

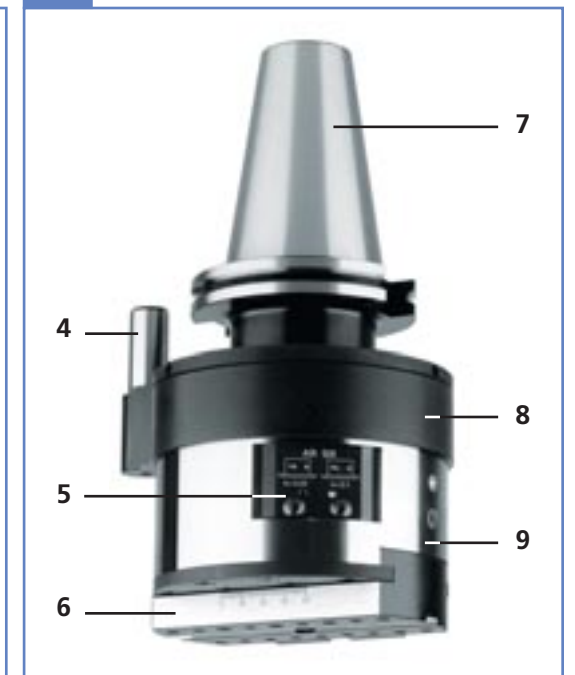
Facing heads with automatic feed and quick return of the slide without stopping or reversing the spindle of the machine tool. Available in 3 models: AR 100, AR 125 and AR 160; they have got a feed and quick return. To change the feed, some interchangeable, optional, gear blocks (F) are available, for feeds in mm/rev. of: 0.05; 0.10; 0.20; 0.40; 0.60 and a quick return of 0.08 mm/rev. The interchangeable arbor uses the same locking system used in the MHD' modular system. A simple attachment of the toolholders to the slide favours the manufacturing of special toolholders. The AUTORADIAL heads are applicable on machining centres and on N.C. machines and, without the need of any electronic interface, they can execute automatically a working cycle of:

- Facing
- Backfacing
- Internal or external grooving for spring washers and O-rings
- Record spiral cutting on flanges.

The cycle is composed of the working feed and of the quick return of the slide without ever stopping or reversing the rotation of the spindle. To reset the cycle, merely reverse the spindle rotation for a few revolutions.

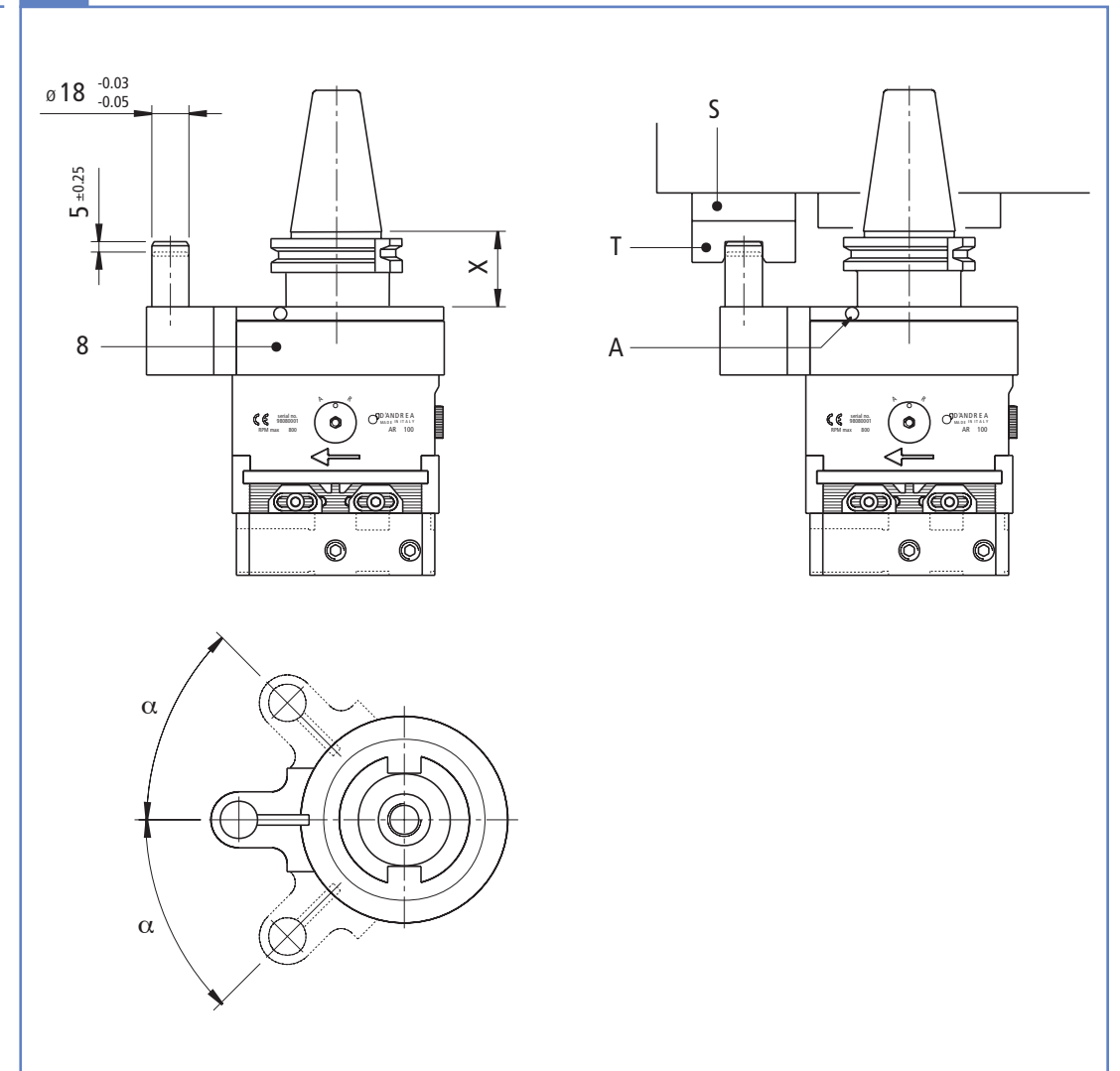
COMPONENTS

1. Override (A), return (R)
2. Limit blocks
3. Control screw
4. Check pin
5. Interchangeable feed block
6. Tool slide
7. Interchangeable arbor
8. Drive flange
9. Rotating body

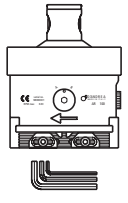


ASSEMBLY

In the AUTORADIAL the slide is moved forward by holding back the drive flange 8 while the spindle is rotating. The T-block supplied with the K-NC KIT is to be applied to a fixed part around the spindle, observing the measurements indicated. If the stroke of the check pin is not 5 ± 0.25 , you must adjust the position of the T-block using the spacer S. The angle α is freely adjustable by loosening the 3 screws A, turning the flange 8 to the desired angle and tightening the screws A.

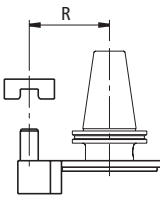


Ko2



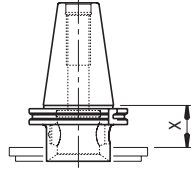
REF.	F		CODE		
	mm/°	inch/°	KO2 AR 100	KO2 AR 125	KO2 AR 160
KO2 AR... - F. 0.05	0.05	.002	50 06 100 20 050	50 06 125 20 050	50 06 160 20 050
KO2 AR... - F. 0.1	0.1	.004	50 06 100 20 100	50 06 125 20 100	50 06 160 20 100
KO2 AR... - F. 0.2	0.2	.0078	50 06 100 20 200	50 06 125 20 200	50 06 160 20 200
KO2 AR... - F. 0.3	0.3	.012	50 06 100 20 300	50 06 125 20 300	50 06 160 20 300
KO2 AR... - F. 0.4	0.4	.0157	50 06 100 20 400	50 06 125 20 400	50 06 160 20 400
KO2 AR... - F. 0.6	0.6	.024	50 06 100 20 600	50 06 125 20 600	50 06 160 20 600

K-NC




REF.	CODE		
	R.65	R.80	R.110
K-NC R... - AR 100	39 41 100 065 02	39 41 100 080 02	-
K-NC R... - AR 125	-	39 41 125 080 02	39 41 125 110 02
K-NC R... - AR 160	-	39 41 160 080 02	39 41 160 110 03

MHD' ARBOR




MHD'	AR 100		AR 125		AR 160	
	CODE	X	CODE	X	CODE	X
		mm inch		mm inch		mm inch
DIN 69871 - A40	41 6 50 01 040 20	36.5 1.44	41 6 63 01 040 20	68.5 2.7	-	-
DIN 69871 - A50	41 6 50 01 050 20	36.5 1.44	41 6 63 01 050 20	44.5 1.75	41 6 80 01 050 20	50.5 2
MAS 403 BT 40	41 6 50 01 040 30	36.5 1.44	41 6 63 01 040 30	54.5 2.15	-	-
MAS 403 BT 50	41 6 50 01 050 30	54.5 2.15	41 6 63 01 050 30	63.5 2.5	41 6 80 01 050 30	63.5 2.5
CAT 40 UNC	41 6 50 01 040 45	54.5 2.15	41 6 63 01 040 45	88.5 3.48	-	-
CAT 50 UNC	41 6 50 01 050 45	36.5 1.44	41 6 63 01 050 45	44.5 1.75	41 6 80 01 050 45	50.5 2
HSK - A63	41 6 50 15 063 20	54.5 2.15	41 6 63 15 063 20	63.5 2.5	-	-
HSK - A100	41 6 50 15 100 20	60.5 2.38	41 6 63 15 100 20	70.5 2.77	41 6 80 15 100 20	76.5 3
DIN 2080 - A40 'OTT'	41 6 50 01 040 00	36.5 1.44	41 6 63 01 040 00	48.5 1.9	-	-
DIN 2080 - A50 'OTT'	41 6 50 01 050 00	36.5 1.44	41 6 63 01 050 00	44.5 1.75	41 6 80 01 050 00	44.5 1.75

TOOLHOLDERS P110

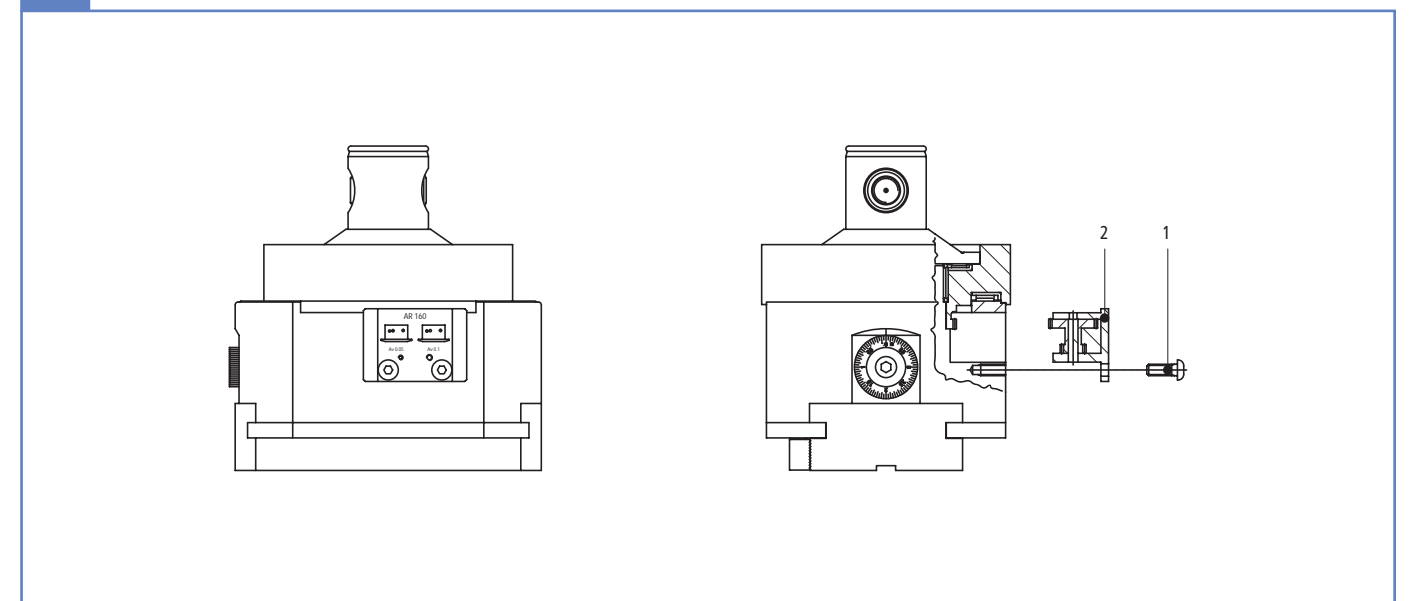


REF.	CODE	G		H		Ø	
		mm	inch	mm	inch	mm	inch
P110 - AR 100	43 30 50 30 096 0	96	3.78	30	1.18	20	.79
P110 - AR 125	43 30 56 38 120 0	121	4.76	39	1.53	25	.98
P110 - AR 160	43 30 63 48 160 0	164	6.46	49	1.93	32	1.26

INTERCHANGEABLE FEEDS F...

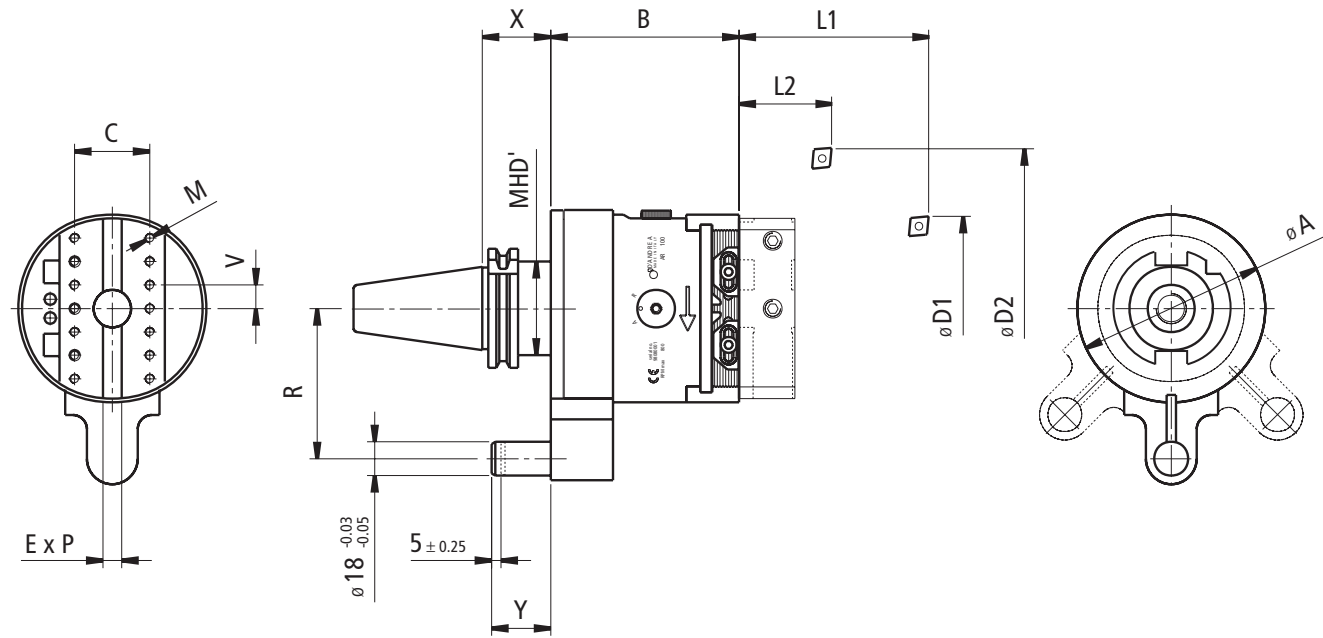


REF.	F		CODE		
	mm/°	inch/°	AR 100	AR 125	AR 160
F 0.05 - AR...	0.05	.002	38 20 060 05 001	38 20 061 05 001	38 20 062 05 001
F 0.1 - AR...	0.1	.004	38 20 060 10 001	38 20 061 10 001	38 20 062 10 001
F 0.2 - AR...	0.2	.0078	38 20 060 20 001	38 20 061 20 001	38 20 062 20 001
F 0.3 - AR...	0.3	.012	38 20 060 30 001	38 20 061 30 001	38 20 062 30 001
F 0.4 - AR...	0.4	.0157	38 20 060 40 001	38 20 061 40 001	38 20 062 40 001
F 0.6 - AR...	0.6	.024	38 20 060 60 001	38 20 061 60 001	38 20 062 60 001



INSTRUCTIONS TO REPLACE THE FEED BLOCK

- a. Loosen the screw 1
- b. Extract block 2
- c. Insert new block 2 lubricated with ISO-UNI XM2 grease
- d. Lock screw 1



AR 100



AR 125



AR 160

TECHNICAL DATA			AR 100		AR 125		AR 160	
ø A	mm	inch	100	3.94"	125	4.92"	160	6.30"
B	mm	inch	100	3.94"	110	4.33"	125	4.72"
R	mm	inch	65-80	2.56"-3.15"	80-110	3.15"-4.33"	80-110	3.15"-4.33"
Y	mm	inch	31.5	1.25"	39.5	1.55"	45.5	1.79"
X	mm	inch	p. 142					
D1 x L1	mm	inch	148x125	5.8x4.9"	190x160	7.5x6.3"	270x200	10.6x7.9"
D2 x L2	mm	inch	250x31	9.8x1.2"	320x40	12.6x1.5"	400x50	15.7x1.2"
C	mm	inch	40	1.57"	40	1.57"	50	1.97"
V	mm	inch	12.5	0.49"	12.5	0.49"	15	0.59"
M	mm	inch	M5		M5		M6	
E x P	mm	inch	10 x 2.5	0.39x0.1"	10 x 2.5	0.39x0.1"	12 x 2.5	0.47x0.1"
MHD'			50		63		80	
Radial trasverse	mm	inch	25	1"	40	1.57"	70	2.76"
Interchangeable feeds	mm/∅	inch/∅	p. 143					
Quick return	mm/∅	inch/∅	0.8	.0315"	0.8	.0315"	0.8	.0315"
Max. rotation	RPM	RPM	630		500		400	
Weight without arbor	Kg	pounds	5.5	12	9	20	14	31

