

# Technical information for DIN 6348 drilling jigs

Using norelem drilling jigs, down times and machine costs can be saved by significantly reducing the clamping times. The stress is removed from the design department and toolmaking through the universal ability to use the drilling jigs, even for small-scale production runs.

The drill and support plates are prepared dependent on the bore spacing of the part to be machined. While the corresponding drill bushes are placed in the drill plate, fixing pins are attached to the support plate to enable quick and easy positioning of the part for machining. Since the drill and supporting plates can be changed quickly, the drilling jig is immediately available for another part to be machined.

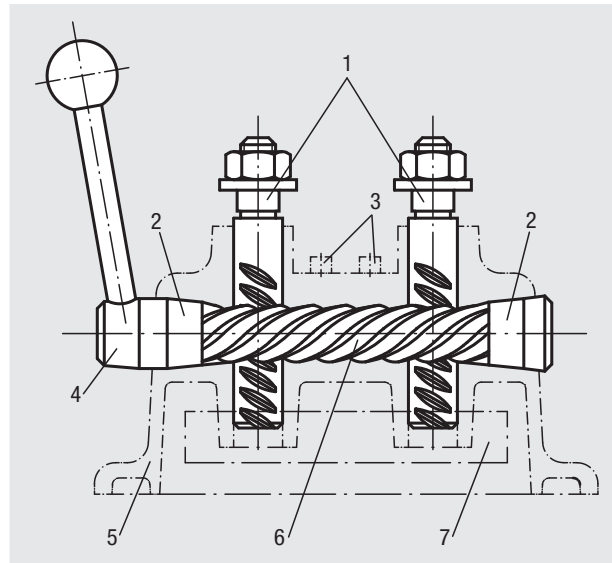
**Version:**

The drilling jigs are supplied in 9 sizes. They differ in terms of the position of the working area relative to the columns. In the case of sizes 0 to 3 the working area is in front of the columns, in sizes 3 to 5 the working area is between the columns.

**Operating method:**

The worm shaft has cones at both ends. The axial force of the helical gear drive pulls the cone of the shaft into a tapered bore in the casing. The pair of cones at the ends of the worm shaft work in opposition to the powerful and consistent clamping top and bottom; as a result, the drill plate cannot fall onto hands when the part to be machined is changed. The clamp holds perfectly and safely, even with vibration. The clamping element can be taken apart and put together by anyone, even those with no technical training. The clamping lever can be changed from left to right-hand use by loosening the screw in the right-hand cone. The worm shaft can now be used with the adjustable clamping lever on the right-hand side.

The clamp is activated by pressing the lever down and released by lifting the lever up. The best working position can be engaged using the adjustable clamping lever, so the operator can work in a standing or seated position.



**Drawing reference:**

- 1. worm column
- 2. cone
- 3. locating pins
- 4. adjustable clamping lever
- 5. housing
- 6. worm shaft
- 7. grip

**Force tables**

Hand force N	Size							
	0	1	2	2S	3S	3	4	5
	Clamping force N							
100	600	1200	1250	1250	1300	2800	2900	3800
200	1100	2100	2150	2150	2200	5500	5600	7500