ASP

Flexible
Drill head System

“Universal Drilling” for small - to - medium batches (Symmetrical and asymmetrical hole patterns of varying types).

Each spindle can handle variable machine planes, revolutions and machining tasks.

Drilling Tapping Flow Drilling - Thread molding Countersinking and Brushing

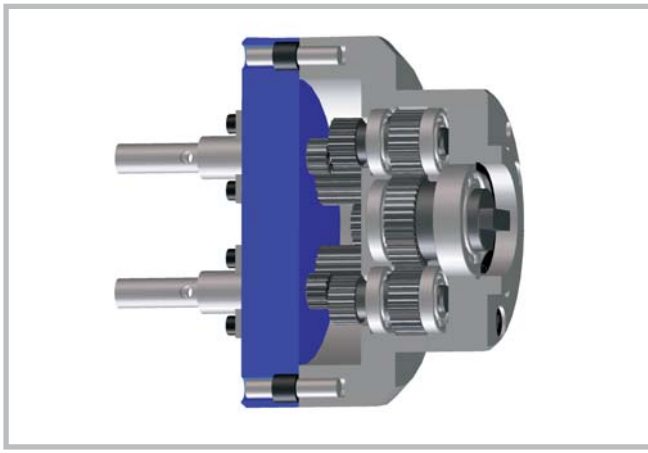
The Multi spindle Drill heads going by the Brand Bormaster® are gear driven and, thus, sturdier than comparable drilling heads with universal joints.

The performance figure taken from the equipment availability (activity unit) is greatly increased due to minor and schedulable maintenance times.

Up to 12 spindles can be driven / powered by using gearbox housing with a minimum of 4 idlers.

Only the Spindle plate has to be replaced should there be changes in dimensions or technical change in the machining tasks.

In general the existing interchangeable spindles (EBS) and idler (EBZ) can be reused.



Resulting in a potential saving of up to 90% compared to a new drill head.

EBS Interchangeable Spindles:

There are many types available depending on the torque, center distance or clamping sleeve.

EBZ Interchangeable Idlers:

There are many different types available depending on ratio.

The flexible Drill head System (ASP) is available in three lines

	ASP 0	ASP 1	ASP 2
Max. Drilling Capacity in St 50	8 mm	14 mm	32 mm
Max. Revolution	5000 rpm	3000 rpm	2000 rpm
BM-Code	BM CODE 6313	BM CODE 6323	BM CODE 6333

ASP 0/100

corresponds with line **ASP 0** with a working area diameter of about **105 mm**.

Type	Working area ASP 0	interchangeable spindle / Type	Drilling capacity in St 50	smallest distance in mm
100	105*	EBS/ER8/4	4 mm	M 3 — 13 mm
150	155*	EBS/60/6	6 mm	M 5 — 18 mm
200	200	EBS/80/8	8 mm	M 6 — 22 mm
200R	200R 60 X 200	-		
380R	380R			

Clamping sleeve

E1						
B1	B2	B3				
C1	C2	C3				

ASP 1/155

corresponds with line **ASP 1** with a working area diameter of about **155 mm**

Type	Working area ASP 1	interchangeable spindle / Type	Drilling capacity in St 50	smallest distance in mm
110	110	EBS1/80/8	8 mm	M 6 — 22 mm
155	155	EBS1/130/11	11 mm	M 10 — 25 mm
195	195	EBS1/S16/11	11 mm	M 10 — 25 mm
250	250	EBS1/130/13	13 mm	M 12 — 30 mm
300	300	EBS1/S16/14	14 mm	M 12 — 30 mm
250R	95 x 250	EBS1/S20/14	14 mm	M 12 — 32,5 mm
380R	380R 65 x 380			

Clamping sleeve

C1	C2	C3				
D1	D2	D3				
G1	H1	H2	F1	F2	E3	E4
D1	D2	D3				
G1	H1	H2	F1	F2	E3	E4
G3	H1	H2	H3	H4		

ASP 2/200

corresponds with line **ASP 2** with a working area diameter of about **206 mm**

Type	Working area ASP 2	interchangeable spindle / Type	Drilling capacity in St 50	smallest distance in mm
200	206	EBS2/S20/16	16 mm	M 14 — 34 mm
250	270	EBS2/S25/20	20 mm	M 16 — 38 mm
300	302	EBS2/S28/23	23 mm	M 18 — 42 mm
		EBS2/S36/32	32 mm	M 22 — 55 mm

Clamping sleeve

G2	H1	H2				
G3	H1	H2	H3	H4		
G4	H1	H2	H3	H4	F3	E5
D1	G5	H3	H4			

*)translation / conversion / ratio optionally 1:1 or 1:2 into the fastest speed

Tapping capacity in St 50

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D - 70435 Stuttgart - Zuffenhausen (Germany)
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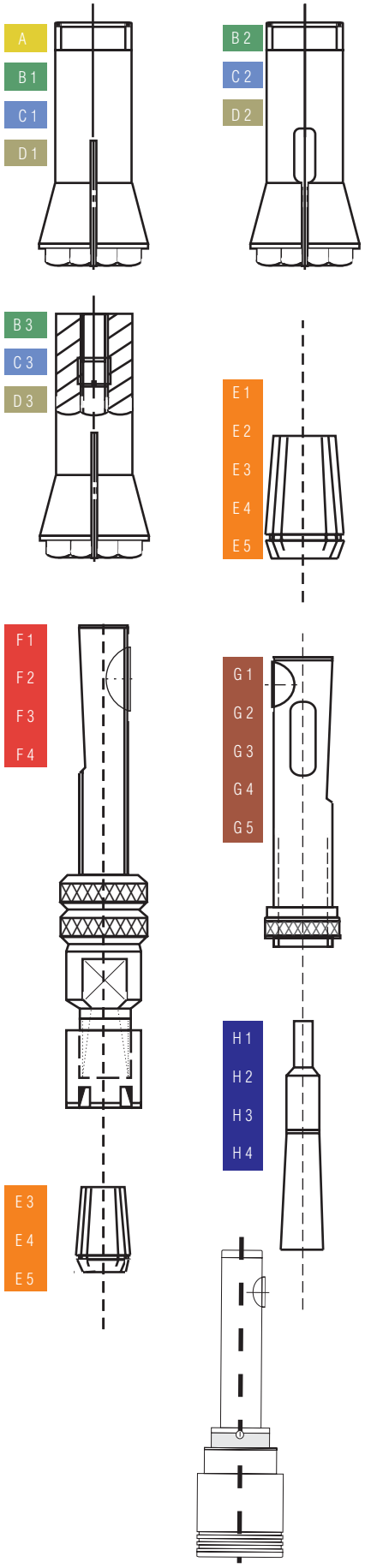
			from - to in mm	grading in mm
E 1	collet	ER 8	1,0 - 5,0	0,5
E 2	collet	ER 11	1,0 - 7,0	0,5
E 3	collet	ER 16	2,0 - 10,0	0,5
E 4	collet	ER 20	2 - 13	0,5
E 5	collet	ER 25	3 - 16	0,5
F 1	collet chuck	ER 16 / Ø 16mm	-	-
F 2	collet chuck	ER 20 / Ø 16mm	-	-
F 3	collet chuck	ER 25 / Ø 28mm	-	-
A	collet	44	1,0 - 4,0	0,1
B 1	collet	60	1,0 - 6,3	0,1
B 3	collet	62	1,0 - 6,3	0,1
B 2	collet	61	M2 - M6	-
C 1	collet	80	1,0 - 8,5	0,1
C 3	collet	82	1,0 - 8,5	0,1
C 2	collet	81	M2 - M8	-
D 1	collet	130	1,0 - 10 10,25 - 14,0	0,1 0,25
D 3	collet	132	1,0 - 10 10,25 - 14,0	0,1 0,25
D 2	collet	131	M2 - M12	-
G 1	shank	MT1 Ø 16mm	-	-
G 2	shank	MT1 Ø 20mm	-	-
G 3	shank	MT1/MT2 Ø 25mm	-	-
G 4	shank	MT1/MT2 Ø 28mm	-	-
G 5	shank	MT2/MT3 Ø 36mm	-	-
H 1	clamping sleeve MT1 DIN 6329		3,0 - 8,0	0,1
H 2	clamping sleeve MT1 DIN 6328		M3 - M10	-
H 3	clamping sleeve MT2 DIN 6329		5,0 - 13,0	0,1
H 4	clamping sleeve MT2 DIN 6328		M4 - M12	-

notice / drawings



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