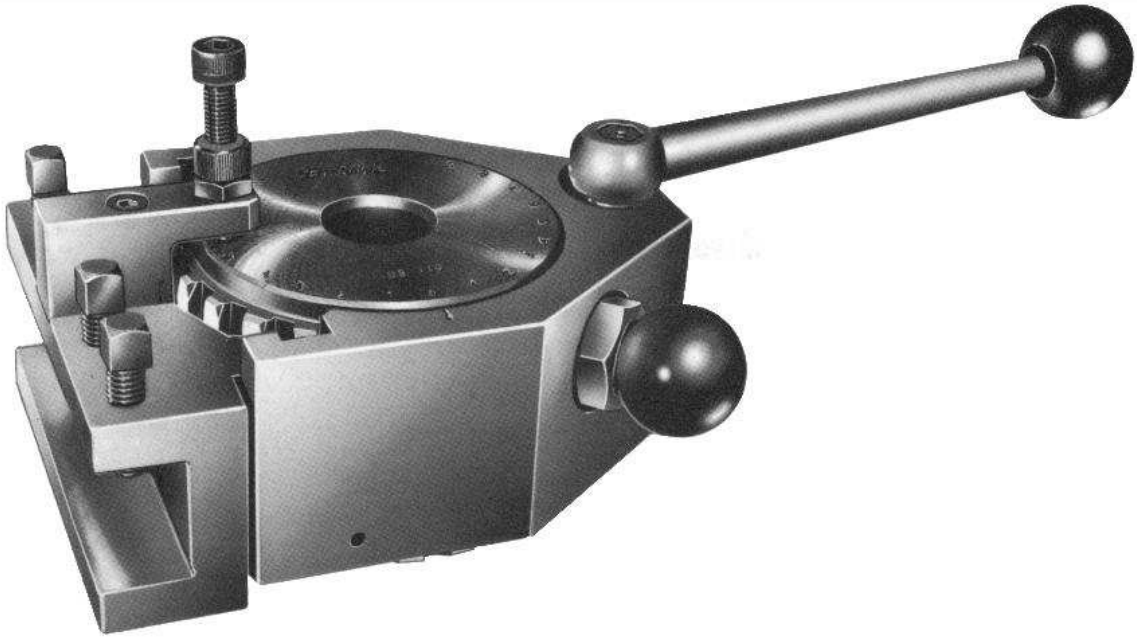
QUICK CHANGE TOOLHOLDER

Drehblitz

= three-point support = absolute fitting



Repeat Accuracy .0001"
Tool change at lightning speed
Chatterproof

Tool changes at lightning speed. Positive indexing by fool-proof ratchet stop and firm lock-grooves.

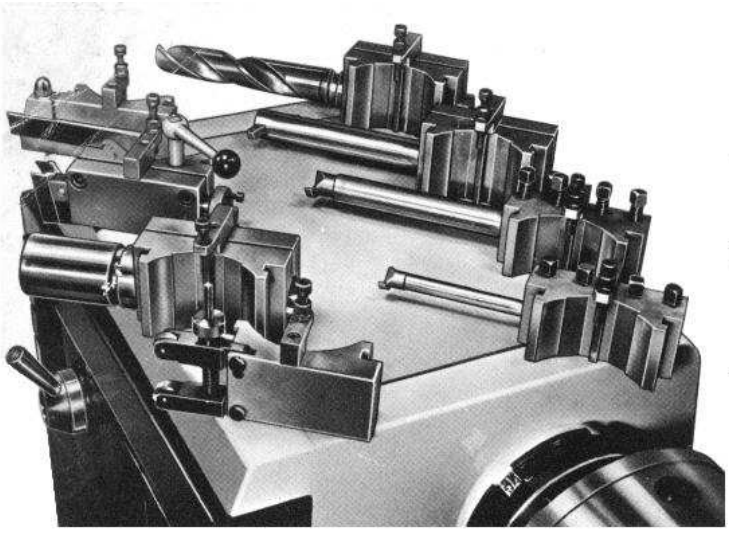
Functional and clear graduations and self-locking indexing positions every 15°.

Chatterproof owing to large support surface.

Solid and compact design.

Large selection of sizes.

Many types of tool holders.



Selection of the proper size

Indications for the selection of the proper size are shown in the table on the next page. The maximum height of the cutting edge is equal to the distance between the top of the support slide and the lathe centre less the height of the base „s".
A great variety of sizes enables the selection of the most suitable type for every lathe.

Mounting

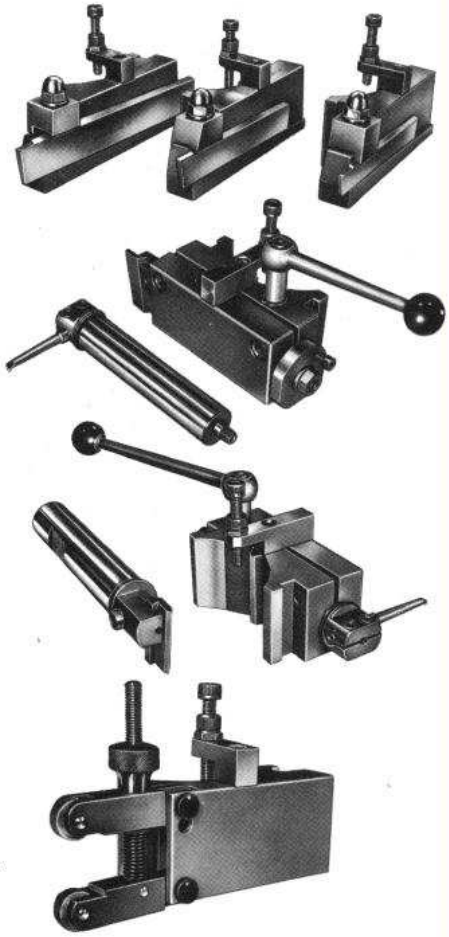
If there is a bolt on the top of the support, the DREHBLITZ is placed over it and locked with a washer and a nut. If there ist a Tee-slot in the top of the compound, a center bolt with threaded end and a Tee-nut is fitted into the slot and the DREHBLITZ placed over it and locked with a washer and a nut. The proper centering is obtained with a bush with the diameter „a" to be slid over the bolt. Always select the maximum diameter bolt which still fits into the centering bush. The turret head is secured against twisting by two dowel pins. These are inserted into the support slide, parallel to the spindle.

Operation

The DREHBLITZ can be indexed every 15° to a full 360° into 24 tool positions. The tool holders are firmly locked against the one-piece bracket of the turret head by a hand lever operated cam and a locking block.

Height adjustment of the tool holder is done quickly, easily and accurately by a height adjustment screw with a double lock nut.

Each angular position into which a tool holder can be inserted on the DREHBLITZ is positively determined by the snapping-in of the bracket and besides, also indicated by the graduations. Quick and above all, position-safe application of the tool holder is thereby ensured. The Head, Bracket and Toolholders are deep case hardened, according to size, to ensure a long life.



With the plain **Tool Holder** all straight tools can be held,

with the **Small Bar Holder** small triangular and round tools,

with the **Large Bar Holder** larger triangular and round tools,

with the **Bush Holder** boring bars, using a split bushing if necessary, a taper sleeve or a threading die,

with the **Parting-off Holder** parting-off blades of HSS or carbide tipped, made to our own standards. Each parting-off holder is suitable to hold blades of three different heights, by using 2 inserts, according to the table.

Very useful is the **Retracting Holder** for threading. It enables both the rapid release of the threading tool at the end of the thread and the feeding-in during the slide return. An adjustable stop screw controls the stroke. By a swivelling pinion gear every required pitch both for RH and LH threads can be cut. Only KOMET Tangential Tools can be used with the retractable holder.

There is also an **attachment for inside threading.**

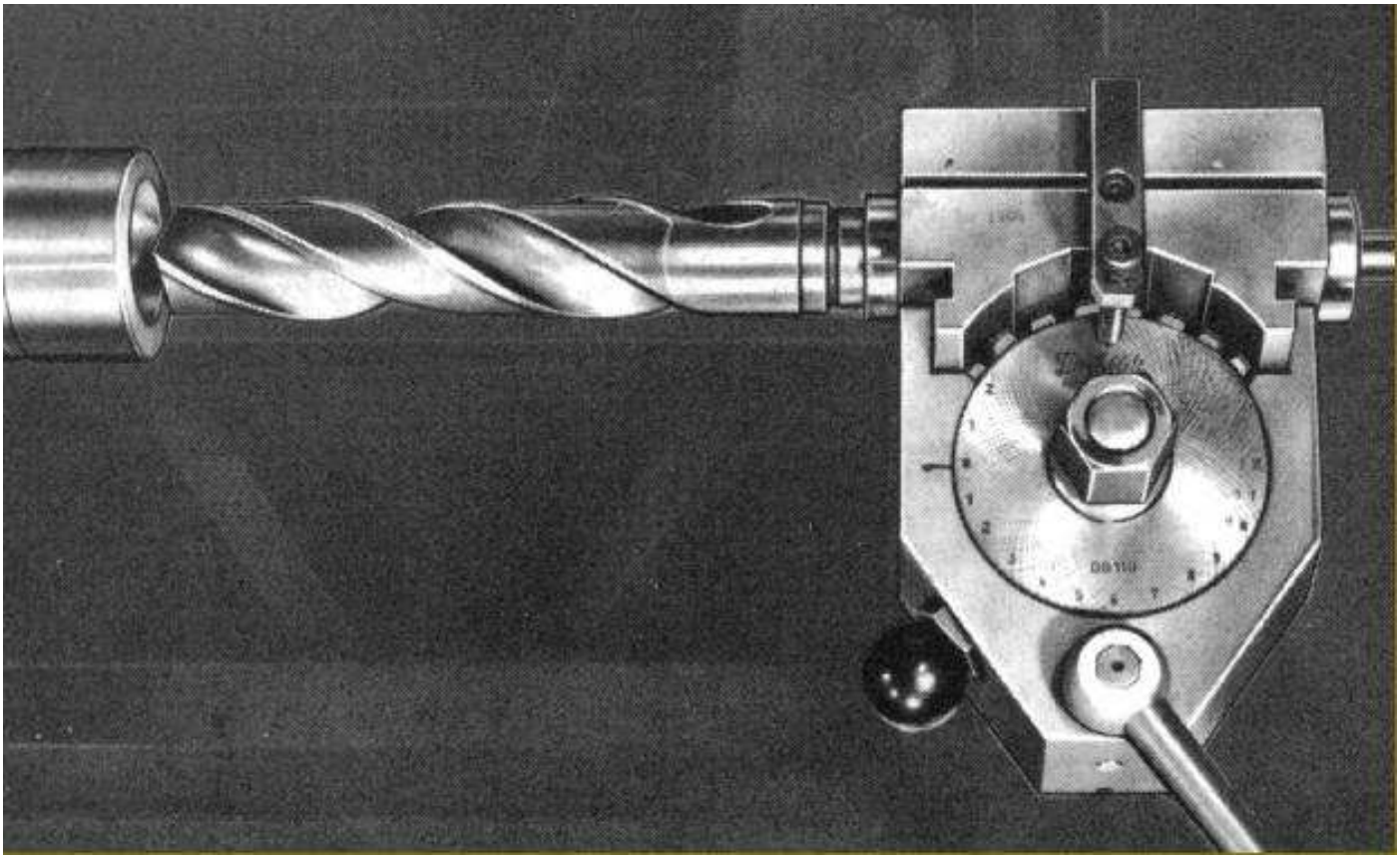
By using the **Knurling Tool Holder** there is no strain on the spindle, tailstock and headstock bearing, since the tool itself absorbs the thrust. The Knurling Tool Holder is supplied without the knurls.

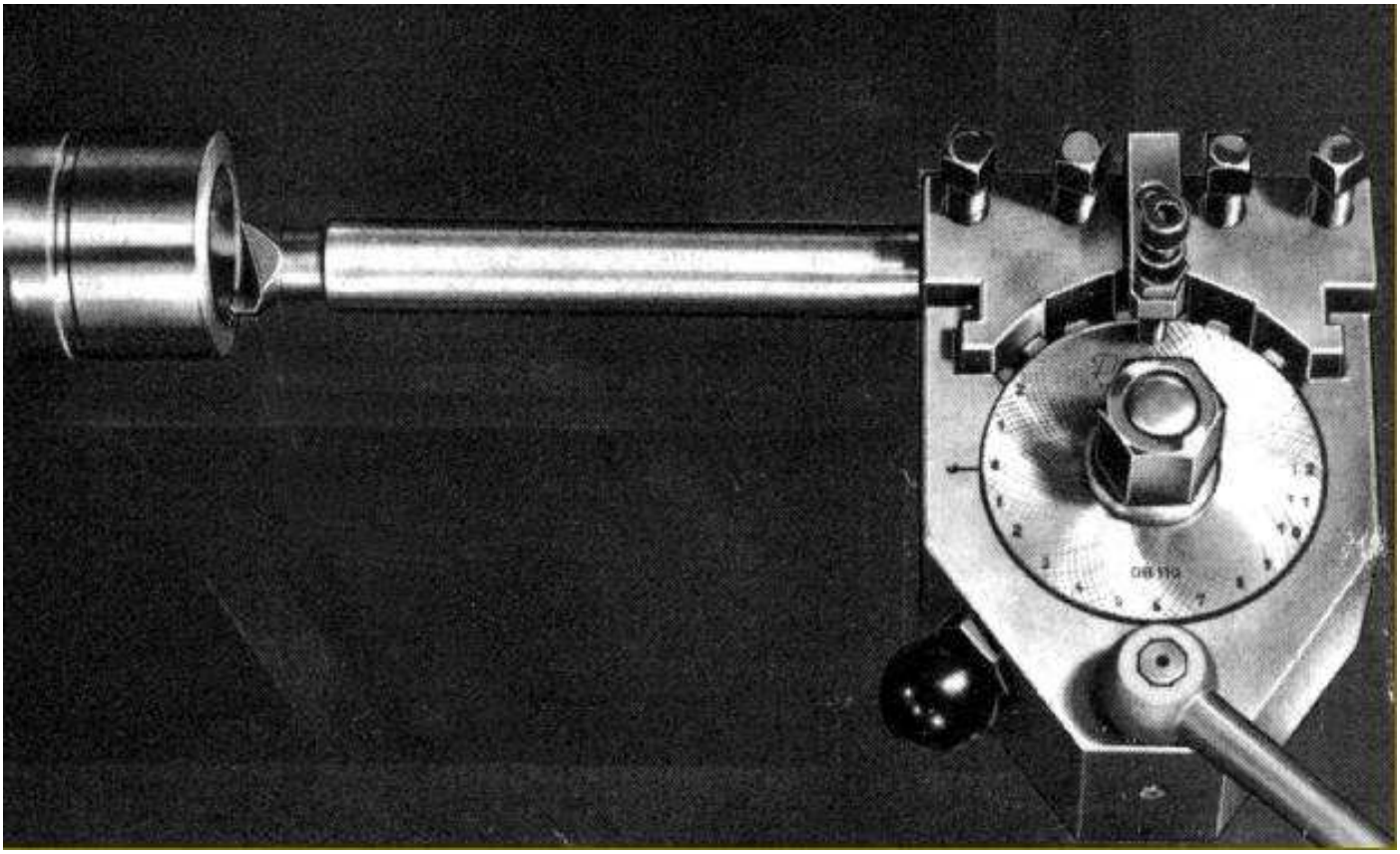
Dismantling

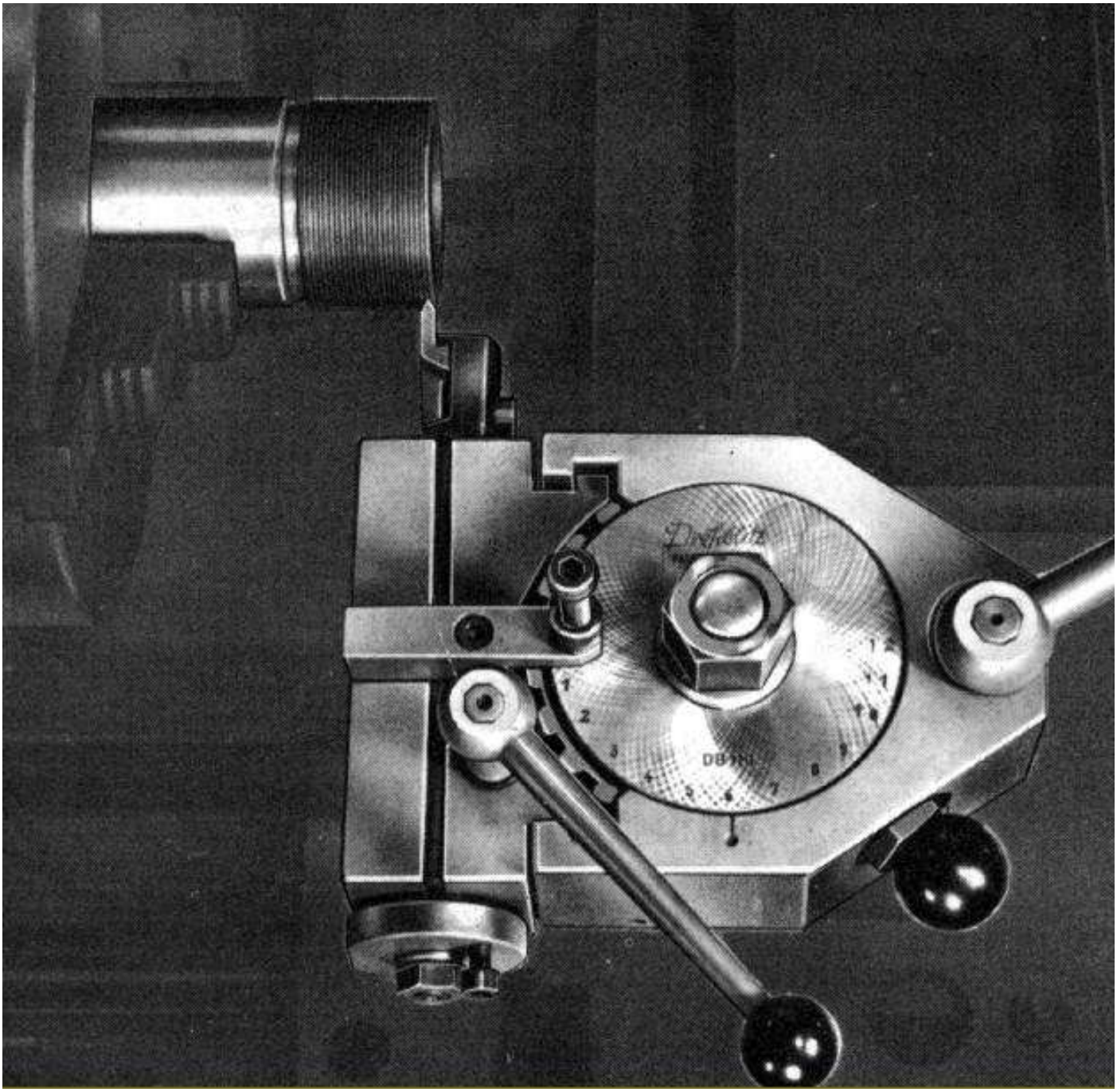
The two hex screws at the side of the bracket are unscrewed and the safety rings between the head and the bracket are pushed out. This is done by holding from the bottom the one half of the ring which is in the slot at the cam bore, with a screw driver, and by turning the bracket. This will release the ring which can be removed. The same procedure applies to the second half ring.
In most cases the ring is released when the bracket is turned quickly so that the DREHBLITZ can be left mounted on the lathe. When pulling up the bracket, watch that the ratchet ball should not jump out or get lost.

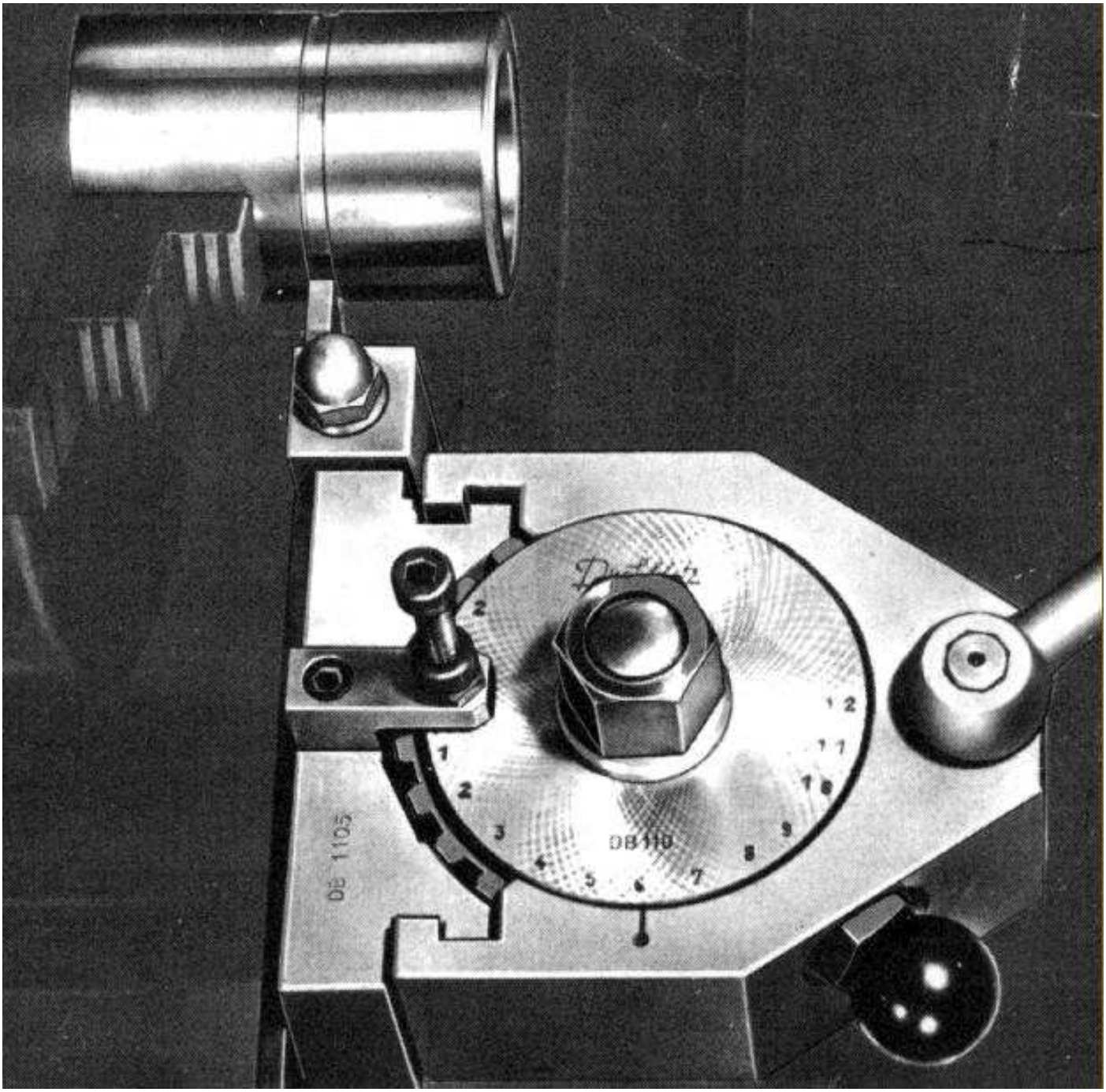
Assembly

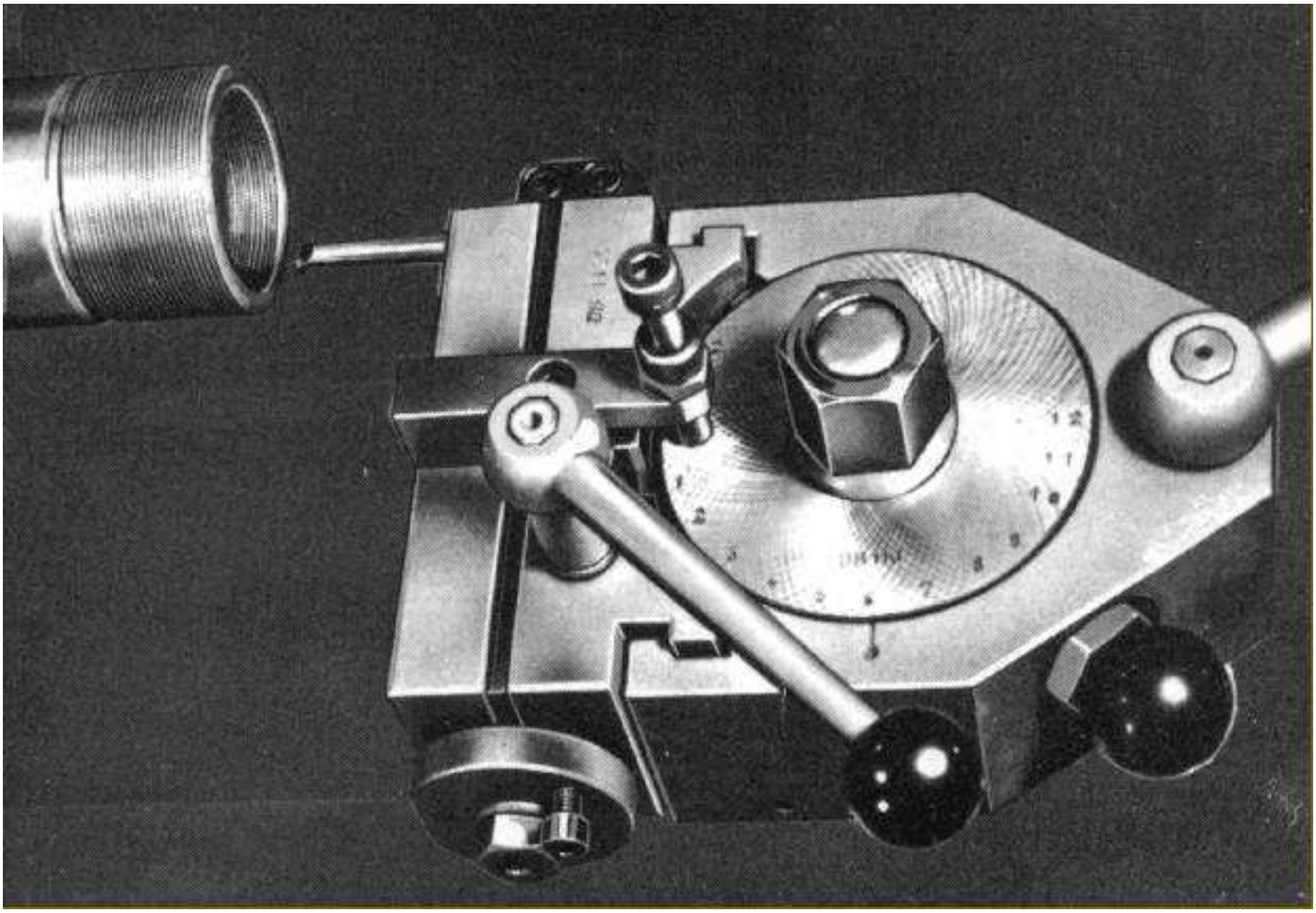
If the ratchet ball cannot be put back during the assembly, the ball of the indexing handle can be removed after releasing the counter nut. The position of the ball should be previously marked since it has an off-set bore for proper seating.

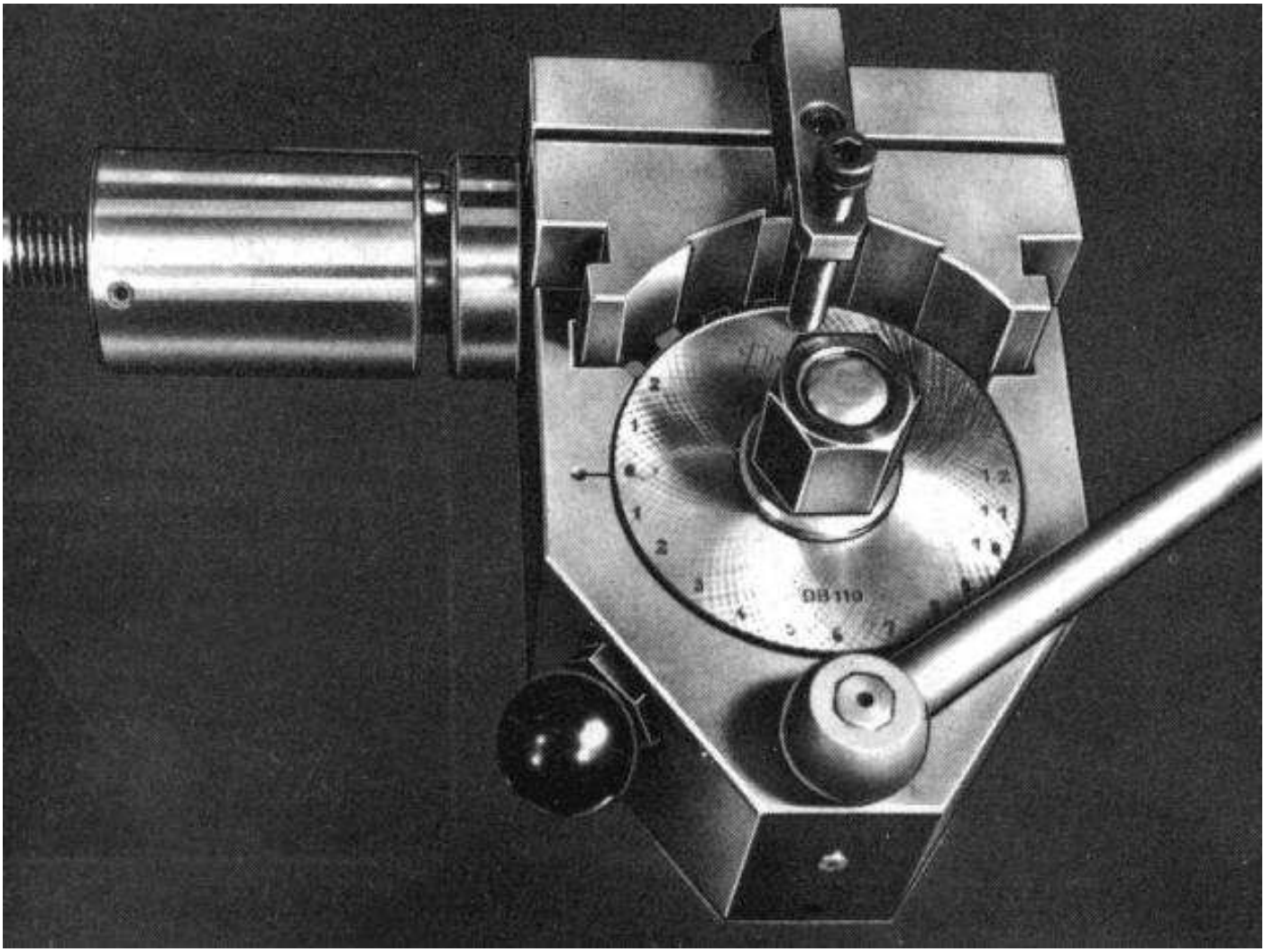


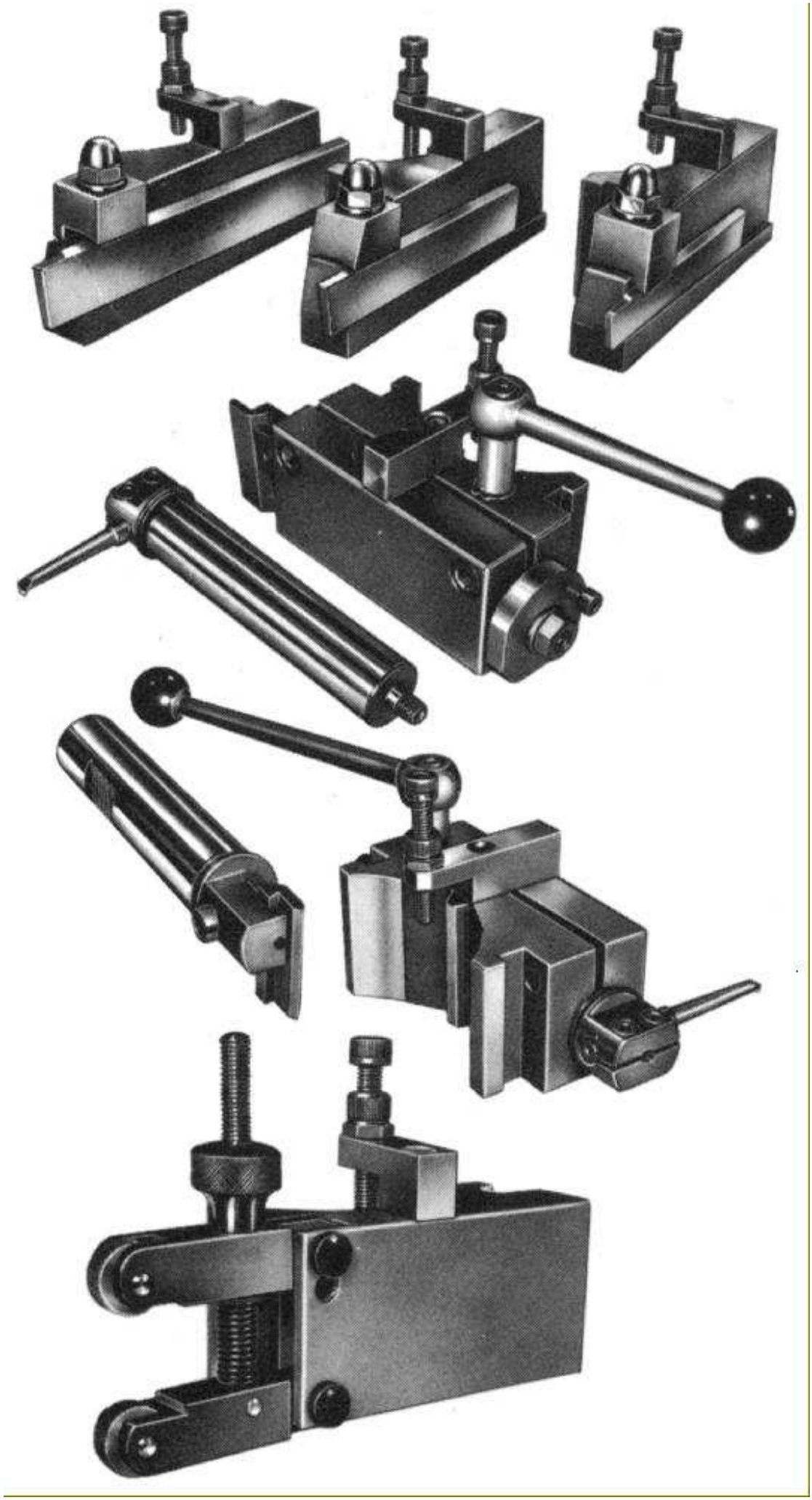




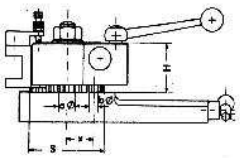

DB 1105
DB110



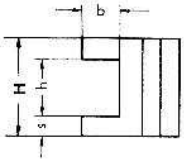

DB110



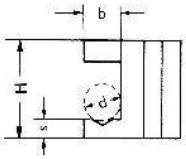
Swing	**min. mm**	–	–	8"	200	13"	320	14"	350	15"	380	17"	420	25"	620
	max. mm	10"	250	15"	380	18"	450	20"	500	25"	620	30"	750	–	–
Ht. of centers	**mm**	4"	100	6"	150	7"	180	8"	200	9"	225	10"	250	14"	350
Max. power	**HP kW**	1	1	3	2	5	4	10	8	16	12	20	15	40	30
Width of top slide	**mm**	2 3/4"	70	4"	100	4 3/4"	120	6"	150	6 3/4"	170	7 1/2"	190	10"	250



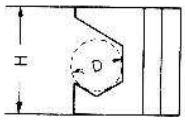
Turret		**DB 50**	**DB 70**	**DB 90**	**DB 110**	**DB 130**	**DB 150**	**DB 200**
Dia.	mm	2" 50	2 3/4" 70	3 9/16" 90	4 5/16" 110	5 1/8" 130	5 7/8" 150	7 7/8" 200
Height **H**	mm	1 5/8" 42	2 1/8" 55	2 7/16" 62	2 7/8" 72	3 3/8" 85	3 5/8" 92	4 7/8" 125
Width	mm	2 3/8" 60	3 3/8" 86	4 1/8" 105	5" 128	5 7/8" 148	6 7/8" 174	8 7/8" 224
Bore dia. **a**	mm	5/8" 16	25/32" 20	1" 25	1" 25	1 1/4" 32	1 1/4" 32	137/64" 40
Bore for pin, dia. **b**	mm	13/64" 5	15/64" 6	5/16" 8	5/16" 8	25/64" 10	25/64" 10	15/32" 12
Center distance **x**	mm	45/64" 18	63/64" 25	1 11/32" 34	1 22/32" 42,5	1 31/32" 50	2 21/64" 59	2 61/64" 75
Weight	lbs kg	2 0,9	4 2,2	10 4,7	15 6,8	26 12	33 15,3	81 37



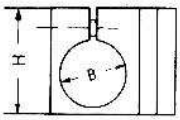
Tool Holder		**DB 501**	**DB 701**	**DB 901**	**DB 1101**	**DB 1301**	**DB 1501**	**DB 2001**
Height **H**	mm	1 3/8" 34	1 3/4" 43	1 7/8" 49	2 1/4" 58	2 3/4" 68	2 7/8" 74	4 1/4" 106
Base height **s**	mm	1/4" 6	3/8" 9	7/16" 11	1/2" 13	9/16" 14	5/8" 15	7/8" 22
Gap height **h**	mm	3/4" 20	1" 25	1" 26	1 1/4" 32	1 5/8" 40	1 3/4" 43	1 1/2" 62
Width **b**	mm	7/16" 10	5/8" 16	3/4" 18	55/64" 22	1" 26	1" 26	1 7/32" 32
Length	mm	2 3/8" 60	3 5/8" 90	4 3/8" 110	5 1/8" 130	6" 150	7 1/8" 180	8 3/4" 220
Weight	lbs kg	.7 0,3	1.55 0,7	2.2 1,0	4.2 1,9	6.6 3,0	8.2 3,7	20 9,0



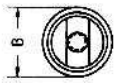
Small Bar Holder		**DB 502**	**DB 702**	**DB 902**	**DB 1102**	**DB 1302**	**DB 1502**	**DB 2002**
Height **H**	mm	1 3/8" 34	1 3/4" 43	1 7/8" 49	2 1/4" 58	2 3/4" 68	2 7/8" 74	4 1/4" 106
Base height **s**	mm	1/4" 6	3/8" 9	7/16" 11	1/2" 13	9/16" 14	5/8" 15	7/8" 22
Bar dia. **D**	mm	7/16" 10	5/8" 16	3/4" 18	55/64" 22	1" 26	1" 26	1 7/32" 32
Length	mm	2 3/8" 60	3 5/8" 90	4 3/8" 110	5 1/8" 130	6" 150	7 1/8" 180	8 3/4" 220
Weight	lbs kg	.7 0,3	1.55 0,7	2.2 1,0	4.2 1,9	6.6 3,0	8.2 3,7	20 9,0



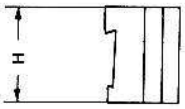
Large Bar Holder			**DB 703**	**DB 903**	**DB 1103**	**DB 1303**	**DB 1503**	**DB 2003**
Height **H**	mm	– –	1 3/4" 43	1 7/8" 49	2 1/4" 59	2 7/8" 74	3 1/8" 79	4 1/4" 106
Bar dia. **D**	mm	– –	7/8" 22	1" 25	1 1/4" 30	1 5/8" 40	1 5/8" 40	2" 50
Length	mm	– –	3 5/8" 90	4 3/8" 110	5 1/8" 130	6" 150	7 1/8" 180	8 3/4" 220
Weight	lbs kg	– –	1.55 0,7	2.2 1,0	4.2 1,9	8.8 4,0	9.9 4,5	21.6 9,8



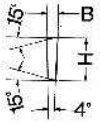
Bush Holder		**DB 504**	**DB 704**	**DB 904**	**DB 1104**	**DB 1304**	**DB 1504**	**DB 2004**
Height **H**	mm	1 3/8" 34	1 3/4" 45	2 1/4" 58	2 3/4" 69	3 1/8" 78	3 1/8" 79	3 1/2" 87
Bore dia. **B**	mm	5/8" 16	7/8" 22	1 3/16" 30	1 9/16" 40	1 9/16" 40	1 31/32" 50	2 7/32" 56
Length	mm	2 3/8" 60	3 5/8" 68	4 3/8" 110	5 1/8" 130	6" 150	7 1/8" 180	8 3/4" 220
Weight	lbs kg	.7 0,3	1.8 0,8	2.4 1,1	5.8 2,6	7.7 3,5	12 5,4	17.6 8,0



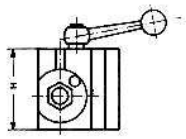
Bush		**KB 1**	**KB 2**	**KB 3**	**KB 4**	**KB 4**	**KB 4/5**	**KB 5**
Morse Taper	MK	**MT 1** 1	**MT 2** 2	**MT 3** 3	**MT 4** 4	**MT 4** 4	**MT 4** 4	**MT 5** 5
Dia.	mm	5.8" 16	7/8" 22	1 3/16" 30	1 9/16" 40	1 9/16" 40	1 31/32" 50	2 7/32" 56
Length	mm	3 1/8" 80	3 5/8" 93	4 9/16" 115	5 5/8" 155	5 5/8" 155	6 7/8" 175	6 7/8" 175
Weight	lbs kg	.2 0,1	.2 0,1	.7 0,3	1.6 1,0	2.2 1,0	2.4 1,1	2.4 1,1



Parting-off Holder		**DB 505**	**DB 705**	**DB 905**	**DB 1105**	**DB 1305**	**DB 1505**	**DB 2005**
Height **H**	mm	1 3/8" 34	1 3/4" 43	1 7/8" 49	2 1/4" 58	2 1/2" 64	2 3/4" 68	– –
Tool Width **A**		A1, A2, A3	A3, A4, A5	A4, A5, A6	A5, A6, A7	A6, A7, A8	A6, A7, A8	– –
Length	mm	3" 75	4" 103	5" 128	6" 158	7 3/8" 188	8 1/4" 208	– –
Weight	lbs kg	.7 0,3	1.8 0,8	2.6 1,2	4.8 2,2	7.5 3,4	8.4 3,8	– –

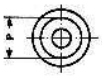


Parting-off tool HSS		**A 1**	**A 2**	**A 3**	**A 4**	**A 5**	**A 6**	**A 7**	**A 8**
Height **H**	mm	5/16" 8	3/8" 10	1/2" 12	5/8" 16	3/4" 20	1" 25	1 7/32" 30	1 3/8" 35
Width	mm	3/32" 2	3/32" 2,5	1/8" 3	1/8" 3,5	5/32" 4	3/16" 5	1/4" 6	9/32" 7
Length		3 1/8" 80	4" 100	5" 125	5" 125	6" 150	6" 150	8" 200	8" 200

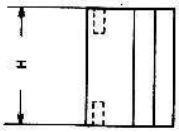


Retracting Holder			**DB 706**	**DB 906**	**DB 1106**	**DB 1306**	**DB 1506**	
Height **H**	mm	–	1 3/4" 43	2 1/8" 53	2 3/8" 59	3" 74	3" 74	–
Length	mm	–	4" 100	6" 150	6 3/4" 170	8" 200	9 1/2" 240	–
Weight	lbs kg	–	4.4 2,0	6.2 2,8	8 3,6	11 5,0	15.4 7,0	–

Threading tool HSS or Carbide			**FG I**	**FG I**	**FG II**	**FG III**	**FG III**	



Inside Threading Bar			**DB 707**	**DB 907**	**DB 1107**	**DB 1307**	**DB 1507**	
Dia.	**P** mm		3/4" 20	1" 25	1 3/16" 30	1 3/8" 35	1 5/8" 40	–
Length	mm		4 3/8" 110	6 3/8" 160	7 1/8" 180	8 1/4" 210	10" 250	–
Tool Bore dia.	mm		5/16" 8	3/8" 10	1/2" 13	3/4" 20	1 1/8" 28	–
Weight	kg		.9 0,4	1.5 0,7	2.4 1,1	4 1,8	4.8 2,2	–



Knurling Tool Holder			**DB 708**	**DB 908**	**DB 1108**	**DB 1308**	**DB 1508**	
Height	**H** mm		2" 50	2 3/8" 60	2 3/4" 70	2 3/4" 70	2 7/8" 74	–
Length	mm		5 1/8" 130	6" 150	6 3/4" 170	8 1/4" 210	9 1/2" 240	–
Knurling capac. dia.	mm		2" 50	2" 50	2" 50	4" 100	4" 100	–
Weight	lbs kg		2.2 1,0	3.1 1,4	4.6 2,1	8.4 3,8	11 5,0	–

Standard: measurements in millimeters