

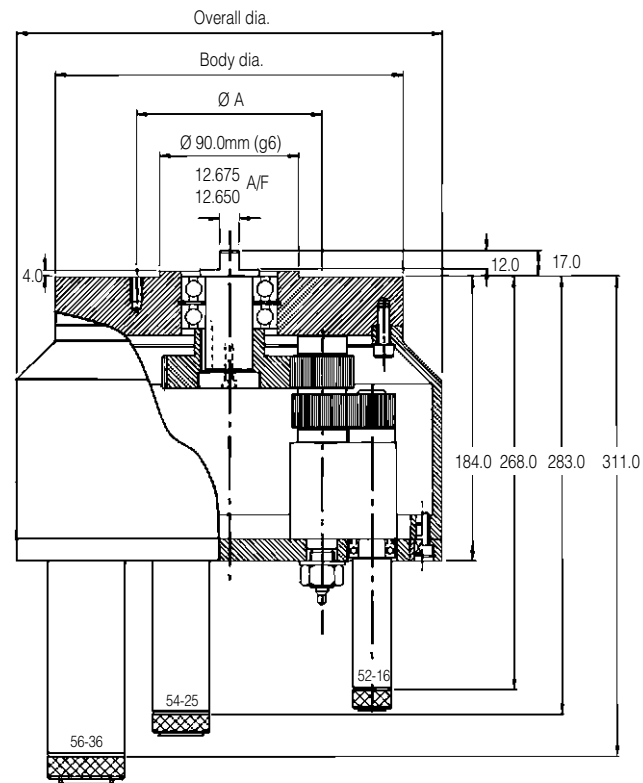
# 50 RANGE



Unit B Grovelands Estate, Longford Road, Exhall, Coventry CV7 9ND  
 Tel: +44 (0)24 7664 5999 | Fax: +44 (0)24 7664 4081  
 E-mail: ppickering@coventrytoolholders.co.uk | Web: www.cil-centrelines.com  
 A Member of Coventry Engineering Group

## MAIN BODY ASSEMBLY

| Dimensions (mm)    |              |           |                        |                  |
|--------------------|--------------|-----------|------------------------|------------------|
| Main Body Assembly | Overall dia. | Body dia. | A (8 holes equispaced) | Unit Weight (kg) |
| 50 FG 32           | 200.0        | 175.0     | Ø120.0mm (M8 x 16 d'p) | 7.90             |
| 50 HK 42           | 275.0        | 225.0     | Ø120.0mm (M8 x 16 d'p) | 11.80            |
| 50 LN XX           | 350.0        | 300.0     | Ø120.0mm (M8 x 16 d'p) | 13.00            |



## SPECIFICATIONS

|                    |                  | Maximum and Minimum Pitch Circle Diameters with Spindles Equispaced                    |       |       |       |       |       |       |       |                    |       |       |       |       |       |       |       |                    |       |       |       |       |       |       |       |       |
|--------------------|------------------|--|-------|-------|-------|-------|-------|-------|-------|--------------------|-------|-------|-------|-------|-------|-------|-------|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|
| Main Body Assembly | Spindle Assembly | 52-16  |       |       |       |       |       |       |       | 54-25              |       |       |       |       |       |       |       | 56-36              |       |       |       |       |       |       |       |       |
|                    |                  | No. of Spindles  | 2     | 3     | 4     | 5     | 6     | 7     | 8     | 2                  | 3     | 4     | 5     | 6     | 7     | 8     | 2     | 3                  | 4     | 5     | 6     | 7     | 8     |       |       |       |
| 50 FG 32           | Max. P.C. Ø      | 128.0  | 128.0 | 128.0 | 128.0 |       |       |       |       | 118.8              | 118.8 | 118.8 |       |       |       |       | 100.0 | 100.0              |       |       |       |       |       |       | fig.1 |       |
|                    |                  |  |       |       | 116.7 |       |       |       |       |                    |       | 101.6 |       |       |       |       |       | 88.2               |       |       |       |       |       |       |       | fig.2 |
|                    | Min. P.C. Ø      |  | 37.0  | 45.3  |       |       |       |       |       |                    | 47.5  |       |       |       |       |       |       | 60.0               |       |       |       |       |       |       |       | fig.3 |
|                    |                  | 35.5   |       |       |       |       |       |       |       | 41.2               |       |       |       |       |       |       | 60.0  |                    |       |       |       |       |       |       |       | fig.4 |
|                    |                  | Head Ratio: 2.25:1   |       |       |       |       |       |       |       | Head Ratio: 1.78:1 |       |       |       |       |       |       |       | Head Ratio: 1.23:1 |       |       |       |       |       |       |       |       |
| 50 HK 42           | Max. P.C. Ø      | 184.5  | 184.5 | 184.5 | 184.5 | 184.5 | 184.5 | 184.5 | 192.0 | 192.0              | 192.0 | 192.0 | 192.0 | 192.0 | 192.0 | 175.0 | 175.0 | 175.0              | 175.0 |       |       |       |       |       | fig.1 |       |
|                    |                  |  |       |       |       | 137.6 | 149.4 | 162.0 |       |                    |       |       |       | 128.4 | 152.4 | 164.9 | 172.7 |                    |       |       | 126.7 | 160.1 |       |       |       | fig.2 |
|                    | Min. P.C. Ø      |  |       |       |       | 70.5  |       |       |       |                    |       |       |       |       |       |       |       |                    |       |       | 69.3  |       |       |       |       | fig.3 |
|                    |                  | 55.5   | 55.5  | 55.5  | 55.5  |       |       |       |       | 48.0               | 48.0  |       |       |       |       |       | 60.0  |                    |       |       |       |       |       |       | fig.4 |       |
|                    |                  | Head Ratio: 2.95:1   |       |       |       |       |       |       |       | Head Ratio: 2.33:1 |       |       |       |       |       |       |       | Head Ratio: 1.61:1 |       |       |       |       |       |       |       |       |
| 50 LN XX           | Max. P.C. Ø      | 264.5  | 264.5 | 264.5 | 264.5 | 264.5 | 264.5 | 264.5 | 268.0 | 268.0              | 268.0 | 268.0 | 268.0 | 268.0 | 268.0 | 248.0 | 248.0 | 248.0              | 248.0 | 248.0 | 248.0 | 248.0 | 248.0 | 248.0 | fig.1 |       |
|                    |                  |  |       |       |       |       |       |       |       |                    |       |       |       |       |       |       |       |                    |       |       |       |       |       |       | fig.2 |       |
|                    | Min. P.C. Ø      |  |       |       |       |       |       |       |       |                    |       |       |       |       |       |       |       |                    |       |       |       |       |       |       | fig.3 |       |
|                    |                  | 83.5   | 83.5  | 83.5  | 83.5  | 83.5  | 83.5  | 83.5  | 80.0  | 80.0               | 80.0  | 80.0  | 80.0  | 80.0  | 80.0  | 60.0  | 60.0  | 60.0               | 60.0  | 60.0  | 60.0  | 60.0  | 60.0  | 60.0  | fig.4 |       |
|                    |                  | Please refer to Centreline's Engineering Department for more information on this range |       |       |       |       |       |       |       |                    |       |       |       |       |       |       |       |                    |       |       |       |       |       |       |       |       |

## SPINDLE ASSEMBLY

| Spindles         |                |                   |                  |
|------------------|----------------|-------------------|------------------|
| Spindle Assembly | Max. Tool dia. | Max. Speed r.p.m. | Unit Weight (kg) |
| 52-16            | 14.00          | 3500              | 2.0              |
| 54-25            | 23.00          | 3500              | 2.6              |
| 56-36            | 31.75          | 2500              | 5.7              |

| Minimum Centre Distances |       |       |       |
|--------------------------|-------|-------|-------|
| Spindle Assembly         | 52-16 | 54-25 | 56-36 |
| 52-16                    | 32.0  | 36.4  | 45.8  |
| 54-25                    | 36.4  | 41.2  | 50.6  |
| 56-36                    | 45.8  | 50.6  | 60.0  |

The 52, 54 and 56 spindle assemblies can be fitted to the same head. This is useful in overcoming possible close centre problems. A further advantage is the higher gear ratio of the smaller spindles, which helps if drilling large and small holes at the same time.

