	3802650	5-4	3804670	7-6
3801640	4-3	3802660	6-5	3804680	8-7
3801650	5-4	3802670	7-6	3804690	9-8
3801660	6-5	3802680	8-7	3804700	10-9
3801670	7-6	3802690	9-8	3804710	11-10
		3802700	10-9	3804720	12-11
		3802710	11-10	3804730	13-12
		3802720	12-11	3804740	14-13
		3802730	13-12	3804750	15-14
				3804760	16-15
				3804770	17-16
				3804780	18-17
				3804790	19-18
				3804800	20-19

* Drive not in Collet set

Collet Nut – Wrench Sizes

Description	Flex Collets	Description	ER Collets
AF17	1	AF17	ER11
AF27	2	WHH020	ER20
AF40	4	WHH032	ER32

SPARES



NOTE

974 Collets can be found on the relevant Reamer Holder pages

ORDERING SPARES

The above numbers are generic. For example **972** (Collet Nut) describes the spare part but not the size of holder it fits.

The spares part numbering system works, as follows;

