

Designers & Manufacturers of Drilling & Tapping Solutions

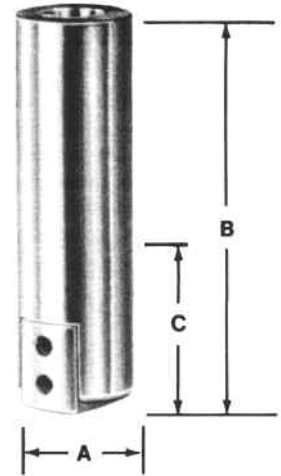
Single purpose insert tool holders

Single purpose insert drill, tap or reamer holders meet close center and true running tool requirements. Their rugged unique design features, such as preset overall tool lengths and vertical adjustment, will save set up and tool costs.

Preset overall tool lengths, important for blind hole drilling, may be accurately set away from the machine or multiple spindle head. One can imagine the difficulty of measuring and setting tools in a crowded area with close center spindles. Tooling changeover only requires an Allen wrench to loosen one set screw, removing the dull tool insert and installing another insert with sharpened tool. During the following production run another set of sharpened tools, using previously removed inserts, are reset for next changeover.

Vertical adjustment of insert will give up to 1/2 inch tool sharpening before machine stroke has to be adjusted.

Tap shank square is used for drive on tapping operations. Tap and drill shanks require modification for retention in insert, refer to page 8 for dimensions.

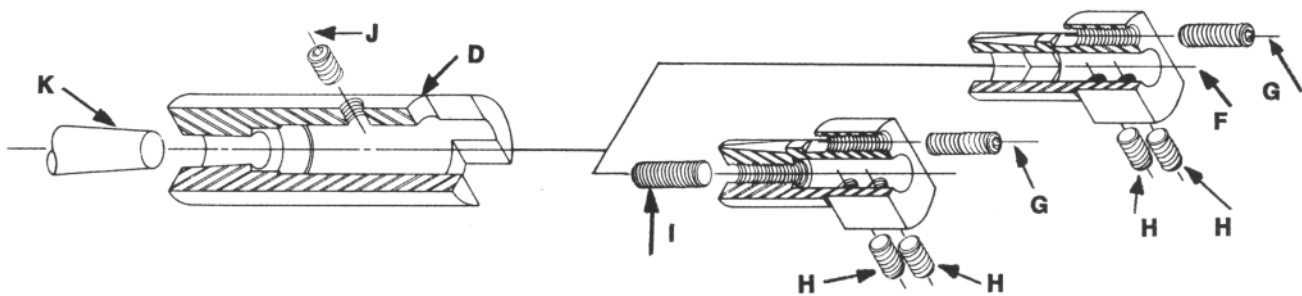


Ordering Information:

1. Order by part number as shown in tabulation; body and insert are sold separately.
2. Inserts are single purpose, order one insert for each tool size; identify type of tool and add the decimal equivalent of tool shank diameter in place of XXXX. EXAMPLE: Drill insert part number 5302BXXXX for 1/4 drill becomes 5302B2500. Tap insert part number 5303BXXXX5 for 1/4 tap becomes 5303B2555.
3. Tool holders on existing equipment are identified by the "T" shaped insert and measuring the assembly outside diameter and overall length.

Series	Capacity		DIMENSIONS				Spindle Taper
	Drill	Tap	A	B	C Drill	C Tap	
5300S	1/16 to 5/32	#0 to #8	.47	2.31	.84	.75	0 Jacobs
5300S	1/16 to 5/32	#0 to #8	.47	2.31	.84	.75	1 Jacobs
5300A	1/16 to 7/32	#0 to #10	.61	2.31	.84	.75	0 Jacobs
5300A	1/16 to 7/32	#0 to #10	.61	2.31	.84	.75	1 Jacobs
5300B	3/32 to 5/16	#0 to 5/16	.78	2.50	1.13	.94	1 Jacobs
5300C	3/16 to 7/16	#10 to 1/2	1.10	2.94	1.13	1.31	1 Jacobs
5300C	3/16 to 7/16	#10 to 1/2	1.10	2.94	1.13	1.31	33 Jacobs

Vertical adjustment for all series .50.
C = depth that tool enters holder.



Series	REPLACEMENT PARTS							
	Body Assy D	Insert Assembly		V/ADJ Screw G	Shank Screw H	Thrust Screw I	Insert Lock Scr. J	Spindle Taper K
5300S	5301S0T00	5302SXXXX	5303SXXX5	#5-40 x 3/8	#6-32 x 3/16	#6-32 x 1/2	#8-32 x 1/8	0 Jacobs
5300S	5301S1A00	5302SXXXX	5303SXXX5	#5-40 x 3/8	#6-32 x 3/16	#6-32 x 1/2	#8-32 x 1/8	1 Jacobs
5300A	5301A0T00	5302AXXXX	5303AXXX5	#6-32 x 3/8	#6-32 x 3/16	#6-32 x 1/2	#10-32 x 3/16	0 Jacobs
5300A	5301A1A00	5302AXXXX	5303AXXX5	#6-32 x 3/8	#6-32 x 3/16	#6-32 x 1/2	#10-32 x 3/16	1 Jacobs
5300B	5301B1A00	5302BXXXX	5303BXXX5	#8-32 x 1/2	#8-32 x 1/4	#8-32 x 1/2	#10-32 x 3/16	1 Jacobs
5300C	5301C1A00	5302CXXXX	5303CXXX5	1/4-20 x 5/8	1/4-20 x 5/16	3/8-24 x 3/4	1/4-20 x 1/4	1 Jacobs
5300C	5301C3300	5302CXXXX	5303CXXX5	1/4-20 x 5/8	1/4-20 x 5/16	3/8-24 x 3/4	1/4-20 x 1/4	33 Jacobs

1. Body assembly includes insert lock screw "J" — insert assembly includes screws G, H, I. — body & insert assemblies are sold separately.
2. Part numbers with "X"—identify type of tool and add decimal equivalent of tool shank in place of X; Example: Drill insert 5302BXXXX for 1/4 drill becomes 5302B2500 or tap insert 5303BXXX5 for 1/4 tap becomes 5303B2555.

