



NORIS SE

Quick-change adapters NORIS SE

Operating instruction

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Warning signs, symbols

This operating instruction uses the following symbols:



Attention

Marks special instructions, rules and prohibitions which are important in order to avoid any damage.

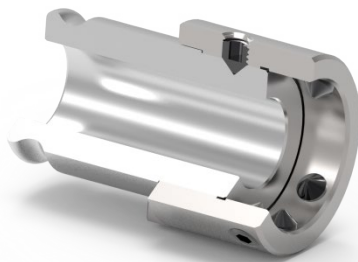
▶ Please observe these instructions!



Note

Marks application instructions and other useful information.

Sectional view:



Quick-change adapter NORIS SE

1 Application range, safety instructions and technical data

1.1 Application range, determined use

Application of the quick-change adapters:

- Adaptation of dies according to DIN EN 22568.
The die is clamped by thread pins.
For assembly instructions please refer to chapter 2.2, page 7
- These quick-change adapters are designed to be used in the following quick-change tap holders. REIME NORIS types:
NORIS UNI NORIS UNI HP
- Producing of external threads.
The max. thread depth to be cut depends on the thread size and the used quick-change adapter size. These values are listed in Table 1, page 6
- Producing of right- and left-hand threads.

The quick-change adapter size is defined by the quick-change tap holder size used.
The required die size is defined by the cutting range.

The non-determined use exempts the manufacturer from any liability.

1.2 Safety instructions and hints

For all works, i.e. putting into operation, production and maintenance, please observe the details given in the operating instructions.

All relevant safety regulations as well as local instructions are to be observed when working.

Below please find some basic rules:



Attention



- ▶ Please wear gloves during tool change to avoid injury.
- ▶ Basically change the tool yourself to avoid the sudden start of the spindle caused by mis-operating.

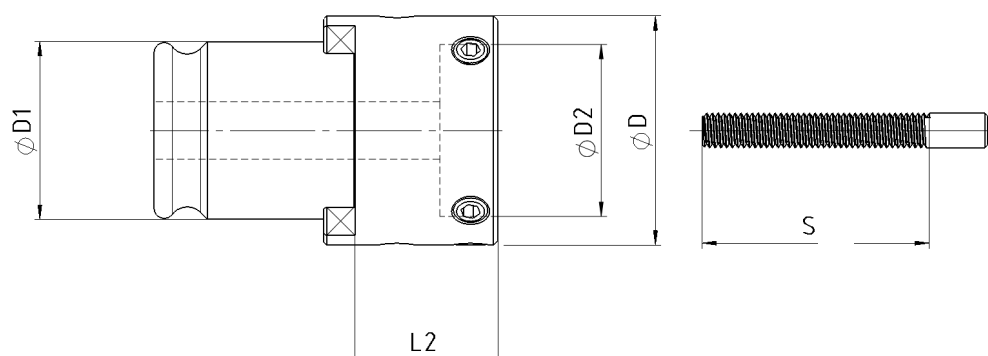


- ▶ Hold the tool when loosening the tool clamping to avoid it falling down and damaging the tool and the work piece.
- ▶ There are maximum values for cutting speeds and feeds for every kind of machining. Please observe such data.
- ▶ Please observe the maximum tool dimensions.
- ▶ Furthermore, the instructions of the tool manufacturers are valid!

1.3 Proprietary rights

The entire contents of these operating instructions are subject to German proprietary rights legislation.

Any form of multiplication, processing, broadcasting, passing on to third parties - also in the form of extracts - and any kind of use outside the boundaries of proprietary rights requires the written consent of REIME NORIS GmbH.

1.4 Dimensions and technical data


Picture 1: Dimensions of the quick-change adapters NORIS SE

Table 1: Technical data of the quick-change adapters NORIS SE

Type	Adapter size	Die size $\varnothing d_2 \times h_1$	Cutting range	$\varnothing D$ [mm]	$\varnothing D_1$ [mm]	$\varnothing D_2$ [mm]	S^1 [mm]	L_2 [mm]
WE 01-SE	01	16 x 5	M1 – M4	30	19	16	36	15
		20 x 5	M3 – M4	30	19	20	36	15
		20 x 7	M4,5 – M6	30	19	20	38	17
		25 x 9	M7 – M9	35	19	25	40	19
		30 x 11	M10 – M11	40	19	30	42	20,5
		38 x 10	M12x1-M15x1,5	48	19	38	41 (M12) 10 (M14-15)	19,5
		38 x 14	M12 – M14	48	19	38	45 (M12) 14 (M14)	23,5
WE 03-SE	03	20 x 5	M3 – M4	40	31	20	55	20
		20 x 7	M4,5 – M6	40	31	20	56	21,5
		25 x 9	M7 – M9	40	31	25	58	23,5
		30 x 11	M10 – M11	40	31	30	60	25
		38 x 10	M12x1-M15x1,5	48	31	38	56	21
		38 x 14	M12 – M14	48	31	38	60	25
		45 x 14	M16x1 – M20x2	57	31	45	60	25
		45 x 18	M16 – M20	57	31	45	64	29
WE 04-SE	04	30 x 11	M10 – M11	60	48	30	84	29
		38 x 10	M12x1-M15x1,5	60	48	38	83	28
		38 x 14	M12 – M14	60	48	38	87	32
		45 x 14	M16x1 – M20x2	60	48	45	87	32
		45 x 18	M16 – M20	60	48	45	91	36
		55 x 16	M22x1 – M26x1,5	72	48	55	85	30
		55 x 22	M22 – M24	72	48	55	90	35
		65 x 18	M27x1 – M36x2	82	48	65	87	32
65 x 25	M27 – M36	82	48	65	93	38		

¹ Maximum thread length to be cut

2 Putting the quick-change adapters into operation

2.1 Unpacking

- Take the quick-change adapter from the plastic case.
- Clean the quick-change adapter with a duster to remove any conservation oil.

! Note

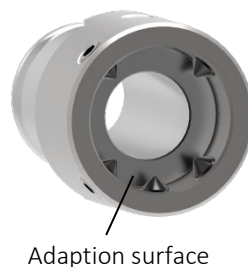
- ▶ Do not use any aggressive solvents.
- ▶ Do not use fibrous materials i.e. steel wool.

✓ The quick-change adapter is now ready for operation

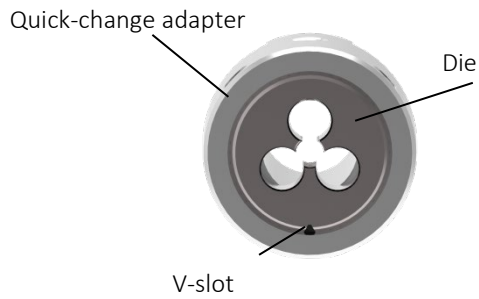
2.2 Insert die

! Note

- ▶ Choose the appropriate quick-change adapter for the required tap/cold-forming tap!
- ▶ **Required tool:**
Screw driver for slotted screws
Hexagon socket wrench



1. Turn out screws until adaptation surface is plane.



2. Insert die

⚠ Attention

The V-slot of the die must be positioned at the middle of the 3 screws



3. Schrauben anziehen

! Note

First tighten the screw at the V-slot
⇒ die is positioned

Insert the quick-change adapter into the quick-change tap holder as described in the operating instruction of the used tap holder.

2.3 Detach die

! Note

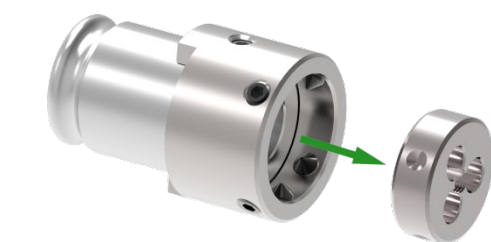
► Required tool:

Screw driver for slotted screws

Hexagon socket wrench



1. Loosen screws



2. Take out die

3 Maintenance

3.1 Maintenance schedule

What?	When?	Who?
External cleaning	Periodically, depending on the degree of dirt.	Operator

3.2 External cleaning

Clean the quick-change adapter at periodic intervals depending on how dirty the adapter is.



Note

- ▶ Do not use any aggressive solvents.
- ▶ Do not use fibrous materials i.e. steel wool.

4 Storage when not in use

If the quick-change adapter is taken out of service, please go through the following working steps:

1. Clean the quick-change adapter with a duster, see chapter 3.2
2. Spray the quick-change adapter with a preservation oil to avoid rusting and to preserve the easy running of the adapter



Attention

Before storage all evidence of coolant-lubricant and machining residues must be removed!

5 Application and choice of other quick-change adapters

Type	Description	Recommended Applications
WE..	Rigid type	Through hole threads
WE../MMS	Rigid type, for minimum-quantity lubrication (MQL)	Through hole threads
WE..-U	With adjustable overload clutch	Blind hole threads
WE..-U/MKBA	With adjustable overload clutch, and internal coolant supply through channels along the tap/cold-forming tap shank.	Blind hole threads
WE..-L	With length adjustment	On multi-spindle heads and transfer lines
WE..-UL	With adjustable overload clutch and length adjustment	Blind hole threads on multi-spindle heads
WE..-Z	Rigid type with adaptation for collets according to DIN ISO 15488	Clamping of carbide tools High coolant-lubricant pressures High-speed machining
WE..-Z/MMS	Rigid type with adaptation for collets according to DIN ISO 15488, for minimum-quantity lubrication, with adjustment screw for presetting the tap/cold-forming tap length	Clamping of carbide tools High-speed machining
WE..L/ER/MKB	With length adjustment and adaptation for collets according to DIN ISO 15488	On multi-spindle heads and transfer lines Clamping of carbide tools High coolant-lubricant pressures High-speed machining
WE..-PGR	Rigid type with adaptation for collets according to type PGR (GB)	Clamping of carbide tools High coolant-lubricant pressures High-speed machining
WE..-R	Reducing adaptation for all WE types	For the extension of the clamping range downwards

All quick-change adapters, unless stated otherwise, can be used for internal coolant supply when the taps/cold-forming taps are designed accordingly.


REIME NORIS quick-change adapter NORIS SE
Operating instruction


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Please keep this for future use!


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