

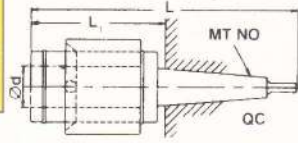


# ELMECA

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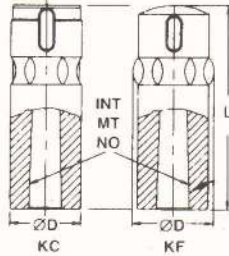
### ELMECA QUICK CHANGE DRILL CHUCKS (IS : 7824-1975)

MODEL NO.	MT NO.	BORE ØD depth	L1	L
QC-2	2	26 60	75	150
QC-3	3	34 65	86	180
QC-4	4	46 76	98	215
QC-5	5	60 98	131	272

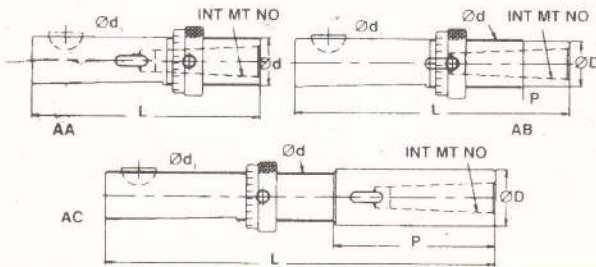
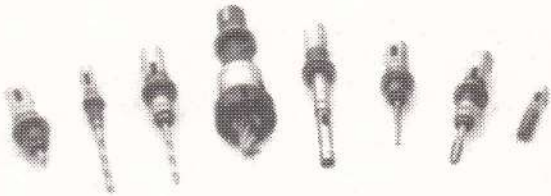


### COLLET (KC), FLOATING REAMER HOLDER (KF).

MODEL NO.	OD	L1	MT NO	SUITABLE CHUCK
KC	KF			
KC-21	KF-21	78	1	
		26		QC-2
KC-22	KF-22	90	2	
KC-31	KF-31	80	1	
KC-32	KF-32	90	2	QC-3
KC-33	KF-33	108	3	
KC-42	KF-42	100	2	
KC-43	KF-43	111	3	QC-4
KC-44	KF-44	135	4	
KC-53	KF-53	130	3	
KC-54	KF-54	140	4	QC-5
KC-55	KF-55	170	5	

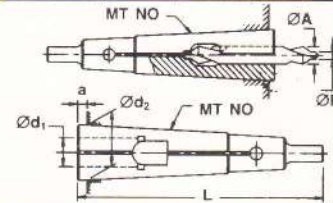


### ADJUSTABLE ADAPTORS (IS 8919-1978)



### SPLIT CENTRE-DRILL SLEEVES

IS SIZE TYPE 'A'			IS SIZE TYPE 'B'			METRIC SIZE TYPE 'A'			
ØA	ØB	MT NO	ØA	ØB	MT NO	Centre No	ØA	ØB	MT
3.15	0.5	0-1	4.0	1.0	0-1	No			No
3.15	1.0	0-1	5.0	1.2	0-1-2	MS-1	3.5	0.75	0-1
4.0	1.6	0-1	6.3	1.6	1-2-3	MS-2	4.0	1.0	0-1
5.0	2.0	1-2	8.0	2.0	1-2-3	MS-3	5.0	1.5	0-1-2
6.3	2.5	1-2-3	10.0	2.5	2-3	MS-4	6.0	2.0	1-2-3
8.0	3.15	1-2-3	11.2	3.15	2-3	MS-5	8.0	2.5	1-2-3
10.0	4.0	2-3	14.0	4.0	2-3-4	MS-6	10.0	3.0	2-3
12.5	5.0	2-3-4	18.0	5.0	3-4	MS-7	12.0	4.0	2-3
16.0	6.3	3-4	20.0	6.3	4-5	MS-8	14.0	5.0	2-3-4
20.0	8.0	4-5	25.0	8.0	4-5	MS-9	18.0	6.0	3-4
25.0	10.0	4-5	31.5	10.0	5	MS-10	20.0	6.3	4-5

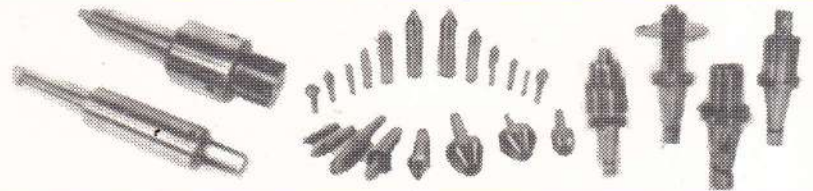


INCH SIZE TYPE 'A'			
Centre No	ØA	ØB	MT No
BS-1	1/8	3/64	0-1
BS-2	3/16	1/16	0-1-2
BS-3	1/4	3/32	1-2-3
BS-4	5/16	1/8	1-2-3
BS-5	7/16	3/16	2-3
BS-6	5/8	1/4	3-4
BS-7	3/4	5/16	3-4

### SPLIT DRILL SLEEVES (DIN-6329)

Morse Taper No	Size Range ød1H7 Above	Size Range ød1H7 Upto	a	Gauge Plane Ød2	L	Morse Taper No	Size Range ød1H7 Above	Size Range ød1H7 Upto
0	3	5.5	3	9.045	59.5	0	3	5
1	3	8.5	3.5	12.065	65.5	1	3	8.5
2	5.5	13	5	17.780	80	2	4.5	12.5
3	8	18	5	23.825	99	3	8	18
4	13	21	6.5	31.267	124	4	12	22
5	18	30	6.5	44.399	156	5	18	30

Split Drill Sleeves (DS) and tap Sleeves (ST) are Advantageous to Super gripping, Quick and accurate holding of straight shank Drills, Taps, Reamers, Deburring tools, Counterbores, Endmills and similar tools with flattened straight shanks and an inexpensive alternative as taper shank drills are more costly than straight shank tools with split sleeves. Split sleeves are available in SJ Number & as Per IS. **Ordering Procedure** : DS or ST - d1 x MT No x Name of tools (inform square sizes in case of square ended shanks). One Piece tools are designed for driving/clamping centre drills (CDS). The offset splined section furnish a positive drive via the Flutes of the centre drill and at the same time the body of the centre drill is held accurately by the sleeves. Centre drill sleeves are precision holding tools built to outlast many centre drills. These sleeves evenly enclose the body of the centre.



### SPLIT TAP SLEEVES (DIN-6328)

### PRODUCTS RANGE

- \* SPLIT SLEEVES (FOR DRILLS, TAPS, CENTRE DRILLS)
  - \* REDUCTION SLEEVES
  - \* EXTENSION SOCKETS
  - \* TURRET SOCKETS
  - \* DEAD CENTRES
  - \* CARBIDE TIPPED DEAD CENTRES
  - \* REVOLVING CENTRES
  - \* PIPE CENTRES
  - \* DRILL CHUCK ADAPTORS
  - \* REDUCTION MILLING SOCKETS
  - \* MILLING COLLET ADAPTORS
  - \* QUICK CHANGE CHUCK
  - \* END MILL HOLDERS
  - \* SHELL MILL & FACE MILL ARBORS
  - \* STUB ARBORS
  - \* BORING BARS
  - \* CENTERING PLUG
  - \* TOOL CLAMPING FIXTURES
  - \* EXPANDING SLEEVES & MANDRELS
  - \* MICROBORING ADAPTORS
  - \* GRINDING M/C ACCESSORIES
  - \* WHEEL BALANCING MANDRELS
  - \* GRINDING SPINDLE (QUILLS)
  - \* GRINDING WHEEL ARBOR (QUILLS)
  - \* COLLET CHUCKS FOR INTERNAL GRINDING MOUNTED POINTS
  - \* COLLETS AND COLLET CHUCKS FOR SCHAUBLIN, DIN (M), ER, DA, HG, M1TR, TRAUB ETC.
  - \* THREAD MILLING & HOBBING ARBORS
- WE ALSO MAKE CUSTOMIER'S SPECIAL PRECISION COMPONENT & TOOLING SYSTEMS.  
 • ALL TOOLING HOLDERS & ARBORS MADE FROM CHROME ALLOY STEEL & COLLETS ARE MADE FROM SPRING STEELS, ARE HARDENED & GROUND TO PRECISION LEVEL.  
 • OUR PRODUCTS ARE BASED ON-DIFFERENT STD.

SIZE	MT NO.	OD	OD1	LENGTH ADJ.	MODEL						
					AA L	ØD	AB L	P	AC ØD	L	P
16 x 0	0				85	14	100	25			
16 x 1	1	Tr 16x1.5	16	28	85	14	135	50		28	182
16 x 2	2						160	75			94
20 x 1	1	Tr 20 x 2	20	28			185	100		28	182
20 x 2	2						113	25			94
28 x 1	1				88	17	138	50			
28 x 2	2	Tr 28x2	28	30	95	25	163	75			
28 x 3	3						188	100		28	182
36 x 2	2										74
36 x 3	3	Tr 36 x 2	36	36	95	25	145	50			
36 x 4	4						170	75			
48 x 3	3						195	100		36	212
48 x 4	4	Tr 48 x 2	48	47	118	33	148	30			
							178	60			
							208	90			
							238	120		48	264
											146
					144	45	184	40			
					144	45	224	80			
							264	120			
							304	160			

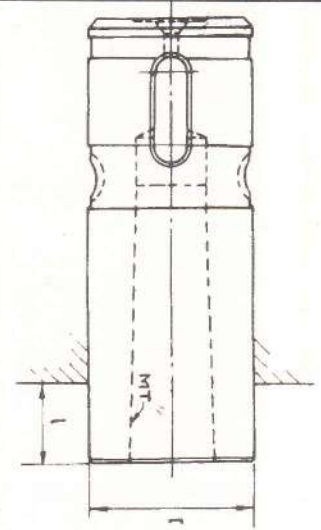
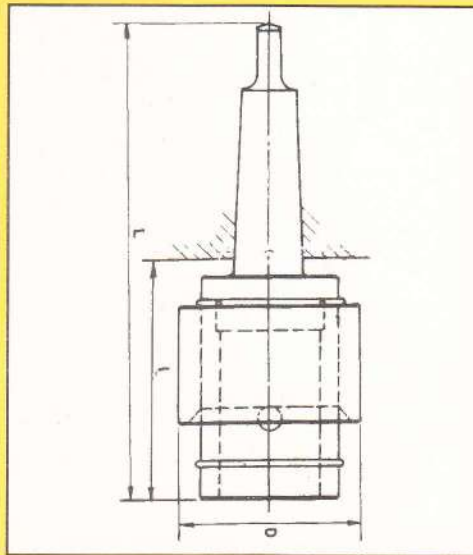
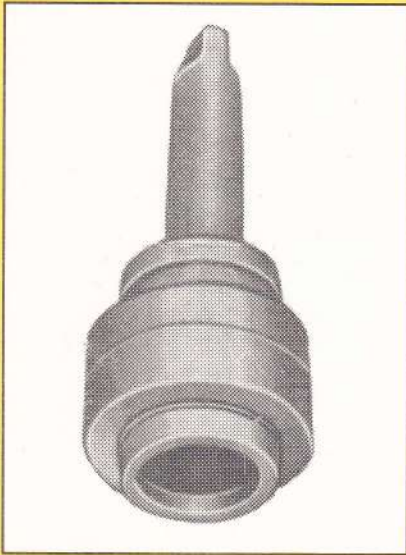
Quick change Chucks are used for batch production or series of drilling, counter boring, chamfering, reaming, counter sinking, spot facing, tapping and other operation on single or multi spindle machine. Tool can be change without stopping the machine resulting considerable saving in time and money. Split sleeves are suitable to fit various tools in the corresponding collets, holders or adaptor to kept handy. **Ordering Procedure** : Model No.

Adjustable adaptors Model (AA), (AB), (AC) are widely used for pricisus setting of depth in various operations and for very closed centre work. It is easy to reduces change over time by setting depth of tool prior to mounting on machine. Special quick lock nut are provided with soft ended grub screw to ensures locking at any point with thread protection. **Ordering Procedure** : Model No. x Size x P

# ELMECA Quick Change Drill Chucks

The use of Quick Change Drill Chucks makes for considerable savings in time and money. Tools can be inserted or removed from the machine without stopping the spindles. These chucks have been found very suitable for series or batch production on single or multi-spindle drilling and

milling machines, capstans, turrets, automatics, radial drilling machines and others where loss of a second means loss of profits. These chucks are made from 4% nickel chrome steel, case-hardened and ground to fine limits.



Code No	Shank		L	Wt. in kg.	Range of feeding	Suitable collets
	L mm	D				
EQ 1	MT1	127.5	36	65.5	0.35	EQ 1C or EQ1R
EQ 2	MT2	150	48	75.5	0.55	EQ 2C or EQ 2R
EQ 3	MT3	176	61	82.5	1.05	EQ 3C or EQ 3R
EQ 4	MT4	222	86	104.3	2.48	EQ 4C or EQ 4R
EQ 5	MT5	282	107	132.5	5.44	EQ 5C or EQ 5R

## Feeders for chills and Reamers

Code No	Morse Taper	d	L	Wt. in kg.	Suitable for
	(MT)				
EQ 1C	MT0	18	21	0.10	EQ 1
	MT1	18	25	0.12	
EQ 2C	MT1	26	18	0.27	EQ 2
	MT2	26	30	0.25	
EQ 3C	MT1	34	30	0.55	EQ 3
	MT2	34	26	0.50	
	MT3	34	44	0.47	
EQ 4C	MT1	46	20	1.20	EQ 4
	MT2	46	16.5	1.06	
	MT3	46	27	1.05	
EQ 5C	MT4	46	53	1.07	EQ 5
	MT1	60	20	2.615	
	MT2	60	24	2.55	
	MT3	60	26	2.50	
	MT4	60	29	2.42	
	MT5	60	68	2.16	

**Ordering Example :** (a) Chuck suitable for MT4 spindle Code No. 'EQ4' (b) Chuck suitable for EF-34 collet: Code No. 'EQ3'



## Ordering Example :

Collets for EQ-2 chucks.

a) EQ 2C - MT1 - 5 Nos.

b) EQ 2C - MT2 - 7 Nos.

For Reamers feeder the code changes from EQC to EQR and the remaining specifications remain unchanged.

**For Example :** Feeder for a reamer with MT2 shank and suitable for use with EQ3 chuck the Code No. EQ3R - MT2



keeping in step with today's technological strides, we make improvements in the designs of our products. Hence the product supplied may have features different from those described in this bulletin.

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