

Output Spindles



- Interchangeable modular output spindles
- Precision option for collet types, R2 and R36

Lou Zampini & Associates

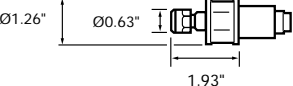
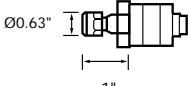
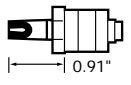

2 Douglas Pike, Rt. 7

Smithfield, RI 02917

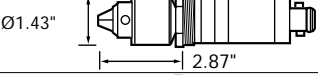
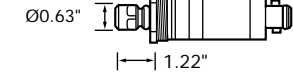
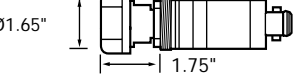

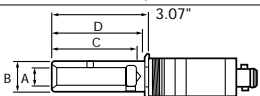
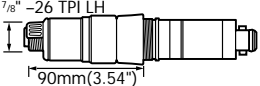

1 800 353 4676

FAX 1 401 679 0165

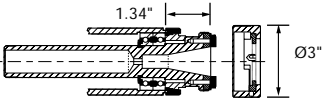
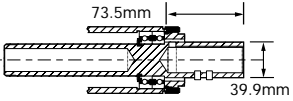
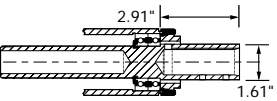
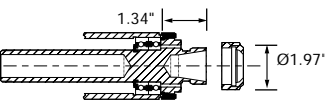
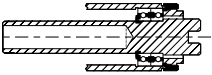
AFD205/AFD215, AFDE200, AFTE270

| | FUNCTION | ORDER CODE | FEATURES | PART NO. | RECOMMENDED SPEED RANGE |
|--|-----------------------------------|------------|--|----------|-------------------------|
|  | High Speed Output Spindle | K42 | Collet Chuck can be fitted to any AFDE200 to step up speed by 4.28 : 1. Note: Max. allowable speed 27000 rpm. See page 29 for collets. | 375263 | ≤5250 rpm |
|  | Collet Chuck | K2 | See page 31 for range of collets. | 357183 | ≤18800 rpm |
|  | No. 1 Jacobs Taper Output Spindle | K32 | No. 1 Jacobs Taper and for use with chucks or multi spindle heads | 382213 | ≤9600 rpm |
|  | Tapping Head Output Spindle | H21 | 3/16"-5/16" (4.5-8.0mm) capacity | 357193 | ≤1200 rpm |

AFD415, AFDE400/410, AFDE600/610/620, AFTE470/480

| | FUNCTION | ORDER CODE | FEATURES | PART NO. | RECOMMENDED SPEED RANGE | | | | | | | | | | | | | |
|--|---|--|---|---|-------------------------|--------|----|---|-----|-----|-----|-----|------|----|------|------|--------|--------|
|  | 3/8" Key Adjustable Chuck Output Spindle | B1 | Part No. includes chuck key | 327723 | ≤9600 | | | | | | | | | | | | | |
|  | Integral Collet Chuck Output Spindle | B2 | Up to 0.276" (7mm) collet capacity (see page 31 for Collet Range) | 326573 | ≤18000 | | | | | | | | | | | | | |
| | | R2 | Standard Output Assembly Precision Output Assembly | 384113 | | | | | | | | | | | | | | |
|  | Large Integral Collet Chuck Output Spindle | R36 | Up to 0.63" (16mm) collet capacity (see page 31 for Collets) | 389273 | ≤18000 | | | | | | | | | | | | | |
| | | B24 | No. 2 Jacobs Taper | A = 1.18" | | 326593 | | | | | | | | | | | | |
|  | Taper Output Spindle and for use with chucks and multi spindle heads | B32 | No. 1 Jacobs Taper | A = 0.95" | ≤9600 | | | | | | | | | | | | | |
| | | B16 | B16 Taper Output | A = 1.37" | | | | | | | | | | | | | | |
| | | B3 | Preset Tooling DIN55058 Output Spindle | <table border="1"> <thead> <tr> <th>ØA</th> <th>ØB</th> <th>C</th> <th>D</th> </tr> <tr> <th>mm</th> <th>mm</th> <th>mm</th> <th>mm</th> </tr> </thead> <tbody> <tr> <td>16</td> <td>25</td> <td>74</td> <td>79</td> </tr> </tbody> </table> | | ØA | ØB | C | D | mm | mm | mm | mm | 16 | 25 | 74 | 79 | 326563 |
| ØA | ØB | C | D | | | | | | | | | | | | | | | |
| mm | mm | mm | mm | | | | | | | | | | | | | | | |
| 16 | 25 | 74 | 79 | | | | | | | | | | | | | | | |
|  | Preset Tooling TMS Standard Output Spindle | B33 | Standard Output Assembly | <table border="1"> <thead> <tr> <th>ØA</th> <th>ØB</th> <th>C</th> <th>D</th> </tr> <tr> <th>ins</th> <th>ins</th> <th>ins</th> <th>ins</th> </tr> </thead> <tbody> <tr> <td>5/8"</td> <td>1</td> <td>2.62</td> <td>2.85</td> </tr> </tbody> </table> | ØA | ØB | C | D | ins | ins | ins | ins | 5/8" | 1 | 2.62 | 2.85 | 356373 | ≤5450 |
| | | ØA | ØB | C | D | | | | | | | | | | | | | |
| ins | ins | ins | ins | | | | | | | | | | | | | | | |
| 5/8" | 1 | 2.62 | 2.85 | | | | | | | | | | | | | | | |
| B5 | AFD415, AFDE400 Externally Adjustable Screwdriver Head Output Spindle | 1/4" fem. hex. drive. Torque range 2.7 - 100 ins. lbs. (0.3 - 11 Nm) | 324903 | | | | | | | | | | | | | | | |
|  | AFD415, AFDE400/410 Tapping Head Output Spindle | B6 | 5/16" fem. hex. drive. Torque range 2.7 - 100 ins. lbs. (0.3 - 11 Nm) | 324913 | ≤2100 | | | | | | | | | | | | | |
| | | B7 | 9/64" - 1/4" (3.5 - 6.5mm) capacity | 92362 | | | | | | | | | | | | | | |
|  | AFDE600/610 Tapping Head Output Spindle | B8 | 3/16" - 5/16" (4.5 - 8mm) capacity | 92892 | ≤1450 | | | | | | | | | | | | | |
| | | J19 | 3/16" - 3/8" (4.5 - 9.5mm) capacity For use with B24 output | 383813 | | | | | | | | | | | | | | |

AFDE700/710

| | FUNCTION | ORDER CODE | DESCRIPTION | PART NO. |
|--|--|------------|---|----------|
|  | Standard machine taper. Adapts to numerous standard machining heads and equipment. | T34 | ISO30 output taper, DIN 2080 | 362443 |
|  | Tooling spindles for 'automotive' preset tooling. | T3 | Preset tooling spindle to DIN 55058 Accepts tooling to DIN 6327 28m diameter, 85mm deep | 362453 |
|  | Tooling spindles for 'automotive' preset tooling. | T33 | Preset tooling spindle to T.M. Smith standard 1 1/16" diameter, 3.3" deep | 373333 |
|  | Accepts straight shank drills up to 20mm diameter (7/8") | T2 | ER32 collet output spindle (See below for collets) Maximum drill depth 1.89" | 362463 |
|  | Drive spindle for use with multi-head or angle head. | T35 | Drive adaptor for multi-heads or angle head | 373343 |

Collets

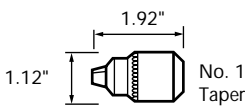
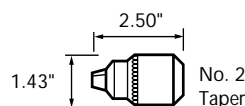
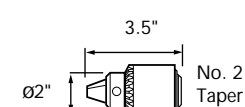
| For use with B2 (326573), R2 (384113), K2 (357183), K42 (375263) ER11 TYPE | | | | | |
|--|----------|---------------------------|----------|---------------------------|----------|
| size | part no. | size | part no. | size | part no. |
| 0.020 - 0.039 (0.5 - 1.0) | 52582 | 0.083 - 0.098 (2.1 - 2.5) | 52622 | 0.161 - 0.197 (4.1 - 5.0) | 52652 |
| 0.043 - 0.059 (1.1 - 1.5) | 52592 | 0.102 - 0.118 (2.6 - 3.0) | 52632 | 0.201 - 0.234 (5.1 - 6.0) | 52662 |
| 0.063 - 0.079 (1.6 - 2.0) | 52602 | 0.121 - 0.157 (3.1 - 4.0) | 52642 | 0.240 - 0.276 (6.1 - 7.0) | 52672 |

| For use with R36 (389273) ER25 TYPE | | | | | |
|-------------------------------------|----------|-----------------------------|----------|-----------------------------|----------|
| size | part no. | size | part no. | size | part no. |
| 0.236 - 0.276 (6.0 - 7.0) | 104942 | 0.397 - 0.433 (10.1 - 11.0) | 104982 | 0.555 - 0.591 (14.1 - 15.0) | 105032 |
| 0.279 - 0.315 (7.1 - 8.0) | 104952 | 0.437 - 0.472 (11.1 - 12.0) | 104992 | 0.594 - 0.630 (15.1 - 16.0) | 105042 |
| 0.319 - 0.354 (8.1 - 9.0) | 104962 | 0.476 - 0.512 (12.1 - 13.0) | 105002 | | |
| 0.358 - 0.394 (9.1 - 10.0) | 104972 | 0.516 - 0.551 (13.1 - 14.0) | 105022 | | |

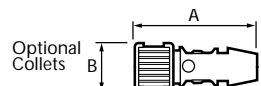

| For use with T2 (362463) ER32 TYPE | | | | | |
|------------------------------------|----------|-----------------------------|----------|-----------------------------|----------|
| size | part no. | size | part no. | size | part no. |
| 0.197 - 0.236 (5.0 - 6.0) | 105092 | 0.397 - 0.423 (10.1 - 11.0) | 105152 | 0.594 - 0.630 (15.1 - 16.0) | 105202 |
| 0.240 - 0.276 (6.1 - 7.0) | 105102 | 0.437 - 0.472 (11.1 - 12.0) | 105162 | 0.634 - 0.669 (16.1 - 17.0) | 105222 |
| 0.279 - 0.315 (7.1 - 8.0) | 105122 | 0.476 - 0.512 (12.1 - 13.0) | 105172 | 0.673 - 0.709 (17.1 - 18.0) | 105232 |
| 0.319 - 0.354 (8.1 - 9.0) | 105132 | 0.516 - 0.551 (13.1 - 14.0) | 105182 | 0.713 - 0.748 (18.1 - 19.0) | 105242 |
| 0.358 - 0.394 (9.1 - 10.0) | 105142 | 0.555 - 0.591 (14.1 - 15.0) | 105192 | 0.752 - 0.787 (19.1 - 20.0) | 105252 |

Chucks

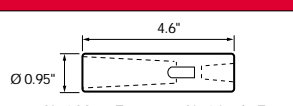
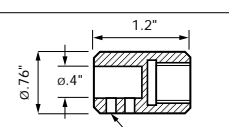
drilling chucks

| | FUNCTION | DESCRIPTION | PART NO. |
|--|---------------------------|---|----------|
| Max Drill Depth 0.59"  | 1/4" Key Adjustable Chuck | Part No. includes Chuck Key. Use with No. 1 standard Jacobs taper outputs K32 and B32 | 29492 |
| Max Drill Depth 1.34"  | 3/8" Key Adjustable Chuck | Part No. includes Chuck Key. Use with No. 2 standard Jacobs taper output B24 | 34752 |
| Max Drill Depth 2.04"  | 1/2" Key Adjustable Chuck | Part No. includes Chuck Key. Use with No. 2 standard Jacobs taper output B24 | 34332 |


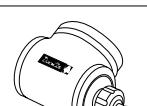
tapping chucks

| | FUNCTION | DESCRIPTION | CHUCK PART NO. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---|--|--|---|-----|---------|-------------|--|-------------|--|----|----|----|----|----|----|-------|----|-----|----|-----|---------|----------|-------|----|-----|----|-----|-------|-----------|-------|----|-----|----|-----|---------|----------|-------------------------|
|  | Tapping Chucks with flexible Collet (included) | <table border="1"> <thead> <tr> <th rowspan="2">JACOBS TAPER FITTING</th> <th colspan="2">A</th> <th colspan="2">B</th> <th colspan="2">Ø TAP SHANK</th> </tr> <tr> <th>mm</th> <th>in</th> <th>mm</th> <th>in</th> <th>mm</th> <th>in</th> </tr> </thead> <tbody> <tr> <td>No. 1</td> <td>64</td> <td>2.5</td> <td>27</td> <td>1.1</td> <td>3.5-6.5</td> <td>9/64-1/4</td> </tr> <tr> <td>No. 1</td> <td>64</td> <td>2.5</td> <td>27</td> <td>1.1</td> <td>4.5-8</td> <td>3/16-5/16</td> </tr> <tr> <td>No. 2</td> <td>79</td> <td>3.1</td> <td>37</td> <td>1.5</td> <td>4.5-9.5</td> <td>3/16-3/8</td> </tr> </tbody> </table> | JACOBS TAPER FITTING | A | | B | | Ø TAP SHANK | | mm | in | mm | in | mm | in | No. 1 | 64 | 2.5 | 27 | 1.1 | 3.5-6.5 | 9/64-1/4 | No. 1 | 64 | 2.5 | 27 | 1.1 | 4.5-8 | 3/16-5/16 | No. 2 | 79 | 3.1 | 37 | 1.5 | 4.5-9.5 | 3/16-3/8 | 29462 29452 34742 |
| JACOBS TAPER FITTING | A | | | B | | Ø TAP SHANK | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | mm | in | mm | in | mm | in | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| No. 1 | 64 | 2.5 | 27 | 1.1 | 3.5-6.5 | 9/64-1/4 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| No. 1 | 64 | 2.5 | 27 | 1.1 | 4.5-8 | 3/16-5/16 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| No. 2 | 79 | 3.1 | 37 | 1.5 | 4.5-9.5 | 3/16-3/8 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | Spare or replacement Collets | 5/64-3/16" (2-4.5mm) Capacity to suit 29462/29452 9/64-1/4" (3.5-6.5mm) Capacity to suit 29462/29452 3/16-5/16" (4.5-8mm) Capacity to suit 29462/29452 3/16-3/8" (4.5-9.5mm) Capacity to suit 34742 9/32-1/2" (9-12.5mm) Capacity to suit 34742 | 75142 29482 29472 36172 39242 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

drill bit/cutter adaptors

| | FUNCTION | DESCRIPTION | PART NO. |
|--|-----------------------------|--|----------|
|  | Morse Taper Adaptor | No. 2 Jacobs female taper to No. 2 Morse female taper | 34862 |
|  | Ø 3/8" Shank Cutter Adaptor | Fits thread of Single Collet Chuck – Part Nos. 326573 and 384113 and Multi Heads – Part Nos. 104062, 104022, 104032, 104042, 104052, 52362, 52462, 52442, 52392, 52422 | 53232 |

multiple spindle heads

| | FUNCTION | DESCRIPTION | PART NO. |
|---|---|---|----------|
| Multi-spindle drilling/tapping heads  | Fixed and adjustable spindle multi-heads (see page 34) | When ordering state number of spindles, diameter of holes, material to be drilled and hole pattern required | - |
| Angle heads/ Offset heads  | Angle heads available to order to suit AFDE400/410/600/610/620/700/710/AFD415 | When ordering state details of application, material to be machined, size and depth to cut | - |

Multiple Spindle Heads



- Range of adjustable spindle positions for 2, 3 and 4 spindle heads
- Special fixed spindle heads available for non standard hole patterns or dedicated applications

drilling

specification

| Multiple Spindle Head Part Numbers | | | | | | | | | | | | |
|------------------------------------|------------------------|-----------|---------------------|-------|-----------------------------|------------------------------|--------|-------------------------------|--------------------|---------|--------------------|------------------------------|
| NUMBER OF SPINDLES | SPINDLE CENTRES OR PCD | | MAXIMUM COLLET SIZE | | AFD205 AFD215 AFDE200 | AFD415 AFDE400 AFDE410 | AFD60 | AFDE600 AFDE610 AFDE620 | AFDE700 AFDE710 | AFTE270 | AFTE470 AFTE480 | COLLET TYPE (SEE PAGE 36) |
| | mm | ins | mm | ins | | | | | | | | |
| 2 | 9.5-54 | 0.37-2.13 | 4.00 | 0.157 | 174183 | 92142 | - | - | - | - | - | A |
| | 12.7-64 | 0.50-2.52 | 6.50 | 0.256 | - | 92152 | - | - | - | - | - | B |
| | 18.4-87.3 | 0.72-3.44 | 7.00 | 0.276 | - | 92162 | 52362 | 104062 | - | - | - | C |
| | 19-95 | 0.75-3.74 | 9.50 | 0.374 | - | 106662 | 204183 | 106672 | - | - | - | D |
| | 41.1-109.9 | 1.62-4.33 | 7.00 | 0.276 | - | 92172 | 52462 | 104022 | - | - | - | C |
| 3 inline | 20.5-55.5 | 0.81-2.19 | 7.00 | 0.276 | - | 92182 | 52442 | 104032 | - | - | - | C |
| 3 PCD | 27.3-96.2 | 1.07-3.79 | 7.00 | 0.276 | - | 92192 | 52392 | 104042 | - | - | - | C |
| 4 PCD | 41.1-109.9 | 1.62-4.33 | 7.00 | 0.276 | - | 92202 | 52422 | 104052 | - | - | - | C |
| Fixed | - | - | - | - | - | MSD100 | MSD200 | MSD200 | MSD300 | - | - | - |

tapping⁽¹⁾

specification

| Multiple Spindle Head Part Numbers | | | | | | | | | | | | |
|------------------------------------|------------------------|-----------|---------------------|-------|-----------------------------|------------------------------|--------|-------------------------------|--------------------|---------|--------------------|------------------------------|
| NUMBER OF SPINDLES | SPINDLE CENTRES OR PCD | | MAXIMUM COLLET SIZE | | AFD205 AFD215 AFDE200 | AFD415 AFDE400 AFDE410 | AFD60 | AFDE600 AFDE610 AFDE620 | AFDE700 AFDE710 | AFTE270 | AFTE470 AFTE480 | COLLET TYPE (SEE PAGE 36) |
| | mm | ins | mm | ins | | | | | | | | |
| 2 | 9.5-54 | 0.37-2.13 | 4.00 | 0.157 | - | - | - | - | - | 174183 | 92142 | A |
| | 12.7-64 | 0.50-2.52 | 6.50 | 0.256 | 204173 | 92222 | - | - | - | - | 92152 | B |
| | 18.4-87.3 | 0.72-3.44 | 7.00 | 0.276 | - | 92232 | - | 104122 | - | - | 92162 | C |
| | 19-95 | 0.75-3.74 | 9.50 | 0.374 | - | 106682 | 204193 | 106692 | - | - | 106662 | D |
| | 41.1-109.9 | 1.62-4.33 | 7.00 | 0.276 | - | 92242 | - | 104072 | - | - | 92172 | C |
| 3 inline | 20.5-55.5 | 0.81-2.19 | 7.00 | 0.276 | - | 92252 | - | 104082 | - | - | 92182 | C |
| 3 PCD | 27.3-96.2 | 1.07-3.79 | 7.00 | 0.276 | - | 92262 | - | 104092 | - | - | 92192 | C |
| 4 PCD | 41.1-109.9 | 1.62-4.33 | 7.00 | 0.276 | - | 92272 | - | 104102 | - | - | 92202 | C |
| Fixed | - | - | - | - | - | MST100 | MST200 | MST200 | MSD300 | - | MSD100 | - |

output spindles for use with multiple spindle heads⁽²⁾

specification

| Multiple Spindle Head Part Numbers | | | | | | |
|------------------------------------|------------------------------|-------|-------------------------------|--------------------|---------|--------------------|
| AFD205 AFD215 AFDE200 | AFD415 AFDE400 AFDE410 | AFD60 | AFDE600 AFDE610 AFDE620 | AFDE700 AFDE710 | AFTE270 | AFTE470 AFTE480 |
| K32 | B24 | - | B24 | T35 | K32 | B24 |

⁽¹⁾ All tapping heads incorporate a reversing gearbox except heads for AFDE700/710 and AFTE270/470/480

⁽²⁾ How to order

Examples:

AFDE200-2850-A1 + K32 + 174183

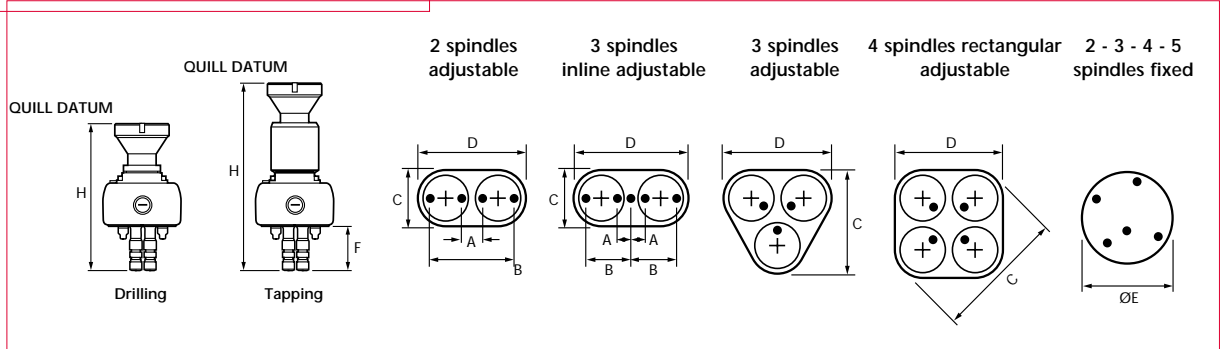
AFD415-3400-A6 + B24 + 92182

AFDE610-900-A1 + B24 + 104092

AFD60-2100 + 52442

AFDE70-950-A1-T35 + MSD300

Multiple Spindle Heads dimensions



adjustable spindle

specification

| PART NO. | MAXIMUM SPEED | MINIMUM/MAXIMUM CENTRES | | PCD | | MINIMUM | | MAXIMUM | | C | | D | | F | | H | |
|----------|---------------|-------------------------|-----------|------|------|---------|------|---------|------|-----|------|------|------|-------|-------|----|-----|
| | rpm | mm | ins | mm | ins | mm | ins | mm | ins | mm | ins | mm | ins | mm | ins | mm | ins |
| 174183 | 5300 | 9.5-66.7 | 0.37-2.63 | - | - | - | - | 50.8 | 2.00 | 83 | 3.27 | 50.8 | 2.00 | 169.5 | 6.67 | | |
| 204173 | 5300 | 12.7-64 | 0.50-2.52 | - | - | - | - | 50.8 | 2.00 | 83 | 3.27 | 50.8 | 2.00 | 206.1 | 8.11 | | |
| 92142 | 5300 | 9.5-54 | 0.37-2.13 | - | - | - | - | 50.8 | 2.00 | 83 | 3.27 | 50.8 | 2.00 | 175.4 | 6.91 | | |
| 92152 | 7000 | 12.7-64 | 0.50-2.52 | - | - | - | - | 50.8 | 2.00 | 83 | 3.27 | 50.8 | 2.00 | 175.4 | 6.91 | | |
| 92162 | 8500 | 18.4-87.3 | 0.72-3.44 | - | - | - | - | 62 | 2.44 | 115 | 4.53 | 60 | 2.36 | 196 | 7.72 | | |
| 106662 | 5300 | 19-95 | 0.75-3.74 | - | - | - | - | 76 | 2.99 | 124 | 4.88 | 68.3 | 2.69 | 212 | 8.35 | | |
| 92172 | 8500 | 41.1-109.9 | 1.62-4.33 | - | - | - | - | 62 | 2.44 | 137 | 5.39 | 60 | 2.36 | 196 | 7.72 | | |
| 92182 | 8500 | 20.5-55.5 | 0.81-2.19 | - | - | - | - | 62 | 2.44 | 137 | 5.39 | 60 | 2.36 | 196 | 7.72 | | |
| 92192 | 8500 | - | - | 27.3 | 1.07 | 96.2 | 3.79 | 108 | 4.25 | 116 | 4.57 | 60 | 2.36 | 196 | 7.72 | | |
| 92202 | 8500 | - | - | 41.1 | 1.62 | 109.9 | 4.33 | 138 | 5.43 | 116 | 4.57 | 60 | 2.36 | 196 | 7.72 | | |
| 92222 | 1400 | 12.7-64 | 0.50-2.52 | - | - | - | - | 50.8 | 2.00 | 83 | 3.27 | 50.8 | 2.00 | 233.8 | 9.20 | | |
| 92232 | 1400 | 18.4-64 | 0.72-3.44 | - | - | - | - | 62 | 2.44 | 115 | 4.53 | 60 | 2.36 | 253 | 9.96 | | |
| 106682 | 1500 | 19-95 | 0.75-3.74 | - | - | - | - | 76 | 2.99 | 124 | 4.88 | 68.3 | 2.69 | 261.5 | 10.30 | | |
| 92242 | 1400 | 41.1-109.9 | 1.62-4.33 | - | - | - | - | 62 | 2.44 | 137 | 5.39 | 60 | 2.36 | 253 | 9.96 | | |
| 92252 | 1400 | 20.5-55.5 | 0.81-2.19 | - | - | - | - | 62 | 2.44 | 137 | 5.39 | 60 | 2.36 | 253 | 9.96 | | |
| 92262 | 1400 | - | - | 27.3 | 1.07 | 96.2 | 3.79 | 108 | 4.25 | 116 | 4.57 | 60 | 2.36 | 253 | 9.96 | | |
| 92272 | 1400 | - | - | 41.1 | 1.62 | 109.9 | 4.33 | 138 | 5.43 | 116 | 4.57 | 60 | 2.36 | 253 | 9.96 | | |
| 52362 | 8500 | 18.4-87.3 | 0.72-3.44 | - | - | - | - | 62 | 2.44 | 115 | 4.53 | 60 | 2.36 | 193.5 | 7.62 | | |
| 204183 | 5300 | 19-95 | 0.75-3.74 | - | - | - | - | 76 | 2.99 | 124 | 4.88 | 68.3 | 2.69 | 188 | 7.40 | | |
| 52462 | 8500 | 41.1-109.9 | 1.62-4.33 | - | - | - | - | 62 | 2.44 | 137 | 5.39 | 60 | 2.36 | 193.5 | 7.62 | | |
| 52442 | 8500 | 20.5-55.5 | 0.81-2.19 | - | - | - | - | 62 | 2.44 | 137 | 5.39 | 60 | 2.36 | 193.5 | 7.62 | | |
| 52392 | 8500 | - | - | 27.3 | 1.07 | 96.2 | 3.79 | 108 | 4.25 | 116 | 4.57 | 60 | 2.36 | 193.5 | 7.62 | | |
| 52422 | 8500 | - | - | 41.1 | 1.62 | 109.9 | 4.33 | 138 | 5.43 | 116 | 4.57 | 60 | 2.36 | 193.5 | 7.62 | | |
| 204193 | 700 | 19-95 | 0.75-3.74 | - | - | - | - | 76 | 2.99 | 124 | 4.88 | 68.3 | 2.69 | 260.4 | 10.25 | | |
| 104062 | 8500 | 18.4-87.3 | 0.72-3.44 | - | - | - | - | 62 | 2.44 | 115 | 4.53 | 60 | 2.36 | 196 | 7.72 | | |
| 106672 | 5300 | 19-95 | 0.75-3.74 | - | - | - | - | 76 | 2.99 | 124 | 4.88 | 68.3 | 2.69 | 211 | 8.31 | | |
| 104022 | 8500 | 41.1-109.9 | 1.62-4.33 | - | - | - | - | 62 | 2.44 | 137 | 5.39 | 60 | 2.36 | 196 | 7.72 | | |
| 104032 | 8500 | 20.5-55.5 | 0.81-2.19 | - | - | - | - | 62 | 2.44 | 137 | 5.39 | 60 | 2.36 | 196 | 7.72 | | |
| 104042 | 8500 | - | - | 27.3 | 1.07 | 96.2 | 3.79 | 108 | 4.25 | 116 | 4.57 | 60 | 2.36 | 196 | 7.72 | | |
| 104052 | 8500 | - | - | 41.1 | 1.62 | 109.9 | 4.33 | 138 | 5.43 | 116 | 4.57 | 60 | 2.36 | 196 | 7.72 | | |
| 104122 | 1400 | 18.4-87.3 | 0.72-3.44 | - | - | - | - | 62 | 2.44 | 115 | 4.53 | 60 | 2.36 | 196 | 7.72 | | |
| 106692 | 1500 | 19-95 | 0.75-3.74 | - | - | - | - | 76 | 2.99 | 124 | 4.88 | 68.3 | 2.69 | 260 | 10.24 | | |
| 104072 | 1400 | 41.1-109.9 | 1.62-4.33 | - | - | - | - | 62 | 2.44 | 137 | 5.39 | 60 | 2.36 | 233.5 | 9.19 | | |
| 104082 | 1400 | 20.5-55.5 | 0.81-2.19 | - | - | - | - | 62 | 2.44 | 137 | 5.39 | 60 | 2.36 | 233.5 | 9.19 | | |
| 104092 | 1400 | - | - | 27.3 | 1.07 | 96.2 | 3.79 | 108 | 4.25 | 116 | 4.57 | 60 | 2.36 | 233.5 | 9.19 | | |
| 104102 | 1400 | - | - | 41.1 | 1.62 | 109.9 | 4.33 | 138 | 5.43 | 116 | 4.57 | 60 | 2.36 | 233.5 | 9.19 | | |

fixed spindle

specification

| PART NO. | MAXIMUM SPEED | MINIMUM/MAXIMUM CENTRES | | MINIMUM PCD | | MAXIMUM PCD | | OE | | F | | H | |
|----------|---------------|-------------------------|-----------|-------------|-----------|-------------|------|-------------|-----------|---------|-----------|-------------|-----------|
| | rpm | mm | ins | mm | ins | mm | ins | mm | ins | mm | ins | mm | ins |
| MSD100 | 5300 | 9.5-63.5 | 0.37-2.52 | 9.5/12.7 | 0.37/0.50 | 63.5 | 2.50 | 56-81.8 | 2.20-3.22 | 37/40.5 | 1.46/1.59 | 168/175.4 | 6.61/6.91 |
| MST100 | 1400 | 9.5-63.5 | 0.37-2.52 | 9.5/12.7 | 0.37/0.50 | 63.5 | 2.50 | 56-81.8 | 2.20-3.22 | 37/40.5 | 1.46/1.59 | 227.8/233.8 | 8.97/9.20 |
| MSD200 | 5300 | 19-95 | 0.75-3.74 | 19 | 0.75 | 95 | 3.74 | 100.8-126.2 | 3.97-4.97 | 57.2 | 2.25 | 211.1 | 8.31 |
| MST200 | 700 | 19-95 | 0.75-3.74 | 19 | 0.75 | 95 | 3.74 | 100.8-126.2 | 3.97-4.97 | 57.2 | 2.25 | 260 | 10.24 |
| MSD300 | 3500 | 17.4-157 | 0.69-6.18 | 17.4 | 0.69 | 157 | 6.18 | 150-225 | 5.91-8.86 | 26-41 | 1.02-1.61 | 221-241 | 8.70-9.49 |
| MST300 | 1500 | 17.4-157 | 0.69-6.18 | 17.4 | 0.69 | 157 | 6.18 | 150-225 | 5.91-8.86 | 26-41 | 1.02-1.61 | 221-241 | 8.70-9.49 |

For fixed spindle heads minimum centres are dependent on collet size, overall diameter on the distance between spindles and overall lengths on collet size. Desoutter can provide dimensions if required.

Always provide details of hole pattern, hole diameters and material to be machined when ordering a fixed spindle head.

Multiple Spindle Heads – Collets



- Collets for multiple spindle heads
- Types A, B and D are threaded types
- Type C are ER11 type

| SIZE | | COLLET TYPE | | | |
|-------|-----|-------------|-------|-------|-------|
| ins | mm | A | B | C | D |
| 0.020 | 0.5 | | | 52582 | |
| 0.024 | 0.6 | | | 52582 | |
| 0.028 | 0.7 | | | 52582 | |
| 0.031 | 0.8 | | | 52582 | |
| 0.035 | 0.9 | | | 52582 | |
| 0.039 | 1 | 60002 | 39442 | 52582 | |
| 0.043 | 1.1 | 60022 | 39452 | 52592 | |
| 0.047 | 1.2 | 60032 | 39462 | 52592 | |
| 0.051 | 1.3 | 60042 | 39472 | 52592 | |
| 0.055 | 1.4 | 60052 | 39482 | 52592 | |
| 0.059 | 1.5 | 60062 | 39492 | 52592 | |
| 0.063 | 1.6 | 60072 | 27852 | 52602 | |
| 0.067 | 1.7 | 60082 | 39502 | 52602 | |
| 0.071 | 1.8 | 60092 | 27862 | 52602 | |
| 0.075 | 1.9 | 60102 | 39522 | 52602 | |
| 0.079 | 2 | 60122 | 27872 | 52602 | 39302 |
| 0.083 | 2.1 | 60132 | 27882 | 52622 | 39322 |
| 0.087 | 2.2 | 60142 | 27892 | 52622 | 39332 |
| 0.091 | 2.3 | 60152 | 27902 | 52622 | 39342 |
| 0.094 | 2.4 | 60162 | 27922 | 52622 | 39352 |
| 0.098 | 2.5 | 60172 | 27932 | 52622 | 39362 |
| 0.102 | 2.6 | 60182 | 27942 | 52632 | 39372 |
| 0.106 | 2.7 | 60192 | 27952 | 52632 | 39382 |
| 0.110 | 2.8 | 60202 | 27962 | 52632 | 39392 |
| 0.114 | 2.9 | 60222 | 27972 | 52632 | 39402 |
| 0.118 | 3 | 60232 | 27982 | 52632 | 39422 |
| 0.122 | 3.1 | 60242 | 27992 | 52642 | 39432 |
| 0.126 | 3.2 | 60252 | 28002 | 52642 | 34902 |
| 0.130 | 3.3 | 60262 | 28032 | 52642 | 34932 |
| 0.134 | 3.4 | 60272 | 28042 | 52642 | 34942 |
| 0.138 | 3.5 | 60282 | 28052 | 52642 | 34952 |
| 0.142 | 3.6 | 60292 | 28062 | 52642 | 34962 |
| 0.146 | 3.7 | 60302 | 28082 | 52642 | 34982 |
| 0.150 | 3.8 | 60322 | 28092 | 52642 | 34992 |
| 0.154 | 3.9 | 60332 | 28102 | 52642 | 35002 |
| 0.157 | 4 | 60342 | 28122 | 52642 | 35022 |
| 0.161 | 4.1 | | 28132 | 52652 | 35032 |
| 0.165 | 4.2 | | 28142 | 52652 | 35042 |
| 0.169 | 4.3 | | 28152 | 52652 | 35052 |
| 0.173 | 4.4 | | 28162 | 52652 | 35062 |
| 0.177 | 4.5 | | 28172 | 52652 | 35072 |
| 0.181 | 4.6 | | 28182 | 52652 | 35082 |
| 0.185 | 4.7 | | 28192 | 52652 | 35092 |
| 0.189 | 4.8 | | 28202 | 52652 | 35102 |
| 0.193 | 4.9 | | 28222 | 52652 | 35122 |
| 0.197 | 5 | | 28232 | 52652 | 35132 |

| SIZE | | COLLET TYPE | | | |
|-------|-----|-------------|-------|-------|-------|
| ins | mm | A | B | C | D |
| 0.201 | 5.1 | | 28252 | 52662 | 35152 |
| 0.205 | 5.2 | | 28272 | 52662 | 35172 |
| 0.209 | 5.3 | | 28282 | 52662 | 35182 |
| 0.213 | 5.4 | | 28292 | 52662 | 35192 |
| 0.217 | 5.5 | | 28302 | 52662 | 35202 |
| 0.220 | 5.6 | | 28322 | 52662 | 35222 |
| 0.224 | 5.7 | | 28332 | 52662 | 35232 |
| 0.228 | 5.8 | | 28342 | 52662 | 35242 |
| 0.232 | 5.9 | | 28352 | 52662 | 35252 |
| 0.236 | 6 | | 28372 | 52662 | 35272 |
| 0.240 | 6.1 | | 28382 | 52672 | 35282 |
| 0.244 | 6.2 | | 28392 | 52672 | 35292 |
| 0.248 | 6.3 | | 28402 | 52672 | 35302 |
| 0.252 | 6.4 | | 39532 | 52672 | 35332 |
| 0.256 | 6.5 | | 39542 | 52672 | 35342 |
| 0.260 | 6.6 | | | 52672 | 35352 |
| 0.264 | 6.7 | | | 52672 | 35362 |
| 0.268 | 6.8 | | | 52672 | 35382 |
| 0.272 | 6.9 | | | 52672 | 35392 |
| 0.276 | 7 | | | 52672 | 35402 |
| 0.280 | 7.1 | | | | 35422 |
| 0.283 | 7.2 | | | | 35432 |
| 0.287 | 7.3 | | | | 35452 |
| 0.291 | 7.4 | | | | 35462 |
| 0.295 | 7.5 | | | | 35472 |
| 0.299 | 7.6 | | | | 35492 |
| 0.303 | 7.7 | | | | 35502 |
| 0.307 | 7.8 | | | | 35522 |
| 0.311 | 7.9 | | | | 35532 |
| 0.315 | 8 | | | | 35552 |
| 0.319 | 8.1 | | | | 35562 |
| 0.323 | 8.2 | | | | 35572 |
| 0.327 | 8.3 | | | | 35582 |
| 0.331 | 8.4 | | | | 35592 |
| 0.335 | 8.5 | | | | 35602 |
| 0.339 | 8.6 | | | | 35622 |
| 0.343 | 8.7 | | | | 35632 |
| 0.346 | 8.8 | | | | 35652 |
| 0.350 | 8.9 | | | | 35672 |
| 0.354 | 9 | | | | 35682 |
| 0.358 | 9.1 | | | | 35692 |
| 0.362 | 9.2 | | | | 35722 |
| 0.366 | 9.3 | | | | 35732 |
| 0.370 | 9.4 | | | | 35752 |
| 0.374 | 9.5 | | | | 35762 |