

# Drilling jigs for cylindrical parts

## Surface finish:

A consisting of:

- 08550 drilling jig DIN 6348
- 08710 V-Block with stop
- 08641 locating plate
- 08640 Index drilling disc with 16 accessible drill-bush diameters, see table. Intermediate dimensions can be partially achieved by means of removable drilling bushes DIN 173.

B consisting of:

- 08550 drilling jig DIN 6348
- 08710 V-Block with stop
- 08641 locating plate (this may be omitted in the case of Size 2, but then the max. clamping width is reduced by 30 mm)
- 08650 drill-bush support plate with 4 drill-bush supports Size 5-8,  $\varnothing$  8,  $\varnothing$  10,  $\varnothing$  12 und  $\varnothing$  15. Intermediate dimensions can be achieved in each case using removable drill bushes DIN 173. See table for drill-bush supports of your choice sizes 1 to 4. All drill-bush supports can be used for size 0 and size 2 supports.

## Sample order:

nim 08630-12

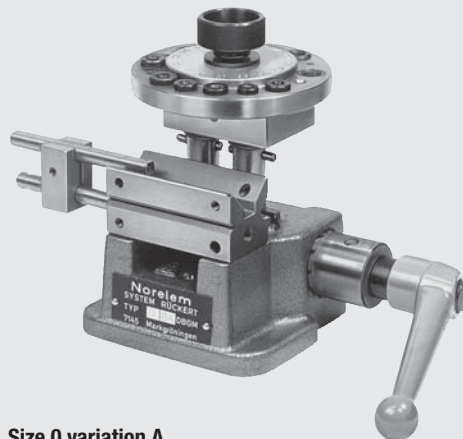
## Note:

Rotary drilling jigs are particularly rational for producing cross holes in rotating parts. The drilling jig DIN 6348 Size 0 and 2 is used as the basic component.

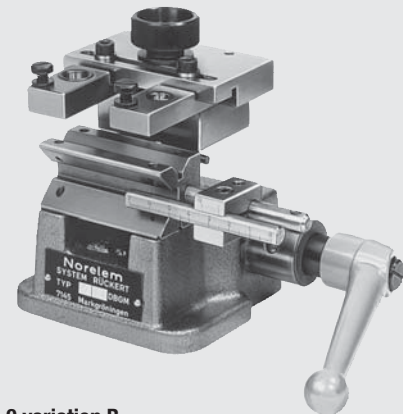
A v-block with adjustable stop, having mini-divisions and vernier is used instead of the standard locating plate. The index drilling discs or drill-bush supports are mounted on the columns. Set-up is very easy and can be done without any technical knowledge.

All parts can be individually supplied later: they are manufactured true to gauge size. This enables finishes A and B to be interchangeable. A clamped part can have holes drilled, countersunk, milled or have threads cut in it using plug-in bushes..

**Size 0**  
for workpieces  $\varnothing$  2 to 28 mm

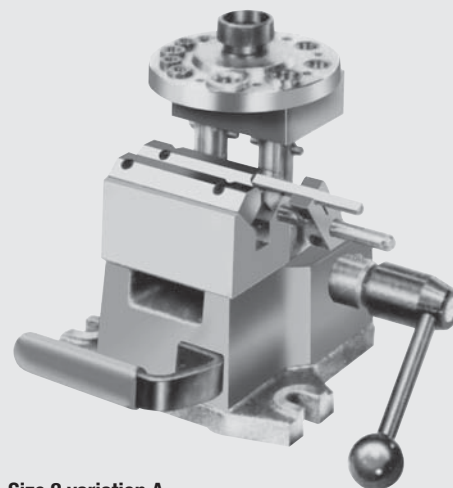


**Size 0 variation A**  
with V-block and index drilling disc



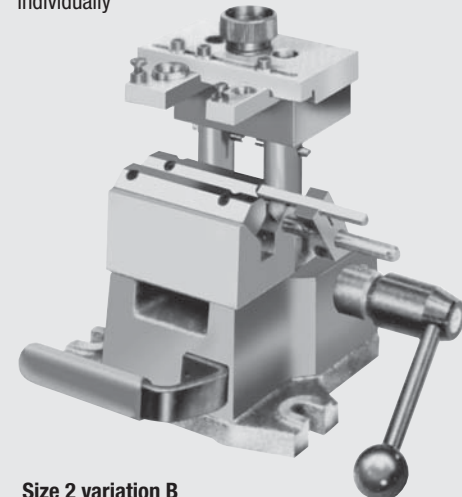
**Size 0 variation B**  
with V-block and bush supports,  
adjustment range of supports: 64 mm

**Size 2**  
for workpieces  $\varnothing$  6 to 60 mm



**Size 2 variation A**  
with V-block and index drilling disc

A shaft having approx. 10 mm  $\varnothing$  should be inserted in order to align the upper strips of the V-block: only then can you tighten the hexagon socket screws individually



**Size 2 variation B**  
with V-block and bush supports,  
adjustment range of supports: 100 mm

Order No.	Size	Surface finish	Approx. weight kg
08630-10	0	A	3,000
08630-12	2	A	7,000
08630-20	0	B	3,000
08630-22	2	B	7,000